Serie MDR

V16/18
V22
V25
V30

F22
F28

R32
R40
R45

TCS
DIGIT
AUTOMAX

MDR12
MDR16
MDR22
MDR32

VFRHTMDR

SERIE

Tiekstra Techniek
Metaalbewerkingsmachines en toebehoren
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MDR12
MDR16
MDR22
MDR32

SERRMAC INTERNATIONAL SRL

CE

MADE IN ITALY

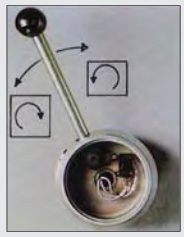
MDR12/MDR16

Maschiatrici automatiche a velocità variabile
Automatic Tapping machines with variables speeds
Taraudeuses automatiques à vitesse variable
Automatische Gewindescheidmaschinen mit Geschwindigkeitsregler

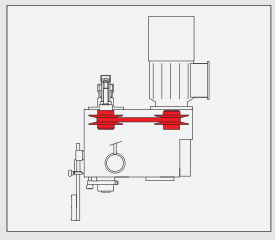
* Da banco
banch model
d'etabli
tisch modellen

**

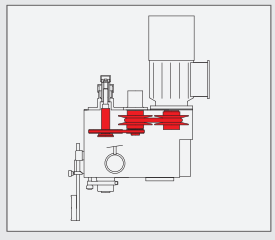
Leva sensitiva ad inversione
Levier sensitif d'inversion
Reversing sesitiv lever
Sensibilinversionshebef



MDR 12
Variatore di Velocità
Variateur de vitesse
Variable speeds drive
Stufenloser Drehzahlregler
275 ÷ 1785 1/min kW1,1



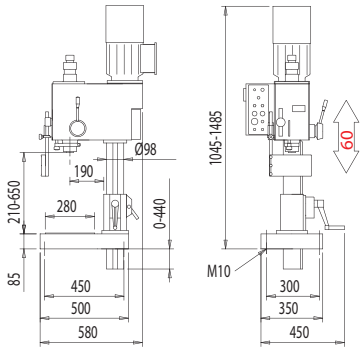
MDR 16
Variatore di Velocità
Variateur de vitesse
Variable speeds drive
Stufenloser Drehzahlregler
140 ÷ 900 1/min kW1,1



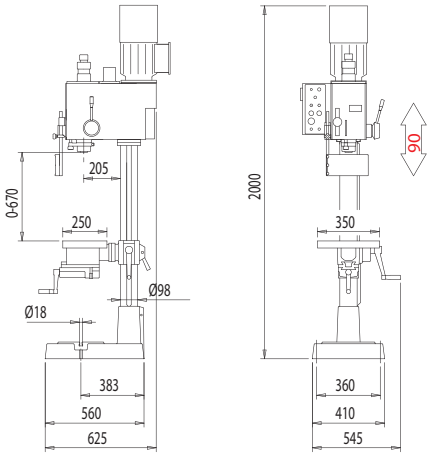
SERRMAC INTERNATIONAL SRL

CE MADE IN ITALY

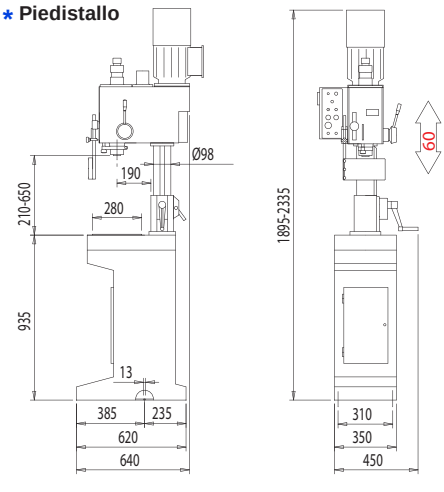
***Banco**



Colonna



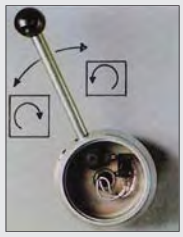
**** Piedistallo**



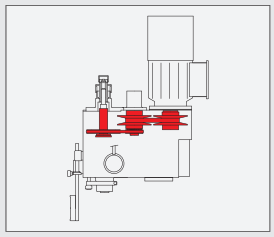
MDR22

Maschiatrici automatiche a velocità variabile
Automatic Tapping machines with variables speeds
Taraudeuses automatiques à vitesse variable
Automatische Gewindescheidmaschinen mit Geschwindigkeitsregler

