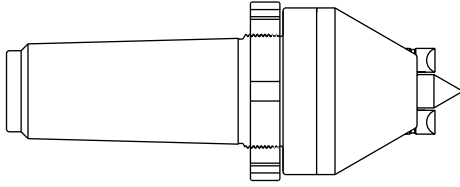
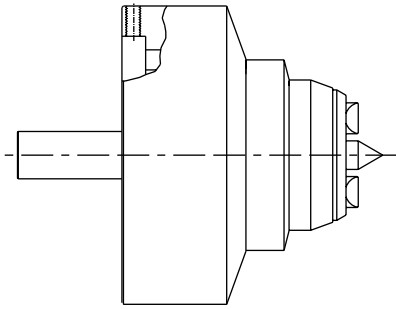


Two Face Driver Designs



Mechanical Design — Type 40 thru 49

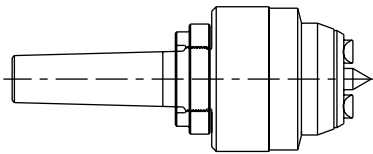
The Type 40 Series allows a driving diameter of 0.32" to 3.90". The driving pins move independently to allow a five-degree pitch of the end face of the workpiece. The mechanical compensation and lock down center point allow a constant length to be held from center to the taper. The Type 40 Series is available in 3, 4, 5, and 6 morse taper designs as well as a flange mount. Chuck mounting can be achieved as described in the mounting procedures.



Hydraulic Design — Type 60 thru 68

The Type 60 Series allows a driving diameter of 0.28" to 5.74". This design is generally used in medium roughing operations and can handle loads of up to 3,000 lbs. The pressure equalization of the driving pins is provided by hydraulic fluid. This permits a seven-degree pitch on the end face of the part. Behind every driving pin is a sealed piston that prevents oil leakage. The oil cavities behind the pistons are interconnected and the whole system is enclosed. This series is available in a taper shank, chuck or flange mount. The flange mount is preferred due to higher stability and increased concentricity capabilities. When using a flange mount design, a spindle adapter and mounting screws are required (see below and page 5). The flange mount results in less wear on the machine and machine spindle. The taper shank and chuck mount allow for the face driver to be changed quickly when using the machine for other applications.

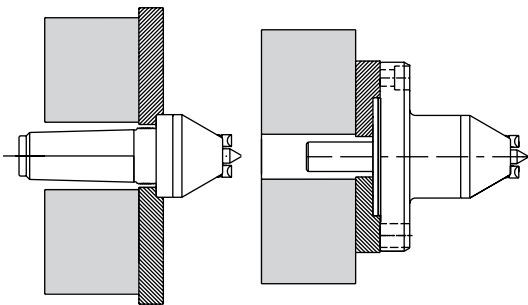
Mounting Procedures



Shank Mount — All Models

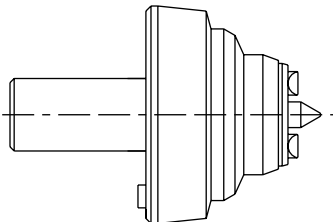
Used when machine spindle requires a morse taper mount.

- Easy change-over.
- No other tooling required to mount.



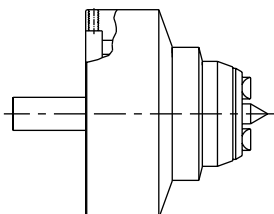
Chuck Mount — Type 40 thru 49

- Grip tapered shank model directly on the driver head (largest OD), and use bored-out soft chuck jaws.
- Use a flange mount and make a simple adapter plate and bolt to chuck face, or master jaw "T" nuts.



Chuck Mount — Type 60 thru 68

- The flange O.D. has a six-degree angle, therefore the chuck jaws need to accept a six-degree angle. Some adjustments to the chuck jaws may be required.

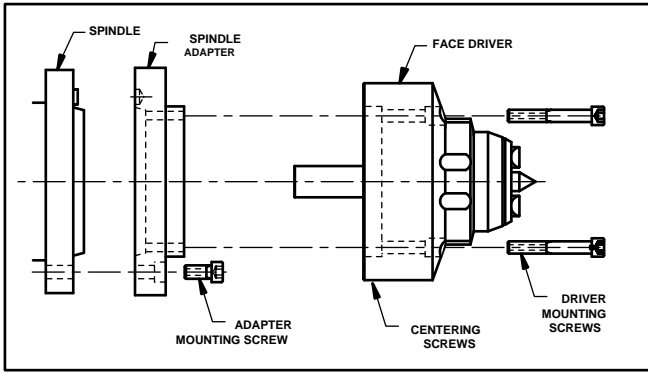


Flange Mount — All Models

With a spindle adapter this design mounts directly to the machine.

