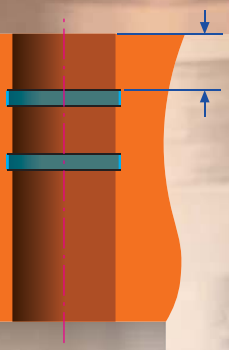
Holetool

MAUS ITALIA

F/26

Self-centering grooving tool with **adjustable B depth** and interchangeable **HSS-Co** blades



MA-2501

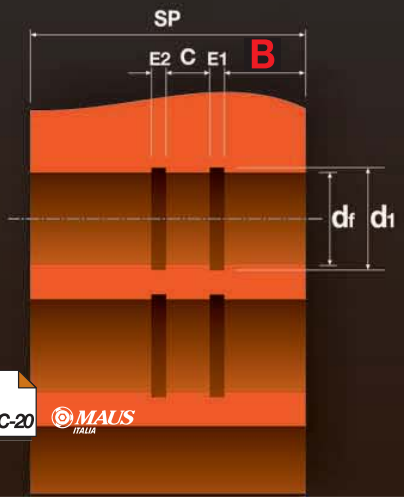
Automatic grooving

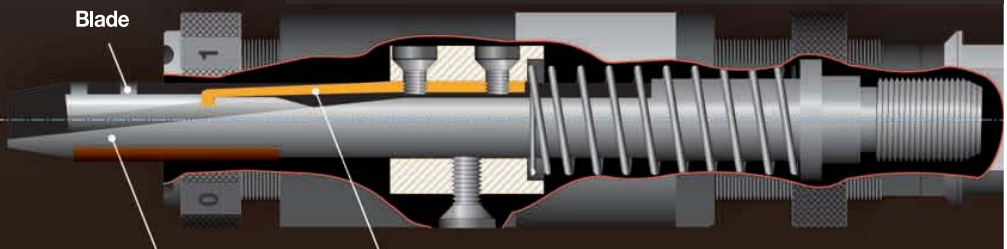
A due reference to the ***MA-2501*** work centre, the flagship of Maus Italia, the leading company for industrial automation in this market sector
*(see catalogue "**Automation**")*

This **fully automatic** system (single or double axis), can be used for tube expansion, facing and welding and for grooving tube sheet holes.

The ***F/26*** series is designed with a special connector and provides excellent results in large productions.

900 holes/hr (2 holes in 8 sec.)





AC-20 MAUS ITALIA

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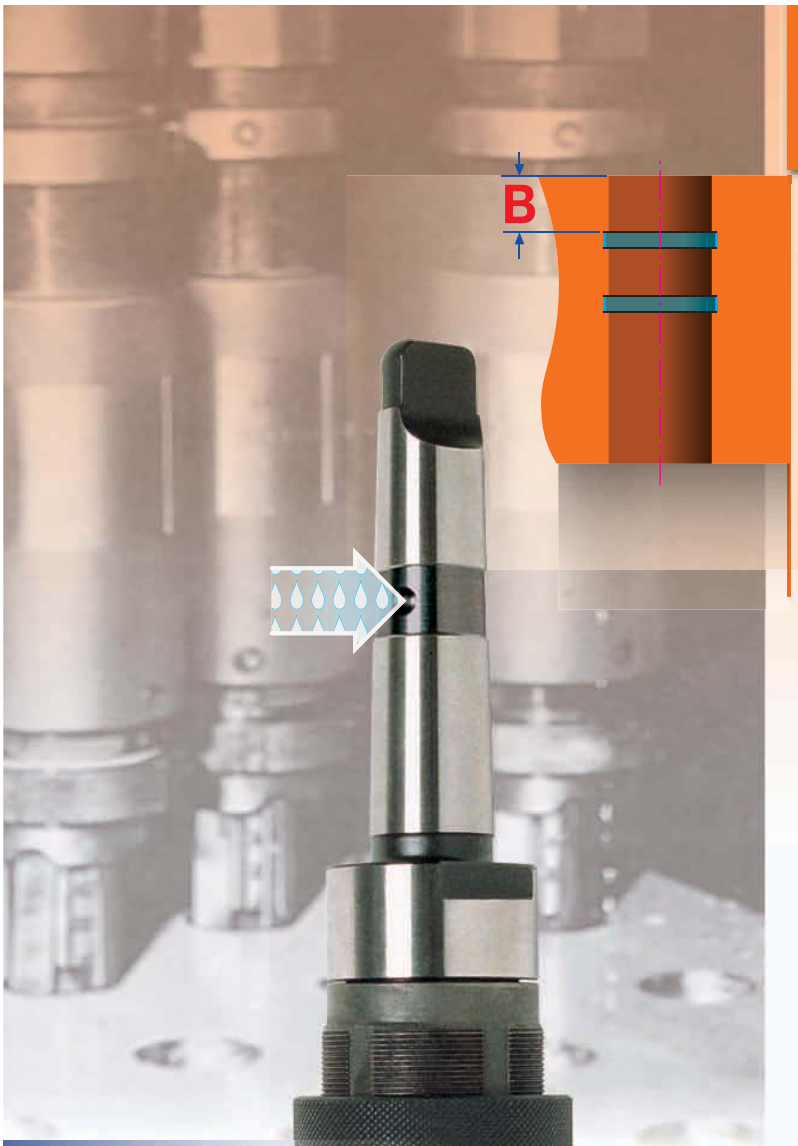
Holetool



