BIG DAISHOWA

MAXIMUM PERFORMANCE

Selected tools for Brother Speedio machines

brother
at your side

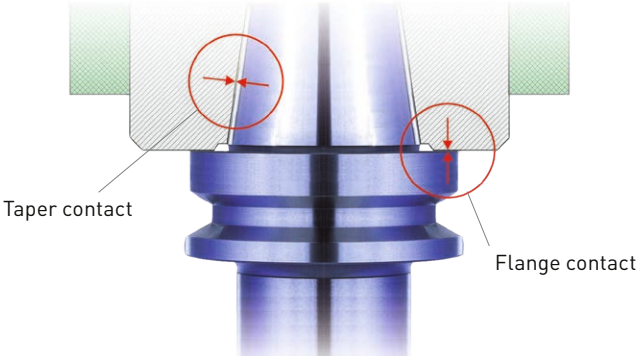
BIG-PLUS spindle is standard in SPEEDIO

BIG-PLUS® SPINDLE SYSTEM DUAL CONTACT

The BIG-PLUS® spindle system exceeds all other interface concepts thanks to simultaneous taper and face contact between machine spindle and tool holder. Furthermore the system offers full interchangeability with existing machines and tool holders.

In a first step a taper contact is resulting during entering the tool into the machine spindle. Due to the pull-in force the tool taper expands the spindle in the elastic range. The tool is pulled further into the spindle until the tool flange reaches the surface of the spindle nose.

Advantages
- Improved surface finish & dimensional accuracy
- Extended tool life
- Prevention of fretting corrosion caused by heavy cutting
- Improvement of ATC repeatability
- Elimination of Z-axial movement at high speeds
- Improved roundness of boring operation



Basic concept
The BIG-PLUS® Spindle System is based on the most current available standards in JIS B6339(BBT) and DIN 69871(BDV).

A conventional steep taper tool holder is supported on a reference diameter called the gauge face. On the contrary, a BIG-PLUS® tool holder is supported on the flange face, which brings remarkable improvement to rigidity.

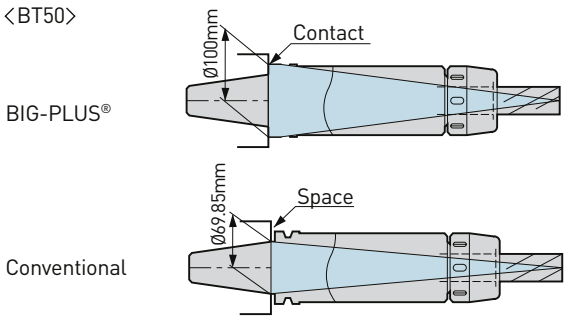
	Conventional	BIG-PLUS®
BT50	Ø 69.85	Ø 100
BT40	Ø 44.45	Ø 63
BT30	Ø 31.75	Ø 46

Perfect interchangeability
BIG-PLUS® tool holders can be used on existing standard machine spindles. Existing standard tool holders can also be used on BIG-PLUS® spindles. In this case, simultaneous contact cannot be attained.

BIG-PLUS® Spindle + BIG-PLUS® Holder — **Contact**

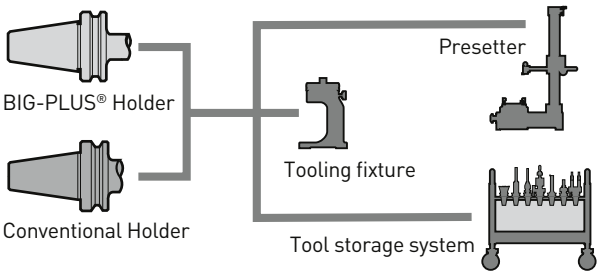
Conventional Spindle + BIG-PLUS® Holder — Clearance

Increased contact diameter (example of BT50)

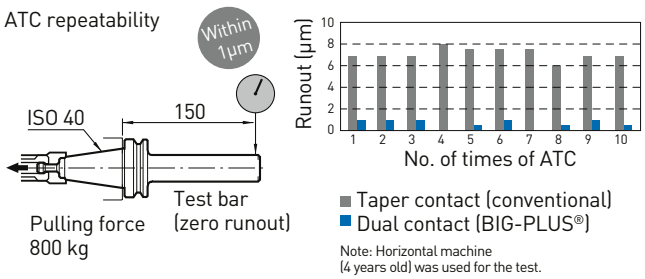


Although other simultaneous contact systems require exclusive new accessories, the BIG-PLUS® spindle uses existing accessories such as a presetter and tool holder fixture as it is based on a conventional steep taper shank. Further, it is not necessary to modify tool magazines and ATC devices of existing machines.

Existing accessories utilized



Improvement of ATC repeatability
The BIG-PLUS® spindle System assures the highest precision location of the tool holder in the spindle when using the ATC for loading tools, as a result of the dual contact which precisely positions the tool holder within 1 micron.



Note: Horizontal machine (4 years old) was used for the test.

Content

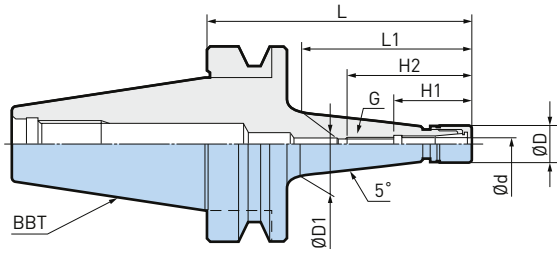
Collet Chuck	MEGA Micro Chuck	**4**
	MEGA New Baby Chuck	**5**
	New Baby Chuck Extra Short	**6**
Milling Chuck	MEGA Double Power Chuck	**7**
	New Hi-Power Milling Chuck	**8**
	Accessories	**9**
Hydraulic Chuck	Super Slim, Jet Through and Standard	**10-11**
Tapping Holder	MEGA Synchro Tapping Holder Body	**12**
	Tapping Holder	**13-14**
	Tapping Holder MGT3	**15**
Side Lock Holder	ISL and TSL	**16**
Shrink Fit Holder	Standard and Slim	**17**
Milling Arbor	Face Mill FMH and Screw-On Holder	**18**
Profit Makers	Angle Head Lightweight	**19**
	Air Turbine Spindle	**20**
Indexable cutting tool	Full Cut Mill FCR and FCM	**21-22**
	Surface Mill and C-cutter Mini	**23**
	Inserts	**24-25**
Machine instruments	Dyna Test, Pull Stud Bolt and Tooling Mate	**26**
Turning Tool	Turning body	**27-29**
	Cartridge	**28,29**

* All Toolholder are designed for Center Trough coolant.

Please use the model name for inquiries and orders.
(e.g. BBT30-MEGA3S-45T)

MEGA Micro Chuck Type T

Tapered and slim design, minimal interference combined with maximized rigidity.



ø0.45 - 8.05mm

Model	Article No.	Ød	ØD	ØD1	L	L1	H1	H2	G	max. min-1	Collet Model	Nut Model	Weight (kg)
BBT30-MEGA3S-45T	969.209	0.45 - 3.25	10	11.5	45	20	22	38	M4 P0.7	40,000	NBC3S	MGN3S	0.39
BBT30-MEGA3S-75T	969.210	0.45 - 3.25	10	16	75	48	22	38	M4 P0.7	33,000	NBC3S	MGN3S	0.41
BBT30-MEGA3S-90T	969.211	0.45 - 3.25	10	18.5	90	63	22	38	M4 P0.7	26,000	NBC3S	MGN3S	0.45
BBT30-MEGA3S-105T	969.212	0,45 - 3,25	10	21	105	78	22	38	M4 P0.7	21,000	NBC3S	MGN3S	0.48
BBT30-MEGA4S-60T	969.213	0,45 - 4,05	12	15	60	33	26,5	47	M5 P0.8	40,000	NBC4S	MGN4S	0.42
BBT30-MEGA4S-75T	969.214	0.45 - 4.05	12	17.5	75	48	26.5	47	M5 P0.8	40,000	NBC4S	MGN4S	0.44
BBT30-MEGA4S-90T	969.215	0.45 - 4.05	12	20	90	63	26.5	47	M5 P0.8	30,000	NBC4S	MGN4S	0.47
BBT30-MEGA4S-105T	969.316	0,45 - 4,05	12	20	105	78	26,5	47	M5 P0.8	24,000	NBC4S	MGN4S	0.52
BBT30-MEGA4S-120T	969.217	0,45 - 4,05	12	25.5	120	93	26,5	47	M5 P0.8	20,000	NBC4S	MGN4S	0.57
BBT30-MEGA6S-60T	969.218	0.45 - 6.05	14	16.5	60	33	28.5	49	M7 P0.75	40,000	NBC6S	MGN6S	0.42
BBT30-MEGA6S-75T	969.319	0.45 - 6.05	14	19	75	48	28.5	49	M7 P0.75	40,000	NBC6S	MGN6S	0.44
BBT30-MEGA6S-90T	969.220	0.45 - 6.05	14	22	90	63	28.5	49	M7 P0.75	35,000	NBC6S	MGN6S	0.48
BBT30-MEGA6S-105T	969.221	0.45 - 6.05	14	24.5	105	78	28.5	49	M7 P0.75	28,000	NBC6S	MGN6S	0.51
BBT30-MEGA6S-120T	969.222	0.45 - 6.05	14	22	120	93	28.5	49	M7 P0.75	23,000	NBC6S	MGN6S	0.59
BBT30-MEGA8S-75T	803.597	2.95 - 8.05	18	23	75	48	31	50.5	M9 P0.75	40,000	NBC8S	MGN8S	0.48
BBT30-MEGA8S-105T	803.598	2.95 - 8.05	18	28	105	78	31	50.5	M9 P0.75	30,000	NBC8S	MGN8S	0.59

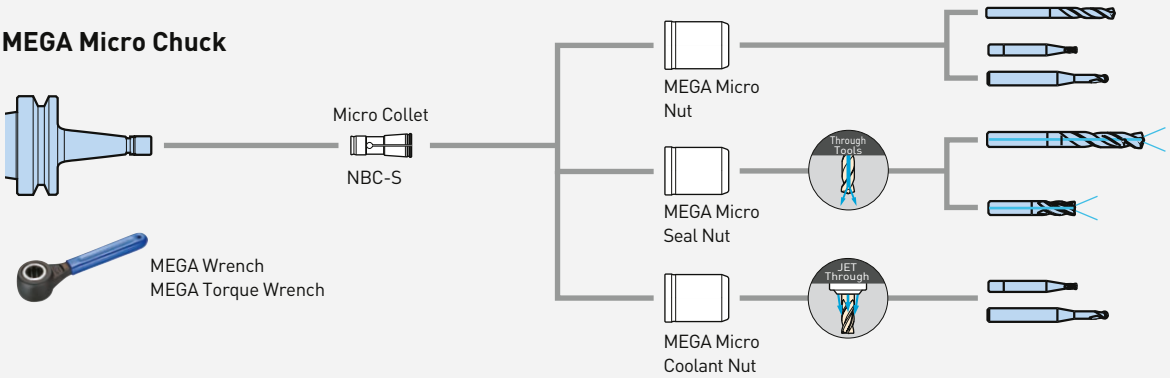
1. MEGA nut is included in delivery.

MEGA Micro Chuck - Accessories & Spare Parts

Spare Parts			Accessories						
	MEGA Nuts		MEGA Wrench		Micro Collets	Micro Seal Nuts	MEGA Micro Coolant Nuts	Taper Cleaners	
MEGA Micro Chuck	Model	Order No.	Model	Order No.	Model	Model	Model	Model	Order No.
MEGA3S	MGN3S	969.480	MGR10	969.449	NBC3S-Ød	MGN3S-PSØd	MGN3S-ØdJ	SC-NBC3S	961.278
MEGA4S	MGN4S	969.481	MGR12	969.450	NBC4S-Ød	MGN4S-PSØd	MGN4S-ØdJ	SC-NBC4S	961.279
MEGA6S	MGN6S	969.482	MGR14	969.452	NBC6S-Ød	MGN6S-PSØd	MGN6S-ØdJ	SC-NBC6S	961.280
MEGA8S	MGN8S	804.108	MGR18	801.705	NBC8S-Ød	MGN8S-PSØd	MGN8S-ØdJ	SC-NBC8S	805.827

1. **Ød** corresponds to the diameter of the tool shank and must be specified when ordering.

MEGA Micro Chuck



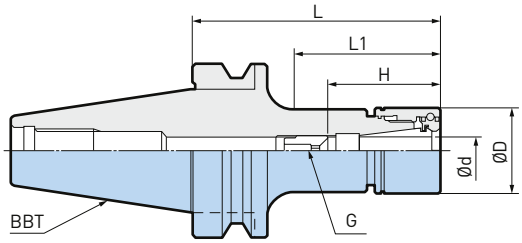
Micro Collets

Micro Seal Nuts

MEGA Micro Coolant Nuts

MEGA New Baby Chuck

Ideal ultra precision collet holders for high speed machining. A wide range of lengths and a variety of collet series covers all machining applications.

