



## TECMATOR INSTALLATION MACHINES



### **Tried-and-tested technology for fast and safe working.**

The value of a movement system is a combination of many factors. In addition to the visual and functional characteristics, the focus is on durable and consistent quality and the possibility of efficient assembly. With this in mind, GRASS offers professional installation and assembly aids for all product families – individually designed to suit our customers' production technology.










ASSEMBLY TECHNOLOGY

Tecmator – the ideal machine for cabinet makers,  
shop fitters and for small series production.



# ASSEMBLY TECHNOLOGY

Installation and assembly aids. Tried-and-tested machinery for professional efficiency.

	Product description	Page
	<p><b>Tecmator COMBI</b></p> <ul style="list-style-type: none"> <li>• 23-spindle vertical drilling gear, 90° swivel action</li> <li>• 19-spindle horizontal drilling gear</li> <li>• Machine base incl. drawer</li> <li>• Extensive range of accessories</li> </ul>	760
	<p><b>Tecmator FLEXI</b></p> <ul style="list-style-type: none"> <li>• 22-spindle vertical drilling gear, 90° swivel action</li> <li>• 3-spindle horizontal drilling gear</li> <li>• Extensive range of accessories</li> <li>• Very maintenance friendly</li> </ul>	764
	<p><b>Tecmator MULTI</b></p> <ul style="list-style-type: none"> <li>• 14-spindle vertical drilling gear, 90° swivel action</li> <li>• 3-spindle horizontal drilling gear</li> <li>• Connections for plastic dust extraction</li> <li>• Extensive range of accessories</li> </ul>	768
	<p><b>Tecmator ECO V</b></p> <ul style="list-style-type: none"> <li>• Different vertical drilling gears available</li> <li>• Pneumatic hold-down blocks</li> <li>• Connection for plastic dust extraction</li> <li>• Extensive range of accessories</li> </ul>	772
	<p><b>Tecmator ECO P</b></p> <ul style="list-style-type: none"> <li>• 5-spindle vertical drilling gear</li> <li>• Pneumatic hold-down blocks</li> <li>• Connection for plastic dust extraction</li> <li>• Extensive range of accessories</li> </ul>	776
	<p><b>Tecmator ECO M</b></p> <ul style="list-style-type: none"> <li>• 5-spindle vertical drilling gear</li> <li>• No compressed air required</li> <li>• Connection for plastic dust extraction</li> <li>• Extensive range of accessories</li> </ul>	780
	<p><b>Tecmator ZP-XP</b></p> <ul style="list-style-type: none"> <li>• For all DWD XP drawer types</li> <li>• For large series production</li> <li>• Adjustment with pneumatic clamping</li> <li>• Very simple maintenance</li> </ul>	784

# TECMATOR COMBI

Ideal for cabinet makers, shop fitters and for larger series production



- Drilling depth stop with scale
- Extendible vertical drilling gear
- Easy, logical handling = efficient operation
- Compact design, sturdy frame construction
- Easy to service

### Standard specification

- Work table 2000 x 650
- Machine stand with drawer
- Connection for dust extraction
- 23-spindle vertical drilling gear including quick-change drill chuck, 90° swivel action
- 19-spindle horizontal drilling gear including quick-change drill chuck
- Side stops, left (2x)/right (2x)
- Hold-down block for insertion die arm
- Scale extensions for left- and right-hand use (4x)
- Stop set tool - 600 mm with 4 stop rings
- Stop set tool - 2000 mm with 5 stop rings
- Stop pins for stop bar (12x)
- Marking gauge/stop set/tool set/operating instructions
- 2nd and 3rd fence/stop system with 2 side stops each

## ORDER INFORMATION

Designation	Voltage	Frequency	Item No.
Tecmator Combi with drilling distance 45 <sup>1</sup>	3 x 400 V	50 Hz	<b>F146077960</b>