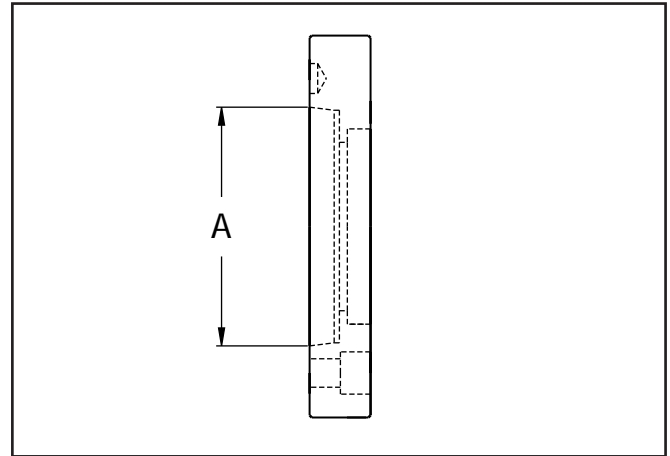
- Most rigid mounting procedure.
- Required when holding higher tolerances.
- Spindle adapter and mounting screws required. (*See next page*)

Spindle Adapters



Spindle Adapter

ORDER CODE	FACE DRIVER	SPINDLE SIZE	UPC NUMBER
705046	60-62	A2-5"	662503-00264
705047	60-62	A2-6"	662503-00265
705048	60-62	A2-8"	662503-00266
705049	60-62	A2-11"	662503-00267
705050	63-64	A2-6"	662503-00293
705051	63-64	A2-8"	662503-00294
705052	63-64	A2-11"	662503-00295
705053	66	A2-6"	662503-00312
705054	66	A2-8"	662503-00313
705055	66	A2-11"	662503-00314
705056	66	A2-15"	662503-00315
705057	68	A2-6"	662503-00322
705058	68	A2-8"	662503-00323
705059	68	A2-11"	662503-00324
705060	68	A2-15"	662503-00325



"A" dimension = largest diameter of spindle nose to determine spindle size.

Spindle Adapter

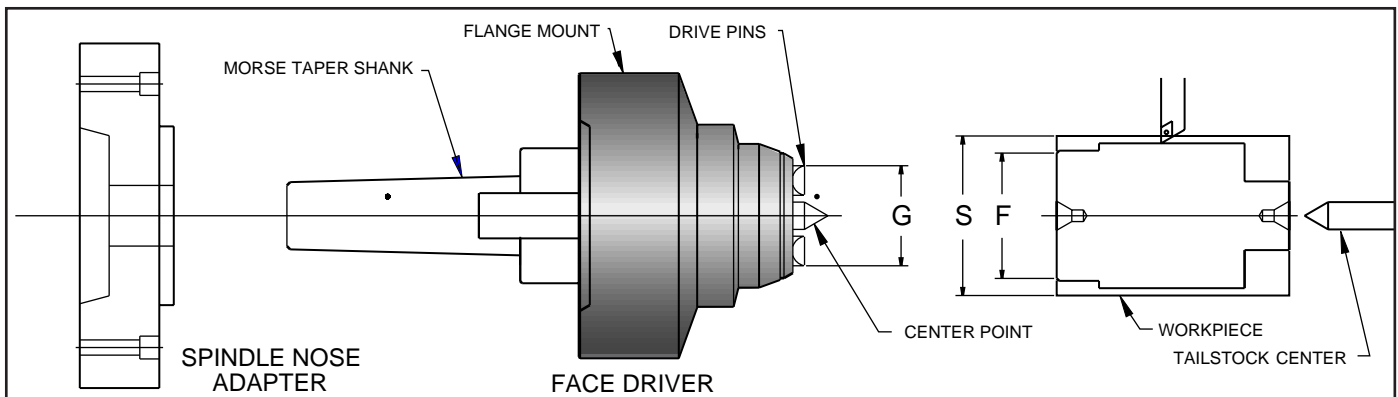
ORDER CODE	FACE DRIVER	"A" DIMENSION	SPINDLE SIZE	UPC NUMBER
708037	40-49	3.250 in./82.55 mm	A2-5"	662503-00218
708038	40-49	4.188 in./106.37 mm	A2-6"	662503-00219
708039	40-49	5.500 in./139.70 mm	A2-8"	662503-00220
708040	40-49	7.750 in./196.85 mm	A2-11"	662503-00221

