



*The Three-S Promise:
Superior Standards & Services!*



Tooling machines and appliances

Cutting-off and surface grinding machine
Precision Vice / Chuck
Punch-Grinding Equipment
Form Punch-Grinder
Chamfering Machine



DREI-S-WERK

PRECISION STANDARD TOOLS
PINNING SYSTEMS
DREI-S-technologies

CUTTING-OFF AND SURFACE GRINDING MACHINE

Application scope:

The perfect machine for cutting ejector pins, core pins, ejector sleeves, punches and other parts in bar-form.

The requested length is achieved in one work step through precise grinding to length. Uncomplicated setting and simple handling allows a quick cutting of the different dimensions and lengths: \varnothing 1 to approx. 28 mm and lengths up to 300/600 mm. The stability (machine weight approx. 90 kg) and solid construction guarantee a length tolerance of ± 0.01 mm.



Article-No.: HR01.01.000

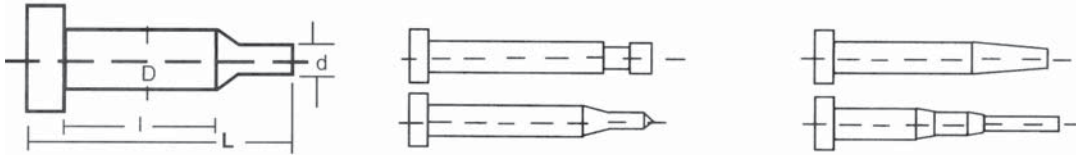
Only dry working, carbide processing not possible.

length tolerance: ± 0.01 mm
right-angle tolerance: ± 0.01 mm
cutting disk : 1 mm x 180 mm \varnothing / 31,8 hole- \varnothing
cup grinding-wheel: 100 x 50 x 20 mm
RPM: 3600 1/min.
motor: 400 V – 1,1 kw
shortest processible length: approx. 40 mm
max. work piece length: 300 mm / 600 mm with extension
max. part- \varnothing : approx. 28 mm
machine dimensions: 430 x 360 x 500 mm (l/w/h)
net-weight: approx. 87.5 kg

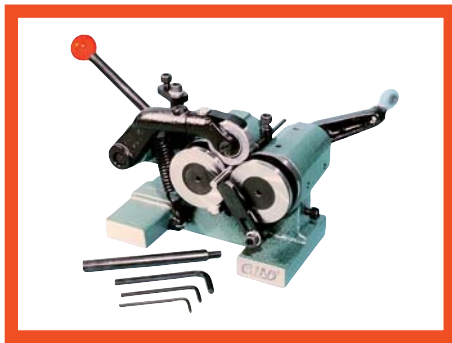
With the additional chuck **HR01.01.200** also shorter parts (between 15 and 20 mm) can be processed (depending on the head height).

PUNCH-GRINDING EQUIPMENT

It is very easy to grind ejector pins, piercing punches, ejector sleeves, bushes and all other round parts with these devices. They have to be mounted on a flat or a tool grinding machine and within some minutes the parts are finished.



Punch-Grinder, manual



Article-No.: HR01.02.100

for work pieces from: \varnothing 3 – 30 mm
lengths: approx. 30 – 300 mm
concentricity: 5 μ m

Punch-Grinder with electric motor



Article-No.: HR01.02.000

for work pieces from: \varnothing 1.6 – 38 mm
lengths: approx. 20 – 260 mm
concentricity: 2 μ m

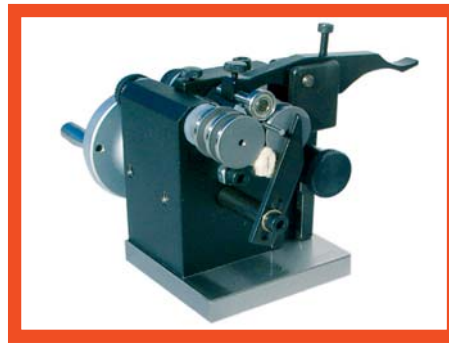
Punch-Grinder with electric motor and sinus 15°



Article-No.: HR01.02.050
alternative 1: for piercing punches
Article-No.: HR01.02.060
alternative 2: for ejector pins and piercing punches

for work pieces from: \varnothing 1.6 – 38 mm
lengths: approx 20 – 260 mm
concentricity: 2 μ m

Miniature Manual Die Grinder (with magnet adhesion)

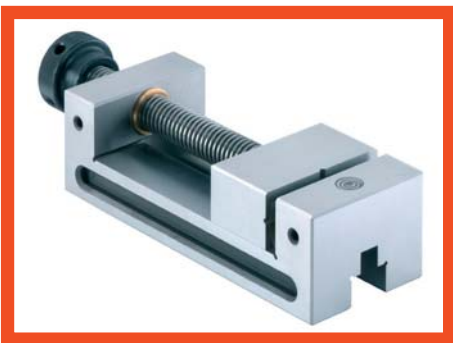


Article-No.: HR01.02.200

for work pieces from: approx. \varnothing 0.8 – 10 mm
lengths: max. 300 mm
concentricity: 5 μ m

Appliances with electric motor are suitable only for dry processing.