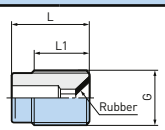


ø0.25 - 20mm

Model	Article No.	Ød	ØD	L	L1	H	max. min-1	Collet Model	Nut Model	Weight (kg)
BBT30-MEGA6N-60	969.509	0.25 - 6	20	60	32	23 - 43	40,000	NBC6	MGN6	0.45
BBT30-MEGA6N-90	969.510	0.25 - 6	20	90	62	23 - 43	30,000	NBC6	MGN6	0.51
BBT30-MEGA6N-120	969.343	0.25 - 6	20	120	90	23 - 43	18,000	NBC6	MGN6	0.55
BBT30-MEGA8N-60	969.511	0.5 - 8	25	60	34	26 - 45	40,000	NBC8	MGN8	0.49
BBT30-MEGA8N-90	969.512	0.5 - 8	25	90	64	26 - 45	30,000	NBC8	MGN8	0.58
BBT30-MEGA8N-120	969.346	0.5 - 8	25	120	92	26 - 45	18,000	NBC8	MGN8	0.67
BBT30-MEGA10N-60	969.513	1.5 - 10	30	60	34	38 - 48	40,000	NBC10	MGN10	0.52
BBT30-MEGA10N-90	969.534	1.5 - 10	30	90	64	38 - 48	25,000	NBC10	MGN10	0.66
BBT30-MEGA10N-120	978.207	1.5 - 10	30	120	94	38 - 48	15,000	NBC10	MGN10	0.78
BBT30-MEGA13N-60	969.516	2.5 - 13	35	60	34	44 - 63	40,000	NBC13	MGN13	0.54
BBT30-MEGA13N-75	969.349	2.5 - 13	35	75	49	44 - 63	30,000	NBC13	MGN13	0.64
BBT30-MEGA13N-90	969.517	2.5 - 13	35	90	64	44 - 63	25,000	NBC13	MGN13	0.73
BBT30-MEGA13N-105	969.350	2.5 - 13	35	105	79	44 - 63	18,000	NBC13	MGN13	0.82
BBT30-MEGA13N-120	969.518	2.5 - 13	35	120	94	44 - 63	15,000	NBC13	MGN13	0.93
BBT30-MEGA16N-60	969.519	2.5 - 16	42	60	37	48 - 63	35,000	NBC16	MGN16	0.57
BBT30-MEGA16N-75	969.351	2.5 - 16	42	75	52	48 - 68	25,000	NBC16	MGN16	0.70
BBT30-MEGA16N-90	969.520	2.5 - 16	42	90	67	48 - 68	20,000	NBC16	MGN16	0.85
BBT30-MEGA16N-105	969.352	2.5 - 16	42	105	82	48 - 68	18,000	NBC16	MGN16	1.00
BBT30-MEGA20N-60 *	969.521	2.5 - 20	46	60	-	70	30,000	NBC20	MGN20	0.60
BBT30-MEGA20N-75	969.353	2.5 - 20	46	75	-	51 - 68	20,000	NBC20	MGN20	0.75
BBT30-MEGA20N-90	969.522	2.5 - 20	46	90	-	51 - 68	15,000	NBC20	MGN20	0.92
BBT30-MEGA20N-105	969.354	2.5 - 20	46	105	-	51 - 68	13,000	NBC20	MGN20	1.10

1. MEGA nut is included in delivery.
2. * Adjusting screw cannot be used.
3. "H" is the max. tool shank length that can be inserted for these models.
4. "G" is the adjusting screw (optional).

MEGA New Baby Chuck - Accessories & Spare Parts

Spare Parts			Accessories								
	MEGA Nuts		MEGA Wrench		Collets NBC	MEGA Perfect Seals	Adjusting Screws 				
MEGA New Baby Chuck	Model	Order No.	Model	Order No.	Model	Model	Model	G	L	B	Order No.
MEGA6N	MGN6	969.483	MGR20	969.454	NBC6-Ød	MPS6-Ød	NBA6B	M7	12	2	961.527
MEGA8N	MGN8	969.484	MGR25	969.456	NBC8-Ød	MPS8-Ød	NBA8B	M9	13	2.5	961.550
MEGA10N	MGN10	969.485	MGR30	969.458	NBC10-Ød	MPS10-Ød	NBA10B	M11	16	3	961.572
MEGA13N	MGN13	969.486	MGR35	969.460	NBC13-Ød	MPS13-Ød	NBA13B	M14	20	4	961.598
MEGA16N	MGN16	969.487	MGR42	969.462	NBC16-Ød	MPS16-Ød	NBA16B	M18	20	4	961.632
MEGA20N	MGN20	969.488	MGR46	969.465	NBC20-Ød	MPS20-Ød	NBA20B	M21	20	4	961.680

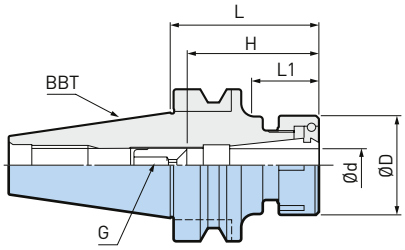
1. Ød corresponds to the diameter of the tool shank and must be specified when ordering.
2. MEGA Perfect Seal increases the sealing performance of the MEGA New Baby Chuck.

Collets NBC

MEGA Perfect Seal

New Baby Chuck Extra Short

A high precision collet chuck to perform all machining applications.

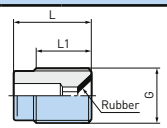


ø1.5 - 16mm

Model	Article No.	Ød	ØD	L	L1	H	Collet Model	Nut Model	Weight (kg)
BBT30-NBS10-45	100007.001.0	1.5 - 10	30	45	20	35 - 45	NBC10	NBN10	0.44
BBT30-NBS13-45	100007.002.0	2.5 - 13	35	45	21	41 - 53	NBC13	NBN13	0.43
BBT30-NBS16-45	100007.003.0	2.5 - 16	42	45	21	45 - 53	NBC16	NBN16	0.43

1. BIG-PLUS® tools can be used in machining centers with non BIG-PLUS® spindles.
2. New Baby Nut is included.
3. "H" is the max. tool shank length that can be inserted for these models.
4. "G" is the adjusting screw (optional).

New Baby Chuck - Accessories & Spare Parts

Spare Parts			Accessories								
	New Baby Nuts		New Baby Wrench		Collets NBC	Baby Perfect Seals	Adjusting Screws 				
New Baby Chuck	Model	Order No.	Model	Order No.	Model	Model	Model	G	L	B	Order No.
NBS10	**NBN10**	961.571	**NBK10**	961.570	**NBC10-Ød**	**BPS10-Ød**	**NBA10B**	M11	16	3	961.572
NBS13	**NBN13**	961.597	**NBK13**	961.596	**NBC13-Ød**	**BPS13-Ød**	**NBA13B**	M14	20	4	961.598
NBS16	**NBN16**	961.631	**NBK16**	961.630	**NBC16-Ød**	**BPS16-Ød**	**NBA16B**	M18	20	4	961.632

1. **Ød** corresponds to the diameter of the tool shank and must be specified when ordering.
2. Baby Perfect Seals increases the sealing performance of the New Baby Chuck.

Collets NBC

Baby Perfect Seals

Collet Ejectors

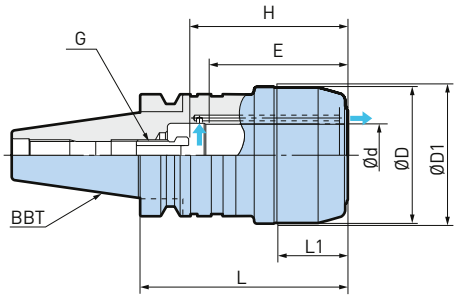
Model	Order No.	Nut Model	Collet Model
NBC6-CE	969.492	MGN6 / NBN6	NBC6
NBC8-CE	969.493	MGN8 / NBN8	NBC8
NBC10-CE	969.494	MGN10 / NBN10	NBC10
NBC13-CE	969.495	MGN13 / NBN13	NBC13

Taper Cleaners

Model	Article No.	Suitable for model
SC-NBC6	961.281	MEGA6N / NBS6
SC-NBC8	961.282	MEGA8N / NBS8
SC-NBC10	961.283	MEGA10N / NBS10
SC-NBC13	961.284	MEGA13N / NBS13
SC-NBC16	961.285	MEGA16N / NBS16
SC-NBC20	961.286	MEGA20N / NBS20

MEGA Double Power Chuck Type DS

Flange contacting nut assures highest rigidity. Unique coolant supply design ensures efficient coolant supply to the cutting tool peripherally.



ø3 - 20mm

Model	Article No.	Ød	ØD	ØD1	L	L1	L2	H	E	max. min-1	Wrench	Weight (kg)
BBT30-MEGA12DS-58	100006.004.0	12	38	43	59	25	33	61	43	30,000	MGR38	0.65
BBT30-MEGA16DS-60	978.030	16	46	47	62.5	28	-	64	50	30,000	MGR46L	0.73
BBT30-MEGA20DS-65 *	978.184	20	50	51	67.5	33	-	62	52	25,000	MGR50L	0.78

1. Wrench and axial adjusting screw are to be ordered separately.
2. "E" is the min. clamping length.
3. "H" is the max. tool shank length that can be inserted for these models.
4. "G" is the adjusting screw (optional).
5. * Adjustable straight collet (C20-_+CS) and OCA collet cannot be used.

MEGA12DS is ideal for Trochoidal milling

High Speed & High Performance MEGA DOUBLE POWER CHUCK ø12mm diameter clamping series is now available

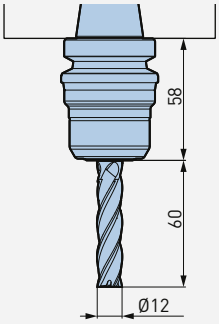
High gripping force, 3-times greater than collet chuck, secures performance with long endmills. Ideal for Trochoidal milling with anti-vibration endmills.

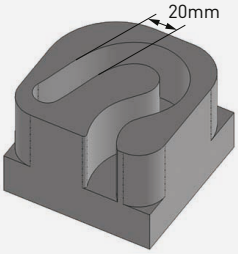
Clamping diameter ø12

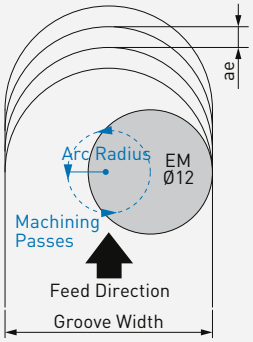
MAX. 30,000min-1

Application Examples

Trochoidal milling







Cutting Conditions

Machine	BBT30 (SPEEDIO)
Holder	BBT30-MEGA12DS-58
Tool	Ø12 carbide damper endmill (4 inserts)
Workpiece material	C55
Spindle speed n	5836 (min-1)
Cutting speed Vc	220 (m/min)
Feed	1868 (mm/min)
Feed rate fz	0.08 (mm/t)
Axial DOC ap	48 (mm)
Radial DOC ae	0.8 (mm)

Result: Stable machining with high cutting parameters without milling cutter fall out.

New Hi-Power Milling Chuck Type S

The original design assures heavy machining with high power and precision.

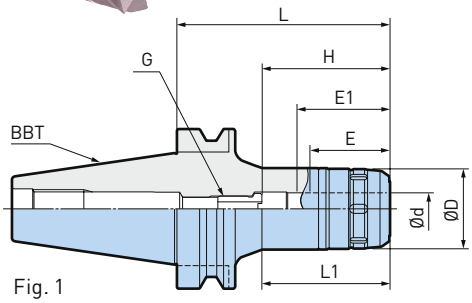


Fig. 1

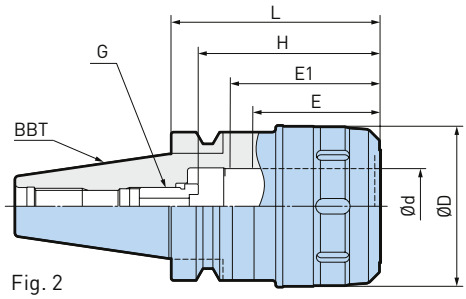


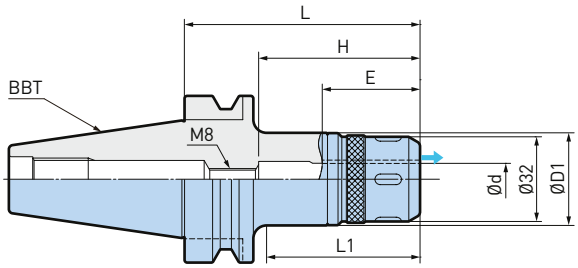
Fig. 2

ø16 - 42mm

Model	Article No.	Fig.	Ød	ØD	L	L1	H	E	E1	Wrench	Weight (kg)
BBT30-HMC16S-70 *	964.101S	1	16	43	70	47	71	48	55	FK45-50L	0.75
BBT30-HMC20S-75	964.102S	2	20	50	75	-	56 - 66	50	56	FK45-50L	0.89
BBT30-HMC25S-90	964.103S	2	25	55	90	-	64 - 74	56	57	FK52-55	1.04
BBT30-HMC32S-105	978.181S	2	32	62	105	-	70 - 80	60	58	FK58-62L	1.34

New Hi-Power Milling Chuck Type HMC12J

Extremely slim and rigid design with jet through coolant.

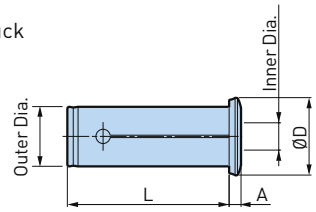


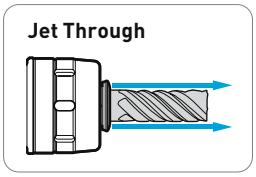
Model	Article No.	Ød	ØD1	L	L1	H	E	Wrench	Weight (kg)
BBT30-HMC12J-60	805.814	12	35	60	38	65	43	FK31-33	0.56

1. Wrench and axial adjusting screw are to be ordered separately.
2. * As a back stop for cutting tools for the HMC16S models, a commercially available hex socket head screw (M8) can be used, without coolant through.
3. "H" is the max. tool shank length that can be inserted for these models.
4. "G" is the adjusting screw (optional).
5. "E" is the min. clamping length.
6. "E1" is the min. clamping length for optimum use with center through coolant.

PJC Collets

For MEGA Double Power Chuck, New Hi-Power Milling Chuck
& Hydraulic Chuck.



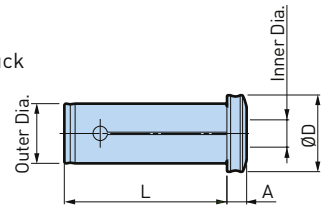


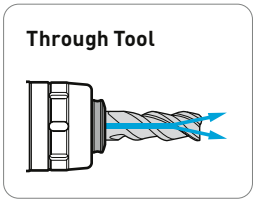
PJC Collets

Straight Collet	Tool Holder
PJC12D - 6, 8, 10	MEGA12DS, HMC12J
PJC16 - 6, 8, 10, 12	MEGA16DS, HMC16S, HDC16, HDC16J
PJC20 - 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16	MEGA20DS, HMC20S, HDC20J
PJC25 - 6, 8, 10, 12, 16, 18, 20	HMC25S
PJC32 - 6, 8, 10, 12, 14, 16, 20, 25	HMC32S

PSC Collets

For New Hi-Power Milling Chuck, MEGA Double Power Chuck
& Hydraulic Chuck.



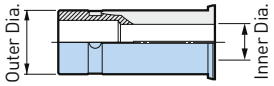


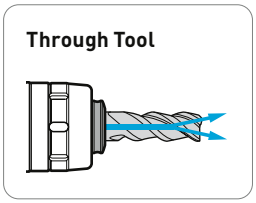
PSC Collets

Straight Collet	Tool Holder
PSC20 - 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16	MEGA20D/DS, HMC20S, HDC20
PSC32 - 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 18, 19, 20, 21, 22, 23, 24, 25	MEGA32D/DS, HMC32S, HDC32

OCA Collets

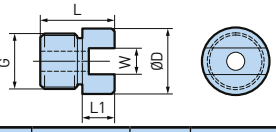
For New Hi-Power Milling Chuck & MEGA Double Power Chuck.