F/26

Self-centering grooving tool with **adjustable B depth** and interchangeable **HSS-Co** blades

The ***F/26*** self-centering grooving tool creates grooves in tube sheet holes *(it is also effectively used for trueing existing grooves)* up to a **standard depth B** that can be **adjusted** to a value ranging between 1 and 12 mm *(0.47" to 0.04")*.
Greater depths, up to 300 mm *(11.81")*, can be easily reached using the **modular stem, spring and bush kits**, while retaining the ability to perform the adjustment mentioned above.
Equipped with a channel allowing coolant to flow through, like the other drilling tools of the ***Holetool*** series, the ***F/26*** is used on radial drills and programmed drilling machines *(even with multiple heads)*.
Entirely designed and manufactured by Maus Italia using high quality materials, the ***F/26*** is offered in 7 sizes, to process holes with diameters ranging between 9,75 and 51,50 mm *(0.384" to 2.028")*.
It is equipped with **HSS blades**, to perform multiple channels/grooves or multiple special processes at the same time.

Blades

HSS Co 10%

The ***F/26*** self-centering grooving tool is equipped with interchangeable **HSS-Co 10%** blades, for performing multiple operations.

Blades come in **3 different sizes.**

Maus Italia's technical staff are at the Customers' disposal to design and produce customised blades for special processes.

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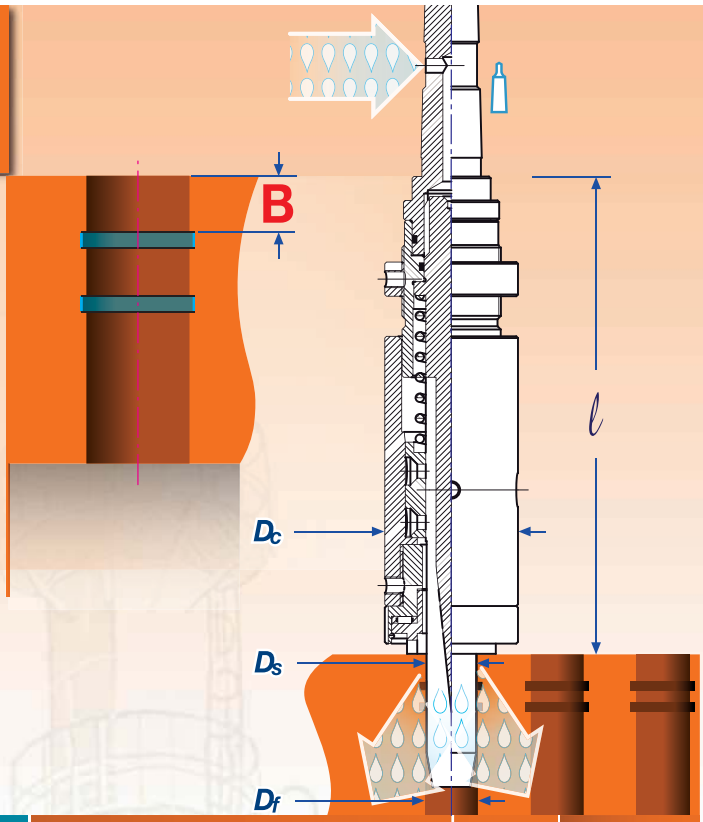
Self-centering grooving tool with **adjustable B depth** and interchangeable **HSS-Co** blades



d_e = 9,52 mm ÷ 50,80 mm
3/8" ÷ 2"