Selecting the Right Face Driver

1. Determine the finish diameter (F) of the workpiece at the driving face.
2. Refer to the Selection Matrix on the following page and select the face driver series whose maximum driving diameter (G) is smaller than the finish diameter (F). Check the maximum raw stock size (S) and the workpiece weight to see if you have selected the correct face driver for your application. Full width drive pins are the first choice. However, offset, half offset and central drive pins are also available to meet a broad range of applications.
3. The Selection Matrix also lists the mounting styles (taper

mount, flange and chuck mount) that are available for each series of face drivers. Special size and styles are available upon request

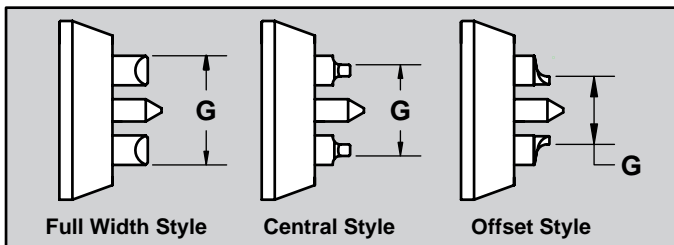
4. Select the appropriate face driver series number in the left-hand column. The catalog page number containing detailed information for that particular series is listed under each series number. Turn to the appropriate page for detailed information and part numbers.
5. Technical information can be found on pages 24 - 28. For further assistance, contact Riten Industries at 800-338-0027.



Face Driver Selection Matrix

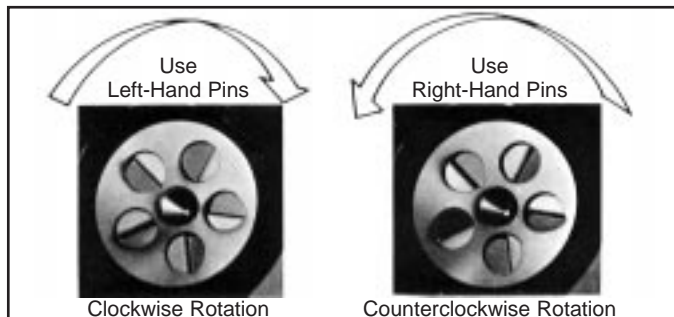
	TOOL SERIES	MOUNTINGS				FLANGE MOUNT	CHUCK MOUNT	DRIVER DIAMETER RANGES "G"	DRIVER RAW STOCK SIZE RANGE "S"	
		MORSE TAPER SHANK							MIN.	MAX.
		3	4	5	6					
MECHANICAL TYPE	40 Page 7	4003	4004	4005		40 FM	SEE PAGE 4	0.32 - 0.67	0.354	1.34
	41 Page 8	4103	4104	4105		41 FM	SEE PAGE 4	0.24 - 0.75	0.276	1.50
	42 Page 9	4203	4204	4205		42 FM	SEE PAGE 4	0.43 - 0.79	0.472	1.58
	43 Page 10	4303	4304	4305		43 FM	SEE PAGE 4	0.51 - 1.02	1.063	2.04
	44 Page 11		4404	4405		44 FM	SEE PAGE 4	1.02 - 1.42	0.552	2.84
	45 Page 12		4504	4505		45 FM	SEE PAGE 4	1.34 - 1.73	1.378	3.46
	46 Page 13					46 FM	SEE PAGE 4	1.14 - 1.93	1.81	3.86
	47 Page 14			4705	4706	47 FM	SEE PAGE 4	1.54 - 2.32	1.575	4.64
	48 Page 15					48 FM	SEE PAGE 4	1.93 - 2.72	1.969	5.44
49 Page 16					49 FM	SEE PAGE 4	2.72 - 3.90	2.756	7.80	
OIL HYDRAULIC TYPE	60 Page 17	6003	6004	6005		60 FM	60 CM	0.28 - 0.55	0.29	1.10
	61 Page 18	6103	6104	6105		61 FM	61 CM	0.60 - 0.98	0.61	2.0
	62 Page 19		6204	6205	6206	62 FM 1-3	62 CM 1-4	0.94 - 1.73	0.95	3.42
	63 Page 20			6305	6306	63 FM 1-4	63 CM 1-4	1.42 - 2.38	1.43	4.80
	64 Page 21			6405	6406	64 FM 1-4	64 CM 1-4	1.93 - 2.91	1.94	5.78
	66 Page 22				6606	66 FM 1-5		3.24 - 4.33	3.25	6.49
	68 Page 23					68 FM 1-6		4.66 - 5.74	4.67	8.59

Drive Pin Styles



Each face driver series covers a wide range of work diameters through the use of four styles of interchangeable drive pins. Each pin style adapts the basic tool to a specific driving diameter range.