OCA Collets

Straight Collet	Tool Holder
OCA16 - 6, 8, 10, 12	HMC16S, MEGA16D/DS
OCA20 - 6, 8, 10, 12, 14, 16	HMC20S, MEGA20D/DS
OCA25 - 6, 8, 10, 12, 14, 16, 18, 20	HMC25S, MEGA25D/DS
OCA32 - 6, 8, 10, 12, 14, 16, 18, 20, 21, 22, 23, 24, 25, 28	HMC32S, MEGA32D/DS

Accessories											
	MEGA Wrench		Wrench		Adjusting Screws						
Milling Chuck	Model	Order No.	Model	Order No.	Model	ØD	L	L1	G	W	Order No.
BBT30-MEGA12DS	MGR38	100237.003.0	-	-	-	-	-	-	-	-	-
BBT30-MEGA16DS	MGR46L	969.465L	-	-	-	-	-	-	-	-	-
BBT30-MEGA20DS	MGR50L	969.464L	-	-	HMA-M16S	19	27	6	M16P1.5	10	962.312
BBT30-HMC12J	-	-	FK31-33	806.462	-	-	-	-	-	-	-
BBT30-HMC16S	-	-	FK45-50L	801.037	-	-	-	-	-	-	-
BBT30-HMC20S	-	-	FK45-50L	801.037	HMA-M16S	19	27	6	M16P1.5	10	962.312
BBT30-HMC25S	-	-	FK52-55	962.294	HMA-M16S	19	27	6	M16P1.5	10	962.312
BBT30-HMC32S	-	-	FK58-62L	801.038	HMA-M16S	19	27	6	M16P1.5	10	962.312

Hydraulic Chuck Super Slim

Ultra precise hydraulic chuck with extremely slim design.

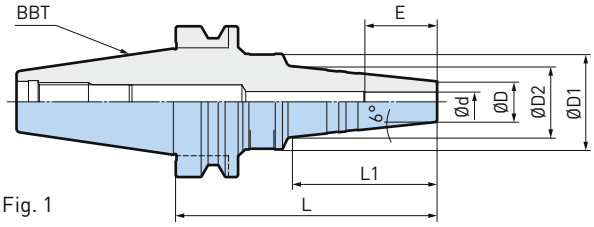


Fig. 1

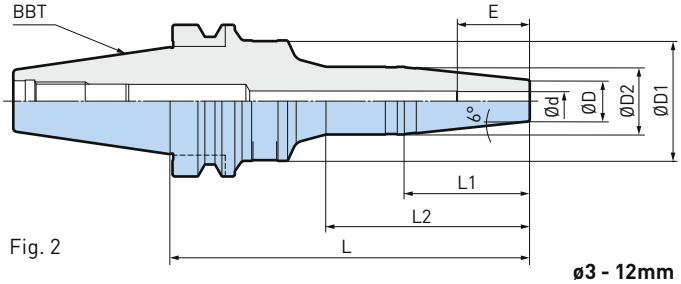


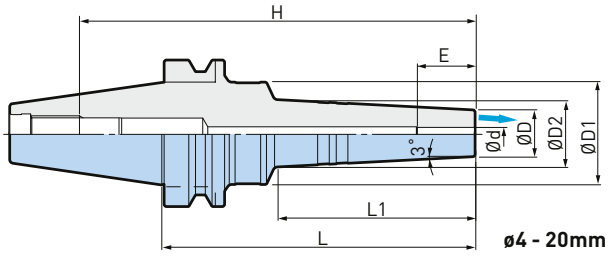
Fig. 2

ø3 - 12mm

Model	Article No.	Fig.	Ød	ØD	ØD1	ØD2	L	L1	L2	E	Weight (kg)
BBT30-HDC3S-60	807.580	1	3	14	42	18	60	19	-	16	0.55
BBT30-HDC3S-90	805.462	1	3	14	42	25	90	50	-	16	0.62
BBT30-HDC4S-60	803.053	1	4	14	46	20	60	28	-	19	0.48
BBT30-HDC4S-90	805.820	1	4	14	42	25	90	50	-	19	0.62
BBT30-HDC6S-60	807.582	1	6	14	42	25	60	19	-	25	0.56
BBT30-HDC6S-90	803.054	1	6	14	42	25	90	50	-	25	0.62
BBT30-HDC6S-120	100010.002.0	2	6	14	42	26	120	57	77	25	0.75
BBT30-HDC8S-90	803.055	1	8	17	42	28	90	50	-	31	0.65
BBT30-HDC8S-120	100010.003.0	2	8	17	42	28	120	52	78	31	0.75
BBT30-HDC10S-90	803.051	1	10	19	44	30	90	50	-	33	0.67
BBT30-HDC10S-120	100010.004.0	2	10	19	44	30	120	52	78	33	0.80
BBT30-HDC12S-90	803.052	1	12	21	46	32	90	50	-	36	0.69
BBT30-HDC12S-120	100010.005.0	2	12	21	46	32	120	52	78	36	0.85

Hydraulic Chuck Jet Through

Coolant or Minimum Quantity Lubrification is supplied to cutting edge securely. Maximum performance and high-precision with 5-axis machining.



ø4 - 20mm

Model	Article No.	Ød	ØD	ØD1	ØD2	L	L1	E	Weight (kg)
BBT30-HDC4J-60	805.077	4	20	46	23	60	28	19	0.50
BBT30-HDC4J-90	807.372	4	20	42	26	90	50	19	0.66
BBT30-HDC6J-90	805.078	6	20	42	26	90	50	25	0.66
BBT30-HDC8J-90	805.079	8	22	42	28	90	50	31	0.68
BBT30-HDC10J-90	805.080	10	24	44	30	90	50	33	0.70
BBT30-HDC12J-90	805.081	12	26	46	32	90	50	36	0.72
BBT30-HDC16J-90	805.480	16	34	46	40	90	49	43	0.83
BBT30-HDC20J-90	805.481	20	38	52	43	90	40	43	0.92

1. Straight collet can be used for HDC16J & 20J size models.
2. Adjusting screw cannot be used.
3. Larger diameter models, HDC16J or bigger are only available with peripheral coolant supply.
4. "E" is the min. clamping length.

Hydraulic Chuck Standard

For high precision machining in automotive, aerospace, medical and die & mold.

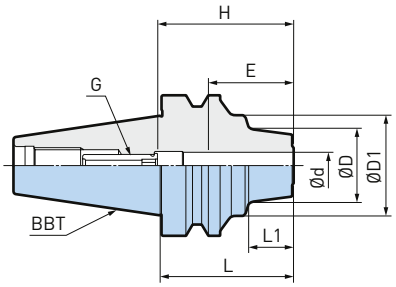


Fig. 1

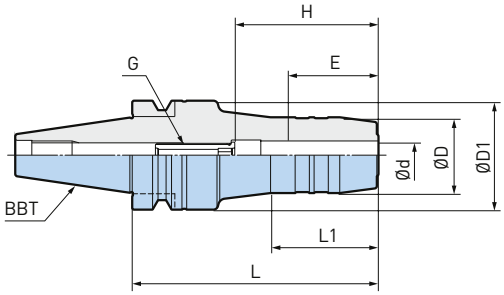


Fig. 2

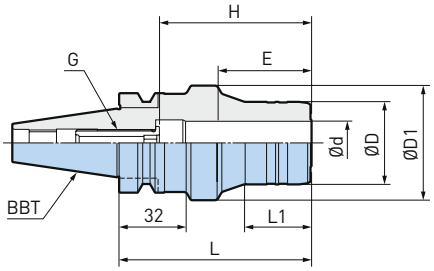


Fig. 3

ø6 - 32mm

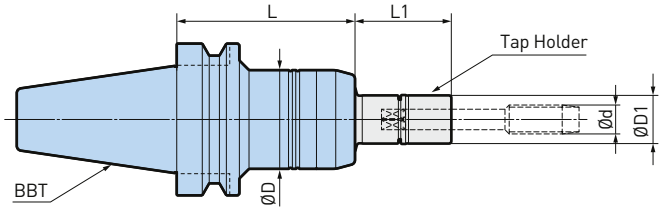
Model	Article No.	Fig.	Ød	ØD	ØD1	L	L1	L2	H	E	G	Weight (kg)
BBT30-HDC6-45	978.071	1	6	30	46	45	7	-	35 - 50	28	HDA6-05020	0.58
BBT30-HDC6-75	978.034	2	6	26	46	75	40	-	28 - 50	28	HDA6-05032	0.64
BBT30-HDC6-90	978.072	2	6	26	46	90	42	57	28 - 50	28	HDA6-05032	0.71
BBT30-HDC6-105	978.073	2	6	26	46	105	43	-	28 - 50	28	HDA6-05032	0.78
BBT30-HDC8-45	978.075	2	8	32	46	45	7	-	35 - 50	28	HDA8-06020	0.58
BBT30-HDC8-75	978.076	2	8	28	46	75	41	-	28 - 50	28	HDA8-06032	0.65
BBT30-HDC8-90	978.077	2	8	28	46	90	44	57	28 - 50	28	HDA6-05032	0.73
BBT30-HDC8-105	978.078	2	8	28	46	105	44	-	28 - 50	28	HDA8-06032	0.81
BBT30-HDC10-45	978.080	1	10	34	46	45	7	-	45 - 55	33	HDA10-08015	0.57
BBT30-HDC10-75	978.081	2	10	30	46	75	36	-	33 - 55	33	HDA10-08032	0.71
BBT30-HDC10-90	978.082	2	10	30	46	90	45	51	33 - 55	33	HDA10-08032	0.79
BBT30-HDC10-105	978.083	2	10	30	46	105	45	-	33 - 55	33	HDA10-08032	0.88
BBT30-HDC12-45	978.085	1	12	36	46	45	7	-	55 - 60	38	HDA12-10010	0.58
BBT30-HDC12-75	978.086	2	12	32	46	75	36	-	38 - 60	38	HDA12-10032	0.72
BBT30-HDC12-90	978.087	2	12	32	46	90	45	51	38 - 60	38	HDA12-10032	0.80
BBT30-HDC12-105	978.088	2	12	32	46	105	45	-	38 - 60	38	HDA12-10032	0.90
BBT30-HDC14-90	978.090	2	14	34	46	90	46	52	38 - 60	38	HDA12-10032	0.82
BBT30-HDC16-45 *	978.092	1	16	42	46	45	7	-	70 - 70	43	-	0.52
BBT30-HDC16-75	978.025	2	16	38	46	75	35	-	43 - 70	43	HDA16-12030	0.74
BBT30-HDC16-90	978.093	2	16	38	46	90	47	-	43 - 70	43	HDA16-12037	0.86
BBT30-HDC16-105	805.550	2	16	38	46	105	47	-	43 - 70	43	HDA16-12037	1.02
BBT30-HDC18-90	978.094	2	18	36	51	90	31	41	43 - 70	43	HDA16-12037	0.90
BBT30-HDC20-60 **	978.095	3	20	38	53	60	-	32	43 - 54	43	HDA16-12030	0.74
BBT30-HDC20-75	978.038	3	20	38	53	75	16	32	46 - 70	43	HDA16-12030	0.81
BBT30-HDC20-90	978.096	2	20	38	38	90	31	41	43 - 70	43	HDA16-12037	0.93
BBT30-HDC25-105	978.097	3	25	55	63	105	44	32	52 - 80	52	HDA25-16039	1.55
BBT30-HDC32-105	978.098	2	32	60	75	105	39	-	56 - 80	56	HDA25-16039	1.70

1. Straight collet (reduction sleeve) is available.
2. "E" is the min. clamping length.
3. "G" is the adjusting screw (optional).
4. "H" is the max. tool shank length that can be inserted for these models.
5. * Adjusting screw cannot be used.
6. ** Straight collet can not be used.

Collet on Page 9

MEGA Synchro Tapping Holder

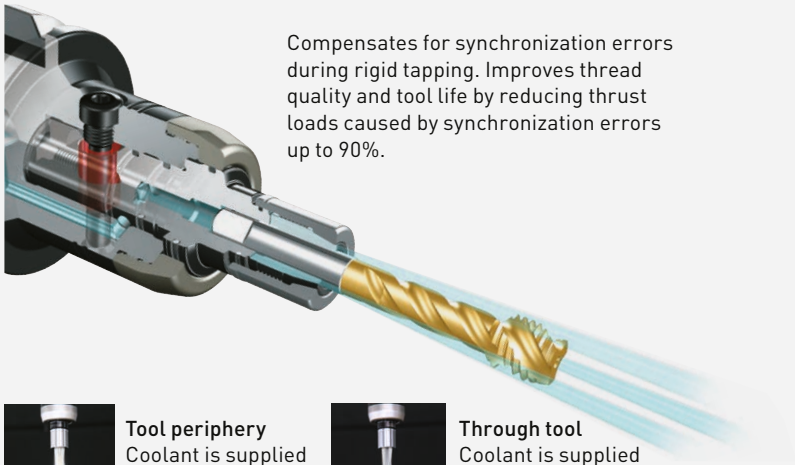
Compensates for synchronization errors during rigid tapping. Improves thread quality and tool life by reducing thrust loads caused by synchronization errors up to 90%.



M2 - M20

Model	Article No.	Tap Holder	Ød	ØD	ØD1	L	L1	Weight (kg)
BBT30-MGT6-70	965.401	MGT6	M2-M8	36	16	70	30 - 200	0.67
BBT30-MGT12-70	965.402	MGT12	M5-M12 / P1/8	41	20	70	30 - 200	0.70
BBT30-MGT20-110	965.403	MGT20	M10-M20 / P1/4-P1/2	54	30	110	35 - 150	1.45

1. BIG-PLUS® tools can be used in machining centers with non BIG-PLUS® spindles.
2. Tap holder is to be ordered separately.
3. Synchronized tapping function is required on the machine.



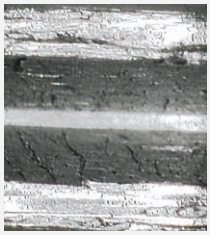
Compensates for synchronization errors during rigid tapping. Improves thread quality and tool life by reducing thrust loads caused by synchronization errors up to 90%.

Tool periphery
Coolant is supplied through slits of the tap holder.

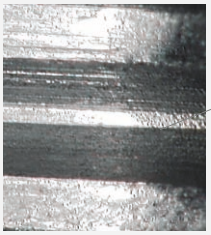
Through tool
Coolant is supplied through both the tool and the slits of tap holder.

Comparison of surface finish
Tapping of exotic materials tends to cause a compressed burr on the thread surface.
BIG KAISER MEGA Synchro compensates for synchronization errors and minimizes cutting load.

