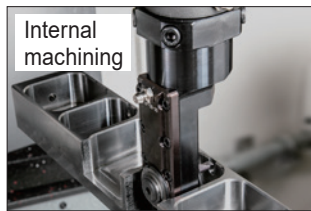
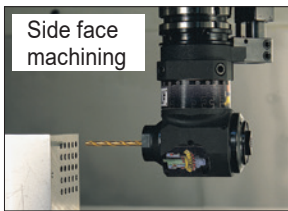


ANGLE HEAD

You can carry out 5-surface machining, such as side face and inside surface, without needing to change the positioning of the work-piece.



Voluminous variety

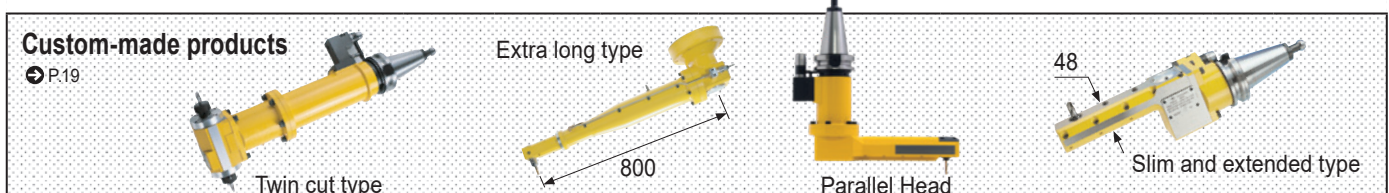
■ New concept Angle head **HALF** for drilling and tapping applications **Affordable • Lightweight • Short delivery!**

Type	Angle	MODEL	Application	Chuckling range (φD)		MAX. (min ⁻¹) [Main spindle : Angle shaft]	ATC	kg
90° type ➡ P. 8  mini type ➡ P. 10	90°	HFC6	Drill Endmill	φ3, 4, 6	FCS6	5680:5000 [1 : 0.88]	○	1.8
		HFD 7		φ1 ~ 7	D 7	6000:6000 [1(CCW):1(CW)]		
		HFD12		φ2.5 ~ 13	D12	4000:4000 [1(CCW):1(CW)]		2.9
		HFA10		φ2.4 ~ 10	C10	6000:6000 [1(CCW):1(CW)]		1.8
		HFA20		φ5.8 ~ 20	C20	6000:5000 [1(CCW):0.83(CW)]		4.4
		HFC6	Tap	M4, 5, 6	FCS6	5680:5000 [1 : 0.88]		1.8
		HFT 4		M2 ~ 8	TA4	6000:6000 [1(CCW):1(CW)]		2.3
		HFT 6		M3 ~ 12	TA6	4000:4000 [1(CCW):1(CW)]		2.9
		HFT12		M3 ~ 16	TA6/12	6000:5000 [1(CCW):0.83(CW)]		4.4
UNIVERSAL type (Free setting of cutting directions) ➡ P. 11 	0° ∠ 120°	HUD 7	Drill Endmill	φ1 ~ 7	D 7	6300:3000(BT30:7200:4000) [1(CCW):0.48(CW)][BT30:1(CCW):0.56(CW)]	○	1.8
		HUA10		φ2.4 ~ 10	C10	6300:3000 [1(CW):0.48(CW)]		3.9
		HUA20		φ5.8 ~ 20	C20			4.8
		HUT 4	Tap	M2 ~ 8	TA4	6300:3000(BT30:7200:4000) [1(CCW):0.48(CW)][BT30:1(CCW):0.56(CW)]		3.8
		HUT 6		M3 ~ 12	TA6	6300:3000 [1(CW):0.48(CW)]		4.8

■ High-rigidity **STANDARD** type

(※Use the BT30 tooling system with the Quick Change system.)

MODULAR type (Recombination type) ➡ P. 15 	90°	AHB 5	Drill Endmill	φ0.5 ~ 5	ER8	6000:6000 [1(CCW):1(CW)]	○	5.5
		AHB 7		φ0.5 ~ 7	ESX12			5.3
		AHB10		φ2.4 ~ 10	C10			6.2
	45°	AHC10	Drill Endmill					
SOLID type ➡ P. 16 	90°	AHA20	Drill Endmill	φ5.8 ~ 20	C20	3000:2430 [1(CCW):0.81(CW)]	○	7.3
		AHA25		φ5.8 ~ 25	C25	2500:2400 [1(CCW):0.96(CW)]		13.6
		AHD30		BT30※	BT30			14.7
FLANGE type (Mounting directly on machine spindle) ➡ P. 17 	90°	AHA20	Drill Endmill	φ5.8 ~ 20	C20	3000:2430 [1(CCW):0.81(CW)]	×	18.0
		AHA25		φ5.8 ~ 25	C25	2500:2400 [1(CCW):0.96(CW)]		18.5
		AHD30		BT30※	BT30			19.6
UNIVERSAL type (Free setting of cutting directions) ➡ P. 18 	0°	AHU10	Drill Endmill	φ2.4 ~ 10	C10	3000:4500 [1(CW):1.5(CW)]	○	9.6
	90°	AHU20		φ5.8 ~ 20	C20	3000:3000 [1(CW):1(CW)]		15.8



ANGLE HEAD HALF

PAT.

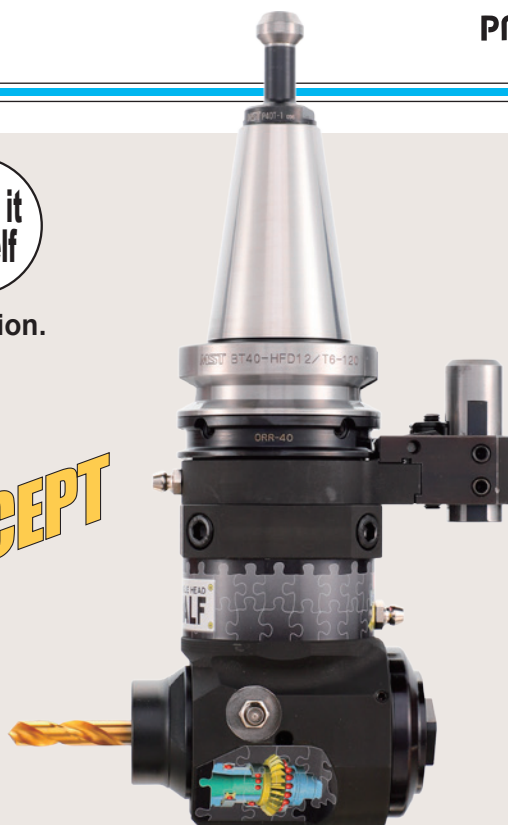
- Affordable**
2,300USD~
- Speedy**
Shorter delivery
- Lightweight**
1.8kg~
- Compact**
φ36~
- Repair it yourself**

Drilling and tapping account for 80% of angle head operation.

The Angle Head HALF was redesigned to achieve the necessary rigidity and accuracy, it allows;

- AFFORDABLE** (Price : 1/2)
- QUICK DELIVERY** (Lead Time : 1/2)
- LIGHTWEIGHT** (Weight : 1/2)

NEW CONCEPT



90° type

BT30/40/50
HSK-A63
DIN40/50,
CAT.40/50

HFD/HFA
φ1~20mm

HFT
M2~16

mini type

Extra-compact head

BT30/40/50
DIN40/50
CAT.40/50

HFCS
φ3,4,6mm
M4,5,6

15.5 31.5 φ36

UNIVERSAL type

Angle can be set arbitrarily

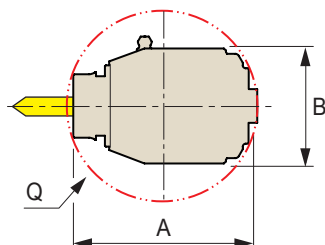
BT30/40/50
DIN40/50
CAT.40/50

HUD/HUA
φ1~20mm

HUT
M2~12

120° 120°

Compact design



Type	MODEL	Q	A	B
90° type	HFD 7	72	68	38
	HFD12	98	93	58
	HFT 4	75	73	38
	HFT 6	97	92	58
	HFA10	90	87	38
	HFA20	119	111	64
	HFT12	97	96	64
mini type	HFCS6	116	115	64
		36	31.5	31

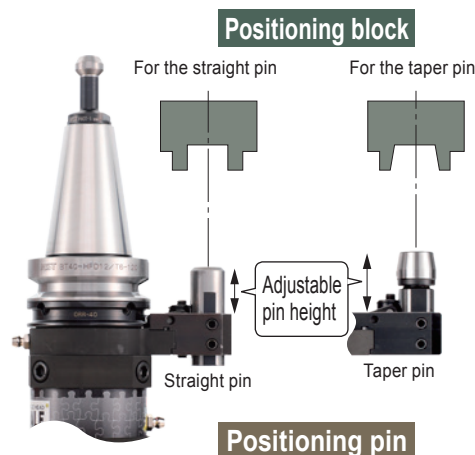
Auto Tool Changer (A.T.C) is available on BT30 machine.



