



MONOFORCE

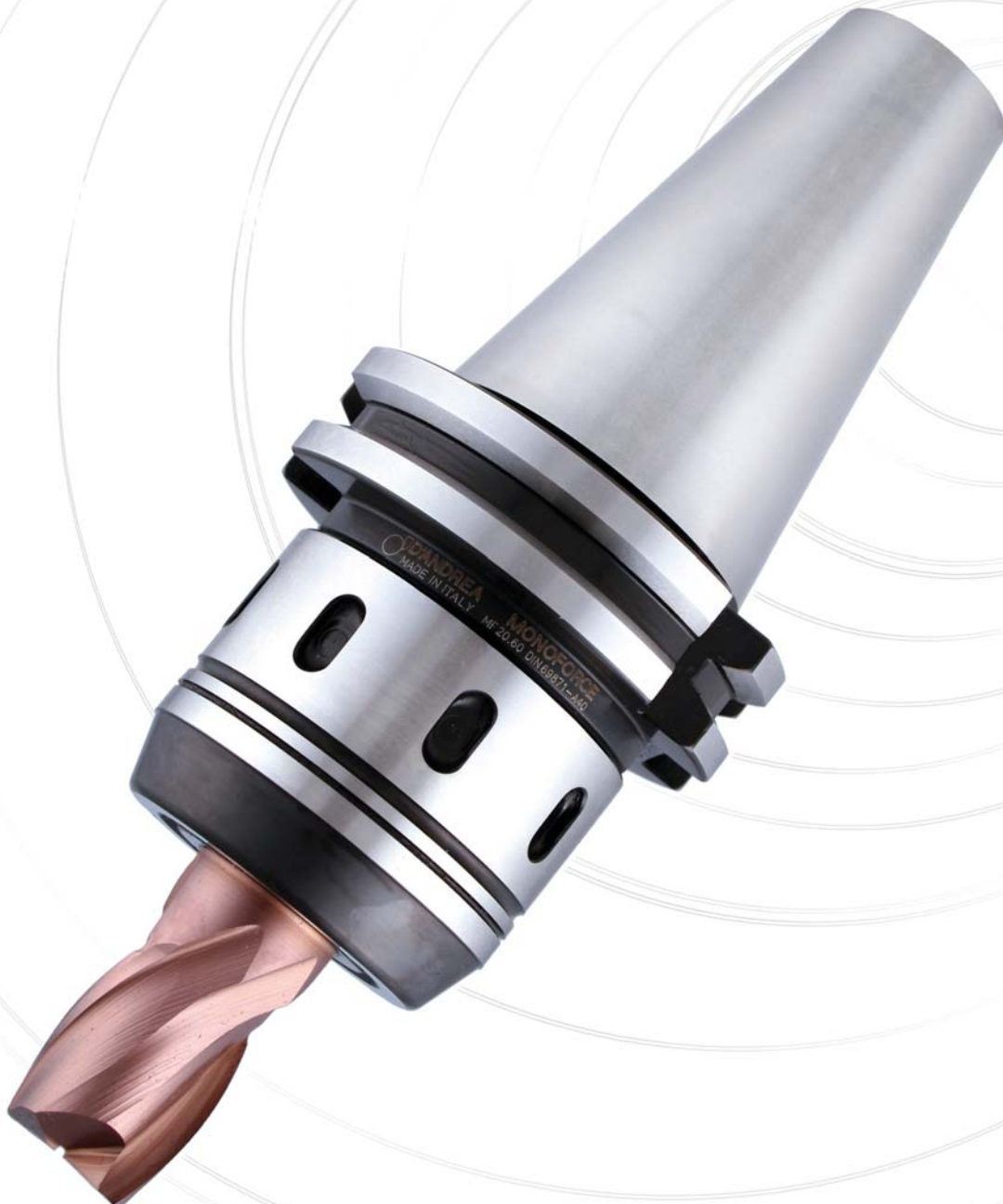
**High precision
ultra-tight
toolholder**

**Präzisionsspannzangenfutter
mit hochfester
Werkzeugspannung**

**Portaherramientas de
precisión de fuerte
blocaje**

**Porte-outil de
précision à
serrage fort**

**Portautensile di
precisione a
forte serraggio**



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 forte serraggio



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DIN 69893 HSK-A



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DIN 69871 AD+B

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MAS 403 BT AD+B

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CAT

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KIT

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MONOforce

High precision
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MONOforce is a new addition to D'Andrea range of tool holders, which complements the existing balanceable FORCE chuck from Toprun family.