Leva sensitiva ad inversione
Levier sensitif d'inversion
Reversing sesitiv lever
Sensibilinversionshebef



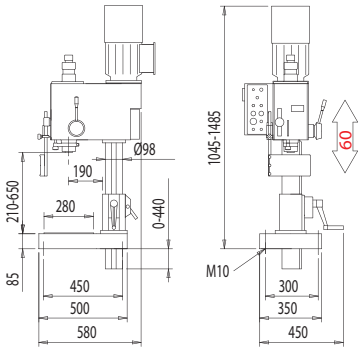
MDR 22
Variatore di Velocità
Variateur de vitesse
Variable speeds drive
Stufenloser Drehzahlregler
130 ÷ 675 1/min kW1,47



SERRMAC INTERNATIONAL SRL

CE MADE IN ITALY

***Banco**



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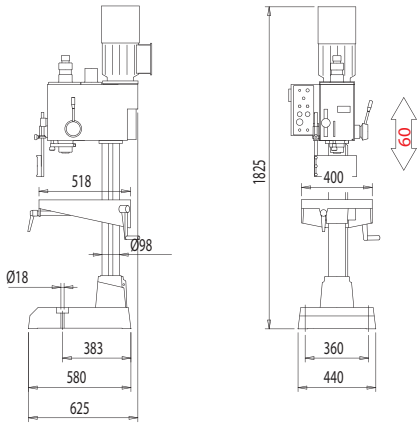

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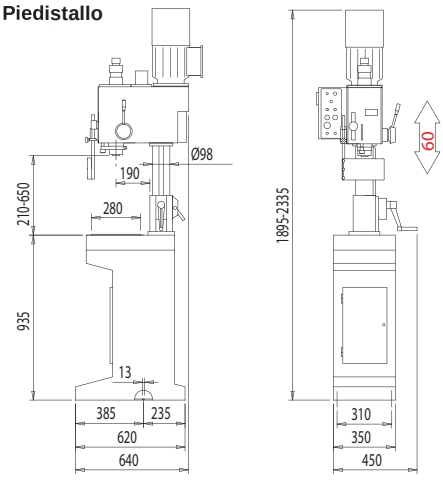


MDR32

Maschiatrice automatica a cambio ingranaggi
Automatic Tapping machines with gesr-box drive
Taraudeuses automatiques à boîte de vitesses
Automatische Gewindescheidmaschinen mit Schaltgetriebe

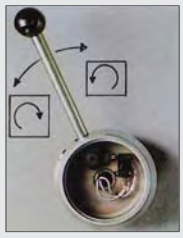
Protezione antinfortunistica
Spindele safety guard
Protection d'outil
Bohrmaschinenschutz

Leva sensitiva di inversione a comando manuale per filettature con rompitruciolo nei materiali difficili per passi fini e molto precisi.

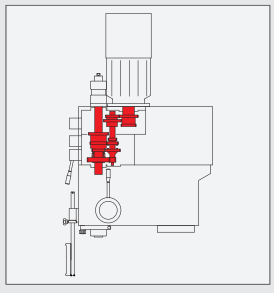
Levier sensitif pour le taraudage avec debourage de matériaux difficiles au pas petit et trés précis.

Manually-operated sensitive lever that enables the cip breakage and high-precision also on small threads.

Sensibilhebel dass beim handbetaetigung ermoeglicht die spaene zum brechen beim jede werkstoff. Hohe genauigkeit auch fuer feingewinden.