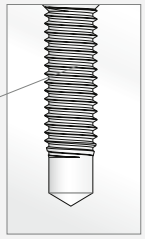
Spiral tap
M5 P0.8 Material : SNCM420(41CrNiMo2)



Collet chuck

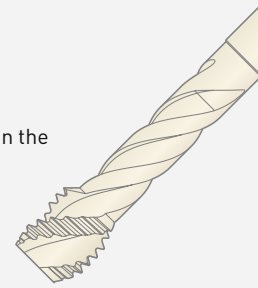


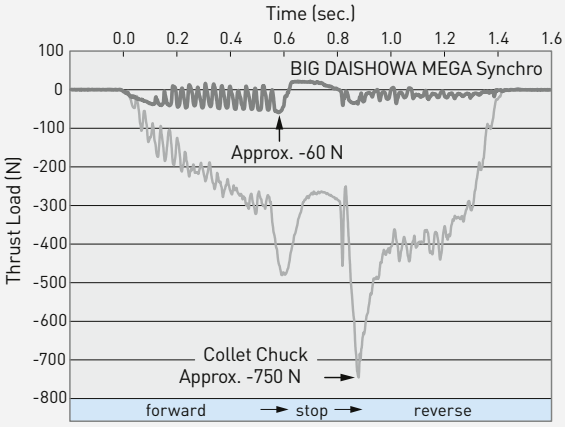
MEGA Synchro



MEGA Synchro Tapping Holder compensates for synchronization errors with any type of tap
Minimized thrust load to both the tap and workpiece improves thread quality and tap life.

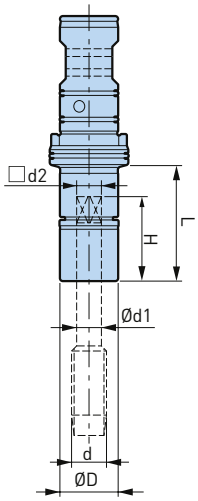
Load to tap – spiral tap
Spiral grooves on spiral tap cause loading in the reverse direction, similar to an end mill.
- M6 P1
- V: 20 m/min (1 060 min^{-1})
- Measured by Kistler dynamometer





Result
MEGA Synchro reduces load to approx. 60N. This is less than 1/10th of the load compared to a collet chuck. Approx. 750N of reversal load is applied to a tap held with a collet chuck.

Tap Holders for MEGA Synchro Tapping Holder DIN



MGT6 (Tap size DIN: M3 - M8; ISO: M3 - M5)

Model	Article No.	Tap Size d DIN 371	Tap Size d DIN 376	Tap Size d ISO 529	Ød1	□d2	ØD	L	H	Weight (kg)
MGT6-031025-30	963.611	-	-	M3	3.15	2.5	16	30	20	0.12
MGT6-031025-70	963.612	-	-	M3	3.15	2.5	16	70	20	0.18
MGT6-031025-100	963.613	-	-	M3	3.15	2.5	16	100	20	0.22
MGT6-031025-150	963.614	-	-	M3	3.15	2.5	16	150	20	0.30
MGT6-035027-30	963.615	M3	M5	-	3.5	2.7	16	30	21	0.12
MGT6-035027-70	963.616	M3	M5	-	3.5	2.7	16	70	21	0.18
MGT6-035027-100	963.617	M3	M5	-	3.5	2.7	16	100	21	0.23
MGT6-035027-150	963.618	M3	M5	-	3.5	2.7	16	150	21	0.30
MGT6-040032-30	963.619	-	-	M4	4	3.15	16	30	21	0.12
MGT6-040032-70	963.620	-	-	M4	4	3.15	16	70	21	0.18
MGT6-040032-100	963.621	-	-	M4	4	3.15	16	100	21	0.22
MGT6-040032-150	963.622	-	-	M4	4	3.15	16	150	21	0.30
MGT6-045034-30	963.623	M4	M6	-	4.5	3.4	16	30	21	0.11
MGT6-045034-70	963.624	M4	M6	-	4.5	3.4	16	70	21	0.18
MGT6-045034-100	963.625	M4	M6	-	4.5	3.4	16	100	21	0.22
MGT6-045034-150	963.626	M4	M6	-	4.5	3.4	16	150	21	0.30
MGT6-050040-30	963.627	-	-	M5	5	4.0	16	30	25	0.11
MGT6-050040-70	963.628	-	-	M5	5	4.0	16	70	25	0.17
MGT6-050040-100	963.629	-	-	M5	5	4.0	16	100	25	0.22
MGT6-050040-150	963.630	-	-	M5	5	4.0	16	150	25	0.29
MGT6-050040-200	963.631	-	-	M5	5	4.0	16	200	25	0.36
MGT6-060049-30	963.632	M5, M6	M8	-	6	4.9	16	30	26	0.11
MGT6-060049-70	963.633	M5, M6	M8	-	6	4.9	16	70	26	0.17
MGT6-060049-100	963.634	M5, M6	M8	-	6	4.9	16	100	26	0.21
MGT6-060049-150	963.635	M5, M6	M8	-	6	4.9	16	150	26	0.29
MGT6-060049-200	963.636	M5, M6	M8	-	6	4.9	16	200	26	0.36

MGT12 (Tap size DIN: M5 - M12; ISO: M6 - M12)

Model	Article No.	Tap Size d DIN 371	Tap Size d DIN 376	Tap Size d ISO 529	Ød1	□d2	ØD	L	H	Weight (kg)
MGT12-060049-30	963.637	M5, M6	M8	-	6	4.9	20	30	28	0.18
MGT12-060049-70	963.638	M5, M6	M8	-	6	4.9	20	70	28	0.28
MGT12-060049-100	963.639	M5, M6	M8	-	6	4.9	20	100	28	0.35
MGT12-060049-150	963.640	M5, M6	M8	-	6	4.9	20	150	28	0.47
MGT12-060049-200	963.641	M5, M6	M8	-	6	4.9	20	200	28	0.59
MGT12-063050-30	963.642	-	-	M6	6.3	5.0	20	30	28	0.18
MGT12-063050-70	963.643	-	-	M6	6.3	5.0	20	70	28	0.28
MGT12-063050-100	963.644	-	-	M6	6.3	5.0	20	100	28	0.35
MGT12-063050-150	963.645	-	-	M6	6.3	5.0	20	150	28	0.47
MGT12-063050-200	963.646	-	-	M6	6.3	5.0	20	200	28	0.58
MGT12-070055-30	963.647	-	M10	-	7	5.5	20	30	28	0.18
MGT12-070055-70	963.648	-	M10	-	7	5.5	20	70	28	0.28
MGT12-070055-100	963.649	-	M10	-	7	5.5	20	100	28	0.35
MGT12-070055-150	963.650	-	M10	-	7	5.5	20	150	28	0.47
MGT12-070055-200	963.651	-	M10	-	7	5.5	20	200	28	0.58
MGT12-080063-30	963.652	M8	-	M8	8	6.3	20	30	29	0.18
MGT12-080063-70	963.653	M8	-	M8	8	6.3	20	70	29	0.27
MGT12-080063-100	963.654	M8	-	M8	8	6.3	20	100	29	0.34
MGT12-080063-150	963.655	M8	-	M8	8	6.3	20	150	29	0.46
MGT12-080063-200	963.656	M8	-	M8	8	6.3	20	200	29	0.58
MGT12-090071-30	963.657	-	M12	M12	9	7.1	20	30	30	0.17
MGT12-090071-70	963.658	-	M12	M12	9	7.1	20	70	30	0.27
MGT12-090071-100	963.659	-	M12	M12	9	7.1	20	100	30	0.33
MGT12-090071-150	963.660	-	M12	M12	9	7.1	20	150	30	0.46
MGT12-090071-200	963.661	-	M12	M12	9	7.1	20	200	30	0.57
MGT12-100080-35	807.211	M10	-	M10	10	8.0	30	35	33	0.26
MGT12-100080-85	807.212	M10	-	M10	10	8.0	30	85	33	0.47
MGT12-100080-115	807.213	M10	-	M10	10	8.0	30	115	33	0.60
MGT12-100080-150	807.214	M10	-	M10	10	8.0	30	150	33	0.75

JIS Size is also available

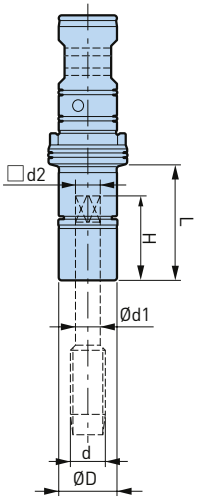
MGT6 -JIS

MGT12 -JIS

1. Nut is included.
2. MEGA wrench is to be ordered separately.

Tap Holders for MEGA Synchro Tapping Holder DIN

Tap Holders MGT20



JIS Size is also available

MGT20 -JIS

MGT20 (Tap size DIN: M10 - M20; ISO: M10 - M20)

Model	Article No.	Tap Size d DIN 371	Tap Size d DIN 376	Tap Size d ISO 529	Ød1	□d2	ØD	L	H	Weight (kg)
MGT20-090071-35	963.662	-	M12	M12	9	7.1	30	35	30	0.53
MGT20-090071-85	963.663	-	M12	M12	9	7.1	30	85	30	0.80
MGT20-090071-115	963.664	-	M12	M12	9	7.1	30	115	30	0.96
MGT20-090071-150	963.665	-	M12	M12	9	7.1	30	150	30	1.15
MGT20-100080-35	963.666	M10	-	M10	10	8.0	30	35	33	0.52
MGT20-100080-85	963.667	M10	-	M10	10	8.0	30	85	33	0.78
MGT20-100080-115	963.668	M10	-	M10	10	8.0	30	115	33	0.94
MGT20-100080-150	963.669	M10	-	M10	10	8.0	30	150	33	1.10
MGT20-110090-35	963.670	-	M14	-	11	9.0	30	35	34	0.51
MGT20-110090-85	963.671	-	M14	-	11	9.0	30	85	34	0.78
MGT20-110090-115	963.672	-	M14	-	11	9.0	30	115	34	0.93
MGT20-110090-150	963.673	-	M14	-	11	9.0	30	150	34	1.10
MGT20-112090-35	963.674	-	-	M14	11.2	9.0	30	35	34	0.51
MGT20-112090-85	963.675	-	-	M14	11.2	9.0	30	85	34	0.78
MGT20-112090-115	963.676	-	-	M14	11.2	9.0	30	115	34	0.93
MGT20-112090-150	963.677	-	-	M14	11.2	9.0	30	150	34	1.10
MGT20-120090-35	963.678	-	M16	-	12	9.0	30	35	34	0.51
MGT20-120090-85	963.679	-	M16	-	12	9.0	30	85	34	0.77
MGT20-120090-115	963.680	-	M16	-	12	9.0	30	115	34	0.93
MGT20-120090-150	963.681	-	M16	-	12	9.0	30	150	34	1.10
MGT20-125100-35	963.682	-	-	M16	12.5	10.0	30	35	35	0.51
MGT20-125100-85	963.683	-	-	M16	12.5	10.0	30	85	35	0.76
MGT20-125100-115	963.684	-	-	M16	12.5	10.0	30	115	35	0.92
MGT20-125100-150	963.685	-	-	M16	12.5	10.0	30	150	35	1.10
MGT20-140110-35	963.686	-	M18	-	14	11.0	30	35	36	0.50
MGT20-140110-85	963.687	-	M18	-	14	11.0	30	85	36	0.75
MGT20-140110-115	963.688	-	M18	-	14	11.0	30	115	36	0.91
MGT20-140110-150	963.689	-	M18	-	14	11.0	30	150	36	1.05
MGT20-140112-35	963.690	-	-	M18, M20	14	11.2	30	35	36	0.50
MGT20-140112-85	963.691	-	-	M18, M20	14	11.2	30	85	36	0.75
MGT20-140112-115	963.692	-	-	M18, M20	14	11.2	30	115	36	0.91
MGT20-140112-150	963.693	-	-	M18, M20	14	11.2	30	150	36	1.08
MGT20-160120-35	805.173	-	M20	-	16	12.0	30	35	37	0.48
MGT20-160120-150	805.172	-	M20	-	16	12.0	30	150	37	1.04

1. Nut is included.
2. MEGA wrench is to be ordered separately.

Synchro Adjuster

For MGT6, MGT12, MGT20, MGT36
Replaceable bushing in tap holder.

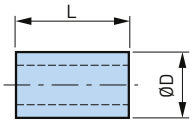


Fig. 1

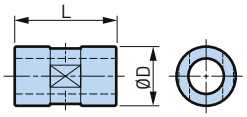


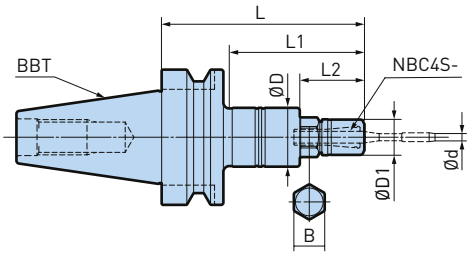
Fig. 2

Model	Article No.	Fig.	ØD	L	Tap Holder
MGT6SAH *	807.197	2	9	11	MGT 6-d-
MGT12SAH *	807.198	2	10	15	MGT 12-d-
MGT20SAH *	807.199	2	14	24	MGT 20-d-
MGT6SA-5P	963.721	1	9	11	MGT 6-d-
MGT12SA-5P	963.722	1	10	15	MGT 12-d-
MGT20SA-5P	963.723	1	14	24	MGT 20-d-

1. Set content 5 pieces.
2. Soft type is included in our standard MEGA Synchro tapping holders.
3. * Hard Type, single piece
4. Hard Type is recommendet for eccentric thread relief tap.

MEGA Synchro Tapping Holder MGT3

For small tapping tools: Type MGT3

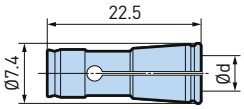


M1 - M3

Model	Article No.	Ød	ØD	ØD1	L	L1	L2	B	Weight (kg)
BBT30-MGT3-70	965.400	M1 - M3	20	12	70	46	22	12	0.46

1. Synchronized tapping function is required on the machine.
2. MEGA nut is included in delivery.
3. MEGA wrench (MGR12) and common spanner (12 mm) are required to clamp/unclamp the tap.