This new chuck provides an economical and innovative solution for tool holding, where precision and high clamping forces for the cutting tool are required.

MONOforce is available with tapers conforming to DIN 69871, MAS-BT and CAT both in ISO 40 and 50 sizes, and also HSK 63. The chuck accepts reduction bushes to suit cutters having shank sizes ranging from 3 mm. to 25 mm.

MONOforce can also be supplied in kit form, which includes of a set of reduction bushes and clamping wrench. **MONOforce** toolholders are manufactured by D'Andrea in their modern manufacturing plants in Italy.

Präzisionsspannzangenfutter
mit hochfester
Werkzeugspannung

MONOforce ist eine weitere Ergänzung der D'Andrea – Werkzeughalterpalette, welche die existierende, auswuchtbare FORCE-Spannzange aus der Toprun-Familie vervollständigt. Diese neue Futter bietet eine wirtschaftliche und innovative Lösung der Werkzeugspannung, wo Präzision und hohe Spannkraft für Fräswerkzeuge erforderlich sind.

MONOforce gibt es sowohl mit Aufnahmekegeln nach DIN 69871, MAS-BT, CAT beide in ISO 40 und ISO 50, als auch in HSK 63. Das Futter kann durch Reduzierhülsen für Fräser von 3-25 mm eingesetzt werden.

MONOforce wird auch in Kit-Form angeboten, welcher einen Satz Reduzierhülsen und Klemmschrauben beinhaltet. **MONOforce** Werkzeughalter werden in den modernen Produktionsräumen bei D'Andrea in Italien hergestellt.

Portaherramientas de
precisión de fuerte
blocaje

MONOforce representa la nueva solución ideal y económica para el equipamiento de todas las Máquinas Herramientas donde existen exigencias de precisión y necesidad de blocaje de herramientas que necesitan elevadas cargas de torsión.

MONOforce acompaña al ya famoso Force de la familia Toprun, el sistema patentado de portaherramientas integrales equilibrables.

El programa **MONOforce** para husillos maquina HSK 63, DIN 69871, MAS-BT y CAT está realizado en los tamaños ISO 40 y ISO 50 con pinzas de reducción de 12 mm, 20 mm y de 32 mm disponibles estándar en toda la gama diametral compatible con estos diámetros de alojamientos para blocaje de Ø 3 mm a Ø 25 mm.

Los portaherramientas **MONOforce**, enteramente producidos por D'Andrea, están disponibles también en prácticos Kits completos con pinzas de reducción y llaves de blocaje.

Porte-outil de précision
à serrage fort

Le **MONOforce** vient agrandir la série de produits D'Andrea dans la gamme des attachements appartenant à la famille Toprun et concernant les attachements équilibrables Force.

Ce nouvel attachement est une solution économique et innovatrice dans le domaine des outils de serrage où précision et grande force de clamage sont nécessaires pour les outils coupants.

MONOforce est disponible avec des cônes conformément aux normes DIN 69871, MAS-BT, CAT toutes les deux en ISO 40, 50 et également HSK 63. Les attachements acceptent des pinces de réduction afin de pouvoir appliquer des outils coupants ayant des queues entre 3 et 25 mm. **MONOforce** peut être fourni en kit, comprenant un set de pinces de réduction ainsi que la clé de serrage. Les attachements **MONOforce** sont fabriqués par D'Andrea dans leur nouvelle usine située en Italie.

Portautensile di
precisione a forte
serraggio

MONOforce rappresenta la nuova soluzione ideale ed economica per l'attrezzatura di tutte le macchine utensili ove sussistano esigenze di precisione e necessità di serraggio utensili sollecitati a elevati carichi torsionali.

