

PARTS

Wrench · Spanner

Fig. 1

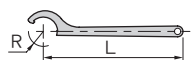


Fig. 2



Fig. 3

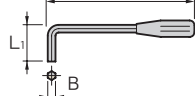


Fig. 4



Fig. 5



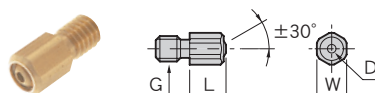
CODE	Fig.	L	R	B	L ₁	Holder type
DW-2.5-110	5	110	—	2.5	—	DTB 3
F - 22	1	110	22	—	—	DTA 3
- 38		148.5	19			DTA 7
- 45		225	22.5			DTA12
FC- 32	1	120	16	—	—	CTH10(A40, E32, E40), HUD, HUA10, AHU10, HUT4
- 36		208	18			CTA10, CTH10
- 50		281	25			CTA20, CTH20
- 55		284	27.5			CTH25(A40)
- 62		312	31			CTA25, CTH25
- 74		364	37			CTA32, CTH32
- 90			45			CTA40
FF- 50	1	165	22.5	—	—	FMA25.4(ST32B)
- 60		195	26			FMA25.4(ST42B), FMA31.75
FM- 72	1	204	36	—	—	ART32(BT40, A50M, A63, NT40, H50)
- 82		234	41			ART32(BT50, A100, NT50)
- 97		239	48.5			ART42(BT50, A100, NT50)
RC- 26	4	240	—	24	—	CTS10(E32)
TW- 4	2	77	—	4	—	DTB 7(E32)
- 5		153	—	5	—	DTB 7
- 6		173	—	6	—	DTB12
W -135	3	132.5	—	5	110	SLK12 (SLIMLINE 2PIECE TYPE)
-135 DR						DTB 7 (F63M), DTB12(E40, E50, F63M), DTE7, DTE12
-206		200		6	30	SLZ25
-308		300		8		SLZ32, SLZ42

Adjustable torque wrench



Spanner for torque wrench	Adjustable torque wrench	R	Holder type	Recommended tightening torque	
F -38AW	AW-1	19	DTA 7	D7-1.5 :	20N·m
-45AW		22.5	DTA12	D7-2.0~7.0 :	40N·m
FC-36AW	AW-1	18	CTA10 / CTH10	C10-2.6~5.0 :	40N·m
				C10-5.2~5.8 :	50N·m
				C10-6~10 :	60N·m
-50AW	AW-2	25	CTA20 / CTH20	C20(All sizes) :	120N·m

Nozzle



CODE	L	G	W	φD	Holder type	Q'ty
NOZ-M4-12	6.3	M4	4.5	1.2	BT40-ART	12pcs.
-60					A63 -ART -SLK	60pcs.
-M6-12	8.5	M6	7	1.8	BT50-ART	12pcs.
-60					A100-ART -SLZ	60pcs.

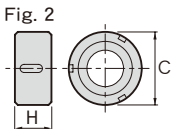
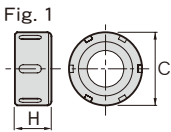
■Std. Access.

- Wrench for attachment

■Caution

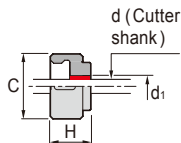
- Four nozzles are necessary for one tool holder.

Nut (For collet holder)



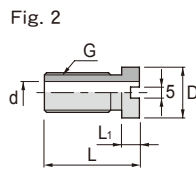
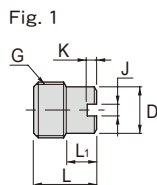
CODE	Fig.	φC	H	Holder type
NUA-CTA10	1	36	18	CTA10, AHB10
-CTA20		50	25	CTA20, AHA20, AHU20
-CTA25		62	28.5	CTA25, AHA25
-CTA32		74	32	CTA32
-CTA40		90	36	CTA40
-CTH10	2	36	18	CTH10
-CTH20		50	25	CTH20
-CTH25		62	28.5	CTH25
-CTH25-55		55		CTH25 (A40)
-CTH32		74	32	CTH32
-CTH10-32	3	32	18	CTH10 (A40, E32, E40), AHU10
-CTS10		26	21	CTS10