BT30
1.8kg

Easy installation

The positioning pin allows an in-use positioning block to be used is now a standard feature. Can be used with a variety of machining centers.



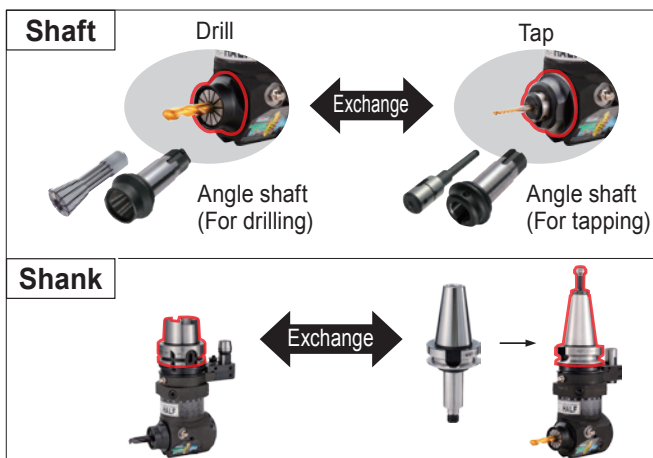
Easy disassembly and assembly

- The number of parts (22 pcs.) is half that of conventional angle heads.
- No need for fine matching and adjustment.
- Makes use of commercial items such as bearings. Affordable and readily available.
- An informative video and an instruction manual for disassembly and reassembly are provided.

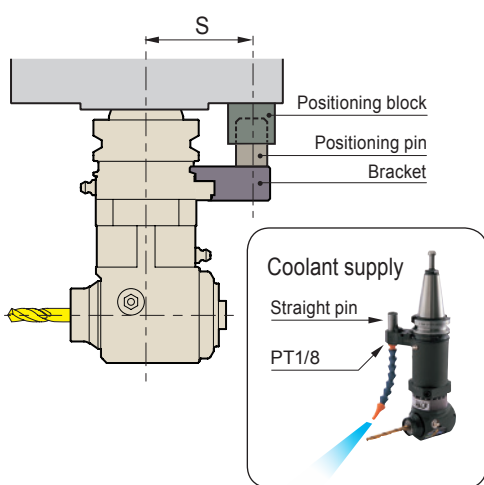


Running cost is reduced by 90% as a result of reduced repair costs and machine down time.

Easy to reassemble



Positioning block and positioning pin

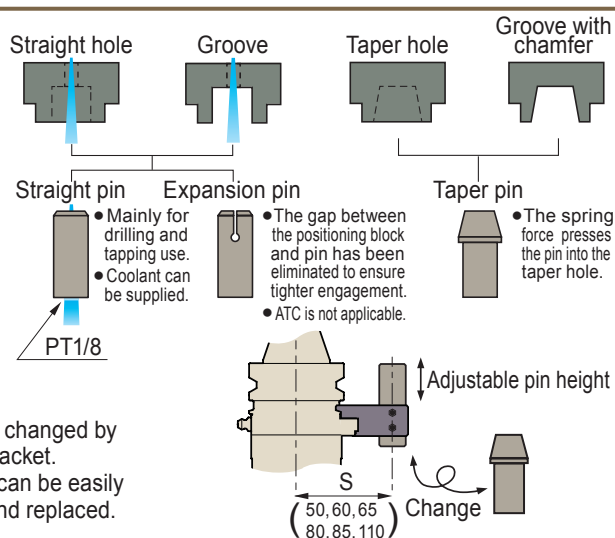


Positioning block

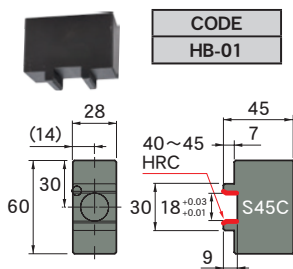
Positioning pin

Bracket

- S dimension can be changed by reassembling the bracket.
- The positioning pin can be easily adjusted in length and replaced.



Semi-finished positioning block



Note

- Please confirm with the machine tool manufacturer about the dimensions of the positioning block.
- We have a semi-finished positioning block with a taper hole available. (→P.19)

Positioning block for machines

- FANUC ROBODRILL α-DiB series



CODE
ABF005

- MAZAK SUPER VELOCITY CENTER 2000L/120-II 2000L/200-II



- Available from Yamazaki Mazak Corp.

- BROTHER SPEEDIO Compact machining center



CODE	NOTE
ABF213	S300X1 /X2, S500X1 /X2, S700X1 /X2
ABF259	S1000X1
ABF176	TC-S2, S2A※, S2B, S2C, S2D, R2B※

Caution

- TC-S2A※ (Tapping center). The user needs to confirm whether the positioning block can be mounted on the machine (spindle surface) or not. Please contact us.
- TC-R2B※ (Tapping center) machining area is limited to some extent due to interference between the positioning block and the internal part cover of the machine. For more information, please contact us.

A product code example when ordering Angle Head HALF.

- FANUC BT30-HFD7-122-S65
- BROTHER BT30-HFD7L-120-S50C

Kit Package

- Learning Kit to understand gear and bearing mechanism.
- There are only 22 parts and anyone can assemble them in about 10 min.
- Spare/consumable parts and assembly tools are included.



	CODE	
Contents of kit	BT40-HF12-LK	BT50-HF12-LK
Complete unit	BT40-HFD12-180-S65 (1pc.)	BT50-HFD12-195-S80 (1pc.)
Angle shaft (For tapping)	FR-T6 (1pc.)	
Tap sleeve	TA6-3, 4, 5, 6, 8 (each 1pc.)	
DETa-1 Collet	D12-4, 6, 8, 10, 12, 13 (each 1pc.)	
Positioning pin	HP-50T(1pc.)	HP-62T(1pc.)
Spare bearing	7005ADB (1set), 6805 (1pc.), 51106 (1pc.)	

CODE (Master holder)	Fig.	φD	L	M	Kg (lbs)
BT30-HFD 7 -122	1	1 ~ 7	122	70	2.3
-182			182	130	3.0
-HFD 7L-120			120	57	1.8
-HFD12 -122	2	2.5~ 13	122	70	2.9
-HFA10 -120	3	2.4~ 10	120	65	1.8
-HFT 4 -122	5	M2~M 8	122	70	2.3
-182			182	130	3.0
-HFT 4L-120			120	57	1.8
-HFT 6 -122	6	M3~M12	122	70	2.9
BT40-HFD 7 -120	1	1 ~ 7	120	70	3.0
-180			180	130	3.3
-HFD12 -120	2	2.5~ 13	120	70	3.6
-180			180	130	4.9
-HFA20 -135	4	5.8~ 20	135	77	4.4
-195			195	137	5.6
-HFT 4 -120	5	M2~M 8	120	70	3.0
-180			180	130	3.3
-HFT 6 -120	6	M3~M12	120	70	3.6
-180			180	130	4.9
-HFT12 -135	7	M3~M16	135	77	4.4
-195			195	137	5.6
BT50-HFD 7 -195	1	1 ~ 7	195	130	6.4
-255			255	190	6.8
-HFD12 -135	2	2.5~ 13	135	70	6.3
-195			195	130	7.6
-255			255	190	8.9
-HFA20 -150	4	5.8~ 20	150	77	7.1
-210			210	137	8.3
-270			270	197	9.4
-HFT 4 -195	5	M2~M 8	195	130	6.4
-255			255	190	6.8
-HFT 6 -135	6	M3~M12	135	70	6.3
-195			195	130	7.6
-255			255	190	8.9
-HFT12 -150	7	M3~M16	150	77	7.1
-210			210	137	8.3
-270			270	197	9.4
A63 -HFD 7 -183	1	1 ~ 7	183	130	3.5
-243			243	190	3.9
-HFD12 -123	2	2.5~ 13	123	70	3.3
-183			183	130	4.7
-243			243	190	6.0
-HFA20 -198	4	5.8~ 20	198	137	5.4
-258			258	197	6.5
-HFT 4 -183	5	M2~M 8	183	130	3.5
-243			243	190	3.9
-HFT 6 -123	6	M3~M12	123	70	3.3
-183			183	130	4.7
-243			243	190	6.0
-HFT12 -198	7	M3~M16	198	137	5.4
-258			258	197	6.5

■ A product code example when ordering.