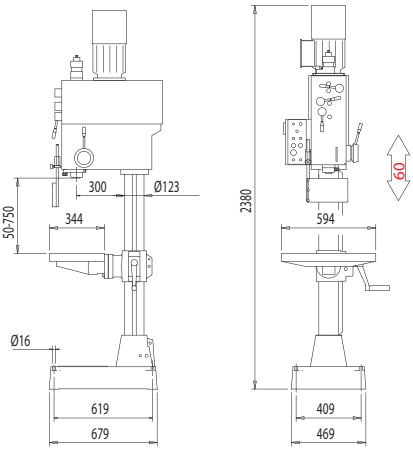
MDR 32
Cambio ingranaggi
Boîte de vitesse
Gear-box drive
Schaltgetriebe
64-105-128-185-210-300
370-500-600-860-1000
1720 1/min kW 2,2



SERRMAC INTERNATIONAL SRL

CE MADE IN ITALY

Colonna



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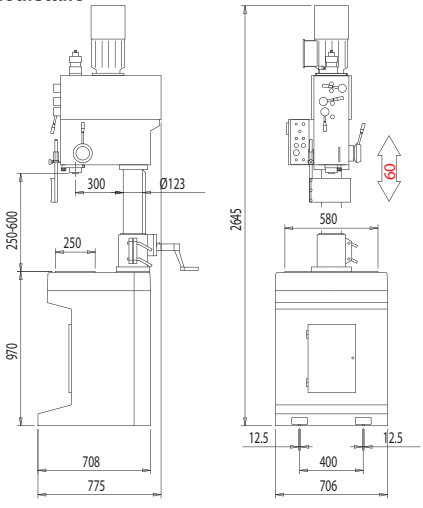
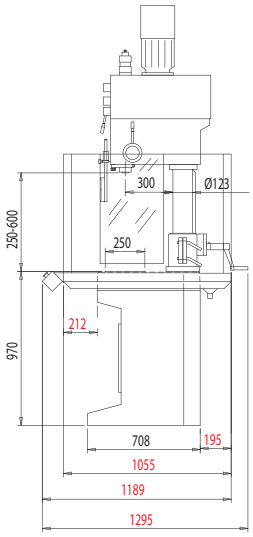
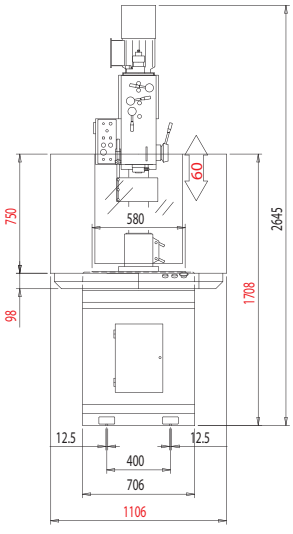
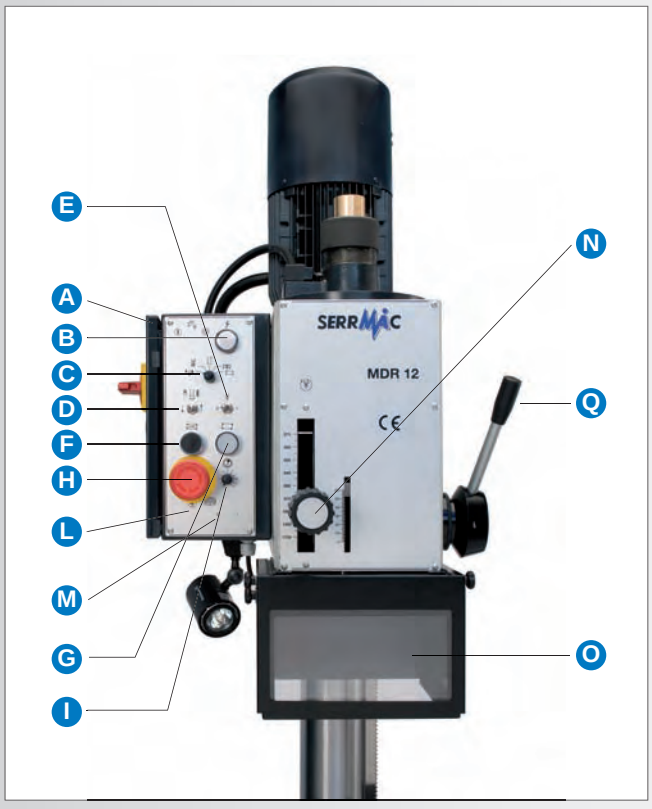