F/26

Tube		Finished tube sheet hole		Grooving tool	Stem Ø		Max. body Ø		Length Body		Shank	Blades
d_e		D_f		F/26	D_s		D_c		ℓ		Morse taper	F/26-BIT
inches	mm	mm	inches	Code	mm	inches	mm	inches	mm	inches	N	Code
3/8"	9,52	9,75	0.384	* F26-00	9,50	0.374						F26-BIT-00
	10,00	10,20 - 10,25	0.402 - 0.404	* F26-00a	10,00	0.394						
	12,00	12,20 - 12,25	0.480 - 0.482	* F26-1a	12,00	0.472						
1/2"	12,70	12,90 - 12,95	0.508 - 0.510	* F26-1b	12,70	0.500	39,00	1.535	180,00	7.087	2	F26-BIT-1
	13,00	13,20 - 13,25	0.520 - 0.522	* F26-1c	13,00	0.512						
	14,00	14,20 - 14,25	0.559 - 0.561	* F26-1d	14,00	0.551						
	15,00	15,20 - 15,25	0.598 - 0.600	* F26-1e	15,00	0.591						
5/8"	15,87	16,10 - 16,20	0.634 - 0.638	F26-2a	16,00	0.630						F26-BIT-2÷6
	16,00	16,20 - 16,25	0.638 - 0.640	F26-2a	16,00	0.630						
	17,00	17,25 - 17,30	0.679 - 0.681	F26-2as	17,00	0.669	47,00	1.850				
	18,00	18,25 - 18,30	0.718 - 0.720	F26-2b	18,00	0.709						
3/4"	19,05	19,25 - 19,30	0.758 - 0.760	F26-2c	19,00	0.748			230,00	9.055	3	
	20,00	20,25	0.797	F26-3a	20,00	0.787						
	22,00	22,25 - 22,30	0.876 - 0.878	F26-3b	22,00	0.866						
7/8"	22,22	22,50	0.886	F26-3b	22,25	0.876	53,00	2.087				
	25,00	25,25 - 25,30	0.994 - 0.996	F26-3c	25,00	0.984						
1"	25,40	25,65 - 25,70	0.010 - 1.012	F26-3d	25,40	1.000						
3/4" GAS	26,90	27,20	1.071	F26-4a	26,90	1.059						
	27,00	27,30	1.075	F26-4a	27,00	1.063	66,00	2.598				
1.1/4"	31,75	32,10	1.264	F26-4b	31,75	1.250						
	32,00	32,25	1.270	F26-4b	32,00	1.260						
1" GAS	33,70	34,00	1.339	F26-5a	33,75	1.329	72,00	2.835	240,00	9.449	4	
1.1/2"	38,10	38,50	1.516	F26-5b	38,10	1.500						
1.1/4" GAS	42,40	42,80	1.685	F26-6a	42,75	1.683						
1.3/4"	44,45	44,80	1.764	F26-6b	44,75	1.762	92,00	3.622				
1.1/2" GAS	48,30	48,80	1.921	F26-6c	48,75	1.919						
2"	50,80	51,50	2.028	F26-6d	51,75	2.037						

* F/26 without coolant channels

MAUS ITALIA Holetool

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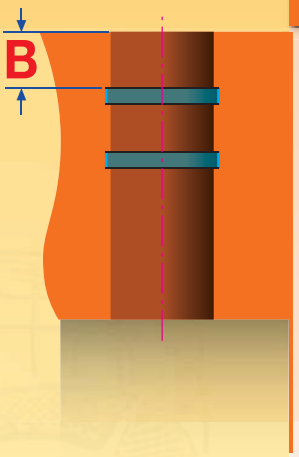
Sample order codes

