

# SPIROL<sup>®</sup>

## PIN DRIVING CHUCKS



# SPIROL®

## Pin Driving Chuck

for use with SPIROL Model PM Manual Pin Inserters, arbor presses, or drill presses

### MODEL SPD

**Low cost alternative for low insertion force.**

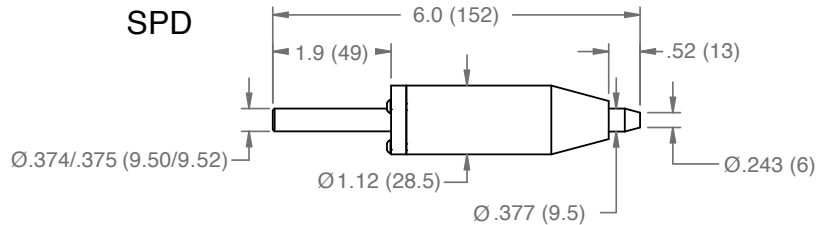
This light duty, stainless steel pin driving chuck is designed for use with SPIROL's Model PM Manual Pin Inserter. It may also be used in a drill press or arbor press with an adaptor.

An internal compression spring acts on the outer flanges of the jaws to provide retention force and hold the pin securely prior to and during installation. This feature eliminates the difficulty with handling small diameter or short pins. The tool is also designed to provide the operator with good visibility for aligning the pin with the hole in the work piece facilitating trouble-free installation.

To use this tool, install the Model SPD into the press adaptor. Insert the pin into the SPD jaws, and align the pin with the hole in the assembly. Pull down the press lever. Downward movement of the press starts insertion of the pin into the hole. When the jaws of the Model SPD contact the assembly surface, an internal punch continues downward to complete the insertion of the pin to the desired depth - below flush, flush or above flush. When used in conjunction with SPIROL's Model PM Pin Inserter, a stop can be set for specific and repeatable installation depths.



*Split jaws retain pins prior to installation*



mm dimensions shown in ( )

#### MATERIAL

300 Series Stainless Steel

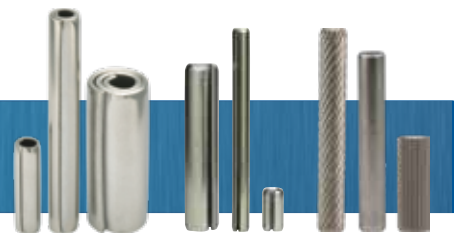
#### MAXIMUM FORCE

200 lbs. (0.89kN)

MODEL	SHANK DIAMETER	OVERALL LENGTH	PIN DIAMETER RANGE	PIN LENGTH RANGE
SPD	.375 (9.5)	6.00 (152)	.031 – .156 (0.8 – 4.0)	Not limited

*Please specify pin diameter at the time of order.*

SPIROL Pin Driving Chucks can be used for installation of Coiled Pins, Slotted Pins, and Solid Pins



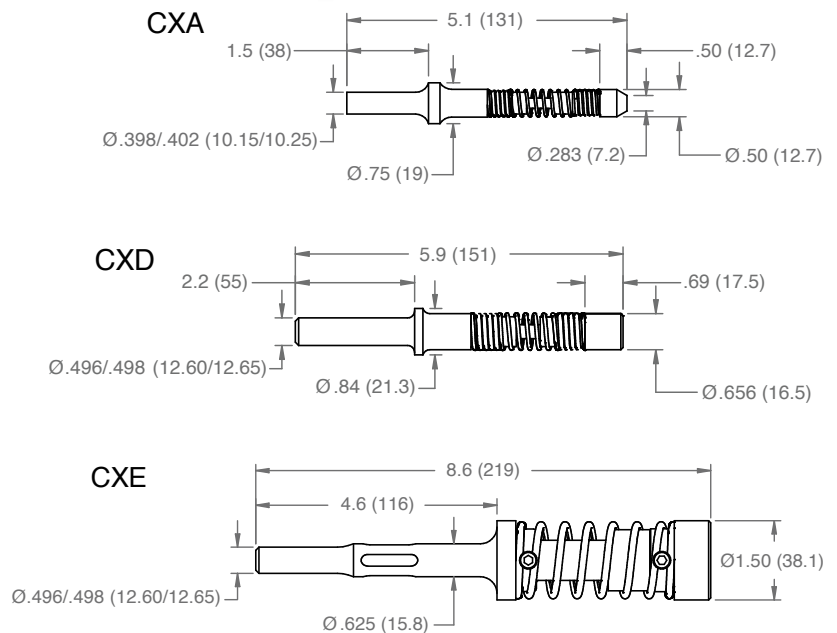
### MODELS CXA, CXD, and CXE

**Low cost alternative for high insertion force.**

These heavy duty pin driving chucks are designed for use with SPIROL's Model PMH or Model PMX Manual Pin Inserter. They may also be used in a drill press or arbor press with an adaptor. In applications where the component is too large for a bench top press, the chuck may be used in conjunction with a pneumatic tool (air hammer).

This method is ideal for low volume applications where insertion forces are greater than 200 lbs. (0.89 kN). To use the tool, the operator would manually place the pin into the end of the driver. The split bushing at the tip provides spring tension to hold the pin securely in place prior to and during installation. The exposed end of the pin is then placed into the hole, and the installation is completed by either advancing the press handle or actuating the air gun.

The tools are available with a flush setting for driving pins flush with the mating surface or with a non-flush setting for driving pins to protrude above or recess below the mating surface. The standard design is focused around installing SPIROL's Coiled Pins; however, custom tools are available for installing Slotted Pins or Solid Pins. Punches, springs and other replacement parts are available from stock.



mm dimensions shown in ( )

**MATERIAL**

High Strength Tool Steel

**MAXIMUM FORCE**

Application Dependent

MODEL	SHANK DIAMETER	OVERALL LENGTH	PIN DIAMETER RANGE	PIN LENGTH RANGE
CXA	.400 (10.2)	5.10 (131)	.031 – .250 (0.8 – 6.0)	Not limited
CXD	.497 (12.7)	5.90 (151)	.250 – .375 (6.0 – 10.0)	Not limited
CXE	.497 (12.7)	8.60 (219)	.500 – .750 (12.0 - 20.0)	Not limited

*Please specify pin diameter at the time of order.*

# SPIROL®

## Model PM, PMH and PMX Manual Pin Inserters



### For Manual Installation

**SPIROL Model PM, PMH and PMX** vertical, manually operated, pin installation machines are designed to be portable, easily adjustable, and are especially suited to prototype and low-volume production.

Chucks for different diameter pins can be quickly and easily interchanged.

These machines use **SPIROL's** standard pin-driving chucks – the SPD, CXA, CXD or CXE.

Each machine includes tooling to install the pin diameter specified at the time of order. Additional tooling is available for all standard diameter pins allowing you to easily change pin sizes.

**SPIROL** Application Engineers will review your application and recommend the best solution to optimize your assembly process.

**Automatic machines are also available from SPIROL!**

Please refer to [www.SPIROL.co.uk](http://www.SPIROL.co.uk) for the most current specifications and standard offering. Printed materials may be out of date.



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