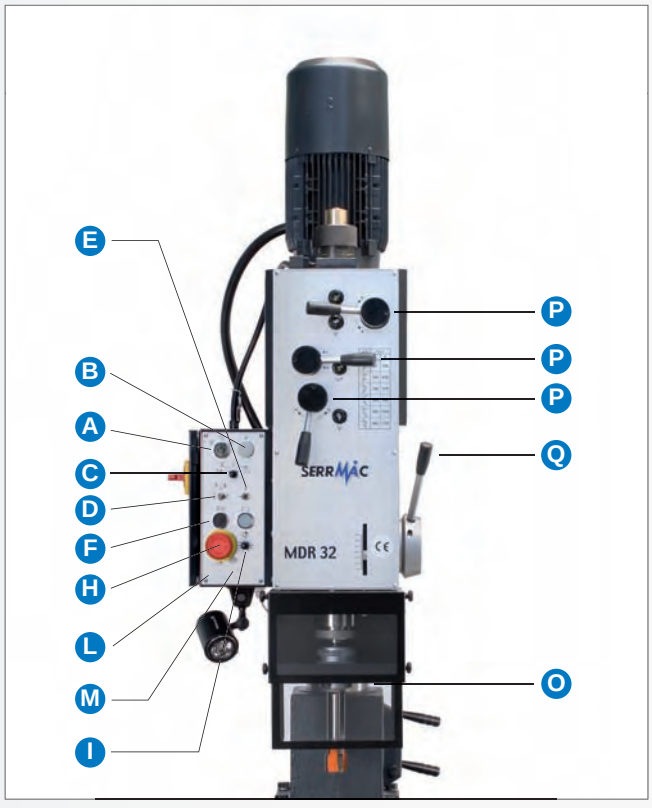


Serie MDR

MDR 12 / MDR 16 / MDR 22



MDR 32



A	- Impianto refrigerante	- Arrosage	- Coolant system	- Küehlmittelanlge
B	- Macchina in tensione	- Machines sous tension	- Machine efectricaly coupled	- Machine elktrisch angekoppelt
C	- Selettore a 5 posizioni: 1 Ciclo prova ad rmpulsl 2 Ciclo manuale con comando mediante leva senelttvaad 3 Ciclo di lavoro singolo 4 Ciclo di lavoro temporizzato 5 Ciclo di lavoro continuo	- Selecteur 5 positions: 1 Cycle d'essais aimpulsion 2 Cycle manuel par levier sensitif 3 Cycle unique de taraudage 4 Cycle de taraudage temporise 5 Cycle de taraudage contlnu	- positions selector switch: 1 Testing cycle by electronic impulse 2 Manual cycle by sensitive lever with reversing control 3 Single work cycle 4 Work cycle with programmed time dwell 5 Continued work cycle	- Stellige Wahlschalter: 1 Auftastimpuls Probezyclus 2 Manuelle Zyklus bei Sensibilinversionshebel 3 Einzeln Arbeitszyklus 4 Zeitgeregelt Arbeitszyklus 5 Dauemde Arbeitszyklus
D	- Avanzamento cannotto mandrino	- Manipulateur d'avance du fourreau de broche	- Spindle up-down manipulator	- Spindelpinole auf-ab Manipulator
E	- Lubrorefrigerazione nebulizzata	- Réfrigération nébulisée	- Coolant unit by spraying nozzle	- Werkzeugabkühlung + schmierung durch Nebulisatoreinrichtung
F	- Fine cicio	- Arret de cycle	- Cycle-end	- Zyklus-ende
G	- Inizio ciclo	- Début de cycle	- Cycle-start	- Zyklus-start
H	- Emergenza	- Arrét d'urgence	- Emergency push-button	- Not Drucktaste
I	- Temporizzatore	- Timer	- Time dwells eelector switch	- Pausenzeit Wähler
L	- Ciclo singolo o continuo tavola rotante	- Cycle unique ou continu de la table	- Single or continued work cycle for rotary table	- Tackttisch Einzeln/Dauemde Zyklus
M	- Abilitazione tavola rotante	- Habilitation de la table rotative	- Divingn table control switch	- Tackttisch insbetriebsetzen Spindel U/Min Schalthebel
N	- Leva variazione giri mandrino	- Levier de variation de tours	- Spindle RPM changing levers	- Arbeitshub
O	- Pomello regolazione corsa di lavoro	- Bouton de réglage course	- Work stroke control roundgrip	- Regulierungskugelgriff
P	- Leva cambio velocità mandrino	- Levier de changement de vitesse	- Spindle RPM changing levers	- Spindel U/Min Schalthebel
Q	- Leva sensitiva	- Levier sensitif d'inversion	- Sensitive fever with movement inversion	- Sensibilinversionshebel

