

# Face Driver FFBR

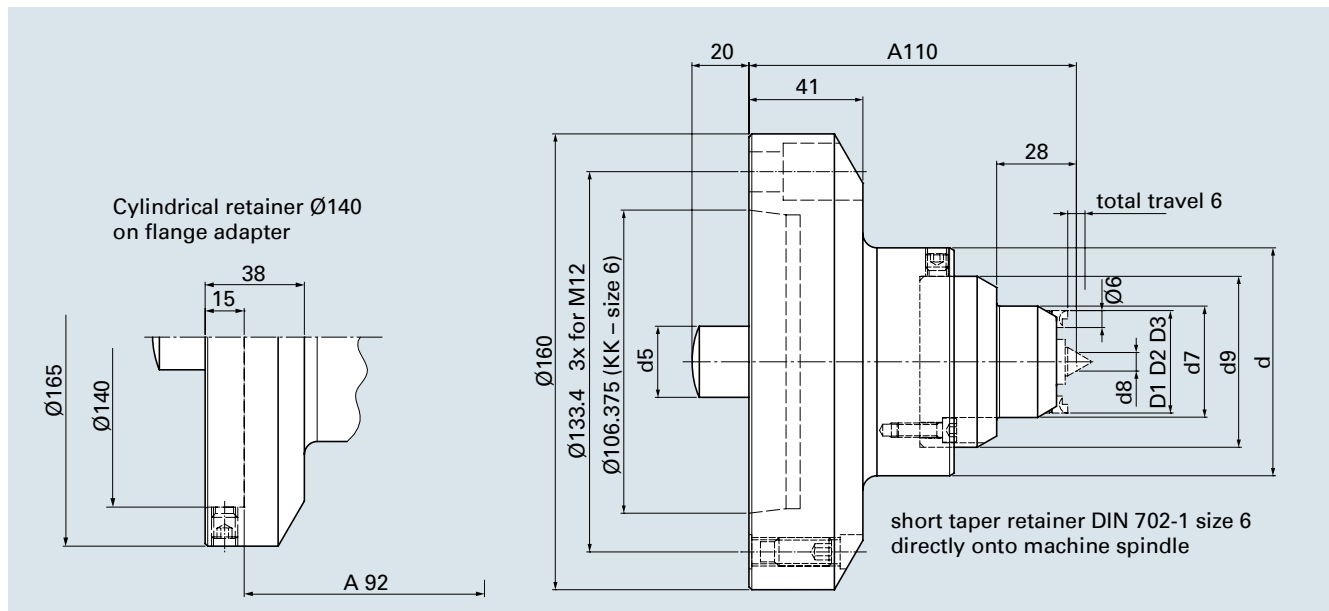
## Type FFBR with flange retainer

### Clamping tools for grinding between centers

The **complete surface** of both, hardened and soft work pieces, can be finish-ground with one single clamping.

Face drivers types FFBR/FBSR are **power-operated** on the **side of the spindle**. The work pieces are clamped centrally using a dead center pin, this way a high true running accuracy is achieved.

There are **two retainer designs** for adapting the face drivers onto the machine spindle – either for adaption onto a flange adapter with 140 in diameter or for direct mounting onto a spindle nose DIN 702-1 size 6 (DIN 55026/28)



- face drivers without changeable parts (types 0/01 include center body)  
center pins, center bodies and drive pins see page 4 and 5

cat. no. cyl. Ø 140	cat. no. KK size 6	type	d	center Ø	d5	d7	d8	d9	clamping diameter-Ø D1 D2 D3		
72631	72601	FFBR 0	65	1 - 3	18	16	1.5	48	6	9	15
72632	72602	FFBR 01	65	1 - 5	18	18	3	48	8	11	17
72633	72603	FFBR 11	65	2 - 6.5	18	21	4.25	48	11	14	20
72634	72604	FFBR 1	65	4 - 8.5	18	25	6.25	48	15	18	24
72635	72605	FFBR 2	77	4 - 9	25	38	6.5	60	27	30	36
72636	72606	FFBR 3	85	6 - 11	25	46	8.5	68	35	38	44
72637	72607	FFBR 4	110	10 - 15	25	62	12.5	85	50	53	59

### NEIDLEIN face drivers type FFBR/FBSR ensure:

- datum-point located in center of work piece
- maximum deviation from run-out 0.002-0.003 mm
- compensating drive components
- retracting of drive pins in case of on- or off-loading
- adjustment true at face drivers for highest run-out requirements