If you need to create a 3-6-3 (*E-C-E*) set of grooves in *3/4"* (**19,00 mm**) holes at a **B** depth of 10 mm *(0.394")*, referring to the two tables (on these pages) you can see that the full order to be placed shall include the following items:

F26-2c	*(1 grooving tool)*
F26-BIT-2- 363	*(1 blade)*



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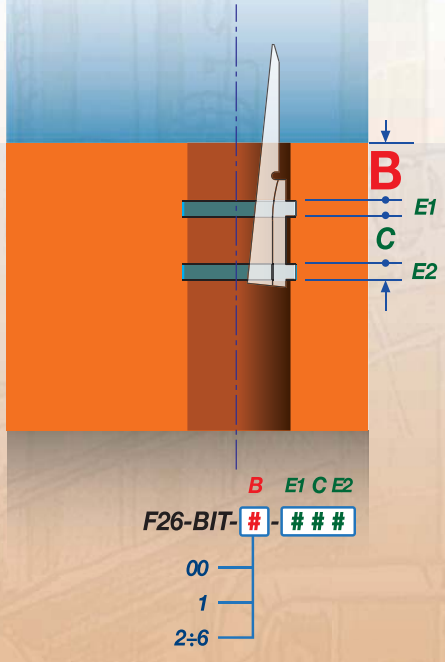
Components for **B depth adjustment** *(distance between the tubesheet surface and the first groove)*

The **depth between the tubesheet surface and the first groove, indicated with B**, can **be set** to a value ranging between 1 and 12 mm *(0.47" to 0.04")* through a ring.

Greater depths, up to 300 mm *(11.81")*, while retaining the ability to perform the ring adjustment, can be easily reached using optional **components**: **stems, blade coupling springs and thrust bushes.**

The table below provides easy identification of the appropriate **grooving tool** and **accessory** code.

Depth		Grooving tool	
B		F/26	
mm	inches	Code	
1,00 ÷ 12,00	0.039 ÷ 0.472	F26-##	F/26 standard
6,00 ÷ 18,00	0.236 ÷ 0.709	F26-##-CTS06	Additional accessory extended blade coupling spring
20,00 ÷ 32,00	0.787 ÷ 1.260	F26-##-EXT20	F/26 extended by 20 mm *(0.787")*
17,00 ÷ 29,00	0.669 ÷ 1.142	F26-##-THR09	Additional accessory extended thrust bush
11,00 ÷ 23,00	0.433 ÷ 0.906	F26-##-THR15	
2,00 ÷ 14,00	0.079 ÷ 0.551	F26-##-THR24	
35,00 ÷ 47,00	1.378 ÷ 1.850	F26-##-EXT35	F/26 extended by 35 mm *(1.378")*
32,00 ÷ 44,00	1.260 ÷ 1.732	F26-##-THR09	Additional accessory extended thrust bush
26,00 ÷ 38,00	1.023 ÷ 1.496	F26-##-THR15	
17,00 ÷ 29,00	0.670 ÷ 1.142	F26-##-THR24	



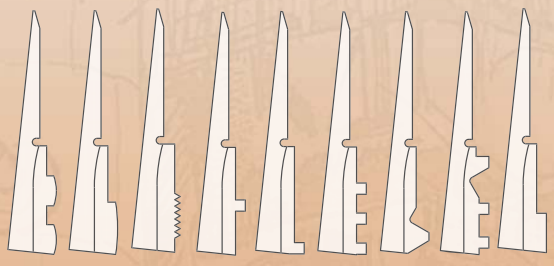
B E1 C E2
F26-BIT-# - ###
00
1
2÷6

Blades

HSS Co 10%

The **fixed groove layout** is given by the **profile of the blades** installed on the *F/26* model. Maus Italia offers a comprehensive range for the most common tasks.

Special blades are designed and manufactured according to customer's specifications. In case of **stainless steel tube sheets** we recommend the blades coated with Titanium Aluminium Nitride - TiAlN, whose order code has the **CTD** suffix



B E1 C E2
F26-BIT-# - ### -CTD
00
1
2÷6

coated blade TiAlN • coated blade TiAlN • HSS Co 10%

MAUS ITALIA AC-23