Sukima nut (For collet holder)



CODE	φC	H	φd	φd ₁	S	Holder type
NUB-CTH10- 3.6	36	23	3	3.6	3.1	CTH10
- 4.5			4	4.5	3.3	
- 5.5			5	5.5	3.7	
- 6.4			6	6.4	3.9	
- 8.4			8	8.4	4.6	
-10.3	50	30	10	10.3	4.8	CTH20
-CTH20- 6.4			6	6.4	3.9	
- 8.4			8	8.4	4.6	
-10.3			10	10.3	4.8	
-12.3			12	12.3		
-16.2	62	34.5	16	16.2	5.1	CTH25
-20.2			20	20.2	5.7	
-CTH25-20.2			25	25.2	5.9	
-CTH32-25.2	74	38	25	25.2		CTH32
-32.1			32	32.1	6.0	

Adjust screw



Use this to adjust the cutter projection length.

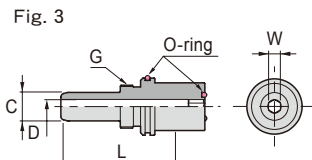
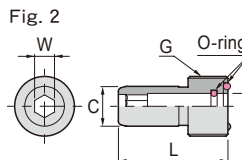
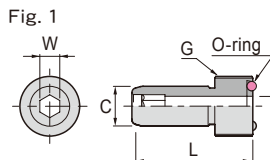
※1 BT30, SE30M, ST25T and ST32T are excluded.

※2 BT40-CTA25-75 is excluded.

CODE	Fig.	L	φD	φd	L ₁	J	K	G	Holder type
AJC-M14	1	22	10	-	8	1.5	3	M14×1.5	CTA10 ST25T-CTA20 SE30M-CTA20
-M24		27	20		13	5	4	M24×1.5	CTA20(※1) BT40-CTA25- 75 BT40-CTA32-105
-M28			25					M28×1.5	CTA25(※2)
-M18		24	15		8			M18×1.5	BT30-CTA20, ST32T-CTA20
-M18L	2	43	23						BT50-CTA32, CTA40 BT50-SLZ25, SLZ32, SLZ42
AJN-M18L	2	38	23	10	8	-	-	M18×1.5	BT40-ART32
-M18		63							BT50-ART32, ART42

Coolant duct

Coolant duct (Fixed)

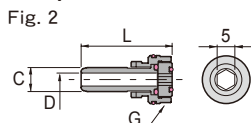
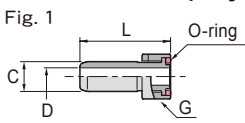


CODE	Fig.	φC	φD	L	G	W	Shank type
CD40 -01	1	8	4	29.5	M12×1	4	A40, T40
-03	3			35.5			A40-CTH10-75
-04				36.5			A40-CTH25-95
CD50 -01	1	10	5	33	M16×1	5	A50, T50
-03	3			39			A50-CTH25-105
-04				59			
CD63 -01	1	12	6	36.5	M18×1	6	A63, T63
-02	2						A63-CTH10-75
-03	3			39.5		5	A63-CTH20-90
-04				60.5			A63-CTH25-105
CD100-01	1	16	8	44	M24×1.5	8	A100, T100
-02	2						10.3

■Note

• Comes as a standard feature with our holders. However, for the CD50-03 and the CD63-03, CD50-04 and CD63-04 come as options, respectively.