Micro Collet for MGT3

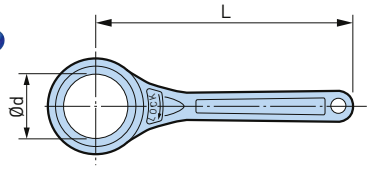


Model		Article No.	Tapping Range			Tap Shank
			DIN 371	ISO 529	JIS	Ød
NBC4S	-2.5AA	961.468	M1 - M1.8	M2		2.50
	-2.8AA	968.353	M2 - M2.6	M2.2, M2.5		2.80
	-3.0AA	961.470	-	-	M1 - M2.6	3.00
	-3.1AA	968.355	-	M3		3.15
	-3.5AA	961.472	M3	-		3.50
	-4.0AA	961.474	-	-	M3	4.00

1. Other sizes available. Please refer to micro collet.

MEGA Wrench

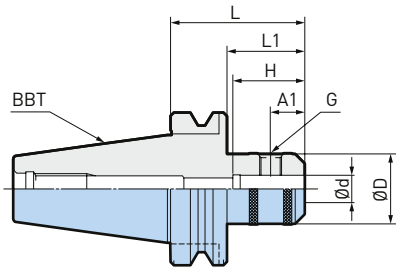
For MGT3, MGT6, MGT12, MGT20



Model	Article No.	Ød	L	Tap Holder
MGR12	969.450	12	90	MGT 3
MGR16	969.446	16	90	MGT 6-d-
MGR20L	969.447	20	160	MGT12-06,-07,-08,-09
MGR30L	969.448	30	220	MGT12-10 / MGT20-d

Side Lock Holders for Weldon

For cutting tools according to DIN 1835 form B.



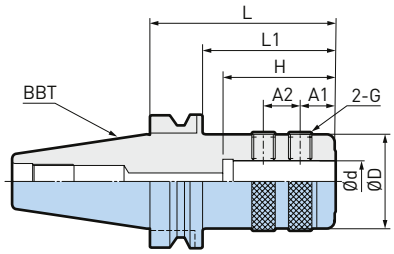
ø6 - 16mm

Model	Article No.	Ød	ØD	L	L1	A1	A2	H	G	Weight (kg)
BBT30-ISL6-60	961.394	6	25	60	38	18	-	85 *	M6	0.50
BBT30-ISL8-60	961.395	8	28	60	38	18	-	85 *	M8	0.52
BBT30-ISL10-60	961.396	10	35	60	38	20	-	45	M10	0.61
BBT30-ISL12-60	961.397	12	42	60	38	22.5	-	48	M12	0.71
BBT30-ISL16-60	966.341	16	48	60	38	24	-	53	M14	0.78

1. Use a cutting tool in accordance to DIN 1835 B/DIN 6535 HB and ISO 5414.
2. "H" is the max. tool shank length that can be inserted for these models.
3. H with * indicates the maximum clamping depth to the Pull Stud Bolt.

Side Lock Holders Type TSL

For side lock drills.



ø16 - 32mm

Model	Article No.	Ød	ØD	L	L1	H	A1	A2	G	Weight (kg)
BBT30-TSL16-75	800.064	16	48	75	-	48	14	14	M10	1.00
BBT30-TSL20-75	978.314	20	48	75	-	50	14	14	M10	0.95
BBT30-TSL25-80	978.315	25	48	80	-	56	15	20	M16	0.93
BBT30-TSL32-85	805.243	32	63	85	-	60	15	20	M16	1.34

1. "H" is the max. tool shank length that can be inserted for these models.
2. Not compatible with Weldon DIN 1835 B / DIN 6535 HB.

Shrink Chuck Standard

Substantial body provides higher rigidity.

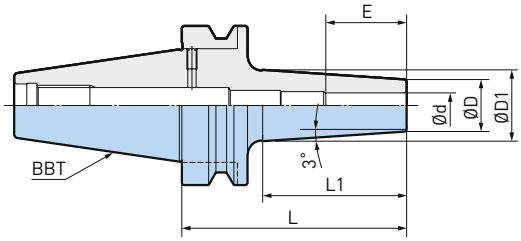


Fig. 1

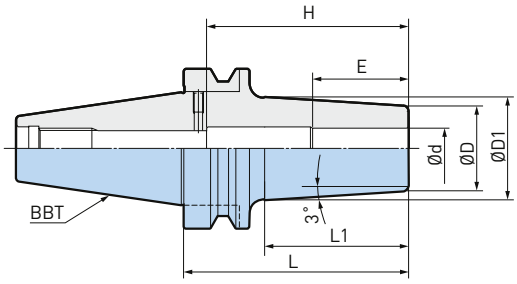


Fig. 2

ø4 -16mm

Model	Article No.	Fig.	Ød	ØD	ØD1	L	L1	H	E	Weight (kg)
BBT30-SRC4-75 *	978.001	1	4	10	15	75	44	-	16	0.50
BBT30-SRC6-75	978.002	1	6	14	19	75	47	-	26	0.50
BBT30-SRC8-75	978.003	1	8	18	23	75	47	-	26	0.50
BBT30-SRC10-75	978.004	2	10	22	27	75	47	62	32	0.60
BBT30-SRC12-75	978.005	2	12	24	29	75	47	72	36	0.60
BBT30-SRC16-75	978.006	2	16	28	33	75	48	80	38	0.60

Shrink Chuck Slim

Slim design reduces outer diameter for machining in tight spaces.

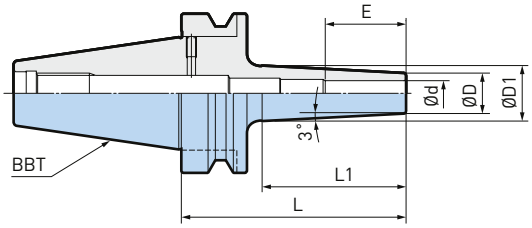


Fig. 1

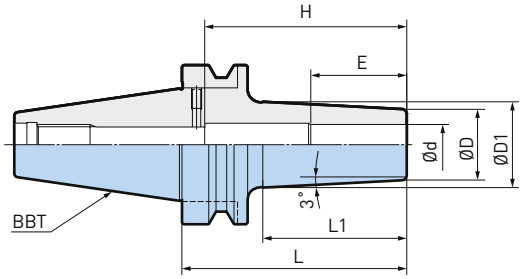


Fig. 2

ø6 - 12mm

Model	Article No.	Fig.	Ød	ØD	ØD1	L	L1	H	E	Weight (kg)
BBT30-SRC6S-105	978.179	1	6	10	18	105	77	129 *	26	0.50
BBT30-SRC8S-105	978.180	1	8	13	21	105	77	129 *	26	0.50
BBT30-SRC10S-105	800.063	2	10	16	24	105	77	62	32	0.60
BBT30-SRC12S-105	978.007	2	12	19	27	105	77	72	36	0.60

1. Use carbide cutter within a tolerance of h6.
2. * Use carbide cutter within a tolerance of h5.
3. Please refer to the operation manual of heating / cooling equipment, as some equipment may not be compatible.
4. "H" is the max. tool shank length that can be inserted for these models.
5. „H" with * indicates the maximum clamping depth to the Pull Stud Bolt.
6. "E" is the min. clamping length.

Face Mill Arbors Type FMH

Coolant ports on the face.

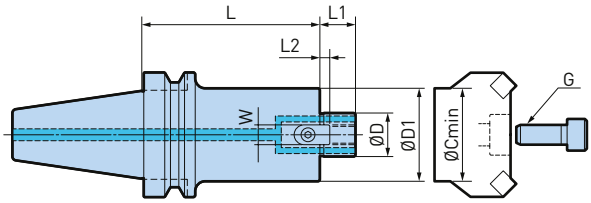
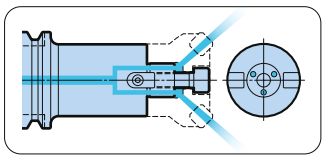


Fig. 1



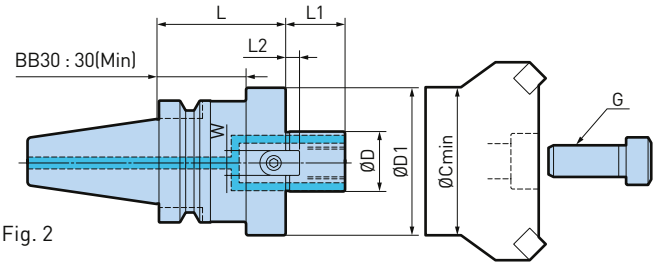


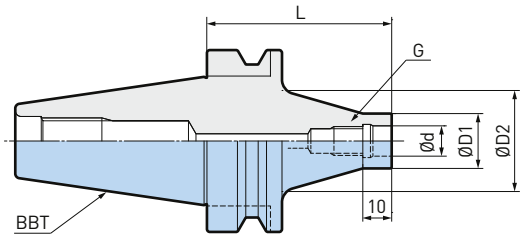
Fig. 2

Model	Article No.	Fig.	ØD	ØD1	L	L1	L2	W	G	ØC min.	Weight (kg)
BBT30-FMH16-37-35	978.326	1	16	37	35	16	5	8	M8	28	0.52
BBT30-FMH22-45-35	-	1	22	45	35	18	5	10	M10	38	0.60
BBT30-FMH22-47-45	978.259	2	22	47	45	18	5	10	M10	38	0.73
BBT30-FMH22-60-45	805.569	2	22	60	45	18	5	10	M10	38	0.87
BBT30-FMH27-45-35	-	1	27	45	35	20	6	12	M12	38	0.64
BBT30-FMH27-60-45	978.273	2	27	60	45	20	6	12	M12	46	0.91

1. Clamp bolt is included.
2. By using a clamping screw with a through bore, coolant is supplied through the screw

Screw-On Holder

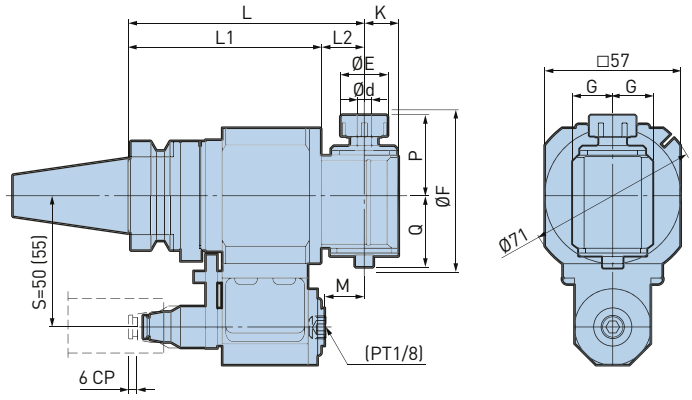
General metric screw-on type cutting tools can be used with these models.



Model	Article No.	Ød	ØD1	ØD2	L	G	Weight (kg)
BBT30-M8-15-50	100019.003.0	8.5	15	30	50	M8	0.45
BBT30-M10-19-45	806.601	10.5	19	35	45	M10	0.45
BBT30-M12-24-40	806.602	12.5	24	40	40	M12	0.45
BBT30-M16-29-35	806.603	17	29	40	35	M16	0.41

BBT30 Angle Head Lightweight

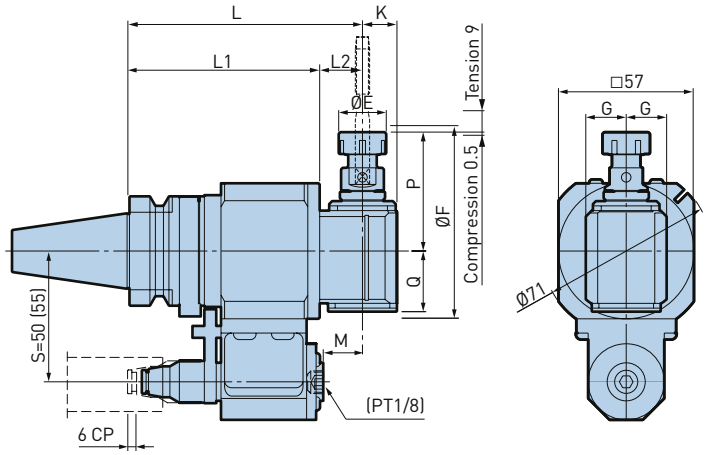
New Baby Type



Model	Article No.	Ød	ØE	ØF	L	L1	L2	G	K	M	P	Q	max. min-1	Collet Model	Weight (kg)	Gewicht (kg)
BBT30-AG90-6-99	101389.001.0	0.25 - 6	20	68	99	81	18	17	14.5	16.5	34	30	6,000	NBC6	1.79	1.790

1. The cutting tool rotates in reverse to the machine spindle.
2. Nut and wrench are included. Collet is to be ordered separately.
3. Stop Block is to be ordered separately.

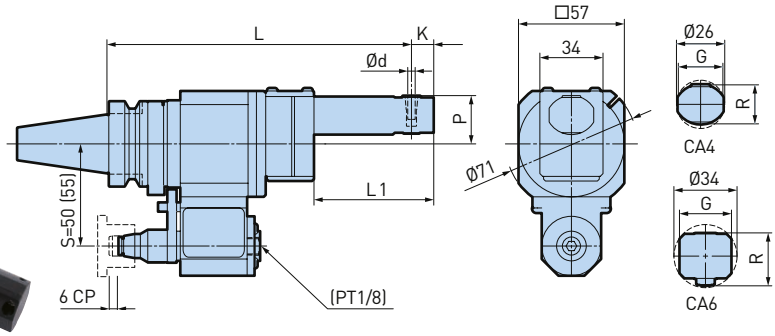
Tapper Type



Model	Article No.	ØE	ØF	L	L1	L2	G	K	M	P	Q	Tap Size d Metric	max. min-1	Collet Model	Weight (kg)	Gewicht (kg)
BBT30-AG90-FT6-99	101388.001.0	20	81	99	81	18	17	14.5	16.5	50	25.5	M2 - M6	2,000	NBC6	1.81	1.810

1. The cutting tool rotates in reverse to the machine spindle.
2. Nut and wrench are included. Collet is to be ordered separately.
3. Stop Block is to be ordered separately.

Small Bore Type



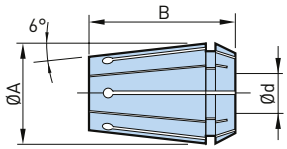
ø3 - 6mm

Model	Article No.	Ød	L	L1	K	P	G	R	Ratio	max. min-1	Collet Model	Weight (kg)
BBT30-AG90-CA4SG-164	805.570	3 - 4	164	64.5	12	26	24	21	1:1.13	2,000	CA4	1.90
BBT30-AG90-CA6SG-164	805.571	3 - 6	164	67	14.5	28	28	28.5	1:0.91	2,000	CA6	1.98

1. **Stop Block and collet are to be ordered separately**

New Baby Collets

For New Baby Chuck and MEGA New Baby Chuck.