<sup>1</sup> Other types on request

## ADVANTAGES

Optimal holding thanks to pneumatic hold-down block



Kinvaro flap systems	46
Hinge systems	81

Easy and accurate working with digital dimension display for Y-axis



Cabinet making accessories	379
Drawer systems	399

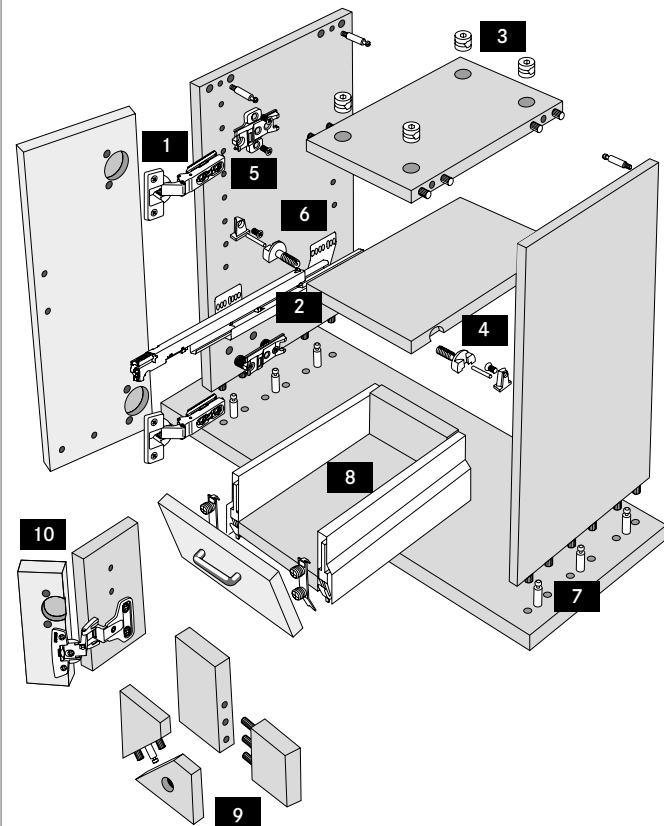
Vertical drilling gear 23-spindle, horizontal drilling gear 19-spindle, both in 32 mm grid



Slide systems	635
Roller systems	701

## APPLICATIONS

One machine for 10 applications



- 1 Furniture hinges: drilling cup holes, press fitting hinges. Can be used for the complete furniture hinge system
- 2 Mounting plates with dowels: drilling and press fitting
- 3 Furniture connectors: horizontal, vertical and face drilling
- 4 Shelf support fittings: face drilling
- 5 Rows of holes: at 32 mm centres, maximum 19 holes.
- 6 Cabinet rails: drilling
- 7 Rows of dowels: drilling
- 8 Drawers + pull-outs: drilling front and back walls (all GRASS slide systems)
- 9 Frame connections - 90° mitre joints:
  - With dowel and eccentric connector
  - Door rebates and decorative profiles with long 16 mm dowels
  - Door frame connections with long 16 mm dowels
- 10 Exposed furniture hinges: drilling cup holes, press fitting hinges