Valeurs indicatives de taraudage avec tarauds HSS

Indicative data for tapping with HSS screw-taps

Valori indicativi per filettare con maschi HSS

Orientierungswerte für Gewindeschneiden mit HSS Gewindebohrer

MDR 32

MDR 22

MDR 16

MDR 12

Vitesses de coupe en metres minute

Cutting-speed in meters/min.

Velocità di taglio in metri al minuto primo

Schnittgeschwindigkeit in meter/min.

Tours minute de broche pour métaux communs

Spindle RPM for the most employed materials

Giri al primo del mandrino per i metalli più correnti

Spindel U/min. für die meist gebrauchte Werkstoffe

Métaux *Metals* Metalli Metalle	Vitesse de coupe *Cut speed* Velocità di taglio Schnittgeschwindigkeit m/1'	Tours par minute pour filetage métrique ISO *Turns per minute for ISO metric threading* Giri al primo per filettature metriche ISO *U/Min. für metrische Regelgewinde ISO*																												
		M1	M 1,1	M 1,2	M 1,4	M 1,6	M 1,8	M 2	M 2,2	M 2,5	M 3	M 3,5	M 4	M 4,5	M 5	M 6	M 8	M 10	M 12	M 14	M 16	M 18	M 20	M 22	M 24	M 27	M 30	M 33	M 35
Acier 50 Kg. - *Steel 50 Kg.* Acciaio 50 Kg. - *Stahl 50 Kg.*	12	3822	3475	3185	2730	2389	2123	1911	1737	1529	1274	1092	956	849	764	637	478	382	319	273	239	212	191	174	159	142	127	116	106
Acier 70 Kg. - *Steel 70 Kg.* Acciaio 70 Kg. - *Stahl 70 Kg.*	8	2548	2316	2123	1820	1593	1416	1274	1158	1019	849	728	637	566	510	425	319	255	212	182	159	142	127	116	106	94	85	77	71
Acier 90 Kg. - *Steel 90 Kg.* Acciaio 90 Kg. - *Stahl 90 Kg.*	6	1911	1737	1593	1365	1194	1062	956	869	764	637	546	478	425	382	319	239	191	159	137	119	106	96	87	80	71	64	58	53
Acier de plus de 100 Kg. - *Steel over 100 Kg.* Acciaio oltre 100 Kg. - *Stahl über 100 Kg.*	3	955	868	796	682	597	531	478	434	382	318	273	239	212	191	159	119	96	80	68	60	53	48	43	40	35	32	29	27
Acier pour outils - *Steel for tools* Acciaio da utensili - *Stahl für Werkzeuge*	4	1274	1158	1062	910	796	708	637	579	510	425	364	319	283	255	212	159	127	105	91	80	71	64	53	53	47	42	39	35
Acier inoxydable - *Stainless steel* Acciaio inossidabile - *Edelstahl*	6	1911	1737	1593	1365	1194	1062	956	869	764	637	546	478	425	382	319	239	191	159	137	119	106	96	87	80	71	64	53	53
Acier forgé 75 Kg. - *Forged steel about 75 Kg.* Acciaio forgiato 75 Kg. - *Schmiedestahl 75 Kg.*	8	2548	2316	2123	1820	1593	1416	1274	1158	1019	849	728	637	566	510	425	319	255	212	182	159	142	127	116	106	94	85	77	71