BT40-HFD7-120 - S 65

Holder

Positioning pin type

S : Straight pin
W : Expansion pin
T : Taper pin

Dimension S

50, 60, 65,
80, 85, 110 ...

CODE (Master holder)	Fig.	φD	L	M	Kg (lbs)
DN40A-HFD 7-135	1	1 ~ 7	135	70	3.1
-195			195	130	3.4
-HFD12-135	2	2.5~ 13	135	70	3.7
-195			195	130	5.0
DIN -HFA20-150	4	5.8~ 20	150	77	4.7
-210			210	137	5.8
-HFT 4-135	5	M2~M 8	135	70	3.1
-195			195	130	3.4
-HFT 6-135	6	M3~M12	135	70	3.7
-195			195	130	5.0
-HFT12-150	7	M3~M16	150	77	4.7
-210			210	137	5.8
DN50A-HFD 7-195	1	1 ~ 7	195	130	5.9
-255			255	190	6.3
-HFD12-135	2	2.5~ 13	135	70	5.8
-195			195	130	7.1
-255			255	190	8.4
DIN -HFA20-150	4	5.8~ 20	150	77	6.6
-210			210	137	7.8
-270			270	197	8.9
-HFT 4-195	5	M2~M 8	195	130	5.9
-255			255	190	6.3
-HFT 6-135	6	M3~M12	135	70	5.8
-195			195	130	7.1
-255			255	190	8.4
-HFT12-150	7	M3~M16	150	77	6.6
-210			210	137	7.8
-270			270	197	8.9
CT40 -HFD 7-135	1	0.4~.28	5.31	2.75	6.8
-195			7.68	5.11	7.5
-HFD12-135	2	2.5~ 13	5.31	2.75	8.2
-195			7.68	5.11	11.0
CAT. -HFA20-150	4	.23~ .79	5.91	3.03	10.4
-210			8.27	5.39	12.9
-HFT 4-135	5	M2~M 8	5.31	2.75	6.8
-195			7.68	5.11	7.5
-HFT 6-135	6	M3~M12	5.31	2.75	8.2
-195			7.68	5.11	11.0
-HFT12-150	7	#4 ~ 5/8	5.91	3.03	10.4
-210			8.27	5.39	12.9
CT50 -HFD 7-195	1	0.4~.28	7.68	5.11	13.0
-255			10.04	7.47	13.8
-HFD12-135	2	.10~ .51	5.31	2.75	12.8
-195			7.68	5.11	15.6
-255			10.04	7.47	18.5
-HFA20-150	4	.23~ .79	5.91	3.03	14.7
-210			8.27	5.39	17.3
-270			10.63	7.76	19.8
CAT. -HFT 4-195	5	M2~M 8	7.68	5.11	13.0
-255			10.04	7.47	13.8
-HFT 6-135	6	M3~M12	5.31	2.75	12.8
-195			7.68	5.39	15.6
-255			10.04	7.47	18.5
-HFT12-150	7	#4 ~ 5/8	5.91	3.03	14.7
-210			8.27	5.39	17.3
-270			10.63	7.76	19.8

■ Option

- DETa-1 Collet (HFD) • Spring collet (HFA) • Tap sleeve (HFT)
- Retention knob→P.64 • Tools for assembly

■ Std. Access.

- Coolant duct (HSK-A) • Fixing spanner(Except for HFA10/HFT4L)
- Hexagonal wrench set • Spanner(HFA)
- Single-ended wrench(HFD7L/HFA10) • Spanner(HFA) • Low head bolt

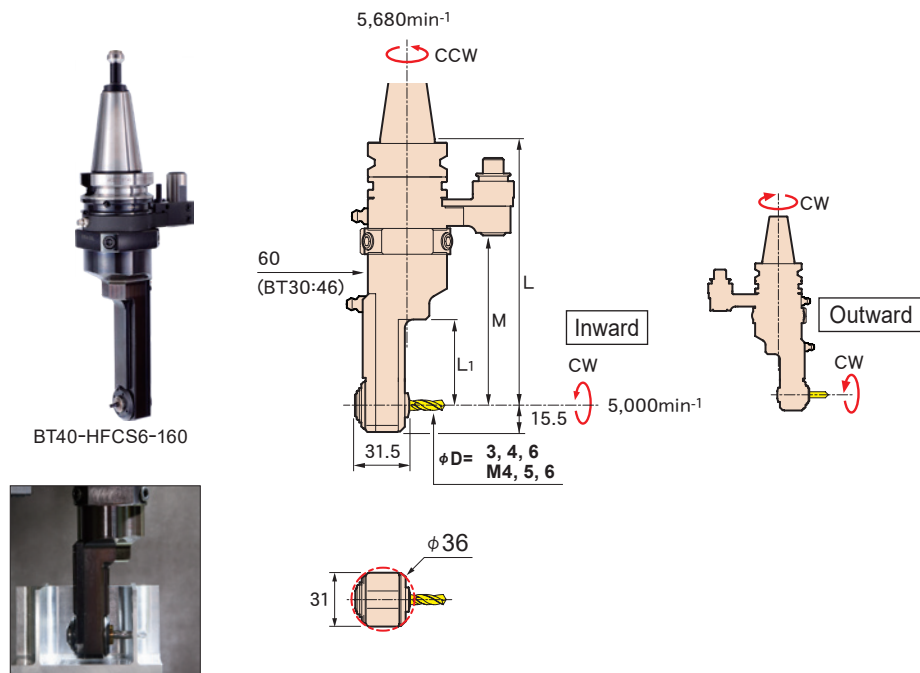
■ Note

- Other shanks are also available upon request.

Cutting data
P.13

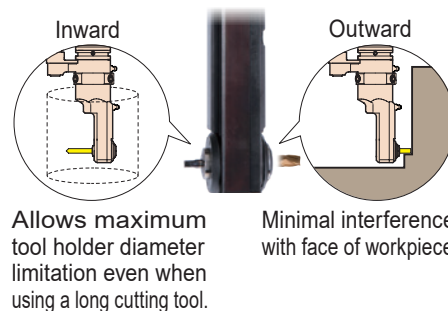
Parts list
P.105

HALF mini type



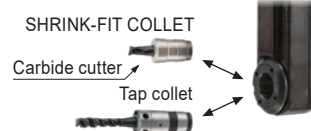
Cutter mounts in two directions

A cutting tool can be mounted both ways, inward or outward, by reassembling the angle shaft.



Collet exchange system

Shaft exchange system for Shrink-fit collet for carbide cutter (end-mill, drill) or Tap collet for Tap.



