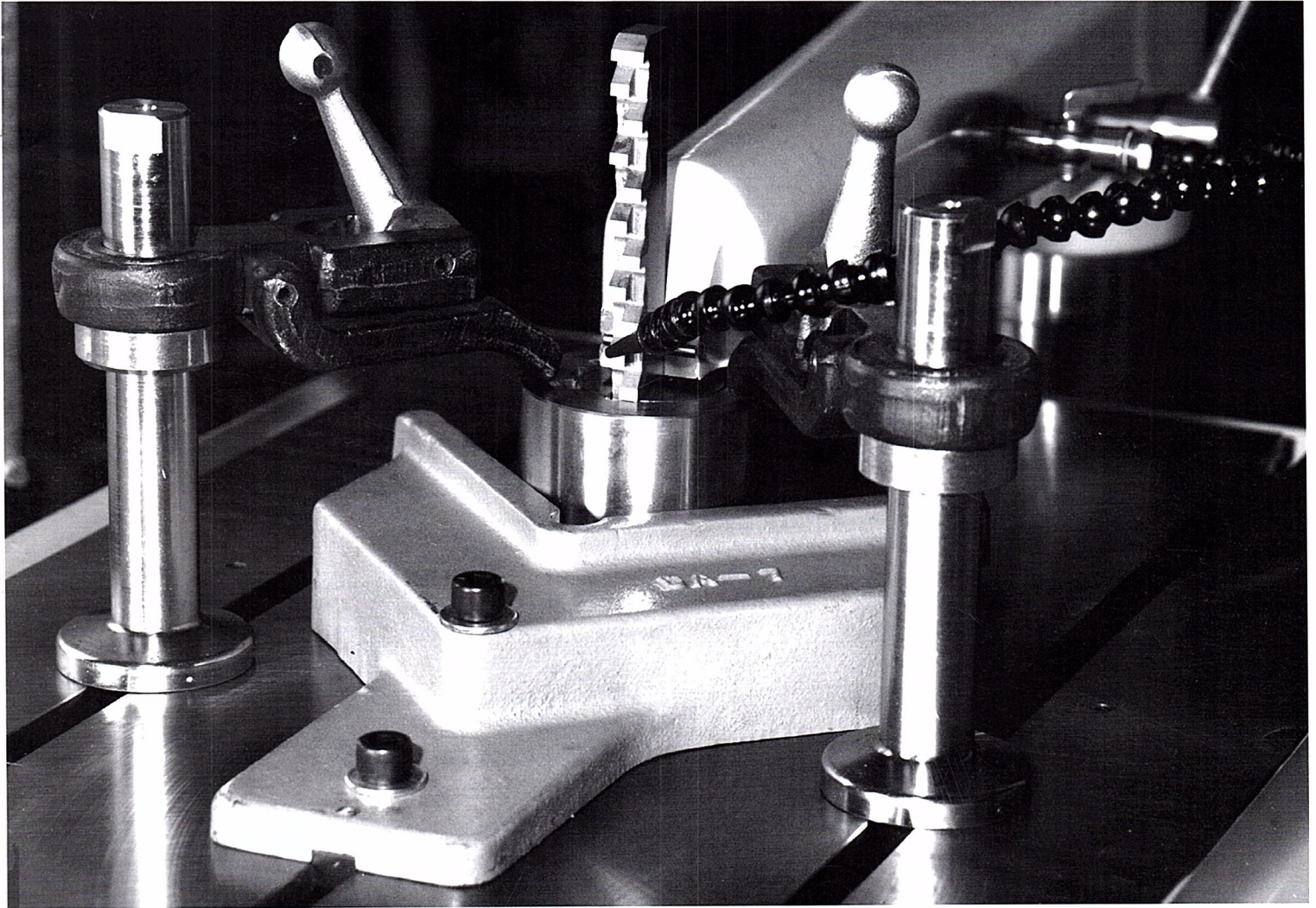


DAVIS MTK KEYSEATERS



Unequaled Multiple Tooth Keyway Cutting



HP HANSFORD
Parts and Products

E X P E C T E X C E L L E N C E

For more than 80 years, the Davis Keyseater has been the machine of choice for manufacturers throughout the world. Its robust construction and multiple tooth cutting action makes it the easiest to operate, fastest cutting, most precise keyseater on the market.