MONOforce si affianca al già noto Force della famiglia Toprun, il sistema brevettato di portautensili integrali bilanciabili.

Il programma **MONOforce** è costruito nella versione per mandrini macchina HSK 63, nonché DIN 69871, MAS-BT e CAT realizzati nelle grandezze ISO 40 e 50 e permette l'impiego di bussole di riduzione da 12 mm, 20 mm. e 32 mm. disponibili standard in tutta la gamma diametrale compatibile con questi diametri d'alloggiamento per serraggi da Ø 3 mm. a Ø 25 mm.

I portautensili **MONOforce** – interamente prodotti dalla D'Andrea – sono disponibili anche in pratici kit completi di bussole di riduzione e chiave di serraggio.



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INSTRUCTIONS

- After lightly tightening by hand, tighten further by spanner (fig.1).
- Tighten by hand. Don't use hammer!
- Only for finishing operations and when higher run-out accuracy is required, return chuck ring just a little (1-2°) after face contact (fig. 2).
- Don't clamp without end mill

GEBRAUCHSANLEITUNG

- Nach leichtem Anziehen von Hand, weiter mit dem Schlüssel anziehen. (fig. 1).
- Ziehen Sie mit der Hand an. Verwenden Sie keinen Hammer!
- Drehen Sie nur für Schlichtbearbeitungen und wenn eine höhere Rundlaufgenauigkeit gefordert wird, die Spannmutter nachdem Flächenkontakt ein wenig (max. 1° - 2°) zurück (fig. 2).
- Klemmen Sie die Spannmutter nicht ohne einen Schafffräser

INSTRUCCIONES

- Después de haber girado a mano la tuerca, blocar a fondo con la llave de apriete correspondiente (fig. 1).
- Apretar a mano. No utilizar nunca el martillo o tubo de prolongación !
- Sólo para operaciones de acabado, o donde se solicita una mayor precisión de run-out, después de apretar con la llave correspondiente, aflojar nuevamente de 1-2° después del contacto (fig. 2).
- No girar la tuerca sin la herramienta incorporada.

INSTRUCCIONES

- Après un léger serrage manuel, continuez à serrer à l'aide de la clé de serrage. (fig. 1).
- Serrer à la main. Ne pas utiliser un marteau!
- Seulement pour des opérations de finition et uniquement lorsqu'une plus grande précision est requise, faire tourner très légèrement le joint du mandrin, (1° - 2° maximum), après le contact (fig. 2).
- Ne serrer pas le joint du mandrin sans la fraise.

ISTRUZIONI

- Dopo aver serrato a mano la ghiera, bloccare a fondo con l'apposita chiave di serraggio (fig.1).
- Serrare a mano. Non usare mai martello o tubo di prolunga!
- Solo per operazioni di finitura, ove è richiesto una maggiore precisione di run-out, dopo il serraggio con l'apposita chiave, allentare nuovamente di 1-2° dopo il contatto (fig. 2).
- Non serrare la ghiera senza utensile inserito.



fig.1



fig.2

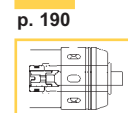
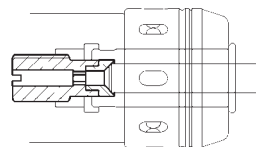
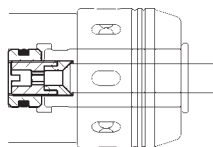
**SETTING SCREW FOR
INTERNAL COOLANT
SUPPLY**

**EINSTELLSCHRAUBE
FÜR INNERE
KÜHLMITTELZUFUHR**

**TORNILLO REGULACIÓN
PASO REFRIGERANTE**

**VIS DE RÉGLAGE POUR
L'ALIMENTATION
DE REFRROIDISSEMENT**

**VITE REGOLAZIONE
CON PASSAGGIO
REFRIGERANTE**



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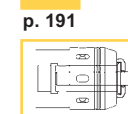
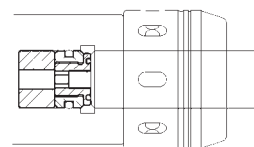
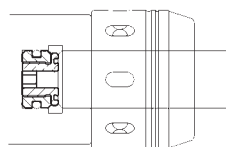
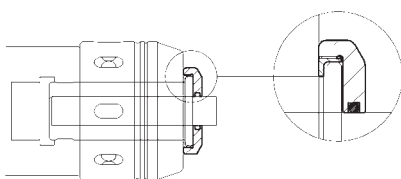
**SEALING DEVICE FOR
HIGH PRESSURE
COOLANT SUPPLY
(max. 40 BAR)**