CODE (Master holder)	φD	L	L ₁	M	Kg (lbs)
BT30 -HFCS6-155	Drill·Endmill φ 3, 4, 6	155	50	100	1.8
BT40 -HFCS6-160		160	50	110	2.8
-205		205	95	155	3.0
BT50 -HFCS6-175	Tap M4, 5, 6	175	50	110	5.6
-220		220	95	155	5.8
DN40A-HFCS6-175	Drill·Endmill φ 3, 4, 6	175	50	110	3.0
-220		220	95	155	3.2
DN50A-HFCS6-175	Tap M4, 5, 6	175	50	110	5.1
-220		220	95	155	5.3
CT40 -HFCS6-175	Drill·Endmill φ 3, 4, 6	6.89	1.97	4.33	6.61
-220		8.66	3.74	6.10	7.28
CT50 -HFCS6-175	Tap M4, 5, 6	6.89	1.97	4.33	11.24
-220		8.66	3.74	6.10	11.68

Option

- Shrink-fit collet • Tap collet
- Retention knob → P.64 • Tools for assembly

Std. Access.

- Fixing spanner • Hexagonal wrench set • Low head bolt

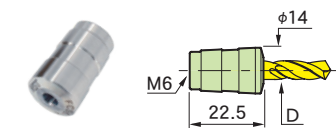
Note

- When shipping, the head direction is inward. The tool for assembly (pliers for retaining ring) is required to reassemble the collet to allow for outward positioning of the cutting tool.
- Other shanks such as HSK are also available upon request.

Caution

- The angle axis rotating direction is different due to its mounting direction, inward and outward.

Shrink-Fit Collet

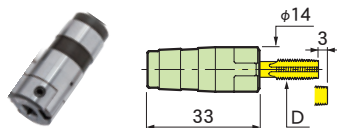


CODE	φD	Holding length
FCS6- 3	3	11~13
- 4	4	
- 6	6	12~13

Caution

- The dedicated shrink-fit collet for the Angle Head Half Mini.
- A shrink-fit heating device is required to insert and remove cutting tools.

Tap collet



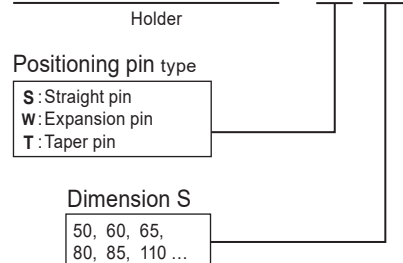
CODE	φD	Holding length
FCS6-M4	M4	16
-M5	M5	
-M6	M6	

Note

- Tap collets meet JIS standards. We can produce ANSI standard tap collet. For more information, please contact us.

■ A product code example when ordering.

BT30-HFCS6-155 - S 65



Procedure of cutter insertion to shrink-fit collet

1. Attach the shrink-fit collet to the adapter (ADH-SLK).
2. Heat the shrink-fit collet with the shrink-fit heater.
3. Attach a stopper to the carbide cutter. After finishing heating, insert the cutter to the shrink-fit collet.
4. Cool the shrink-fit collet with the shrink-fit heater.

Shrink-fit Heater (HRB-01)

1. Attach the shrink-fit collet to the adapter (ADH-SLK).
2. Heat the shrink-fit collet with the shrink-fit heater.
3. Attach a stopper to the carbide cutter. After finishing heating, insert the cutter to the shrink-fit collet.
4. Cool the shrink-fit collet with the shrink-fit heater.

CODE	Power
HRB-01	100V

Cutting data
→ P.13

Parts list
→ P.105

HALF UNIVERSAL type

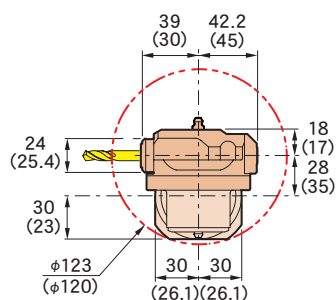
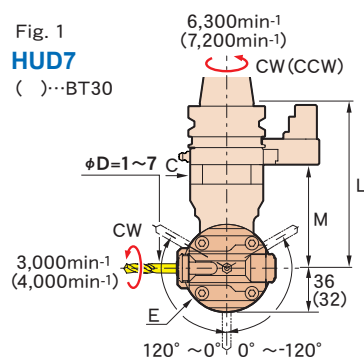
Drill · Endmill

Tap

Fig. 1

HUD7

()...BT30



BT40-HUA20-135

Fig. 2

HUA10

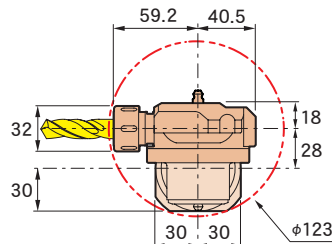
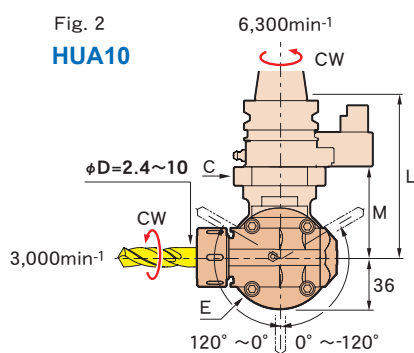


Fig. 3

HUA20

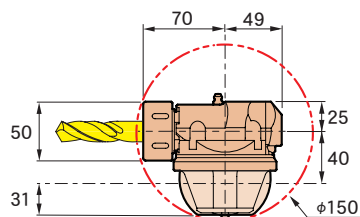
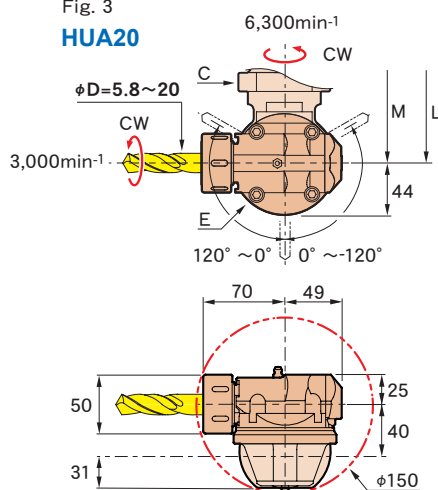


Fig. 4

HUT4

()...BT30

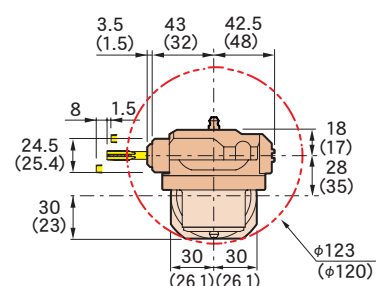
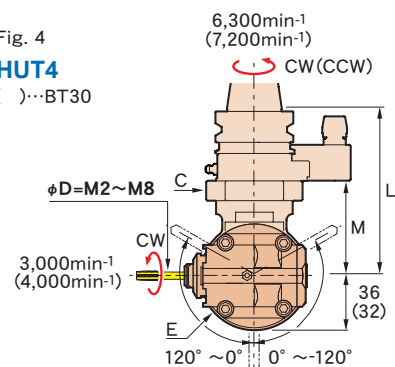
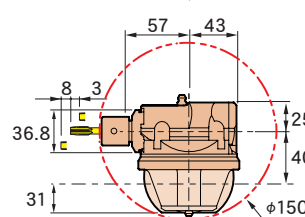
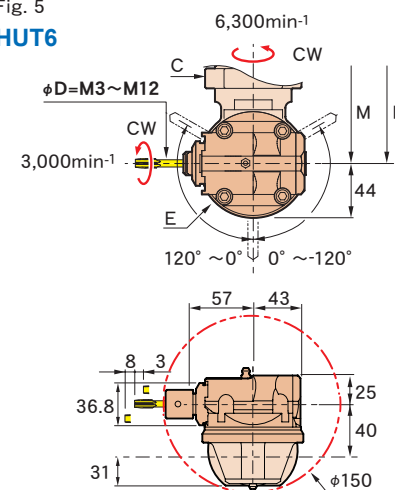