The Most Versatile, Quality Machine in the Shop

- Unequalled cutting speed and precision
- Cuts external slots as well as internal keyways
- Make simple fixtures for conventionally milled pieces
- Ease of use means more production without skilled operators
- Accurate, low cost keyways mean an increase in profits and faster return on your investment
- Cuts wide range of keyway depths
- Accessories enable cutting with bushing diameter smaller than workpiece bore

Multiple Tooth Cutting Principle

- More strokes per minute
- Eliminates frequent re-sharpening
- Faster cutting time, longer life than single tooth cutters
- Proper rake, clearance and hardness ensures efficient cutting
- No need to adjust machine stroke length

Work Locating Bushings

- Ensure concentricity of keyway in the bore
- Allow fast set-up, loading and unloading of parts
- Eliminate manual orientation of tool to the workpiece bore



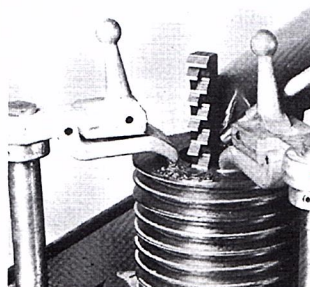
Model 5

- Tilting Table standard
- 1/16" – 1 1/2" Keyway capacity
- Simple manual feed
- 2 HP Belt Drive
- Sturdy cast frame



Model 15

- Accurate micrometer depth stop
- Easy Set-up
- Ideal for use in cells—keyway in cycle for no added cost
- 1/16" – 1 1/2" Keyway Capacity
- Manual and Automatic feed selection standard
- Automatic stop standard
- Coolant system standard, flushes chips away
- 2 HP GearDrive

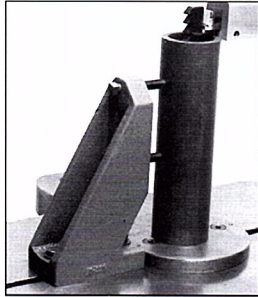


Keyway Cutting



Accessories

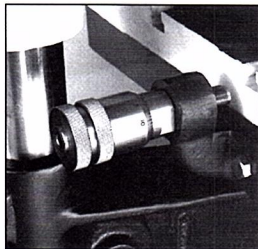
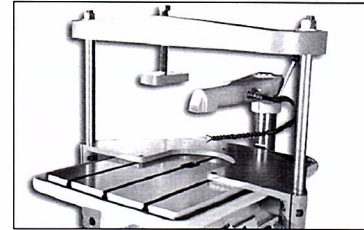
Hansford Parts and Products offers many accessories that allow you to configure your Davis Keyseater to suit your internal keywaying and/or external slotting requirements.



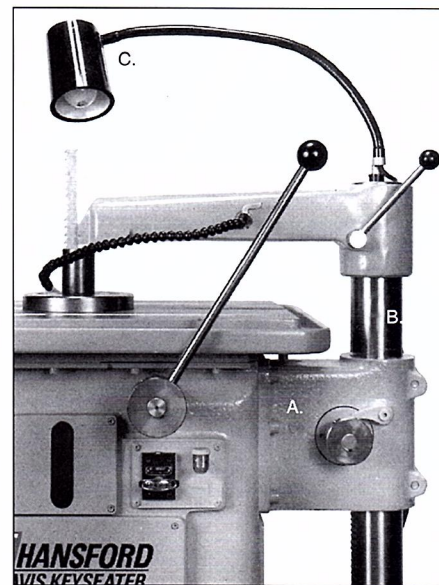
DA-9 Angle Block
Provides back up support for tall work pieces.

DA-59 Swinging Clamp Bar Assembly

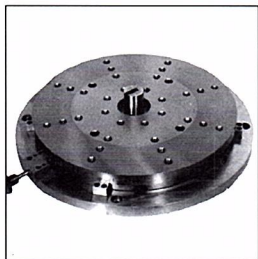
Clamp a large work piece when T slots are not accessible for conventional clamping.



