



Dowel Hole Boring

Machine Type DB 12



By far the greater part of the dowel boring machines on the market – intended for machining workpieces for carcass manufacturer – do not solve the manifold problems occurring in frame boring.

These jobs, i. e. the boring of longitudinal and transverse door frame pieces, framed doors, door panelling, door posts, drawers, cross members etc., are carried out with outstanding success by the **SCHEER DB 12 Dowel Hole Boring Machine**.

The machine excels for the following reasons:

- sturdy box-type substructure with steel sheet panelling
- large dimensioned support table
- powerful 3-spindle boring unit, vertical adjustment by means of a handwheel
- interchangeable swing stop guarantees accurate holes
- to machine long workpieces, the complete machine top section can be tilted 90° backwards
- pneumatic safety controls effected by foot valve "clamping – drilling"
- with built-in servicing unit

Technical Dates

Item No.	363 102 0060 019
Boring unit	Boring motor type BM 520 for three-phase current, n = 2860 rpm, 1.5 HP capacity, with 3 spindles, spindle distance 32/32 mm (other distances to order), with pneumatic feed of spindle head, spindle stroke max. 80 mm, drive rotatable through 360°, locating at settings of 0 and 90°.
Drill spacing	min. 32 mm, max. 64 mm
Drill depth	max. 70 mm (with tool length 105 mm) max. 45 mm (with tool length 80 mm)
Height adjustment	5 to 60 mm from table face to boring center, scale setting
Clamping height	max. 120 mm
Air consumption	approx. 1.7 litres air intake/max. stroke
Table size	400 x 250 mm
Machine dimensions	1350 x 650 x 950 mm (seaworthy case 108 x 72 x 148 cm)
Weight	net 129 kg, gross (seaworthy case) 200 kg

Scope of delivery

Complete DB 12 dowel hole boring machine with 3-spindle boring motor, 1.5 HP at 2860 rpm, spindle distance 32/32 mm with built-in pneumatic feed of boring head, maximum stroke 80 mm, with interchangeable pneumatic chuck, workpiece support table 400 x 250 mm, complete

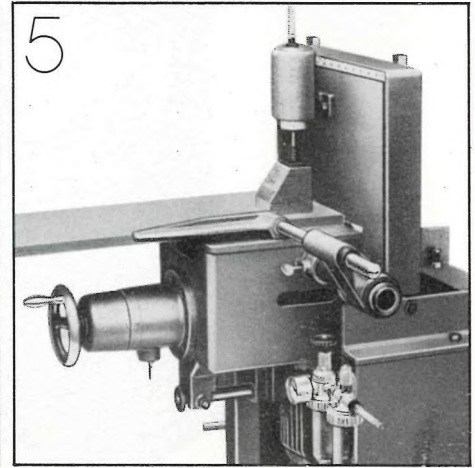
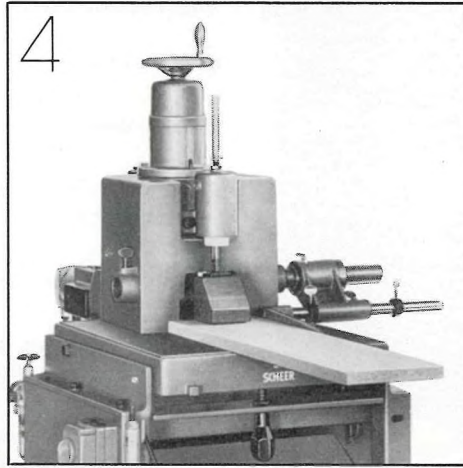
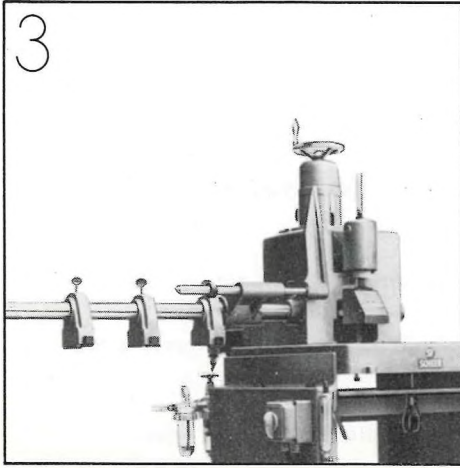
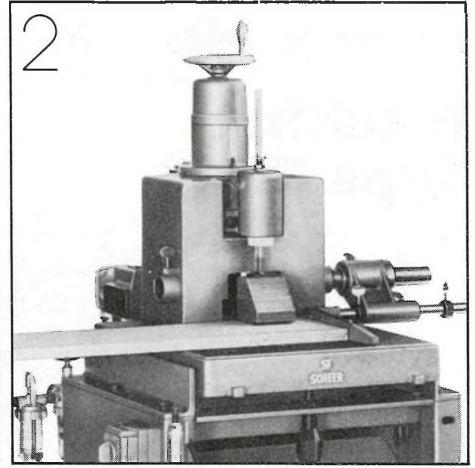
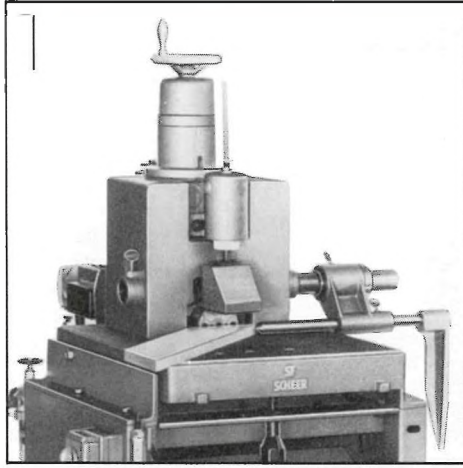
stop system (DGBM) with foot valve control including service unit and blowing-out gun, electric on/off switch, supply cable 4-core less plug, 2 socket pins, one open-ended spanner.

Optionally available

Extended stop tube 1050 mm
Plunge stop LA 344

Ord.No. 369 003 1500 009
Ord.No. 369 003 1400 004

Operating Examples



1 Mitre Boring
 For this purpose the swing stop with round bar is extracted from the guide and is inserted reversed. The bar end is turned at 45° . The workpiece is positioned as per illustration. Matching pieces are positioned against the stop and bored in the same way after changing over the stop system to the other side of the housing. With veneered or plastic-coated workpieces – which do not permit subsequent machining – we recommend the additional use of a boring steadyrest (see illustration) which guides the boring tools right up to the workpiece (price on request).

2 Boring Longitudinal Frame Pieces
 The workpiece is clamped in position flat, the reference edge rests on the angle stop, the reference face resting on the workpiece support table. Both vertical setting and setting of the angle stop can be carried out quite superficially as mating workpieces are automatically matched when correctly positioned.

3 Boring of Extra-wide Workpieces
 e. g. bottom frame pieces for lift gates or centre frame piece boring with longitudinal frame pieces. If single boring with a maximum boring distance of 64 mm is not sufficient as a result of the considerable workpiece length, it is possible by using an extended 1050 mm stop tube or one or several plunge stops (see special equipment) to bore a further hole at the distance required. This stop system can also be reversed so that the mating pieces automatically match.

4 Boring Transverse Frame Pieces
 The workpiece is clamped in position flat, the reference edge rests against the angle stop whilst the reference face rests on the workpiece support table. The matching side is bored in the same way after reversing the swing stop system over to the other side of the housing.

5 Boring Long Workpieces
 Face boring, as for example with door posts. The complete machine top section with pneumatic chuck is tipped backwards so that workpieces of any desired length can be conveniently clamped in position.



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