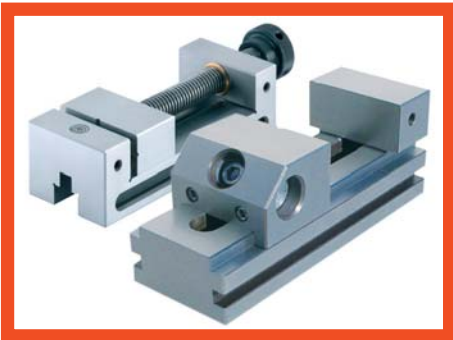
PRECISION VICES



Article-No.: HR01.02.800 HR01.02.850 HR01.02.900

span:	63 mm	75 mm	125 mm
jaw width:	48 mm	75 mm	98 mm
total length:	155 mm	180 mm	250 mm

made of hardened **tool steel**, 56 – 58 HRC
fine finish, in a wooden case
parallelism: 2 μm / 100 mm
right angle: 5 μm / 100 mm



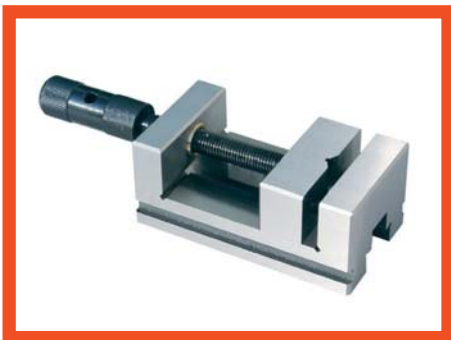
Article-No.: HR01.02.950 HR01.02.960 HR01.02.970
(snap closing) (snap closing) (screw coupling)

span:	85 mm	90 mm	80 mm
jaw width:	50 mm	73 mm	70 mm
total length:	140 mm	180 mm	160 mm

made of hardened **stainless steel**, approx. 56 HRC
fine finish, in a wooden case
parallelism: 2 μm / 100 mm

PRECISION VICES

Low-cost version

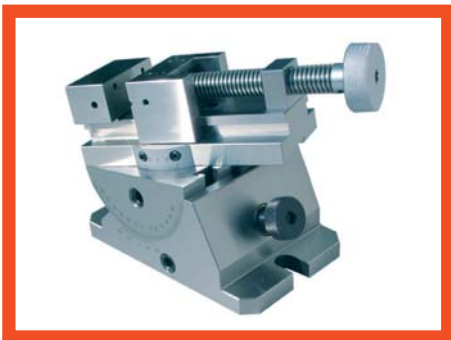


Article-No.: HR01.02.700

made of hardened **tool steel**,
55 – 60 HRC
fine finish, in a wooden case

span: 58 mm
jaw width: 60 mm
total length: 110 mm

Precision Sinusoidal Vice



Article-No.: HR01.02.650

made of hardened **tool steel**,
approx. 56 HRC
for drilling, grinding, controlling and
milling work. Working in 3 dimensions

parallelism: 2 μm / 100 mm-
right angle: 5 μm / 100 mm

span: 80 mm
jaw width: 70 mm

Miniature Universal Vice

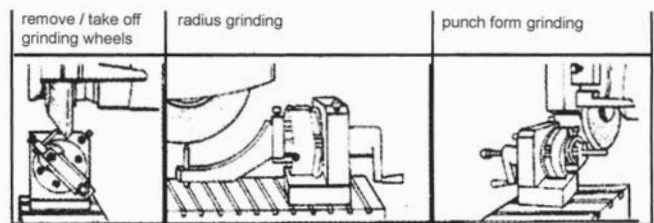
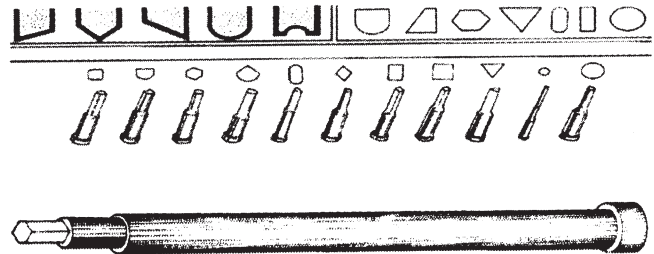