## Face Driver FBSR

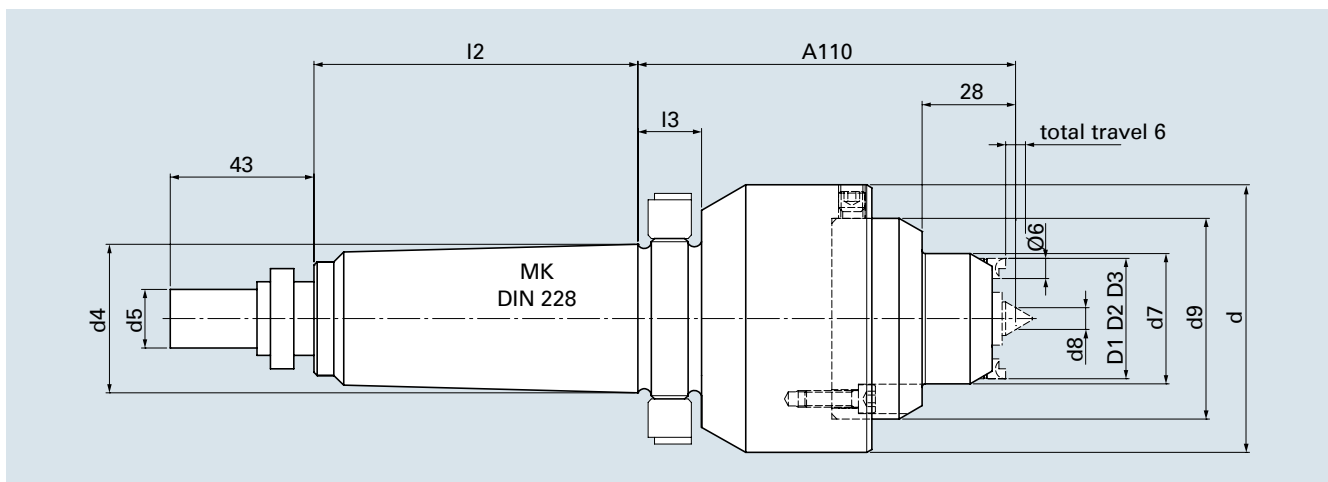
Type FBSR with morse taper retainer

### Clamping tools for grinding between centers

Like face driver FFBR, however, including morse taper shank and extracting nut.

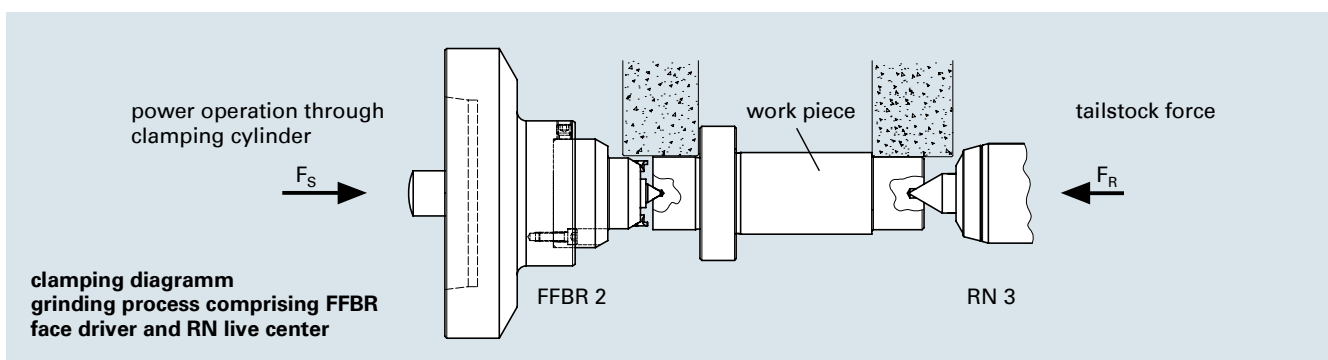
Adjustment true by using set screws inside shank for highest true running accuracy.

Matching changeable parts for grinding soft or hardened work pieces can be found on pages 4 and 5.