**DICHTVORRICHTUNG
FÜR HOCHDRUCK-
KÜHLMITTELZUFUHR
(max. 40 BAR)**

**DISPOSITIVOS DE
RETENCIÓN PAEA
REFRIGERANTE A ALTA
PRESIÓN (max. 40 BAR)**

**SYSTÈME D'ÉTANCHÉITÉ
POUR L'ALIMENTATION
DE REFRROIDISSEMENT
HAUTE PRESSION
(max. 40 BAR)**

**DISPOSITIVI A TENUTA
PER REFRIGERANTE AD
ALTA PRESSIONE
(max. 40 BAR)**



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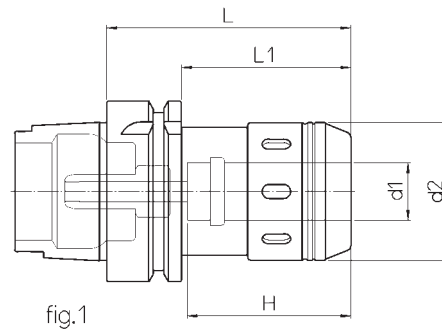


fig.1

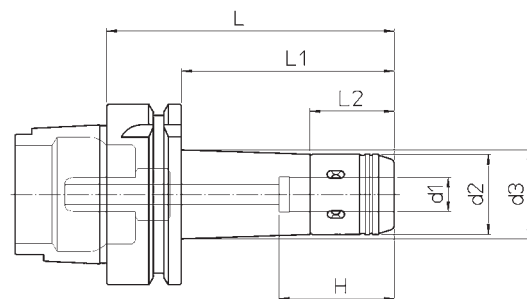


fig.2

Supplied with coolant
tube - without
clamping wrench

Lieferung inklusive
Kühlmittelrohr. Ohne
Spannzangen und
Spannschlüssel.

Completo con racor
para el refrigerante -
Llave de apriete
excluida

Pourvu de raccord
pour liquide
d'arrosage - Sans clef
de serrage

Completo di raccordo
per il refrigerante -
Chiave di serraggio
esclusa

| HSK-A | REF. | CODE | d ₁ | d ₂ | d ₃ | H | L | L ₁ | L ₂ | kg | fig. |
|-------|------------------|-----------------|----------------|----------------|----------------|----|-----|----------------|----------------|-----|------|
| 63 | HSK-A63 MF12.70 | 71HSK-A63MF1207 | 12 | 28 | - | 46 | 70 | 44 | - | 0.8 | 1 |
| | HSK-A63 MF12.100 | 71HSK-A63MF1210 | 12 | 28 | 31 | 46 | 100 | 74 | 29.5 | 1.1 | 2 |
| | HSK-A63 MF20.85 | 71HSK-A63MF2008 | 20 | 48 | - | 60 | 85 | 59 | - | 1.2 | 1 |
| | HSK-A63 MF20.125 | 71HSK-A63MF2012 | 20 | 48 | - | 60 | 125 | 99 | - | 1.7 | 2 |
| | HSK-A63 MF32.105 | 71HSK-A63MF3210 | 32 | 66 | - | 80 | 105 | - | - | 2 | 1 |
| | HSK-A63 MF32.140 | 71HSK-A63MF3214 | 32 | 66 | - | 80 | 140 | - | - | 2.6 | 2 |

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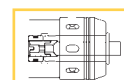
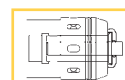
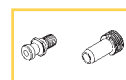
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DIN 69871 AD+B