Fig. 5

HUT6



CODE (Master holder)	Fig.	φD	L	M	φC	φE		Moment kgf·mm
BT30 -HUD 7-102	1	1 ~ 7	102	39	46	64	1.8	116
-HUT 4-102	4	M2 ~ M 8						
BT40 -HUD 7-135	1	1 ~ 7	135	85	60	72	3.8	251
-HUA10-135	2	2.4 ~ 10					3.9	268
-HUA20-135	3	5.8 ~ 20		77	78	88	4.8	392
-HUT 4-135	4	M2 ~ M 8		85	60	72	3.8	251
-HUT 6-135	5	M3 ~ M12		77	78	88	4.8	392
BT50 -HUD 7-150	1	1 ~ 7		150	85	60	72	6.6
-HUA10-150	2	2.4 ~ 10	6.7					295
-HUA20-150	3	5.8 ~ 20	77		78	88	7.5	440
-HUT 4-150	4	M2 ~ M 8	85		60	72	6.6	277
-HUT 6-150	5	M3 ~ M12	77		78	88	7.5	440
DN40A -HUD 7-150	1	1 ~ 7	150		85	60	72	3.8
-HUA10-150	2	2.4 ~ 10						268
 -HUA20-150	3	5.8 ~ 20		77	78	88	5.0	392
-HUT 4-150	4	M2 ~ M 8		85	60	72		
-HUT 6-150	5	M3 ~ M12		77	78	88		
DN50A -HUD 7-150	1	1 ~ 7		150	85	60	72	6.6
-HUA10-150	2	2.4 ~ 10	6.7					295
 -HUA20-150	3	5.8 ~ 20	77		78	88	7.0	440
-HUT 4-150	4	M2 ~ M 8	85		60	72	6.6	277
-HUT 6-150	5	M3 ~ M12	77		78	88	7.0	440
CT40 -HUD 7-150	1	.04 ~ .28	5.91		3.3	2.4	2.8	8.4
-HUA10-150	2	.09 ~ .39		3.3				2.4
 -HUA20-150	3	.23 ~ .79		3	3.1	3.5	11.0	392
-HUT 4-150	4	M2 ~ M 8		3.3	2.4	2.8	8.4	251
-HUT 6-150	5	#4 ~ 1/2		3	3.1	3.5	11.0	392
CT50 -HUD 7-150	1	.04 ~ .28	5.91	3.3	2.4	2.8	14.6	277
-HUA10-150	2	.09 ~ .39					3.3	2.4
 -HUA20-150	3	.23 ~ .79		3	3.1	3.5	15.4	440
-HUT 4-150	4	M2 ~ M 8		3.3	2.4	2.8	14.6	277
-HUT 6-150	5	#4 ~ 1/2		3	3.1	3.5	15.4	440

※Distance from a gage line to center of gravity × weight (kg · mm)

■Option

- DETa-1 Collet (HUD)→P.8 • Spring collet (HUA)→P.8
- Tap sleeve (HUT)→P.8 • Retention knob→P.64 • Tools for assembly

■Std. Access.

- Fixing spanner • Hexagonal wrench set • Spanner (HUA) • Low head bolt

■Note

- Other shanks such as HSK are also available upon request.



■A product code example when ordering.

BT50 -HUA20-150 - S 65

Holder

Positioning pin type

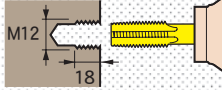
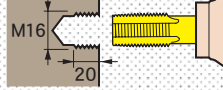
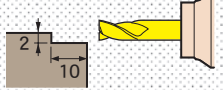
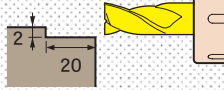
S : Straight pin
W : Expansion pin
T : Taper pin

Dimension S

50, 60, 65,
80, 85, 110 ...

Cutting data

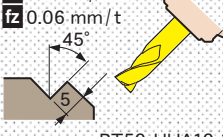
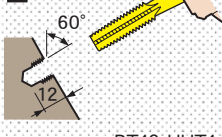
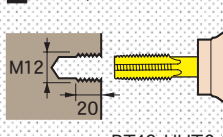
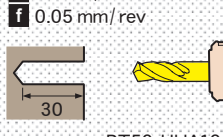
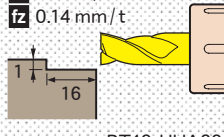
90° type

S55C $\phi 12$ Drill n 670 min ⁻¹ Vf 80 mm/min Vc 25.5 m/min f 0.12 mm/rev  BT40-HFD12-120	S55C M12 Tap n 184 min ⁻¹ Vf 322 mm/min Vc 7 m/min  BT40-HFT6-120	S50C M16 Tap n 60 min ⁻¹ Vf 120 mm/min Vc 3 m/min  BT40-HFT12-135	S55C $\phi 10$ Endmill 2-flutes n 350 min ⁻¹ Vf 50 mm/min Vc 11 m/min fz 0.07 mm/t  BT40-HFD12-120	S50C $\phi 20$ Endmill 2-flutes n 158 min ⁻¹ Vf 32 mm/min Vc 10 m/min fz 0.10 mm/t  BT40-HFA20-135
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mini type

S50C $\phi 6$ Carbide drill n 5000 min ⁻¹ Vf 250 mm/min Vc 94 m/min f 0.05 mm/rev  BT30-HFCS6-155	S50C $\phi 6$ Carbide endmill 2-flutes n 3500 min ⁻¹ Vf 210 mm/min Vc 66 m/min fz 0.03 mm/t  BT40-HFCS6-205	A7075 $\phi 6$ Carbide endmill 2-flutes n 5000 min ⁻¹ Vf 300 mm/min Vc 94 m/min fz 0.03 mm/t  BT30-HFCS6-155
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UNIVERSAL type

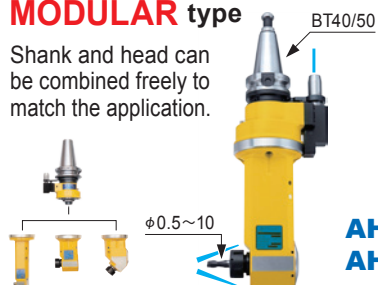
S50C $\phi 10$ Endmill 2-flutes n 900 min ⁻¹ Vf 100 mm/min Vc 28 m/min fz 0.06 mm/t  BT50-HUA10-150	S50C M8 Tap n 250 min ⁻¹ Vf 312 mm/min Vc 6.3 m/min  BT40-HUT4-135	S50C M12 Tap n 184 min ⁻¹ Vf 322 mm/min Vc 7 m/min  BT40-HUT6-135	SUS304 $\phi 10$ Drill n 314 min ⁻¹ Vf 16 mm/min Vc 9.9 m/min f 0.05 mm/rev  BT50-HUA10-150	S50C $\phi 16$ Endmill 2-flutes n 140 min ⁻¹ Vf 40 mm/min Vc 7 m/min fz 0.14 mm/t  BT40-HUA20-135
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ANGLE HEAD STANDARD type

High-rigidity standard type for end-milling applications

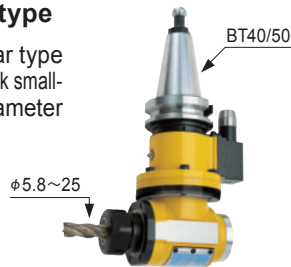
MODULAR type

Shank and head can be combined freely to match the application.



SOLID type

The popular type that can chuck small-to large-diameter cutters.



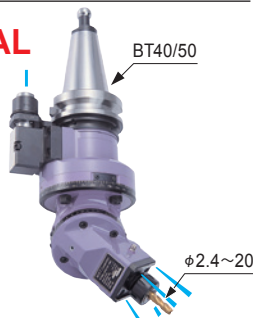
FLANGE type

Heavy-duty type that mounts directly on the machine spindle surface.



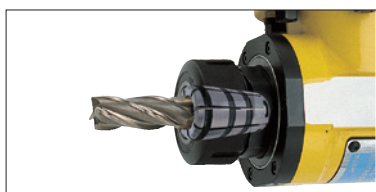
UNIVERSAL type

Cutting angle can be adjusted arbitrarily.



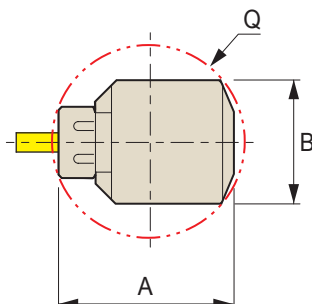
Use of collet holder

To chuck a cutting tool, the collet chuck system is used, which has a long history of good performance. This product is applicable to all the types of machining, including drilling and milling.