- face drivers without changeable parts (types 0/01 include center head)  
center pins, center heads and drive pins see pages 4 and 5

cat. no.	type	MK	d	center Ø	d5	d7	d8	d9	L	l2	l3	clamping diameter-Ø		
												D1	D2	D3
72651	FBSR 0	4	65	1 - 3	11.5	16	1.5	48	183	73	16	6	9	15
72652	FBSR 01	4	65	1 - 5	11.5	18	3	48	183	73	16	8	11	17
72653	FBSR 11	4	65	2 - 6.5	11.5	21	4.25	48	183	73	16	11	14	20
72654	FBSR 1	4	65	4 - 8.5	11.5	25	6.25	48	183	73	16	15	18	24
72655	FBSR 1	5	65	4 - 8.5	17.5	25	6.25	48	207	97	19	15	18	24
72656	FBSR 2	4	77	4 - 9	11.5	38	6.5	60	183	73	16	27	30	36
72657	FBSR 2	5	77	4 - 9	17.5	38	6.5	60	207	97	19	27	30	36
72658	FBSR 3	4	85	6 - 11	11.5	46	8.5	68	183	73	16	35	38	44
72659	FBSR 3	5	85	6 - 11	17.5	46	8.5	68	207	97	19	35	38	44
72660	FBSR 4	4	110	10 - 15	11.5	62	12.5	85	183	73	16	50	53	59
72661	FBSR 4	5	110	10 - 15	17.5	62	12.5	85	207	97	19	50	53	59



# Center Pins / Center Heads FFBR / FBSR

for face drivers type FFBR / FBSR with dead center

Type FFBR / FBSR tool steel or carbide metal

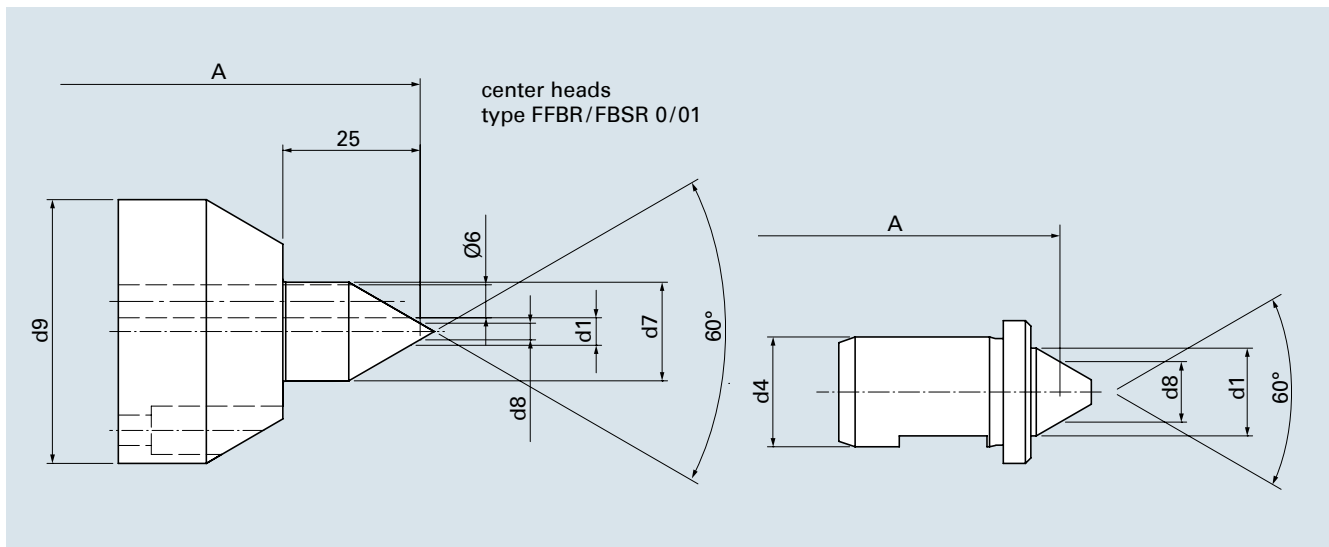
For **maximum stability and run-out requirements** the center pins are produced with narrow tolerances and are fixed safely via set screw and **plane surface** inside the face driver.

For a large batch of hardened work pieces we recommend the construction comprising **carbide insert**. Center heads of type 0/01 consist of 60° cone heads that are carbide coated.

Due to the **accurate assembly** between center pin and head of face driver we ensure **highly accurate replacement**.



fig. center pin with carbide insert



cat. no. tool-steel	cat. no. carbide	type	d1	d4	for center Ø	d7	d8	d9
73415	73431	FFBR 0	3	-	1 - 3	18	1.5	48
73416	73432	FFBR 01	5	-	1 - 5	20	3	48
73411	73433	FFBR 11	7.8	6	2 - 6.5	-	4.25	-
73402	73434	FFBR 1	9.8	8	4 - 8.5	-	6.25	-
73403	73435	FFBR 2	10	14	4 - 9	-	6.5	-
73404	73436	FFBR 3	12	18	6 - 11	-	8.5	-
73405	73438	FFBR 4	16	20	10 - 15	-	12.5	-

Further dimensions upon request.