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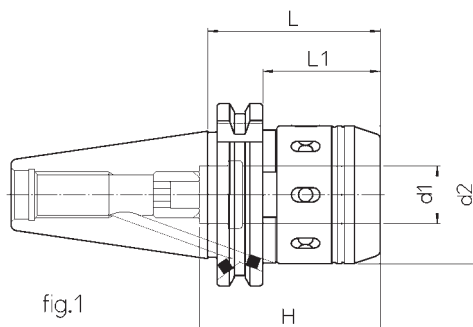


fig.1

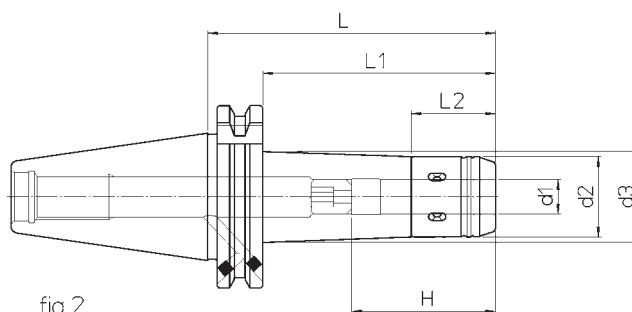


fig.2

without
clamping wrench

Ohne Spannschlüssel.

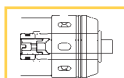
Llave de apriete
excluida

Sans clef de serrage

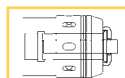
Chiave di serraggio
esclusa

| ISO | REF. | CODE | d ₁ | d ₂ | d ₃ | H | L | L ₁ | L ₂ | kg | fig. |
|-----|--------------------------|-----------------|----------------|----------------|----------------|----|-----|----------------|----------------|-----|------|
| 40 | DIN69871-AD+B40 MF12.50 | 71DIN-B40MF1205 | 12 | 28 | - | 46 | 50 | 31 | - | 0.8 | 1 |
| | DIN69871-AD+B40 MF12.100 | 71DIN-B40MF1210 | 12 | 28 | 32 | 46 | 100 | 81 | 29.5 | 1.2 | 2 |
| | DIN69871-AD+B40 MF20.60 | 71DIN-B40MF2006 | 20 | 48 | - | 63 | 60 | 41 | - | 1.1 | 1 |
| | DIN69871-AD+B40 MF20.100 | 71DIN-B40MF2010 | 20 | 48 | - | 63 | 100 | 81 | - | 1.4 | 2 |
| | DIN69871-AD+B40 MF32.95 | 71DIN-B40MF3209 | 32 | 66 | - | 80 | 95 | - | - | 1.6 | 1 |
| | DIN69871-AD+B40 MF32.140 | 71DIN-B40MF3214 | 32 | 66 | - | 80 | 140 | - | - | 2.0 | 2 |
| 50 | DIN69871-AD+B50 MF20.80 | 71DIN-B50MF2008 | 20 | 48 | - | 63 | 80 | 61 | - | 2.3 | 1 |
| | DIN69871-AD+B50 MF20.125 | 71DIN-B50MF2012 | 20 | 48 | - | 63 | 125 | 106 | - | 2.7 | 2 |
| | DIN69871-AD+B50 MF32.75 | 71DIN-B50MF3207 | 32 | 66 | - | 90 | 75 | 56 | - | 2.8 | 1 |
| | DIN69871-AD+B50 MF32.160 | 71DIN-B50MF3216 | 32 | 66 | - | 90 | 160 | 141 | - | 3.2 | 2 |

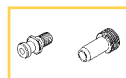
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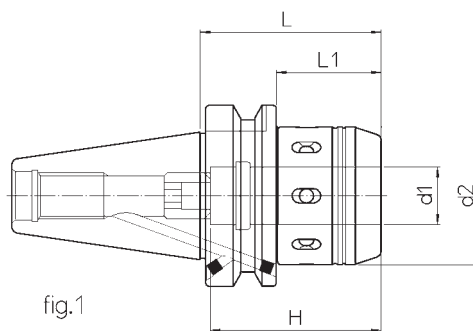