Compact design

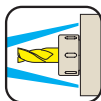
Ideal for internal machining.



Type	Model	Q	A	B
MODULAR type	AHB 5	62	57	46
	AHB 7	76	72	56
	AHB10	96	88	62
SOLID type FLANGE type	AHA20	171	160	88
	AHA25	193	180	90
UNIVERSAL type	AHU10	156	154	27.5
	AHU20	192	188.5	35

Body-through coolant

Coolant can be feed from a closer position to the cutting edge. Prevents heat generation inside the body to achieve high-speed rotation. (MODULAR type, UNIVERSAL type)



MST's Quick Change system(AHD type)

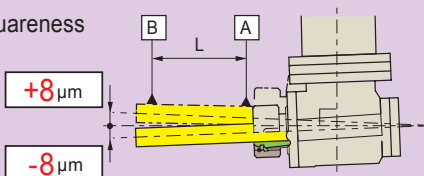
By adopting the BT30 Quick Change mechanism at the angle axis, a large variety of machining applications are made possible.



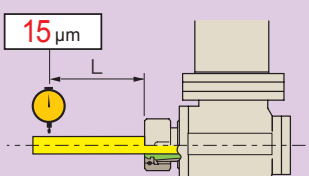
Highest Guaranteed Accuracies

All standard type angle heads have passed an accuracy test and rotation test.

Squareness



Runout accuracy

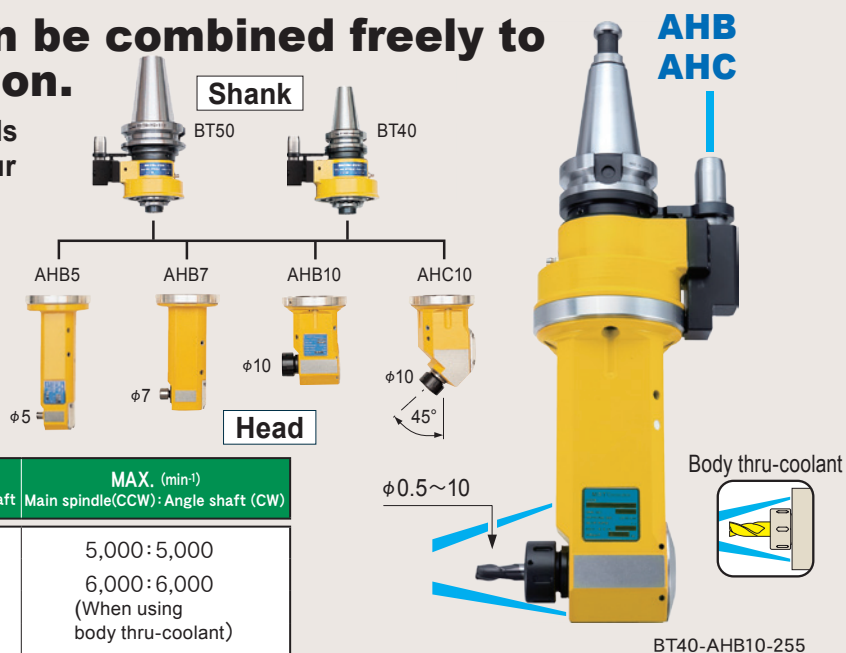


Type	Model	L
MODULAR type	AHB 5 AHB 7 AHB10 AHC10	40
UNIVERSAL type	AHU10	
SOLID type FLANGE type	AHA20 AHA25 AHD30	50
UNIVERSAL type	AHU20	

STANDARD type MODULAR type

Shank and head can be combined freely to match the application.

- ▷ Various types of shanks and heads are freely combined to meet your machining needs.



MODEL	Chuck range	Gear ratio Main spindle:Angle shaft	MAX. (min ⁻¹) Main spindle(CCW): Angle shaft (CW)
AHB 5	φ0.5~ 5	1:1	5,000:5,000
AHB 7	φ0.5~ 7		6,000:6,000
AHB10	φ2.4~ 10		(When using body thru-coolant)
AHC10			

Fig. 1

AHB

CCW

S

Positioning pin

Bracket

Fig. 2

AHC

Fig. 1

AHB

CCW

S

Positioning pin

Bracket

Fig. 2

AHC

Fig. 1

AHB

CCW

S

Positioning pin

Bracket

Fig. 2

AHC

Fig. 1

AHB

CCW

S

Positioning pin

Bracket

Fig. 2

AHC

Fig. 1

AHB

CCW

S

Positioning pin

Bracket

Fig. 2

AHC

Fig. 1

AHB

CCW

S

Positioning pin

Bracket

CODE	Fig.	φD	L	φC	L ₁	M	A	B	G	φQ	Kg	
BT40-AHB 5-210	1	0.5~ 5	210	12	20	85	25	32	46	62	5.5	ER8
-270			270			145					6.4	
-AHB 7-180		0.5~ 7	180	19	22	60	29	43	56	76	5.3	ESX12
-240			240			120					6.6	
-AHB10-195	2	2.4~ 10	195	36	29	80	38	50	62	96	6.2	C10
-255			255			140					7.9	
-AHC10-230			230		—	110	45	32.5	65	—	6.2	
BT50-AHB 5-225	1	0.5~ 5	225	12	20	85	25	32	46	62	8.8	ER8
-285			285			145					9.7	
-AHB 7-195		0.5~ 7	195	19	22	60	29	43	56	76	8.6	ESX12
-255			255			120					9.9	
-AHB10-210		2.4~ 10	210	36	29	80	38	50	62	96	9.5	C10
-270			270			140					11.2	

Option

- Spring collet→P.19 • Retention knob →P.64
- Semi-finished positioning block→P.19

Std. Access.

- A complete set of spanners and wrenches.

Note

- The phase of the drive key and the positioning pin is set freely.
- Standard specifications:
S = 60 mm, 65 mm (BT40), 80 mm, and 110 mm (BT50).
- Other shanks such as HSK are also available upon request.

Caution

- For the shape and mounting position of the positioning block, contact the machine manufacturer or MST.
- The height of the positioning pin depends on the shape of the positioning block.
- The machine spindle and angle shaft should rotate in reverse directions, so make sure the spindle rotates in the reverse direction.
- For precautions and maintenance, refer to page 115.

Shank / Head reference list

CODE	Shank	Head
BT40-AHB 5-210	BT40-MS- 98	MB 5-112
-270		-172
-AHB 7-180		MB 7- 82
-240		-142
-AHB10-195	BT50-MS-113	MB10- 97
-255		-157
-AHC10-230		MC10-132
BT50-AHB 5-225		MB 5-112
-285		-172
-AHB 7-195		MB 7- 82
-255		-142
-AHB10-210		MB10- 97
-270		-157
-AHC10-245		MC10-132

Available for
DIN / CAT.

Cutting data
P.20

STANDARD type **SOLID** type

The popular type that can chuck small- to large-diameter cutters.