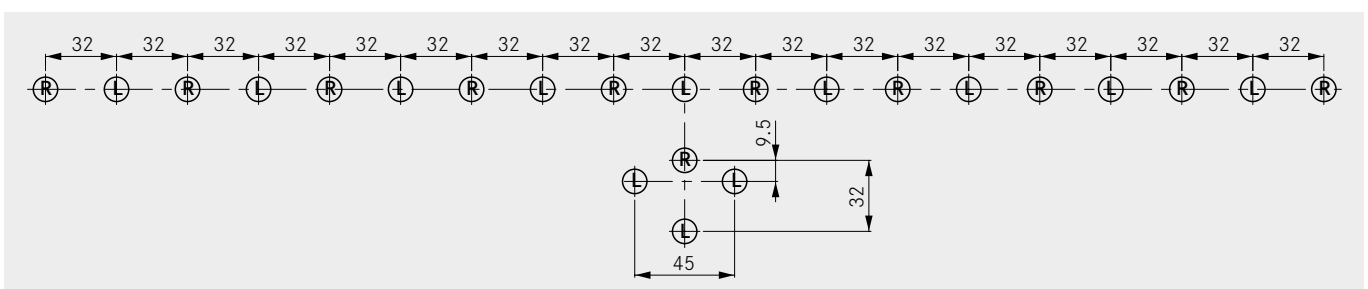
## TECHNICAL DATA

Connections	
Electrical	1.1 kW
Pneumatic	6 bar dry
Dust extraction	2 x Ø 100 mm

Dimensions	
Width	2.00 m
Depth	1.37 m
Height	1.76 m

Weight	
with stand	380 kg

## DRILLING PATTERN




# TECMATOR COMBI

Accessories

## DRILL BITS WITH SHANK Ø 10













	Length of drill bit	Ø of drill bit	Left (red)	Right (black)
	50	2.7	<b>F146090887</b>	<b>F146093569</b>
	57	3	<b>F146038135</b>	<b>F146038136</b>
		5	<b>F146035809</b>	<b>F146035810</b>
		6	<b>F146091572</b>	<b>F146091573</b>
		8	<b>F146035811</b>	<b>F146035812</b>
		10	<b>F146035813</b>	<b>F146035814</b>
		15	<b>F146038178</b>	<b>F146037350</b>
		18	-	<b>F146090928</b>
		20	<b>F146090937</b>	<b>F146090938</b>
		22	-	<b>F146090927</b>
		25	-	<b>F146091070</b>
		26	-	<b>F146094554</b>
30	-	<b>F146090926</b>		
35	<b>F146093091</b>	<b>F146035818</b>		
35.2	-	<b>F146091661</b>		
40	-	<b>F146093093</b>		
	57	8	<b>F146090660</b>	<b>F146090661</b>
		10	<b>F146090662</b>	<b>F146090663</b>
	75	6	<b>F146091762</b>	<b>F146091763</b>
		8	<b>F146038313</b>	<b>F146037351</b>
		10	<b>F146089586</b>	<b>F146038869</b>
	75	6/15	-	<b>F146038369</b>
		8/19	<b>F146090929</b>	<b>F146033402</b>
	100	16	<b>F146030269</b>	<b>F146030270</b>

## INSERTION DIES

	Designation	Item No.
	Nexis 110°	<b>F146095561</b>
	Nexis uni 110°+170°	<b>F146095563</b>
	Mounting plate Nexis/linear plate H0+H3	<b>F146095564</b>
	Front holder DWD XP	<b>F146109858</b>
	Front hook Nova Pro H90	<b>F146092514</b>
	Tiomos 110°	<b>F146101310</b>
	Mounting plate Tiomos/linear plate	<b>F146101312</b>

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ACCESSORIES

	Designation	Item No.
	Stop pins (12x) <sup>1</sup>	<b>F146089748</b>
	Stops for 2nd stop system, left (2x) <sup>1</sup>	<b>F146093314</b>
	Stops for 2nd stop system, right (2x) <sup>1</sup>	<b>F146094292</b>
	Quick-change drill chuck (42x) <sup>1</sup>	<b>F146093200</b>
	Detaching tool for quick-change drill chuck (1x) <sup>1</sup>	<b>F146091094</b>
	Hold-down block (1x) <sup>1</sup>	<b>F146094342</b>
	Pendulum stop for back wall drilling	<b>F146094339</b>
	Revolver stop, triple stop	<b>F146093384</b>
	Zero point wooden block (1x) <sup>1</sup>	<b>F146094486</b>
	Marking gauge (1x) <sup>1</sup>	<b>F146038207</b>
	Table insert plates (2x) <sup>1</sup>	<b>F146093300</b>
	Scale extensions type 1, 360 - 1360 (4x) <sup>1</sup>	<b>F146094204</b>
	Scale extension type 2, 1360 - 2360	<b>F146037536</b>
	Stop set tool, length 600, 4 stop rings (1x) <sup>1</sup>	<b>F146093316</b>
	Stop set tool, length 2000, 5 stop rings (1x) <sup>1</sup>	<b>F146093315</b>
	Stop set (1x) <sup>1</sup>	<b>F146000619</b>

<sup>1</sup> Included in the standard specification