Acier trempé - *Hardenered steel* Acciaio da tempera - *Gehärteter Stahl*	8	2548	2316	2123	1820	1593	1416	1274	1158	1019	849	728	637	566	510	425	319	255	212	182	159	142	127	116	106	94	85	77	71
Fonte douce - *Soft cast iron* Ghisa tenera - *Weiches Gußeisen*	10	3185	2895	2654	2275	1991	1769	1593	1448	1274	1062	910	796	708	637	531	398	319	265	228	199	177	159	145	133	118	106	97	88
Fonte dure - *Hard cast iron* Ghisa dura - *Hartes Gußeisen*	6	1911	1737	1593	1365	1194	1062	956	869	764	637	546	478	425	382	319	239	191	159	137	119	106	96	87	80	71	64	53	53
Aluminium - *Aluminium* Alluminio - *Aluminium*	30	9554	8655	7962	6824	5971	5308	4777	4343	3822	3185	2730	2389	2123	1911	1592	1194	955	796	682	597	531	478	434	398	354	318	290	265
Duraluminium - *Duralumin* Duralluminio - *Duraluminium*	20	6369	5790	5308	4549	3981	3538	3185	2895	2548	2123	1820	1592	1415	1274	1062	796	637	531	455	398	354	318	290	265	236	212	193	177
Anticorodal - *Anticorodal* Anticorodal - *Anticorodal*	15	4777	4343	3981	3412	2986	2654	2369	2171	1911	1592	1365	1194	1062	955	796	597	478	398	341	299	265	239	217	199	177	159	145	133
Cuivre - *Copper* Rame - *Kupfer*	12	3822	3475	3185	2730	2389	2123	1911	1737	1529	1274	1092	956	849	764	637	478	382	319	273	239	212	191	174	159	142	127	116	106
Cuivre électrolytique - *Electrolytic copper* Rame elettrolitico - *Elektrolytkupfer*	10	3185	2895	2654	2275	1991	1769	1593	1448	1274	1062	910	796	708	637	531	398	319	265	228	199	177	159	145	133	118	106	97	88
Bronze - *Bronze* Bronzo - *Bronze*	10	3185	2895	2654	2275	1991	1769	1593	1448	1274	1062	910	796	703	637	531	398	319	265	228	199	177	159	145	133	118	106	97	88
Laiton doux - *Soft brass* Ottone dolce 63 - *Weiches Messing*	15	4777	4343	3981	3412	2986	2654	2386	2171	1911	1592	1365	194	1062	955	796	597	478	398	341	299	265	239	217	199	177	159	145	133
Laiton fragile - *Brittle brass* Ottone fragile 53 - *Brüchinges Messing*	15	4777	4343	3981	3412	2986	2654	2389	2171	1911	1592	1365	194	1062	955	796	597	478	398	341	299	265	239	217	199	177	159	145	133
Argentan - *Nickel silver* Argentana - *Neusilber*	9	2866	2605	2388	2047	1791	1592	1433	1303	1146	955	819	717	637	573	478	358	287	239	205	179	159	143	130	119	106	96	87	80
Zinc alliages - *Zinc alloys* Zinco leghe - *Zinklegierung*	12	3822	3475	3185	2730	2389	2123	1911	1737	1529	1274	1092	956	849	764	637	478	332	319	273	239	212	191	174	159	142	127	116	106
Bakélite - *Bakelite* Bachelite - *Bakelit*	10	3185	2895	2654	2275	1991	1769	1593	1448	1274	1082	910	796	708	637	531	398	319	265	228	199	177	159	145	133	118	106	97	88