MODEL	Chucking range	Gear ratio		MAX. (min ⁻¹)
		Main spindle : Angle shaft	Main spindle(CCW):Angle shaft(CW)	
AHA20	φ 5.8~20	1 : 0.81	3000 : 2430	
AHA25	φ 5.8~25	1 : 0.96	2500 : 2400	
AHD30	BT30 tools			



Fig. 1
AHA

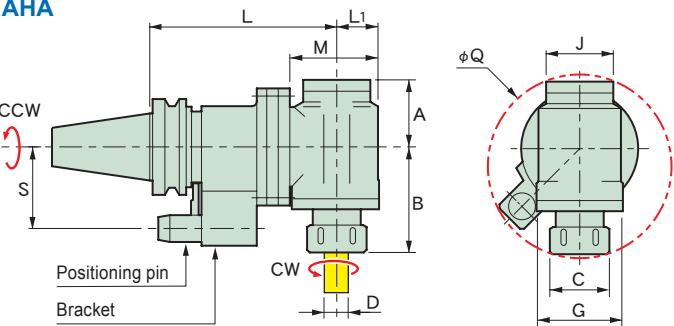
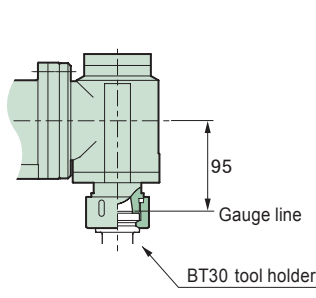


Fig. 2
AHD



CODE	Fig.	φD	L	L ₁	M	A	B	G	φC	J	φQ	K _g	
BT40-AHA20-160	1	5.8~20	160	40	86	65	95	88	50	65	171	7.3	C20
BT50-AHA20-195	1	5.8~20	195	40	92	65	95	88	50	65	171	13.1	C20
-250			249									14.8	
-AHA25-195		5.8~25	195	44	97	70	110	90	62	70	193	13.6	C25
-250			249									15.3	
-AHD30-195	2	—	195	44	97	70	112.6	90	66	70	193	14.7	—

■Option

- Spring collet→P.19 •Retention knob →P.64 •Semi-finished positioning block→P.19

■Std. Access.

- A complete set of spanners and wrenches

■Note

- The phase of the drive key and the positioning pin is set freely.
- Standard specifications: S = 60 mm, 65 mm (BT40), 80 mm, 85 mm, and 110 mm (BT50).
- Other shanks such as HSK are also available upon request.

■Caution

- For the shape and mounting position of the positioning block, contact the machine manufacturer or MST.
- The height of the positioning pin depends on the shape of the positioning block.
- The machine spindle and angle shaft should rotate in reverse directions, so make sure the spindle rotates in the reverse direction.
- For precautions and maintenance, refer to page 115.

Available for
DIN / CAT.

Cutting data
→ P.20

STANDARD type **FLANGE** type

Ideal for heavy cutting by mounting the angle head flange type directly on the machine spindle surface.



MODEL	Chuck range	Gear ratio		MAX. (min ⁻¹)
		Main spindle : Angle shaft	Main spindle(CCW):Angle shaft(CW)	
AHA20	φ5.8~20	1:0.81		3000:2430
AHA25	φ5.8~25	1:0.96		2500:2400
AHD30	BT30 tools	1:0.96		



Fig. 1
AHA

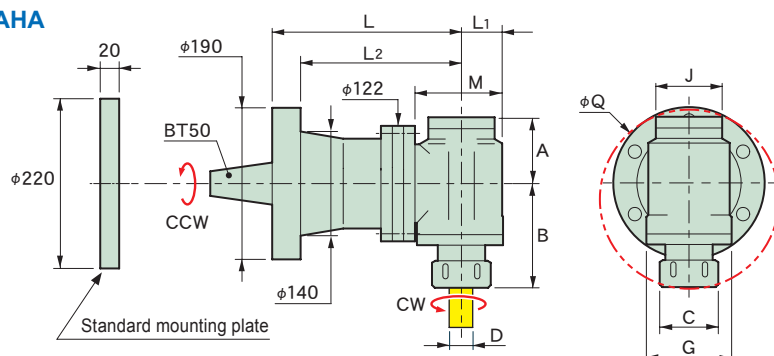
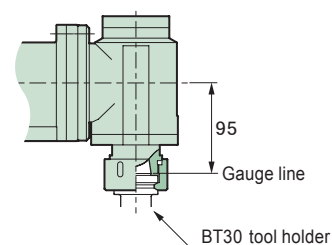


Fig. 2
AHD



CODE	Fig.	φD	L	L ₁	L ₂	M	A	B	G	φC	J	φQ	kg	
F190-AHA20-200	1	5.8~20	200	40	160	92	65	95	88	50	65	171	18	C20
-350			350		310								28	
-AHA25-200		5.8~25	200	44	160	97	70	110	90	62	70	193	18.5	C25
-350			350		310								28.5	
-AHD30-200	2	—	200		160					66			19.6	—
-350			350		310								29.8	

■Option

- Spring collet → P.19
- Retention knob → P.64

■Std. Access.

- A complete set of spanners and wrenches
- Standard mounting plate (No mounting holes are provided.)
- Mounting bolts for ANGLE HEAD

■Note

- NT50U shank is also available.

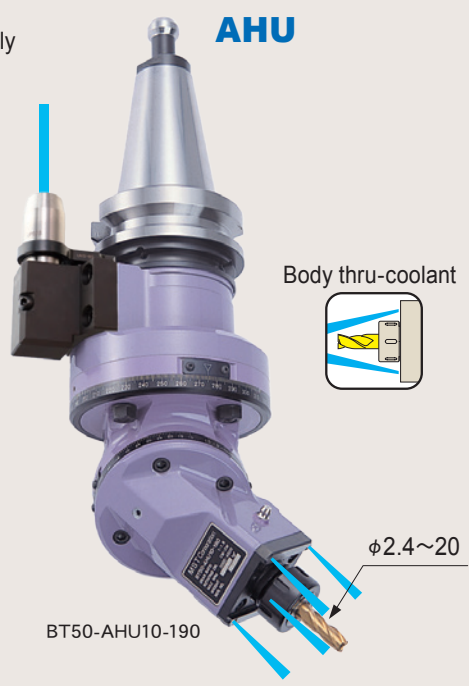
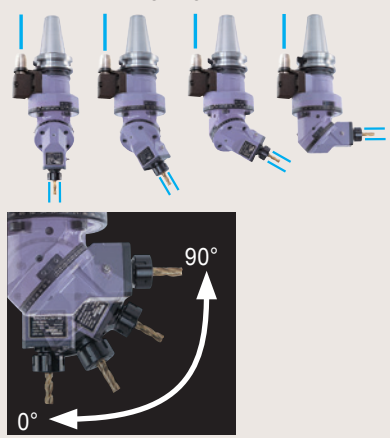
■Caution

- For mounting plate shapes and mounting bolt location, contact the machine manufacturer or MST.
- The machine spindle and angle shaft should rotate in reverse directions, so make sure the spindle rotates in the reverse direction.
- For precautions and maintenance, refer to page 115.

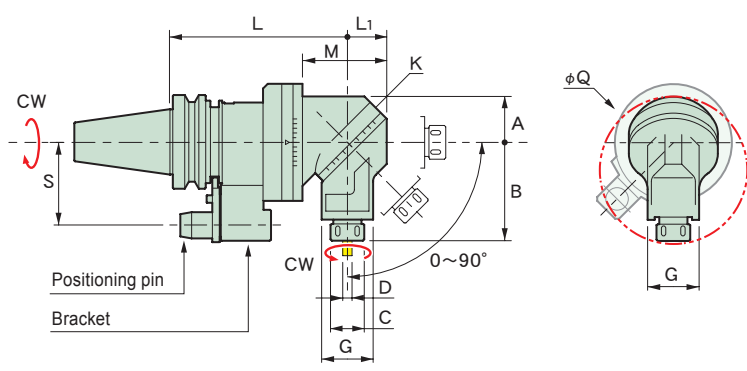
STANDARD type **UNIVERSAL type**

Machining at every angle is possible with just this one unit.

Splash coolant-through body
Whatever machining angle is set, coolant is properly supplied to the cutting edge.



MODEL	Chucking range	Gear ratio Main spindle : Angle shaft	MAX. (min-1) Main spindle(CW):Angle shaft(CW)
AHU10	φ 2.4~10	1 : 1.5	3000 : 4500
AHU20	φ 5.8~20	1 : 1	3000 : 3000



CODE	φD	L	L ₁	M	A	B	K	G	φC	φQ	Kg	
BT40-AHU10-175	2.4~10	175	42	96	49	105	95	55	32	156	9.6	C10
BT50-AHU10-190	2.4~10	190	42	90	49	105	95	55	32	192	13.9	C10
-AHU20-200	5.8~20	200	54	112	58.5	130	120	70	50		15.8	C20

- Option
 - Spring collet →P.19 •Retention knob →P.64 •Semi-finished positioning block →P.19 •Test bar
- Std. Access.
 - A complete set of spanners and wrenches
- Note
 - The phase of the drive key and the positioning pin is set freely.
 - Standard specifications: S = 60 mm, 65 mm (BT40), 80 mm, 85 mm, and 110 mm (BT50).
 - Products other than BT shanks can be manufactured upon request.
- Caution
 - For the shape and mounting position of the positioning block, contact the machine manufacturer or MST.
 - The machine spindle and angle shaft should rotate in reverse directions, so make sure the spindle rotates in the reverse direction.
 - The machine spindle and angle shaft should rotate in forward directions, so make sure the spindle rotates in the forward direction.
 - For precautions and maintenance, refer to page 115.