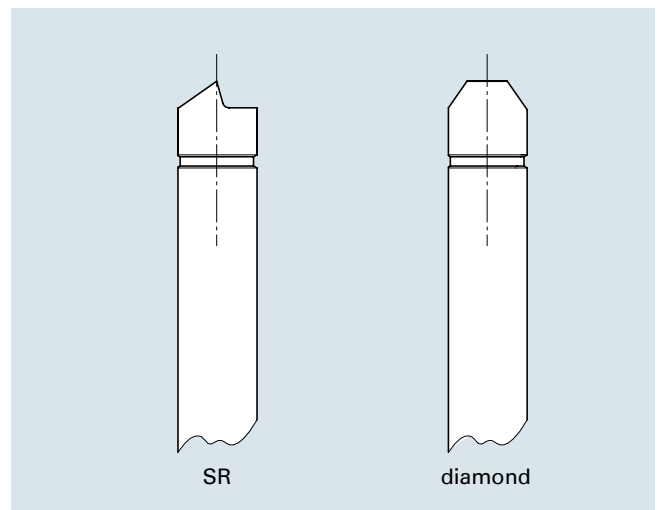
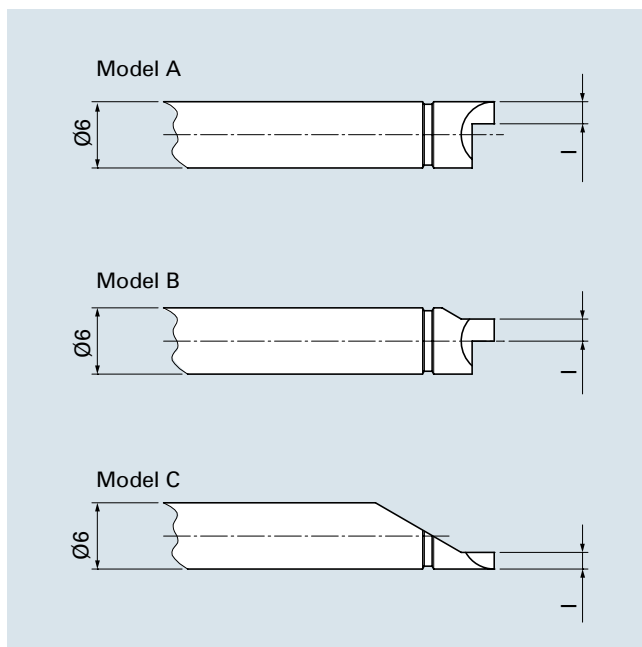
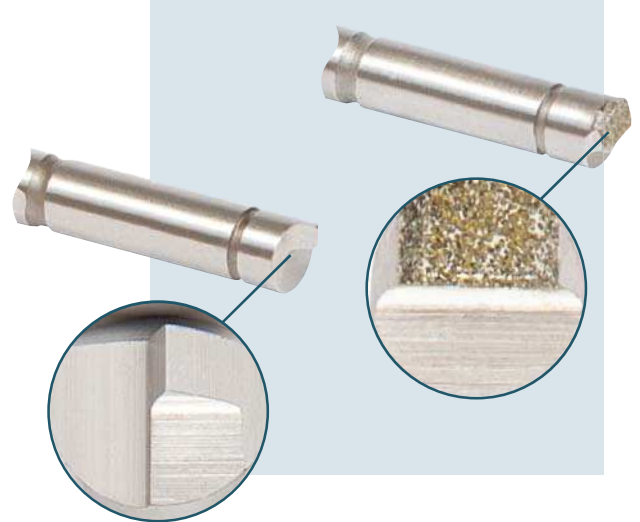
## Drive Pins FFBR / FBSR

Drive pins for torque transmission onto the work piece by grinding soft and hardened work pieces.

For soft work pieces we apply drive pins made of hardened HSS comprising a chisel. They are characterized by high wear-resistance as well as maximum torque transmission.

For hardened work pieces we apply drive pins that are diamond coated. They are characterized by a high frictional coefficient.

Type FFBR / FBSR  
 chisel or diamond coating



cat. no.	type	for clamping diameter	l	model
736651	SR	D1	1.5	C
736652	SR	D2	2	B
736653	SR	D3	2	A
736654	diamond	D1	1.5	C
736655	diamond	D2	3	B
736656	diamond	D3	3	A

● clamping diameter D1/D2/D3 see pages 2 and 3

Further dimensions upon request.