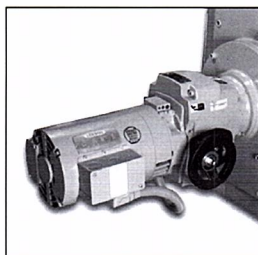
DA-20 Micrometer Depth Stop (Model 5 only. Standard on Model 15)
For faster and more accurate depth setting than the standard stop. Available in both inch or metric calibrations.



- A. DA-60 (Model 15), DA-13 (Model 5) 3" Extra Throat Depth Assembly**
Increases work piece diameter that can be accommodated by 6" when standard throat diameter is exceeded.
- B. D-1701 (Model 15), D-524 (Model 5) 6" Extra Height Armpost**
Increases work piece height that can be accommodated to 18".
- C. DA-62 Worklight**
Illuminates work area.



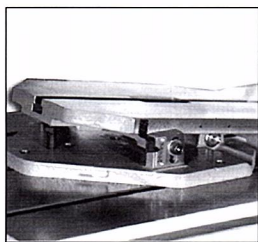
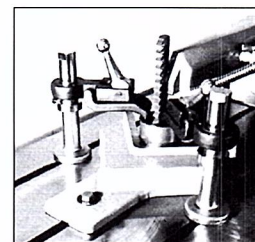
DA-22 Index Table
Accurately indexes work pieces for cutting internal multiple keyways, standard splines or multiple grooves. Special centering bushings and rings are sold separately, based on individual requirements.
Please note: due to the height of the Index Table, cutter length cut capacity is reduced by 2 1/2".



DA-27 Variable Speed Drive (Model 15 only)
Provides infinitely variable speed range of 12 to 56 strokes per minute. Achieve proper surface speed and cutting efficiency for a variety of materials. Slow down the machine speed when cutting hard materials such as stainless, or speed it up when cutting soft materials such as aluminum and cast iron.

DA-23 Kwik Klamps, DA-6/DA-7 Work Centering Vee Blocks

Forged steel clamps use cam-action for fast and secure clamping. Height adjusting collar to allow repeated clamping. Work Centering Vee Blocks allow you to accommodate workpieces that have a larger bore than the bushing you have for a certain cutter size.

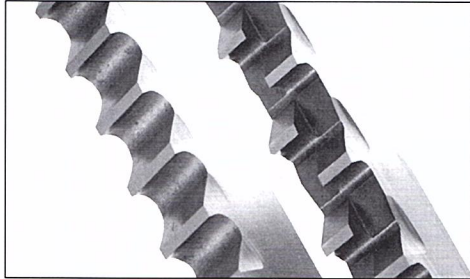


DA-58 Tilting Table Attachment (Model 15 only)
Cuts a keyway parallel to a tapered bore, or a tapered keyway in a straight bore. Accommodate tapers up to 4" per foot (included). Please note: due to the height of the Tilting Table, cutter length cut capacity is reduced by 2 1/2".

Tooling

Davis Keyseater cutters and bushings are available in inch and metric sizes to give you the optimum performance of your Davis Keyseater machine. Standard sizes of cutters from 1/16" to 1 1/2" and 2 mm to 36 mm are available, as well as special sizes, corner radii, and angle cutters to meet your needs. All cutters are accurately hardened and ground to provide optimum cutting efficiency and better finishes.

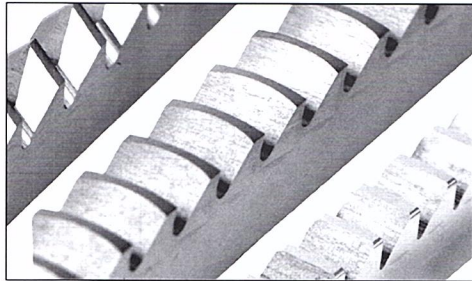
See Bulletin DKS-2A for complete details on the sizes and types available.



Cutters

Series AF Cutters

Side clearance, 10° rake angle and a relief angle for general keywaying.



Series AFS Cutters

Staggered tooth configuration cutter, which may eliminate need for a pilot cut. Will not load with chips when cutting keyways over 5" long and 1/2" wide. Cut with less force than AF Cutters.