Test bar

Use for super accurate angle adjustment.

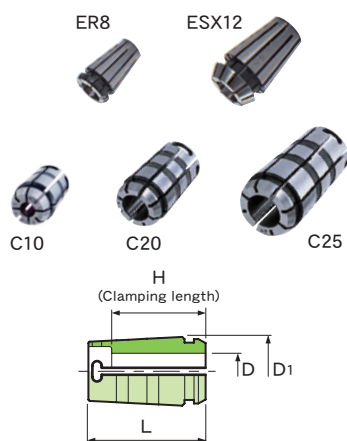
CODE	Holder type
TBU10	AHU10
TBU20	AHU20



Available for
DIN / CAT.

Cutting data
➔ P.20

SPRING COLLET



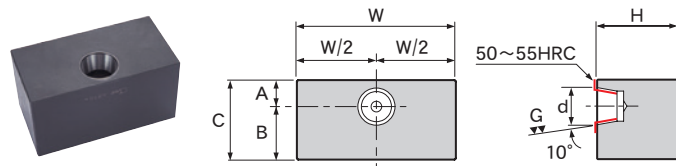
CODE	φD	φD ₁	L	H	Holder type
ER8-D	1 ~ 5 (0.5 Steps)	8.5	13.5	-	AHB 5
ESX12-D	1 ~ 3 (0.5 Steps)	12	19.5	-	AHB 7
	4 ~ 7 (1.0 Steps)				
C10-D	2.6~ 5.8 (0.2 Steps)	17.2	26	18	AHB10
	6 ~10 (0.2 Steps)			20	AHC10 AHU10
C20-D	6 ~ 9.8 (0.2 Steps)	29.5	50	29	AHA20 AHU20
	10 ~15.8 (0.2 Steps)			33	
	16 ~20 (0.2 Steps)			40	
C25-D	6 , 8	36.5	68	35	AHA25
	10 ~15 (0.5 Steps)			46	
	15.5~20 (0.5 Steps)			54	
	20.5~25 (0.5 Steps)			57	

Option

- Collet remover (C10, C20) → P.38

Semi-finished positioning block

The semi-finished positioning block must be modified to the appropriate shape by the customer after delivery. Determine the shape and dimensions as follows, and then modify the positioning block as necessary.



CODE	A	B	C	W	H	d	Spindle	Material
AB-15	15	43	58	92	58	20	BT40	S50C
-12	20		63	120	63	28	BT50	

- Obtain the machine manufacturer's drawing for the positioning block and modify the positioning block in accordance with that drawing.
- Determine the dimensions as shown in the instruction and then modify.
 - This block may not be applicable for dimensional reasons. Carefully check to see whether the positioning block is applicable.
 - The positioning block exclusively for your machine may also be available on request.
 - For further information, please contact MST.

Custom-made products

We are proud of our over 35 years of experience custom making products for our customers. We can produce the best product for you depending on your applications such as O.D and I.D machining thanks to our accumulated know-how.

35

years

Manufacturing history

1

unit

Production starting from just 1 unit

2~4

months

Delivery

19,300

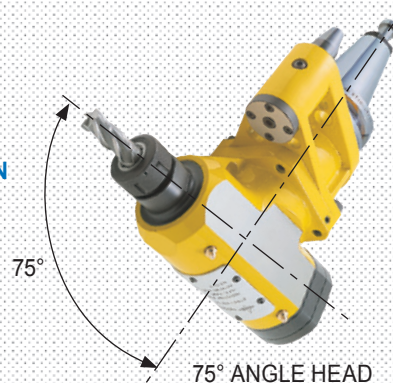
units

Custom : 1,300 units
Design
Standard : 18,000 units

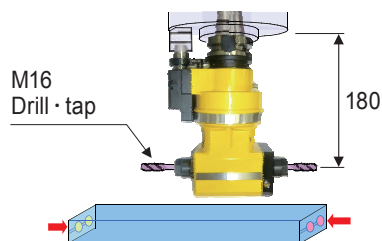
ANGLE HEAD CUSTOM DESIGN



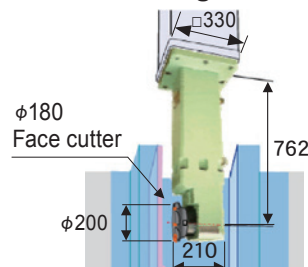
For more information, please contact us.



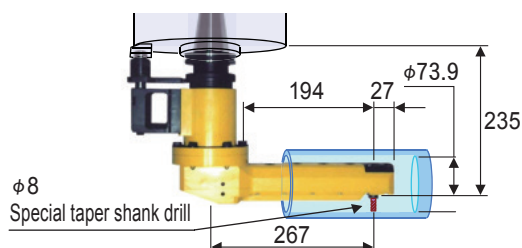
Dual side machining ANGLE HEAD



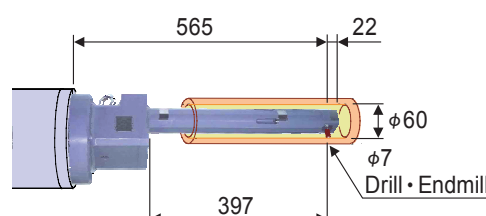
Side face machining ANGLE HEAD



Internal bore surface machining ANGLE HEAD



Internal bore surface machining ANGLE HEAD



Cutting data

MODULAR type

SUS304 $\phi 10$ n 640 min ⁻¹ Endmill Vf 60 mm/min 2 flutes Vc 20 m/min fz 0.05 mm/t BT40-AHB10-195	A2017 $\phi 10$ n 4000 min ⁻¹ Carbide endmill Vf 400 mm/min 2 flutes Vc 126 m/min fz 0.05 mm/t BT40-AHB10-195	S50C $\phi 10$ n 640 min ⁻¹ Endmill Vf 60 mm/min 2 flutes Vc 20 m/min fz 0.05 mm/t BT50-AHB10-210
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SOLID type

A2017 $\phi 16$ n 1800 min ⁻¹ Endmill Vf 130 mm/min 2 flutes Vc 90 m/min fz 0.04 mm/t BT50-AHA25-195	SUS304 $\phi 12$ n 527 min ⁻¹ Endmill Vf 20 mm/min 2 flutes Vc 60 m/min fz 0.06 mm/t BT40-AHA20-160	SUS304 $\phi 16$ n 570 min ⁻¹ Endmill Vf 40 mm/min 2 flutes Vc 29 m/min fz 0.04 mm/t BT50-AHA25-195	S55C $\phi 12$ n 527 min ⁻¹ Drill Vf 39 mm/min 2 flutes Vc 20 m/min f 0.07 mm/rev BT40-AHA20-160	FC30 $\phi 12$ n 816 min ⁻¹ Endmill Vf 60 mm/min 2 flutes Vc 31 m/min fz 0.04 mm/t BT50-AHD30-195 + BT30-CTA20-45
S50C $\phi 16$ n 630 min ⁻¹ Endmill Vf 80 mm/min 2 flutes Vc 32 m/min fz 0.06 mm/t BT50-AHA25-195				

UNIVERSAL type

A2017 $\phi 10$ n 2000 min ⁻¹ Endmill Vf 200 mm/min 2 flutes Vc 63 m/min fz 0.07 mm/t BT50-AHU10-190 (45°)	S50C $\phi 20$ n 350 min ⁻¹ Carbide endmill Vf 70 mm/min 2 flutes Vc 22 m/min fz 0.1 mm/t BT50-AHU20-200 (45°)
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