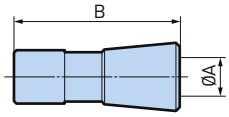


Model	Article No.	Ød	ØA	B
NBC6-0.5AA	961.500	0.25 - 0.5	9.5	14
NBC6-0.75AA	961.501	0.5 - 0.75	9.5	14
NBC6-1AA	961.502	0.75 - 1	9.5	14
NBC6-1.25AA	961.503	1 - 1.25	9.5	14
NBC6-1.5AA	961.504	1.25 - 1.5	9.5	14
NBC6-1.75AA	961.505	1.5 - 1.75	9.5	14
NBC6-2AA	961.506	1.75 - 2	9.5	14
NBC6-2.25AA	961.507	2 - 2.25	9.5	14

Model	Article No.	Ød	ØA	B
NBC6-2.5AA	961.508	2.25 - 2.5	9.5	14
NBC6-2.75AA	961.509	2.5 - 2.75	9.5	14
NBC6-3AA	961.510	2.75 - 3	9.5	14
NBC6-3.25AA	961.511	3 - 3.25	9.5	14
NBC6-3.5AA	961.512	3.25 - 3.5	9.5	14
NBC6-3.75AA	961.513	3.5 - 3.75	9.5	14
NBC6-4AA	961.514	3.75 - 4	9.5	14
NBC6-4.25AA	961.515	4 - 4.25	9.5	14

Model	Article No.	Ød	ØA	B
NBC6-4.5AA	961.516	4.25 - 4.5	9.5	14
NBC6-4.75AA	961.517	4.5 - 4.75	9.5	14
NBC6-5AA	961.518	4.75 - 5	9.5	14
NBC6-5.25AA	961.519	5 - 5.25	9.5	14
NBC6-5.5AA	961.520	5.25 - 5.5	9.5	14
NBC6-5.75AA	961.521	5.5 - 5.75	9.5	14
NBC6-6AA	961.522	5.75 - 6	9.5	14

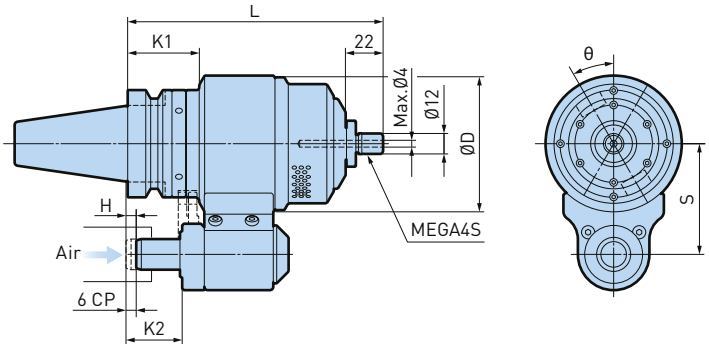
Collet for Angle Head Small Bore Type



Model	Article No.	ØA	B
CA4-3	804.666	3	16.5
CA4-3.5	804.667	3.5	16.5
CA4-4	804.668	4	16.5
CA6-3	804.669	3	22
CA6-4	804.670	4	22
CA6-5	804.671	5	22
CA6-6	804.672	6	22

Air Turbine Spindle Side Through Type

Air -driven speed increaser capable of up to 80000 rpm.



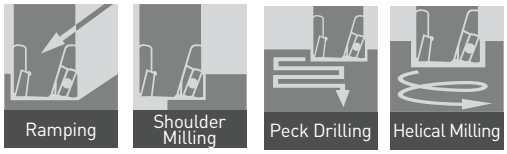
Model	Article No.	Operation Speed (min-1)	ØD	L	K1	K2	S	H	Nut Model	Weight (kg)
BBT30-RBX7-4S-152-55	802.395	60,000 - 80,000	80	152	28	33	55	-10 - 22	MGN4S	2.70

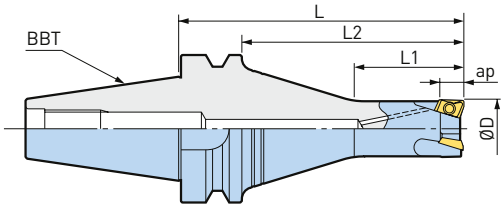
1. Exclusive Stop Block is required.
2. Nut and wrench are included.
3. Collet (NBC4S-_) and XF1 (air unit) are to be ordered separately.
4. „CP" indicates compression.

Micro Collets

Fullcut Mill FCR - For Standard Type with BBT

Designed for multi-functional cutting.





Standard Type

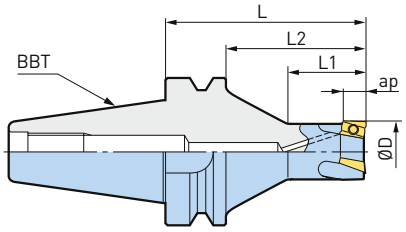
Model	Article No.	ØD	L	L1	L2	ap	Number of Inserts	Insert size	Weight (kg)
BBT30-FCR16082-65	966.683	16	65	28	43	8	2	BRG16	0.47
BBT30-FCR20083-65	966.685	20	65	28	43	8	3	BRG20	0.49
BBT30-FCR25083-65	966.687	25	65	33	43	8	3	BRG25	0.52
BBT30-FCR25083-105	100654.001.0	25	105	35	83	8	3	BRG25	0.73
BBT30-FCR32103-65	966.689	32	65	40	43	10	3	BRG32	0.56
BBT30-FCR32103-105	100654.002.0	32	105	45	83	10	3	BRG32	0.83

Long Type

Model	Article No.	ØD	L	L1	L2	ap	Number of Inserts	Insert size	Weight (kg)
BBT30-FCR16082L-85	966.684	16	85	45	63	8	2	BRG16	0.50
BBT30-FCR20082L-85	966.686	20	85	50	63	8	2	BRG20	0.53
BBT30-FCR25082L-85	966.688	25	85	50	63	8	2	BRG25	0.60
BBT30-FCR32102L-85	966.690	32	85	60	63	10	2	BRG32	0.68

Fullcut Mill FCM

The indexable endmill that combines sharpness and rigidity for best results.



Standard Type

Model	Article No.	ØD	L	L1	L2	ap	Number of Inserts	Insert size	Weight (kg)
BBT30-FCM16092-65	966.216	16	65	23	43	9	2	ARG16	0.48
BBT30-FCM20093-65	966.217	20	65	28	43	9	3	ARG20	0.49
BBT30-FCM25093-65	966.218	25	65	33	43	9	3	ARG25	0.52
BBT30-FCM25093-105	100644.001.0	25	105	34	83	9	3	ARG25	0.75
BBT30-FCM32113-65	966.219	32	65	38	43	11	3	ARG32	0.56
BBT30-FCM32113-105	100644.002.0	32	105	44	83	11	3	ARG32	0.85
BBT30-FCM40114-50	966.220	40	50	25	28	11	4	ARG40	0.54
BBT30-FCM63116-55	100644.004.0	63	55	-	33	11	6	ARG63	0.85

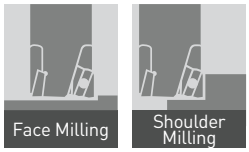
Long Type

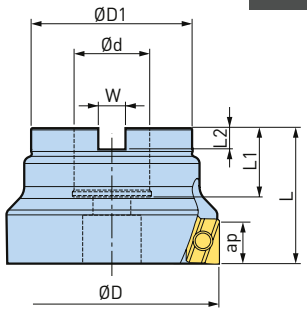
Model	Article No.	ØD	L	L1	L2	ap	Number of Inserts	Insert size	Weight (kg)
BBT30-FCM16092L-85	966.081	16	85	45	63	9	2	ARG16	0.50
BBT30-FCM20092L-85	966.082	20	85	50	63	9	2	ARG20	0.60
BBT30-FCM25092L-85	966.083	25	85	50	63	9	2	ARG25	0.60
BBT30-FCM32112L-85	966.084	32	85	60	63	11	2	ARG32	0.70

1. BIG-PLUS® tools can be used in machining centers with non BIG-PLUS® spindles.
2. Wrench is included.
3. Inserts are to be ordered separately.

Fullcut Mill FCM - Arbor Type

Corresponding to Form FMH of new standard face milling adapter.



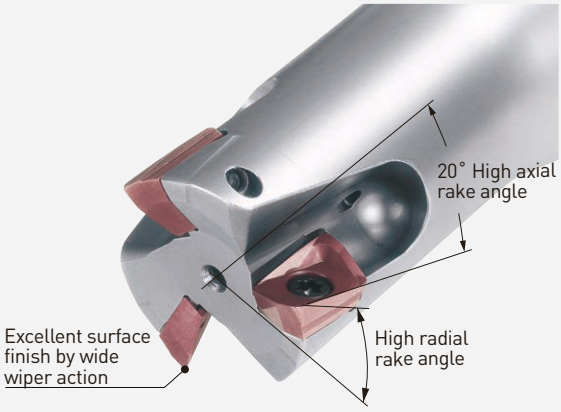


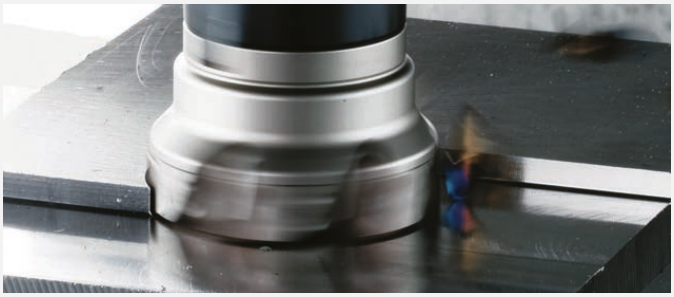
Model	Article No.	ØD	Ød	ØD1	L	L1	L2	ap	W	Number of Inserts	Insert size	Weight (kg)
FMH22-FCM50115-40	966.212	50	22	47	40	20	6	11	10.4	5	ARG40	0.40
FMH22-FCM63116-40	966.213	63	22	47	40	20	6	11	10.4	6	ARG63	0.50
FMH27-FCM80116-50	966.214	80	27	60	50	22	7	11	12.4	6	ARG80	1.10

1. Wrench is included.
2. Inserts are to be ordered separately.

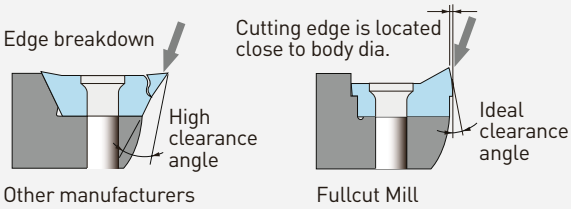
FaceMill Arbor on Page 18

Sharp cutting edge by both high radial and axial rake angles
Positive high rake cutting edge for both radial and axial directions achieves smooth and quiet endmilling.

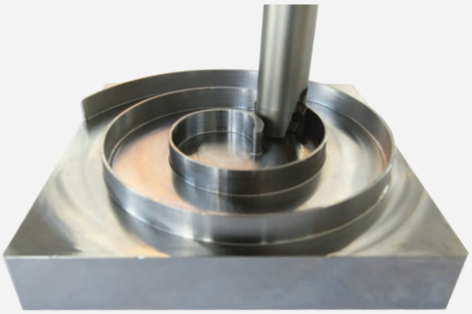




Strong cutting edge reduces edge chipping



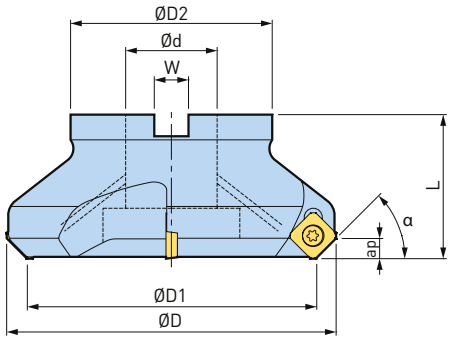
Cutting example (with BBT30)



Full Cut Mill FCM				
Tool	BBT30-FCM20092L-85			Time
Insert	ARG200904			
	ACM300F			
Cutting data	Diameter	20	Ø - mm	3' 36''
	Number of teeth	2	tooth	
	Cutting speed	150	m/min	
	Feed / tooth	0.12	mm/tooth	
	Revolution	2 387	min^{-1}	
	Feed	573	mm/min	
	Ad	9	mm	
	Ae	20	mm	

Surface Mill

For superior surface finishing.



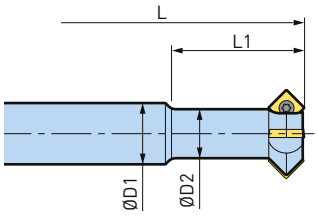
Model	Article No.	ØD	ØD1	ØD2	Ød	L	W	ap	α	Number of Inserts	Insert size	Weight (kg)
FM22-SFM503-35	-	61.6	50	47	22	35	10.4	5	45°	3	CM10C1	0.40
FM22-SFM634-35	-	74.6	63	47	22	35	10.4	5	45°	4	CM10C1	0.50
FM27-SFM804-40	805.890	91.6	80	60	27	40	12.4	5	45°	4	CM10C1	0.90

1. Wrench and screws are included.
2. Inserts are to be ordered separately.
3. MBA - M12H (802.758) is required to be mounted on FMH25.4 and FMH27.

FaceMill Arbor on Page 18

C-Cutter Mini, Multi Insert Type

For High speed front and back chamfering.