fig.1

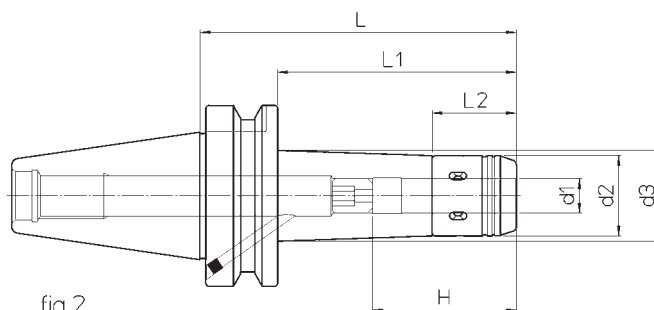


fig.2

without
clamping wrench

Ohne Spannschlüssel.

Llave de apriete
excluida

Sans clef de serrage

Chiave di serraggio
esclusa

| ISO | REF. | CODE | d ₁ | d ₂ | d ₃ | H | L | L ₁ | L ₂ | kg | fig. |
|-----|---------------------------|-----------------|----------------|----------------|----------------|----|-----|----------------|----------------|-----|------|
| 40 | MAS403 BT40-AD+B MF12.60 | 71MBT-B40MF1206 | 12 | 28 | - | 46 | 60 | 33 | - | 0.9 | 1 |
| | MAS403 BT40-AD+B MF12.100 | 71MBT-B40MF1210 | 12 | 28 | 31 | 46 | 100 | 73 | 29.5 | 1.4 | 2 |
| | MAS403 BT40-AD+B MF20.63 | 71MBT-B40MF2006 | 20 | 48 | - | 63 | 63 | 36 | - | 1.3 | 1 |
| | MAS403 BT40-AD+B MF20.100 | 71MBT-B40MF2010 | 20 | 48 | - | 63 | 100 | 73 | - | 1.9 | 2 |
| | MAS403 BT40-AD+B MF32.90 | 71MBT-B40MF3209 | 32 | 66 | - | 80 | 90 | - | - | 2.1 | 1 |
| | MAS403 BT40-AD+B MF32.140 | 71MBT-B40MF3214 | 32 | 66 | - | 80 | 140 | - | - | 3.1 | 2 |
| 50 | MAS403 BT50-AD+B MF20.85 | 71MBT-B50MF2008 | 20 | 48 | - | 63 | 85 | 47 | - | 3.7 | 1 |
| | MAS403 BT50-AD+B MF20.125 | 71MBT-B50MF2012 | 20 | 48 | - | 63 | 125 | 87 | - | 4.1 | 2 |
| | MAS403 BT50-AD+B MF32.95 | 71MBT-B50MF3209 | 32 | 66 | - | 90 | 95 | 57 | - | 4.4 | 1 |
| | MAS403 BT50-AD+B MF32.160 | 71MBT-B50MF3216 | 32 | 66 | - | 90 | 160 | 122 | - | 4.9 | 2 |

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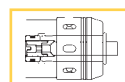
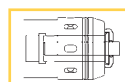
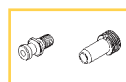
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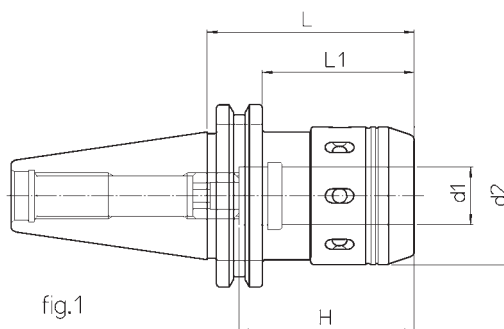


fig.1

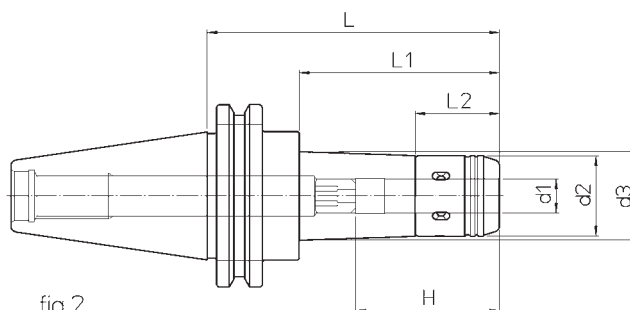


fig.2

without
clamping wrench

Ohne Spannschlüssel.