Serie MDR

CARATTERISTICHE TECNICHE /TECHNICAL DATA

		MDR12			MDR16		
		Banco *Bench model Etabli Tisch Modell*	Piedistallo *On Pedestal Sur socle Pultstaender*	Colonna *On Column Sur colonne Saeule*	Banco *Bench model Etabli Tisch Modell*	Piedistallo *On Pedestal Sur socle Pultstaender*	Colonna *On Column Sur colonne Saeule*
Capacità di maschiatura su acciaio R50 / Tapping capacity on steel Taraudage sur acier / Gewindeschneideleistung auf Stahl 50		M 12			M 16		
Cono mandrino / Spindle taper Attesch / Spindelkonus	*mm*	CM2			CM2		
Corsa mandrino / Quill stroke Course du forreau / Pinolenhub	*mm*	60			60		
Velocità mandrino / Spindle speed Tours de broche / Spindeldrehzahl	*rpm*	275 ÷ 1785			140 ÷ 900		
Potenza motore (400 V 50 Hz) / Spindle motorpower Puissance moteur (400 V 50 Hz) / Motorleistung	*kW*	1.1			1.1		
Tavola / Table dimensions Dimension de la table / Tischabmessungen	*mm*	315x350		250x350	315x350		250x350
Diametro colonna / Column diameter Diamètre colonne / Saule Durchmesser	*mm*	98			98		
Distanza colonna centro mandrino / Distance spindle axis-column Distance colonn-centre broche / Ausladung (Saeule-Spindelmitte)	*mm*	205			205		
Distanza tavola naso mandrino (min-max) / Distance spindle-end table, min-max Distance table-nez de broche (min-max) / Abstand Spindel-Tisch, min. max	*mm*	210 - 600		45 - 760	210 - 600		45 - 760
Distanza base naso mandrino / Distance spindle-end to basis Distance base-nez de broche / Abstand Spindel-Füss	*mm*	-	-	1120	-	-	1120
Dimensioni (l x p x h) a colonna / Overall dimensions Dimension (l x p x h) sul colonne / Platzbedarf (l x p x h)	*mm*	450x580x1485	450x640x2335	545x625x2000	450x580x1485	450x640x2335	545x625x2000
Peso / Weight Poids / Gewicht ca.	*kg*	140 - 150	250 - 260	200 - 210	140 - 150	250 - 260	200 - 210

CARACTERISTIQUES /TECHNISCHE HAUPOATEN

		MDR22			MDR32	
		Banco *Bench model Etabli Tisch Modell*	Piedistallo *On Pedestal Sur socle Pultstaender*	Colonna *On Column Sur colonne Saeule*	Piedistallo *On Pedestal Sur socle Pultstaender*	Colonna *On Column Sur colonne Saeule*
Capacità di maschiatura su acciaio R50 / Tapping capacity on steel Taraudage sur acier / Gewindeschneideleistung auf Stahl 50		M 22			M 32	
Cono mandrino / Spindle taper Attesch / Spindelkonus	mm	CM3			CM4	
Corsa mandrino / Quill stroke Course du forreau / Pinolenhub	mm	60			60	
Velocità mandrino / Spindle speed Tours de broche / Spindeldrehzahl	rpm	130 ÷ 675			64 ÷ 1720	
Potenza motore (400 V 50 Hz) / Spindle motorpower Puissance moteur (400 V 50 Hz) / Motorleistung	kW	1.47			2.2	
Tavola / Table dimensions Dimension de la table / Tischabmessungen	mm	315x350		250x350	300x700	600x345
Diametro colonna / Column diameter Diamètre colonne / Saule Durchmesser	mm	98			123	
Distanza colonna centro mandrino / Distance spindle axis-column Distance colonn-centre broche / Ausladung (Saeule-Spindelmitte)	mm	205			300	
Distanza tavola naso mandrino (min-max) / Distance spindle-end table, min-max Distance table-nez de broche (min-max) / Abstand Spindel-Tisch, min. max	mm	210 - 600		45 - 760	250 - 600	50 - 750
Distanza base naso mandrino / Distance spindle-end to basis Distance base-nez de broche / Abstand Spindel-Füss	mm	-	-	1120	-	1160
Dimensioni (l x p x h) a colonna / Overall dimensions Dimension (l x p x h) sul colonne / Platzbedaft (l x p x h)	mm	450x580x1485	450x640x2335	440x625x1825	706x775x2645	469x679x2380
Peso / Weight Poids / Gewicht ca.	kg	150	260	210	310	380

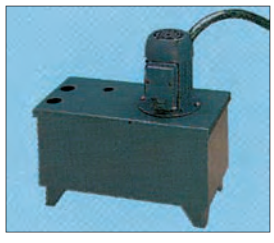
OPZIONI

Mandrino portamaschi
Mandrin porte taurauds
Screw-taps chuck
Gewindeboher Spannfutter

Patrona
Patrone
Lead-screw
Leitpatrone

Contagiri digitale mandrino per variatore
Compte tours digitai pour variateur
Spindle RPM digital read-out
Spindel U/Min Digitalanzeiger

Dispositivo di lubrorefrigerazione
Dispositif de nébulisation
Synchronized spraying nozzle
Nebulisatoreinrichtung



Impianto refrigerante
Arrosage
Coolant system
Küehlmittelanlage