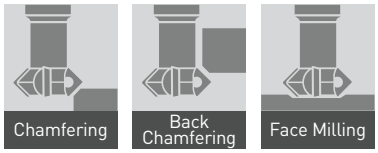


Fig. 1

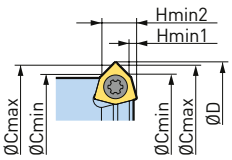


Fig. 2

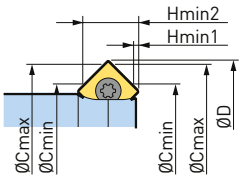
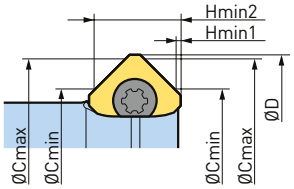


Fig. 3

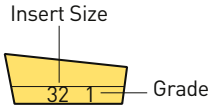


Model	Article No.	Fig.	ØD	ØD1	ØD2	L	L1	α1	α2	ØC min1	ØC min2	ØC max1	ØC max2	H min1	H min2	Insert Type	Number of Inserts	Weight (kg)
ST12-C0916-3060B-25	-	2	16.7	12	11.2	98	25	30°	60°	9	16	13	16	0,2	5,7	CM05	4	0.09
ST20-C1931-3060B-50	-	3	32.7	20	19.4	130	50	30°	60°	19	31	26	32	0,2	11,2	CM10	4	0.31
ST10-C0810-45B-15	807.192	1	10.5	10	7.4	78	15	45°	45°	8	10	8	10	0.7	3.2	CM03	3	0.05
ST10-C0810-45B-27	807.193	1	10.5	10	7.4	90	27	45°	45°	8	10	8	10	0.7	3.2	CM03	3	0.05
ST12-C1012-45B-20	966.461	1	12.7	12	9	93	20	45°	45°	10	12	10	12	1	3.7	CM04	3	0.08
ST12-C1012-45B-35	966.462	1	12.7	12	9	108	35	45°	45°	10	12	10	12	1	3.7	CM04	3	0.08
ST12-C1116-45B-25	966.433	2	17.1	12	9.6	98	25	45°	45°	11	16	11	16	0.4	6.2	CM05	4	0.08
ST12-C1116-45B-40	966.463	2	17.1	12	9.6	113	40	45°	45°	11	16	11	16	0.4	6.2	CM05	4	0.09
ST16-C1520-45B-50	966.464	2	20.7	16	13.2	123	50	45°	45°	15	20	15	20	0.6	6.3	CM05	4	0.17
ST20-C1924-45B-60	966.465	2	24.7	20	17.2	143	60	45°	45°	19	24	19	24	0.6	6.3	CM05	4	0.31
ST20-C2232-45B-50	966.434	3	32.7	20	19.2	130	50	45°	45°	22	32	22	32	0.4	12.4	CM10	4	0.31
ST20-C2232-45B-80	966.466	3	32.7	20	19.2	160	80	45°	45°	22	32	22	32	0.4	12.4	CM10	4	0.37
ST32-C3242-45B-65	966.435	3	42.7	32	30.6	175	65	45°	45°	32	42	32	42	0.4	12.4	CM10	4	1.04
ST32-C3242-45B-100	966.467	3	42.7	32	30.6	211	100	45°	45°	32	42	32	42	0.4	12.4	CM10	4	1.24
ST12-C1317-6030B-25	-	2	17.4	12	8.4	98	25	60°	30°	13	17	10	16	0,3	6,4	CM05	4	0.08
ST20-C2632-6030B-50	-	3	32.7	20	17.0	130	50	60°	30°	26	32	19	31	1,5	12,4	CM10	4	0.29

1. Wrench and screws are included.
2. Inserts are to be ordered separately.
3. In case of chamfering with 4 insert type, chatter may occur due to increased cutting resistance when plunge cutting. Please try the different types with less inserts, 1 or 2.

Indexable Inserts for Fullcut Mill FCM

Marking Description



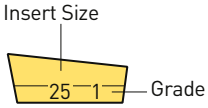
1: ACZ310
2: DS20
P2: ACP200
3F: ACM300F
P3: ACP300

Model	Article No.	ØD	ap	Nose R	Insert Grade	Material
ARG160902(DS20)	978.801	12 - 17	9	0.2	DS20	Aluminium
ARG160902(ACM300F)	807.728	12 - 17	9	0.2	ACM300F	Stainless Steel
ARG160902(ACP300)	978.812	12 - 17	9	0.2	ACP300	General Steel
ARG160902(ACZ310)	800.488	12 - 17	9	0.2	ACZ310	Cast iron
ARG160904(DS20)	966.249	12 - 17	9	0.4	DS20	Aluminium
ARG160904(ACP200)	978.827	12 - 17	9	0.4	ACP200	Prehardened steel
ARG160904(ACM300F)	807.729	12 - 17	9	0.4	ACM300F	Stainless Steel
ARG160904(ACP300)	966.245	12 - 17	9	0.4	ACP300	General Steel
ARG160904(ACZ310)	966.248	12 - 17	9	0.4	ACZ310	Cast iron
ARG200902(DS20)	978.807	20, 21	9	0.2	DS20	Aluminium
ARG200902(ACM300F)	807.730	20, 21	9	0.2	ACM300F	Stainless Steel
ARG200902(ACP300)	978.813	20, 21	9	0.2	ACP300	General Steel
ARG200902(ACZ310)	800.046	20, 21	9	0.2	ACZ310	Cast iron
ARG200904(DS20)	966.254	20, 21	9	0.4	DS20	Aluminium
ARG200904(ACP200)	978.804	20, 21	9	0.4	ACP200	Prehardened steel
ARG200904(ACM300F)	807.731	20, 21	9	0.4	ACM300F	Stainless Steel
ARG200904(ACP300)	966.250	20, 21	9	0.4	ACP300	General Steel
ARG200904(ACZ310)	966.253	20, 21	9	0.4	ACZ310	Cast iron
ARG250902(DS20)	978.803	25, 26	9	0.2	DS20	Aluminium
ARG250902(ACM300F)	807.732	25, 26	9	0.2	ACM300F	Stainless Steel
ARG250902(ACP300)	978.814	25, 26	9	0.2	ACP300	General Steel
ARG250902(ACZ310)	800.047	25, 26	9	0.2	ACZ310	Cast iron
ARG250904(DS20)	966.259	25, 26	9	0.4	DS20	Aluminium
ARG250904(ACP200)	800.048	25, 26	9	0.4	ACP200	Prehardened steel
ARG250904(ACM300F)	807.733	25, 26	9	0.4	ACM300F	Stainless Steel
ARG250904(ACP300)	966.255	25, 26	9	0.4	ACP300	General Steel
ARG250904(ACZ310)	966.258	25, 26	9	0.4	ACZ310	Cast iron
ARG321102(DS20)	966.270	32, 33	11	0.2	DS20	Aluminium
ARG321102(ACM300F)	807.735	32, 33	11	0.2	ACM300F	Stainless Steel
ARG321102(ACP300)	978.828	32, 33	11	0.2	ACP300	General Steel
ARG321102(ACZ310)	800.049	32, 33	11	0.2	ACZ310	Cast iron
ARG321104(DS20)	966.264	32, 33	11	0.4	DS20	Aluminium
ARG321104(ACP200)	800.051	32, 33	11	0.4	ACP200	Prehardened steel
ARG321104(ACM300F)	807.736	32, 33	11	0.4	ACM300F	Stainless Steel
ARG321104(ACP300)	966.260	32, 33	11	0.4	ACP300	General Steel
ARG321104(ACZ310)	966.263	32, 33	11	0.4	ACZ310	Cast iron
ARG401102(DS20)	978.821	40, 50	11	0.2	DS20	Aluminium
ARG401102(ACM300F)	807.737	40, 50	11	0.2	ACM300F	Stainless Steel
ARG401102(ACP300)	800.052	40, 50	11	0.2	ACP300	General Steel
ARG401102(ACZ310)	800.053	40, 50	11	0.2	ACZ310	Cast iron
ARG401104(DS20)	966.269	40, 50	11	0.4	DS20	Aluminium
ARG401104(ACP200)	978.809	40, 50	11	0.4	ACP200	Prehardened steel
ARG401104(ACM300F)	807.738	40, 50	11	0.4	ACM300F	Stainless Steel
ARG401104(ACP300)	966.265	40, 50	11	0.4	ACP300	General Steel
ARG401104(ACZ310)	966.268	40, 50	11	0.4	ACZ310	Cast iron
ARG631104(DS20)	978.830	63	11	0.4	DS20	Aluminium
ARG631104(ACM300F)	807.739	63	11	0.4	ACM300F	Stainless Steel
ARG631104(ACP300)	978.829	63	11	0.4	ACP300	General Steel
ARG631108(DS20)	966.284	63	11	0.8	DS20	Aluminium
ARG631108(ACP200)	978.810	63	11	0.8	ACP200	Prehardened steel
ARG631108(ACM300F)	807.740	63	11	0.8	ACM300F	Stainless Steel
ARG631108(ACP300)	966.280	63	11	0.8	ACP300	General Steel
ARG631108(ACZ310)	966.283	63	11	0.8	ACZ310	Cast iron
ARG801104(DS20)	978.832	80, 100	11	0.4	DS20	Aluminium
ARG801104(ACM300F)	807.741	80, 100	11	0.4	ACM300F	Stainless Steel
ARG801104(ACP300)	978.831	80, 100	11	0.4	ACP300	General Steel
ARG801108(DS20)	966.289	80, 100	11	0.8	DS20	Aluminium
ARG801108(ACP200)	978.811	80, 100	11	0.8	ACP200	Prehardened steel
ARG801108(ACM300F)	807.742	80, 100	11	0.8	ACM300F	Stainless Steel
ARG801108(ACP300)	966.285	80, 100	11	0.8	ACP300	General Steel
ARG801108(ACZ310)	966.288	80, 100	11	0.8	ACZ310	Cast iron

1. ACP300 is first recommendation for steel and ACM300F is first recommendation for stainless steel.
2. Inserts are available in a packet of 10 pcs.

Indexable Inserts for Fullcut Mill FCR

Marking Description



1: ACZ310
2: DS20
P3: ACP300
3F: ACM300F

Model	Article No.	ØD	ap	Nose R	Insert Grade	Material
BRG160808(DS20)	966.653	16 - 17	8	0.8	DS20	Aluminium
BRG160808(ACM300F)	807.135	16 - 17	8	0.8	ACM300F	Stainless Steel
BRG160808(ACP300)	807.131	16 - 17	8	0.8	ACP300	General Steel
BRG160808(ACZ310)	966.652	16 - 17	8	0.8	ACZ310	Cast iron
BRG200808(DS20)	966.658	20 - 21	8	0.8	DS20	Aluminium
BRG200808(ACM300F)	807.136	20 - 21	8	0.8	ACM300F	Stainless Steel
BRG200808(ACP300)	807.132	20 - 21	8	0.8	ACP300	General Steel
BRG200808(ACZ310)	800.587	20 - 21	8	0.8	ACZ310	Cast iron
BRG250808(DS20)	966.663	25 - 26	8	0.8	DS20	Aluminium
BRG250808(ACM300F)	807.137	25 - 26	8	0.8	ACM300F	Stainless Steel
BRG250808(ACP300)	807.133	25 - 26	8	0.8	ACP300	General Steel
BRG250808(ACZ310)	966.662	25 - 26	8	0.8	ACZ310	Cast iron
BRG321008(DS20)	966.668	32 - 33	10	0.8	DS20	Aluminium
BRG321008(ACM300F)	807.138	32 - 33	10	0.8	ACM300F	Stainless Steel
BRG321008(ACP300)	807.134	32 - 33	10	0.8	ACP300	General Steel
BRG321008(ACZ310)	966.667	32 - 33	10	0.8	ACZ310	Cast iron
BRG321032(DS20)	966.669	32 - 33	10	3.2	DS20	Aluminium

1. Inserts are available in a packet of 10 pcs.

Indexable Inserts for C-Cutter Mini and Surface Mill

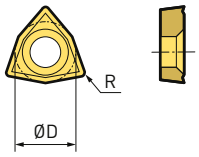


Fig. 1

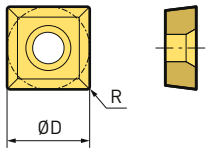


Fig. 2

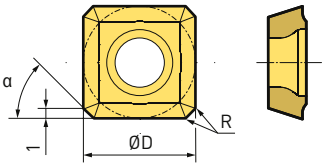


Fig. 3

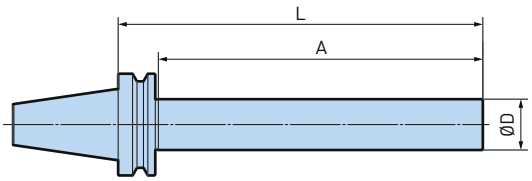
Model	Article No.	Fig.	ØD	α	Nose R	Insert Grade	Material	Screw Set
CM0302(ACP300)	807.226	1	3.31	45°	0.2	ACP300	Stainless Steel	S1.6S-T3
CM0302(ACM250F)	807.448	1	3.31	45°	0.2	ACM250F	Stainless Steel	S1.6S-T3
CM0302(DS20)	807.449	1	3.31	45°	0.2	DS20	Aluminium	S1.6S-T3
CM0402(ACP300)	966.440	1	3.97	45°	0.2	ACP300	Stainless Steel	S2SS-T6
CM0402(ACM250F)	807.450	1	3.97	45°	0.2	ACM250F	Stainless Steel	S2SS-T6
CM0402(DS20)	807.451	1	3.97	45°	0.2	DS20	Aluminium	S2SS-T6
CM0502SE(ACP300)	800.950	2	5	45°	0.2	ACP300	Stainless Steel	S2TS-T6
CM0502(ACM250F)	807.187	2	5	45°	0.2	ACM250F	Stainless Steel	S2TS-T6
CM0502(ACP200)	966.441	2	5	45°	0.2	ACP200	General Steel	S2TS-T6
CM0502SE(ACP200)	966.443	2	5	45°	0.2	ACP200	General Steel	S2TS-T6
CM0502(DS20)	966.442	2	5	45°	0.2	DS20	Aluminium	S2TS-T6
CM0502(CWS20A)	100736.001.0	2	5	45°	0.2	CWS20A	Prehardenend Steel & Hardended Steel	S2TS-T6
CM0502(NF15KA)	807.683	2	5	45°	0.2	NF15KA	Cast iron	S2TS-T6
CM10C1(ACM250F)	807.188	3	10	45°	0.2	ACM250F	Stainless Steel	S4S-T15
CM10C1(CWS20A)	100736.002.2	3	10	45°	0.2	CWS20A	Prehardenend Steel & Hardended Steel	S4S-T15
CM10C1SE(ACP200)	966.447	3	10	45°	0.2	ACP200	General Steel	S4S-T15
CM10C1(ACP200)	966.445	3	10	45°	0.2	ACP200	General Steel	S4S-T15
CM10C1(NF15KA)	807.684	3	10	45°	0.2	NF15KA	Cast iron	S4S-T15
CM10C1(DS20)	966.446	3	10	45°	0.2	DS20	Aluminium & Non-Ferrous	S4S-T15

1. The suffix SE designates a sharp cutting edge version.
2. Inserts are available in a packet of 10 pcs.
3. It is recommended to regularly replace clamping screws and wrench to ensure the correct clamping force is maintained.

Insert classifications

ISO	Grade	Material	Coating
P20	ACP200	Prehardened steel	TiAlN / AlCrN
P30	ACP300	General steel	
M30	ACM300F	Stainless steel	TiAlN / TiCN
K10	ACZ310	Cast iron	
N20	DS20	Aluminium	DLC

Dyna Test BIG-PLUS BT Type



BIG-PLUS Dual-Contact

Model	Article No.	ØD	L	A	Weight (kg)
BBT30-32-L150	800.054	32	150	125	1.04
BBT30-32-L235	961.264	32	235	210	1.50

1. BIG-PLUS® tools can be used in machining centers with non BIG-PLUS® spindles.
2. Taper length is in accordance with JIS BT standard.
3. Supplied in aluminium case.