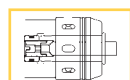
Llave de apriete
excluida

Sans clef de serrage

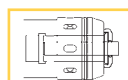
Chiave di serraggio
esclusa

| CAT | REF. | CODE | d ₁ | d ₂ | d ₃ | H | L | L ₁ | L ₂ | kg | fig. |
|-----|------------------------|-----------------|----------------|----------------|----------------|-------|-------|----------------|----------------|-----|------|
| 40 | CAT40 UNC MF1/2 2.50 | 71CAT-40-MF1306 | 1/2" | 1.10" | - | 1.85" | 2.50" | 1.25" | - | 0.6 | 1 |
| | CAT40 UNC MF1/2 4.00 | 71CAT-40-MF1310 | 1/2" | 1.10" | 1.21" | 1.85" | 4.00" | 2.75" | 1.16" | 1.2 | 2 |
| | CAT40 UNC MF3/4 3.00 | 71CAT-40-MF1907 | 3/4" | 1.89" | - | 2.48" | 3.00" | 2.25" | - | 1.1 | 1 |
| | CAT40 UNC MF3/4 5.00 | 71CAT-40-MF1912 | 3/4" | 1.89" | - | 2.48" | 5.00" | 4.25" | - | 1.7 | 2 |
| | CAT40 UNC MF1-1/4 4.25 | 71CAT-40-MF3110 | 1-1/4" | 2.59" | - | 3.15" | 4.25" | - | - | 1.6 | 1 |
| | CAT40 UNC MF1-1/4 5.50 | 71CAT-40-MF3114 | 1-1/4" | 2.59" | - | 3.15" | 5.50" | - | - | 2.5 | 2 |
| 50 | CAT50 UNC MF3/4 3.00 | 71CAT-50-MF1907 | 3/4" | 1.89" | - | 2.48" | 3.00" | 1.56" | - | 2.3 | 1 |
| | CAT50 UNC MF3/4 6.00 | 71CAT-50-MF1915 | 3/4" | 1.89" | - | 2.48" | 6.00" | 4.56" | - | 2.9 | 2 |
| | CAT50 UNC MF1-1/4 3.25 | 71CAT-50-MF3108 | 1-1/4" | 2.59" | - | 3.54" | 3.25" | 2.50" | - | 2.8 | 1 |
| | CAT50 UNC MF1-1/4 6.50 | 71CAT-50-MF3116 | 1-1/4" | 2.59" | - | 3.54" | 6.50" | 5.75" | - | 3.9 | 2 |

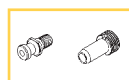
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HSK



KIT K01 MONOFORCE 12

- 1 MONOFORCE 12
- 1 RC 12.04
- 1 RC 12.06
- 1 RC 12.08
- 1 RC 12.10
- 1 CHV 28

KIT K01 MONOFORCE 20

- 1 MONOFORCE 20
- 1 RC 20.06
- 1 RC 20.08
- 1 RC 20.10
- 1 RC 20.12
- 1 RC 20.16
- 1 CHV 50

KIT K01 MONOFORCE 32

- 1 MONOFORCE 32
- 1 RC 32.06
- 1 RC 32.08
- 1 RC 32.10
- 1 RC 32.12
- 1 RC 32.16
- 1 RC 32.20
- 1 RC 32.25
- 1 CHV 75

| HSK-A | REF. | CODE |
|-------|--------------------------------|-----------------|
| 63 | KIT K01 MONOFORCE 12.70 HSK63 | 7KHSK-A63MF1207 |
| | KIT K01 MONOFORCE 20.85 HSK63 | 7KHSK-A63MF2008 |
| | KIT K01 MONOFORCE 32.105 HSK63 | 7KHSK-A63MF3210 |