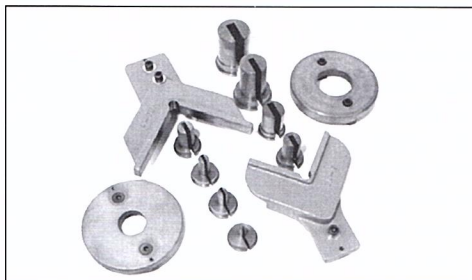
Special Cutters

For keyways that are not standard, such as radius cutters, angle cutters, and cutters made to your size and or length requirements.



Cutter Sets

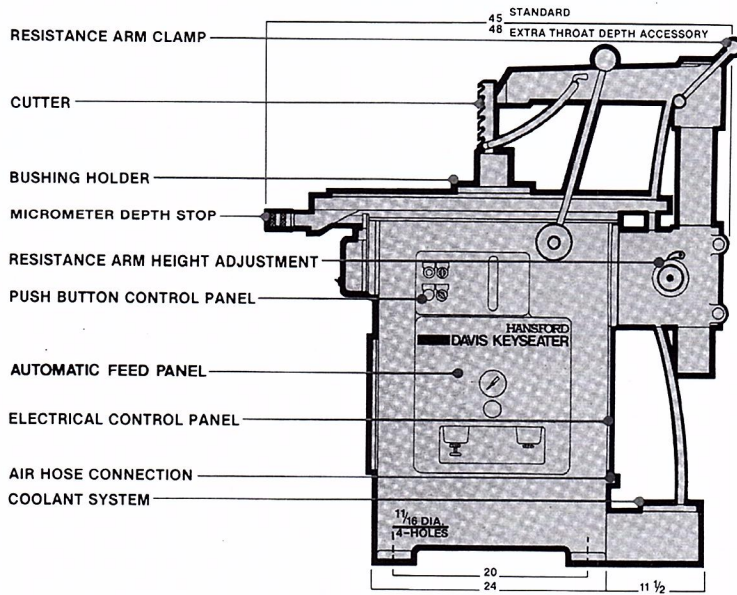
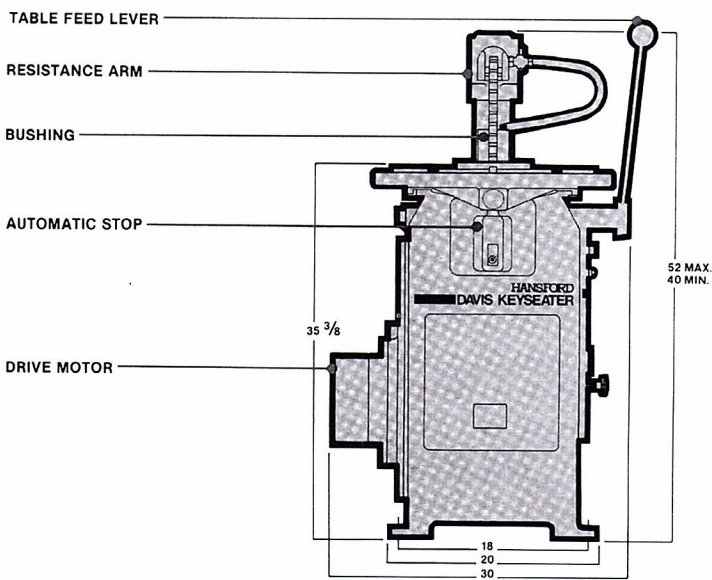
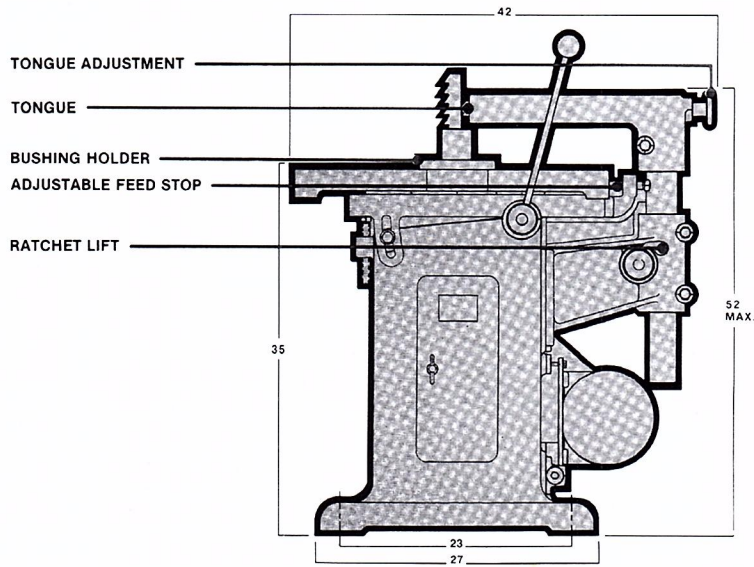
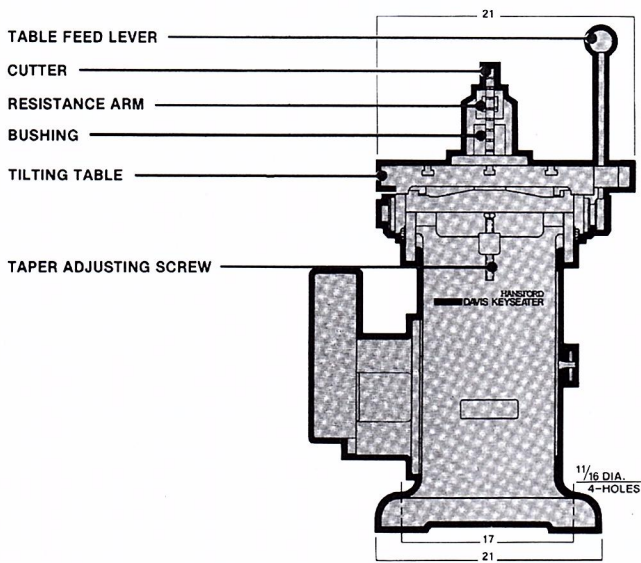
Cutters for keyway sizes from 1/16" to 3/4" (DA-17) and from 7/8" to 1 1/2" (DA-18). See price list DKS-2A for detailed list of cutter sizes in set.