Article-No.: HR01.02.600

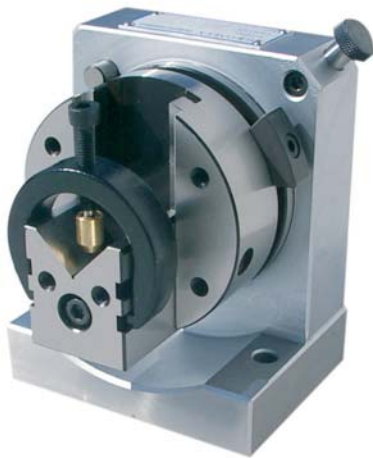
made of hardened **tool steel**,
approx. 56 HRC
tolerance of the inclination /
slewing range: max. 0.01 mm

span: 16 mm
jaw width: 70 mm

FORM PUNCH-GRINDER WITH WHEEL BRACE

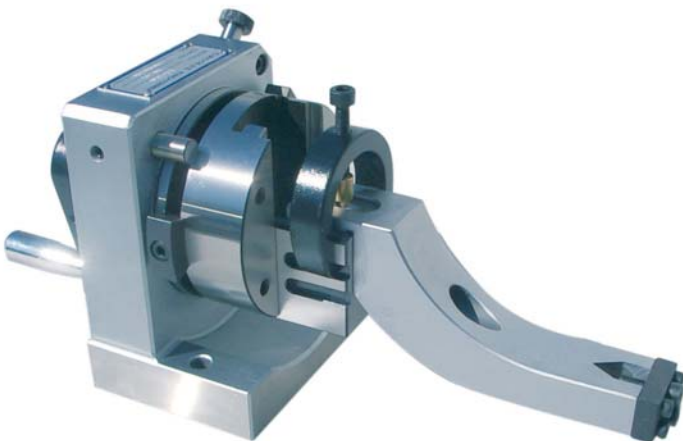


For grinding concave and convex radii as well trihedral, square and hexagonal tips.
Can also be applied for profiling grinding wheels.
Within shortest time the flat grinding machine can be modified to a form-grinding machine.



manufactured using hardened **tool steel**,
approx. 60 HRC
fine finish
height: approx. 75 mm
max. part-Ø: 31 mm
max. pitch: 24-fold
max. V-way: 32 mm
max. parallelism + right angle: 5 µm / 50 mm

Version 1 : small holding fixture
Article-No.: HR01.02.400



Version 2 : wide holding fixture
Article-No.: HR01.02.300

CHAMFERING MACHINE

For high safety and precision at low costs.
For fast and clean burr-free grinding of metal parts, form plates and other hardened and unhardened parts.



Article-No.: HR01.02.500

Only dry working, carbide processing not possible.

micrometer depth setting: for 45°-chamfering
width of chamfer 0 – 16 mm
lamallae sanding wheel with 60 grain
work top: approx. 120 x 300 mm

Additional parts available from our product range:

- ejector pins DIN ISO 6751 / DIN ISO 8693 / DIN ISO 8694 / DIN ISO 1530
- ejector sleeves DIN ISO 8405
- core pins
- ejector pins: customized models
- lubricant
- piercing punches DIN 9861 / DIN 9844 / DIN ISO 8020
- piercing punches with trombone neck
- perforating pins
- piercing punches: customized models
- hot runner nozzle shut-off needles
- axles and arbors
- parts manufactured according to drawing
- dowel pins former DIN 6325
- dowel pins former DIN 7979
- measuring pins DIN 2269, single and in sets
- storage cases
- metal-holder for measuring pins
- plastic-handles for measuring pins (replaceable)
- magnetic measuring pins
- grinding
- heat forming
- heat treatment
- coating technology
- upsetting ejector pins



DIN EN ISO 9001:2000

Zertifikat: 01 100 80420

Always one step ahead

DREI-S-WERK was the first manufacturer of ejector pins in Europe and pathfinder for the former DIN 1530 standard. We have traditionally always played an active role in DIN standardisations. DREI-S-WERK was one of the first to develop and use nitriding technologies which today are customary in the market.

150 years of industrial experience has allowed us to build up a wealth of knowledge and show our willingness to adapt to new situations. Our committed staff is used to self dependent work and comprehensive thinking. It is driven by the desire of presenting new products and innovations in production.

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