DIN



KIT K01 MONOFORCE 12

- 1 MONOFORCE 12
- 1 RC 12.04
- 1 RC 12.06
- 1 RC 12.08
- 1 RC 12.10
- 1 CHV 28

KIT K01 MONOFORCE 20

- 1 MONOFORCE 20
- 1 RC 20.06
- 1 RC 20.08
- 1 RC 20.10
- 1 RC 20.12
- 1 RC 20.16
- 1 CHV 50

KIT K01 MONOFORCE 32

- 1 MONOFORCE 32
- 1 RC 32.06
- 1 RC 32.08
- 1 RC 32.10
- 1 RC 32.12
- 1 RC 32.16
- 1 RC 32.20
- 1 RC 32.25
- 1 CHV 75

| ISO | REF. | CODE |
|-----|-----------------------------------|-----------------|
| 40 | KIT K01 MONOFORCE 12.50 DIN40AD+B | 7KDIN-B40MF1205 |
| | KIT K01 MONOFORCE 20.60 DIN40AD+B | 7KDIN-B40MF2006 |
| | KIT K01 MONOFORCE 32.95 DIN40AD+B | 7KDIN-B40MF3209 |
| 50 | KIT K01 MONOFORCE 20.80 DIN50AD+B | 7KDIN-B50MF2008 |
| | KIT K01 MONOFORCE 32.75 DIN50AD+B | 7KDIN-B50MF3207 |

MAS



KIT K01 MONOFORCE 12

- 1 MONOFORCE 12
- 1 RC 12.04
- 1 RC 12.06
- 1 RC 12.08
- 1 RC 12.10
- 1 CHV 28

KIT K01 MONOFORCE 20

- 1 MONOFORCE 20
- 1 RC 20.06
- 1 RC 20.08
- 1 RC 20.10
- 1 RC 20.12
- 1 RC 20.16
- 1 CHV 50

KIT K01 MONOFORCE 32

- 1 MONOFORCE 32
- 1 RC 32.06
- 1 RC 32.08
- 1 RC 32.10
- 1 RC 32.12
- 1 RC 32.16
- 1 RC 32.20
- 1 RC 32.25
- 1 CHV 75

| ISO | REF. | CODE |
|-----|----------------------------------|-----------------|
| 40 | KIT K01 MONOFORCE 12.60 BT40AD+B | 7KMBT-B40MF1206 |
| | KIT K01 MONOFORCE 20.63 BT40AD+B | 7KMBT-B40MF2006 |
| | KIT K01 MONOFORCE 32.90 BT40AD+B | 7KMBT-B40MF3209 |
| 50 | KIT K01 MONOFORCE 20.85 BT50AD+B | 7KMBT-B50MF2008 |
| | KIT K01 MONOFORCE 32.95 BT50AD+B | 7KMBT-B50MF3209 |

CAT



KIT K01 MONOFORCE 1/2

- 1 MONOFORCE 1/2
- 1 RC 1/2.1/4
- 1 RC 1/2.5/16
- 1 RC 1/2.3/8
- 1 CHV 28

KIT K01 MONOFORCE 3/4

- 1 MONOFORCE 3/4
- 1 RC 3/4.1/4
- 1 RC 3/4.5/16
- 1 RC 3/4.3/8
- 1 RC 3/4.1/2
- 1 RC 3/4.5/8
- 1 CHV 50

KIT K01 MONOFORCE 1-1/4

- 1 MONOFORCE 1-1/4
- 1 RC 1-1/4.3/8
- 1 RC 1-1/4.1/2
- 1 RC 1-1/4.5/8
- 1 RC 1-1/4.3/4
- 1 RC 1-1/4.1
- 1 CHV 75

| CAT | REF. | CODE |
|-----|------------------------------------|-----------------|
| 40 | KIT K01 MONOFORCE 1/2 2.50 CAT40 | 7KCAT-40-MF1306 |
| | KIT K01 MONOFORCE 3/4 3.00 CAT40 | 7KCAT-40-MF1907 |
| | KIT K01 MONOFORCE 1 1/4 4.25 CAT40 | 7KCAT-40-MF3110 |
| 50 | KIT K01 MONOFORCE 3/4 3.00 CAT50 | 7KCAT-50-MF1907 |
| | KIT K01 MONOFORCE 1 1/4 3.25 CAT50 | 7KCAT-50-MF3108 |