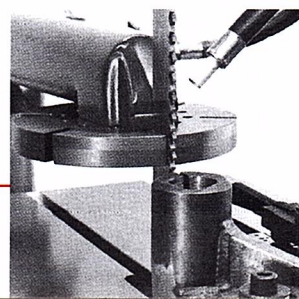
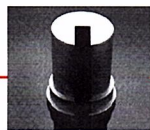
Bushing Sets

For use with cutter sets, see price list DKS-2A for details

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Metal Slotting



Specifications

	Model 15	Model 5
Keyway Cutting Capacity (in steel)	1/16" - 1 1/2"	1/16" - 1 1/2"
Throat Depth		
From face of 1" wide cutter to armpost	19"	18 3/4"
With special assembly	22" (DA-60)	21 3/4" (DA-13)
Maximum height of work		
From table surface	12"	12"
With special arm post	18" (D-1701)	18" (D-524)
Maximum length of cut (with 3/4" bushing holder)		
16" long cutter	4"	3"
20" long cutter	8"	7"
24" long cutter	12"	11"
30" long cutter	18" (DA-61)	17" (DA-48)
Table size	20" x 31"	21" x 31"
Table movement	1 1/2"	1 3/8"
Stroke	4 1/2"	4 1/2"
Strokes per minute	STD:44, 12-56 w/ DA27	48
Air pressure required for automatic feed	minimum 80 psi	N/A
Air consumption	3 SCFM	N/A
Motor HP	2	2
Number of T slots in table	3	3
Maximum included taper cut per foot	-	3"
Net weight	1,250 lbs.	1,200
Gross weight		
Domestic crating	1,350 lbs.	1,300 lbs.
Export crating	1,550 lbs.	1,500 lbs.
Dimensions of shipping crate (domestic)	40 1/2" x 43 1/2" x 48"	40 1/2" x 43 1/2" x 48"

protect
your
investment

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