Pullstud Bolts

For SPEEDIO.
Before ordering: Ensure to check the dimensions of the required pullstud bolt by referring to the specification sheet of the machine tool.

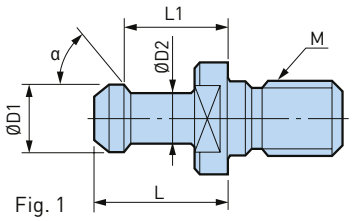


Fig. 1

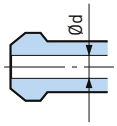


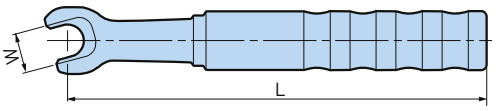
Fig. 2

Model	Article No.	Fig.	Ød	Ød1	ØD1	ØD2	L	L1	α	Weight (kg)
P30T-2MG	978.979	1	-	-	11	7	23	18	60	0.03
P30T-2MGH3	801.787	2	2.5	-	11	7.5	23	18	60	0.03

1. The use of the incorrect bolts may result in injury or property damage for your machining center.
2. Other sizes are also available. Contact BIG agent for pullstud bolts.

Pullstud Wrenches

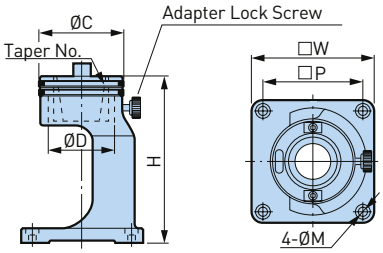
For P30T-2MG and 2MGH3.



Model	Article No.	L	W	Weight (kg)
PLW30	805.544	140	13	0.31

Tooling Mate

For BBT30 and BT30 tool holders.

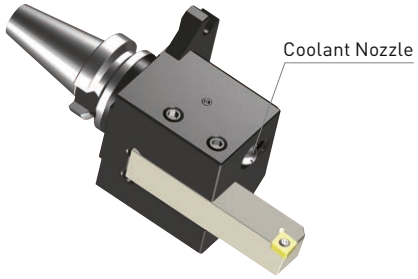


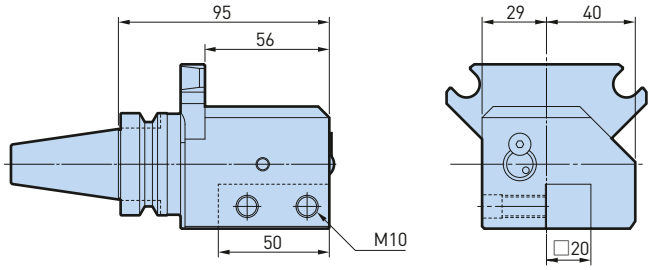
Model	Article No.	Taper	ØC	ØD	ØM	H	W	P	Adapter	Weight (kg)
TMS40-30	961.270	BT30	76	60	7	150	110	90	TMA40-30	2.50

1. 1 pce. of adapter is included.
2. Adapter can be ordered individually.

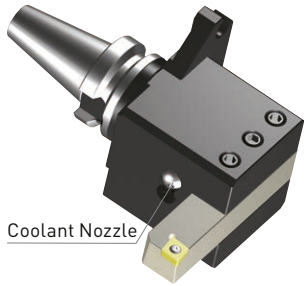
Turning Tools for SPEEDIO M300X3 and M200X3

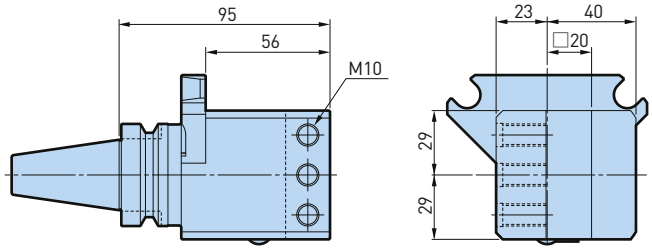
Square Tool Holder
For outer diameter.





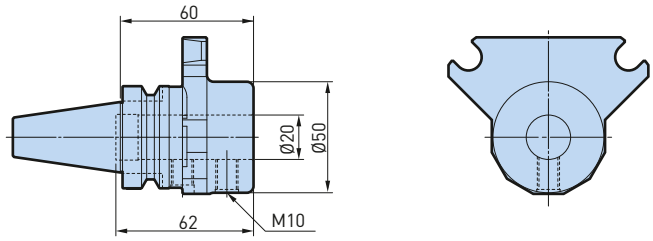
Model	Order No.	Weight (kg)
BBT30/BR-180-BH20L-95	807.044	2.20





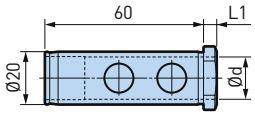
Model	Order No.	Weight (kg)
BBT30/BR-90-BH20N-95	807.045	2.30

Side Lock Holder
For internal bore.



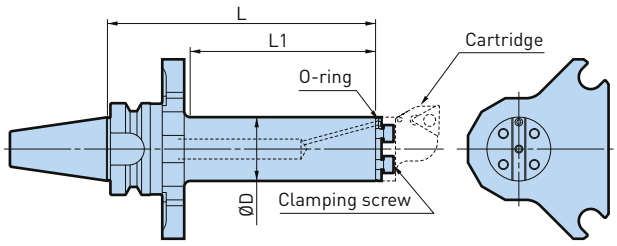
Model	Order No.	Weight (kg)
BBT30/BR-SL20-60	807.046	1.00

BSL Sleeve
For Side Lock Holder.



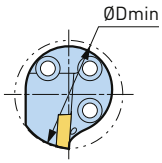
Model	Order No.	Ød	L1
BSLA20 - 6	805.728	6	5
- 8	805.733	8	7
-10	805.734	10	5
-12	805.735	12	
-16	805.736	16	

Turning Adapter



Model	Order No.	Cartridge	ØD	Min. Ø	L	L1	Clamping screw	O-ring	Weight (kg)
BBT30/BR-TAD40XR-135	-	B32..	32	40	135	93	C0510(M5x10L)	SDB20OR-2P	1.50
BBT30/BR-TAD50XR-168	-	B40..	40	50	168	126	C0610(M6x10L)	SDB20OR-2P	2.20

Cartridges for Turning Adapter - Positive



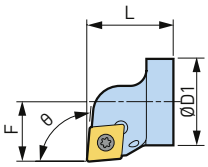


Fig. 1

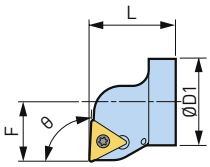


Fig. 2

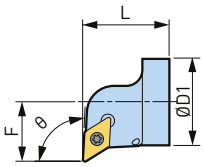


Fig. 3

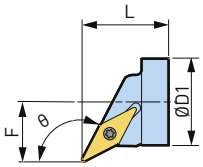
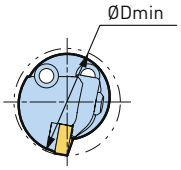


Fig. 4

Model	Article No.	Fig.	Type	Insert	Hand	ØD1	L	F	Entering Angle	Screw Set	Weight (kg)
B32-SDUCR-22032-11	806.426	3	B32	DC11T3	R	32	32	22	93°	S4 S-15IP	0.10
B32-STUCR-22032-11	806.802	2	B32	TC1102	R	32	32	22	93°	S2.5S-7IP	0.12
B32-SCLCR-22032-12	806.424	1	B32	CC1204	R	32	32	22	95°	S5 S-20IP	0.11
B32-STUPR-22032-16	806.425	2	B32	TP1604	R	32	32	22	93°	S4 S-15IP	0.11
B32-SVUBR 22032-16	-	4	B32	VB1604	R	32	32	22	93°	S3.5S-15IP	0.10
B32-SVPBR-22032A-16	-	4	B32	VB1604	R	32	32	22	117.5°	S3.5S-15IP	0.09
B40-SDUCR-27032-11	806.429	3	B40	DC11T3	R	40	32	27	93°	S4 S-15IP	0.16
B40-STUCR-27032-11	806.803	2	B40	TC1102	R	40	32	27	93°	S2.5S-7IP	0.18
B40-SCLCR-27032-12	806.427	1	B40	CC1204	R	40	32	27	95°	S5 S-20IP	0.17
B40-STUPR-27032-16	806.428	2	B40	TP1604	R	40	32	27	93°	S4 S-15IP	0.17
B40-SVUBR-27032-16	-	4	B40	VB1604	R	40	32	27	93°	S3.5S-15IP	0.20
B40-SVPBR-27032A-16	-	4	B40	VB1604	R	40	32	27	117.5°	S3.5S-15IP	0.13

Cartridges for Turning Adapter - Negative



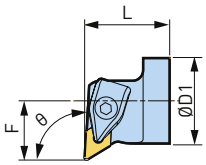


Fig. 1

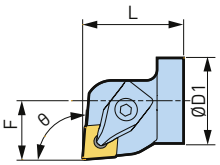


Fig. 2

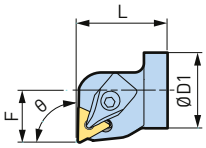
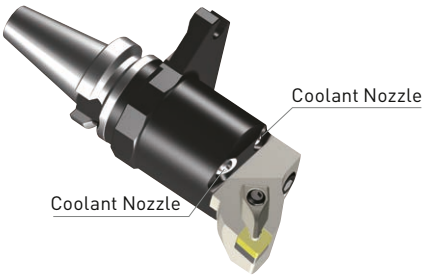


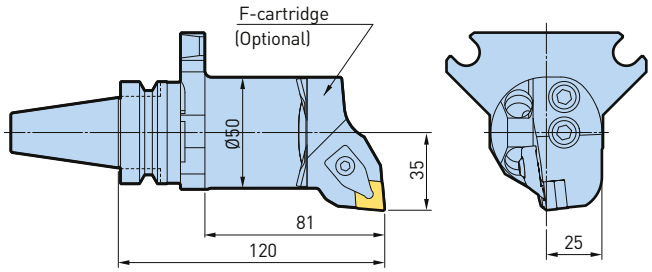
Fig. 3

Model	Article No.	Fig.	Type	Insert	Hand	ØD1	L	F	Entering Angle	Weight (kg)
B32-DDUNR-22032-11	807.404	1	B32	DN1104	R	32	32	22	93°	0.12
B32-DCLNR-22038-12	807.405	2	B32	CN1204	R	32	38	22	95°	0.15
B32-DTFNR-22038-16	-	3	B32	TN1604	R	32	38	22	91°	0.16
B40-DDUNR-27032-15	807.407	1	B40	DN1506*/ DN1504	R	40	32	27	93°	0.18
B40-DCLNR-27038-12	807.408	2	B40	CN1204	R	40	38	27	95°	0.23
B40-DTFNR-27038-16	-	3	B40	TN1604	R	40	38	27	91°	0.23

1. Wrench is included.
2. Inserts are to be ordered separately.
3. * Carbide shim for 6.35 mm thick DN1506 insert is included as standard. In case of DN1504 insert (thickness of 4.76 mm), please replace the standard carbide shim with DNS1506 (option).

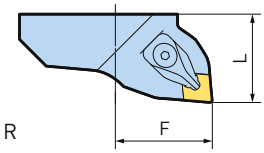
Basic Holder F Type
For outer diameter.





Model	Order No.	Weight (kg)
BBT30/BR-F50-85	**807.043**	1.80

90° Cartridges Type F



Model	Article No.	Type	Hand	Entering Angle	Insert	L	F	Weight (kg)
F50-DCLNL-35035-12	973.065	F50	L	95°	CN1204	35	45	0.25
F50-DCLNR-35035-12	973.064	F50	R	95°	CN1204	35	45	0.25
F50-DDJNL-35035-15	973.071	F50	L	95°	DN1504 * (DN1506)	35	45	0.23
F50-DDJNR-35035-15	973.070	F50	R	95°	DN1504 * (DN1506)	35	45	0.22
F50-DCLNL-35035-16	973.067	F50	L	95°	CN1606	35	45	0.24
F50-DCLNR-35035-16	973.066	F50	R	95°	CN1606	35	45	0.24
F50-DTJNL-35035-16	973.069	F50	L	93°	TN1604	35	45	0.24
F50-DTJNR-35035-16	973.068	F50	R	93°	TN1604	35	45	0.24
F50-DDJNL-35050-15	973.073	F50	L	95°	DN1504 * (DN1506)	50	45	0.30
F50-DDJNR-35050-15	973.072	F50	R	95°	DN1504 * (DN1506)	50	45	0.30
F63-DCLNL-45035-12	973.077	F63	L	95°	CN1204	35	45	0.33
F63-DCLNR-45035-12	973.076	F63	R	95°	CN1204	35	45	0.33
F63-DDJNL-45035-15	973.083	F63	L	93°	DN1504 * (DN1506)	35	45	0.31
F63-DDJNR-45035-15	973.082	F63	R	93°	DN1504 * (DN1506)	35	45	0.31
F63-DCLNL-45035-16	973.079	F63	L	95°	CN1606	35	45	0.33
F63-DCLNR-45035-16	973.078	F63	R	95°	CN1606	35	45	0.34
F63-DTJNL-45035-16	973.081	F63	L	93°	TN1604	35	45	0.33
F63-DTJNR-45035-16	973.080	F63	R	93°	TN1604	35	45	0.35
F63-SVQBL-45035-16	973.087	F63	L	117.5°	VB1604 / VC1604 **	35	45	0.26
F63-SVQBR-45035-16	973.086	F63	R	117.5°	VB1604 / VC1604 **	35	45	0.26
F63-DDJNL-45055-15	973.085	F63	L	93°	DN1504 * (DN1506)	55	45	0.41
F63-DDJNR-45055-15	973.084	F63	R	93°	DN1504 * (DN1506)	55	45	0.31

1. Inserts are not included.
2. Wrench is to be ordered separately.
3. * Carbide shim for 4.76 mm thick DN1504 insert is included as standard. In case of DN1506 insert (thickness of 6.35 mm), please replace the standard carbide shim with DNS1506 (option).

Coding system for cartridge

F63 - D C L N R - 45 035 - 12

- Insert Size
- Length
- Offset Value
- Hand
- Relief Angle
- Entering Angle
- Insert Shape
- Clamping Method
- Cartridge Type and Size

Clamping Method	
D	Double-Clamp
S	Screw-On

Insert Shape	
C	Rhombic 80°
T	Triangle 60°
D	Rhombic 55°
V	Rhombic 35°

Entering Angle	
J	93°
L	95°
Q	117.5°

Relief Angle	
N	0° Negative
B	5° Positive

Hand	
R	Right Hand
L	Left Hand

The complete product overview and accessories
can be found in the BIG DAISHOWA main catalogue.
www.bigdaishowa.eu

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