Pins are ordered separately with each face driver ordered. However, when general purpose workholding is anticipated, **it is recommended that the other three drive pin styles be purchased** to cover the entire range of potential work diameters.

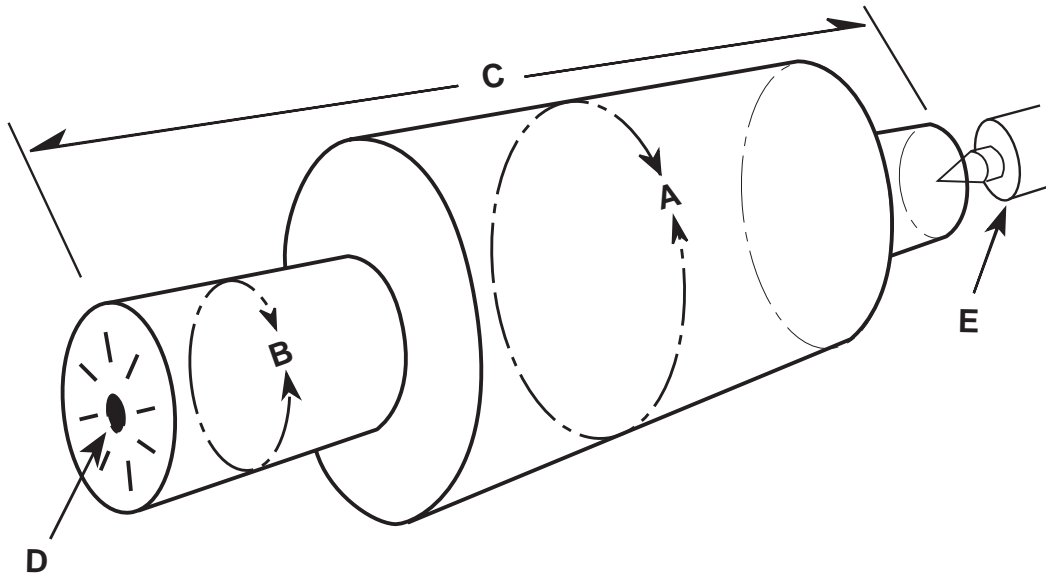


Before using the driver, make sure that the drive pins are oriented with respect to driver rotation. Correct pin orientation for both right-hand (normal engine lathe spindle rotation) and left-hand rotation is shown to the left.

Note: The first (cutting) operation needs to be toward the face driver.

RITEN USA FACE DRIVERS INFORMATION REQUEST

The following technical information is needed to determine your face driver requirements. Please complete and fax to Riten at 1-800-338-0717. If you have any questions please phone our customer service department by calling 1-800-338-0027.



MOUNTING DATA

Morse Taper: _____
 Chuck Mount: _____
 Flange Mount: _____
 Spindle Size if Flange Mounting: _____
 Spindle Rotation: Clockwise Counterclockwise Both

WORKPIECE DATA

Workpiece Name (description): _____

A. Beginning Diameter: _____	• Material Type: _____
B. Finished Diameter: _____	• Material Hardness: Rc _____ BHN _____
C. Overall Length of Workpiece: _____	• Workpiece Weight: _____
D. Center Hole Diameter: _____	• Concentricity to Achieve: _____
E. Center: Live _____ Dead _____	• Maximum Tailstock Ability Force (lbs.): _____

Please attach finished part print to this application data request sheet.

OPERATION

Maximum Depth of Cut: _____
 Feed/Revolution: _____
 Cutting Speed (inch/rev.): _____
 RPM: _____
 Are there simultaneous operations? (check one): Yes No

MACHINE DATA

Machine Type: _____
 Machine Manufacturer: _____
 Machine Size: _____
 Tool Holder: Left Right
 Machining Conditions (check one): Very Good Good Acceptable Bad