Coolant duct (Adjustable)

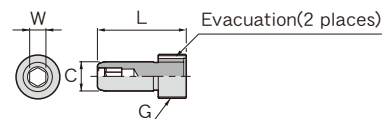


CODE	Fig.	φC	L	φD	G	Replaceable coolant duct
CD63 -01F	1	12	36.5	7	M18×1	CD 63-01
-03F	2		45.5	6.5		CD 63-03
CD100-01F	1	16	44	10	M24×1.5	CD100-01

■Note

- For some machines, the use of a coolant duct (Adjustable) is recommended. The existing coolant duct is replaced with an adjustable one at your request only when you have placed an order for the holder.
- If the replacement of the coolant duct is needed after the purchase, use the wrench CD63-01F-RNT.

Dummy duct



CODE	φC	L	G	W	Replaceable coolant duct
CD40 -A1	8	29.5	M12×1	4	CD 40-01
CD50 -A1	10	33	M16×1	5	CD 50-01
CD63 -A1	12	36.5	M18×1	6	CD 63-01
CD100-A1	16	44	M24×1.5	8	CD100-01

ANGLE HEAD **HALF** PARTS LIST

HFD7 / HFT4 (BT30/40/50, A63, DN40/50, CT40/50)

CODE (Master holder)	1 Shank	2 Orientation Ring	8 Washer for intermediate bearing B	9 Intermediate bearing	19 Head
BT30 -HFD7-122	BT30 -FSA-7S	ORR-30	-	-	FBA-7S
-HFT4-122	BT30 -FSA-7L		FZ-7	6804ZZ	FBA-7L
-HFD7-182					
-HFT4-182					
BT40 -HFD7-120	BT40 -FSA-7S	ORR-40	-	-	FBA-7S
-HFT4-120	BT40 -FSA-7L		FZ-7	6804ZZ	FBA-7L
-HFD7-180	BT40 -FSA-7L				
-HFT4-180					
BT50 -HFD7-195	BT50 -FSA-7L	ORR-40			FBA-7L
-HFT4-195	BT50 -FSA-7XL				FBA-7XL
-HFD7-255					
-HFT4-255					
A63 -HFD7-183	A63 -FSA-7L	ORR-40	FZ-7	6804ZZ	FBA-7L
-HFT4-183	A63 -FSA-7XL				FBA-7XL
-HFD7-243					
-HFT4-243					
DN40A-HFD7-135	DN40A-FSA-7S	ORR-40	-	-	FBA-7S
-HFT4-135	DN40A-FSA-7L		FZ-7	6804ZZ	FBA-7L
-HFD7-195	DN40A-FSA-7L				
-HFT4-195	DN40A-FSA-7L				
DN50A-HFD7-195	DN50A-FSA-7L				FBA-7L
-HFT4-195	DN50A-FSA-7XL				FBA-7XL
-HFD7-255					
-HFT4-255					
CT40 -HFD7-135	CT40 -FSA-7S	ORR-40	-	-	FBA-7S
-HFT4-135	CT40 -FSA-7L		FZ-7	6804ZZ	FBA-7L
-HFD7-195	CT40 -FSA-7L				
-HFT4-195	CT40 -FSA-7L				
CT50 -HFD7-195	CT50 -FSA-7L				FBA-7L
-HFT4-195	CT50 -FSA-7XL				FBA-7XL
-HFD7-255					
-HFT4-255					

■ Std. Access.

- Fixing spanner (KS-23) • Hexagonal wrench set (W-1550S)
- Single-ended wrench 13mm (SN-13)

※ 3, 9, 11, 14 and 22 are able to use standard commercial items.

The tools for assembly

Wrench (for shank)

To be used for tightening 11.

CODE
FC-32



Wrench (for head)

To be used for tightening 12 and 13.

CODE
TSH-HF7



HFD7

Drill
(φ1~7)

DETa-1 Collet
(D7)→P.8

23 Angle shaft(for drilling)
CODE FR-D7L

26 Draw bolt
CODE FR-7BL

21 Collar C
CODE FBC-7C

HFT4

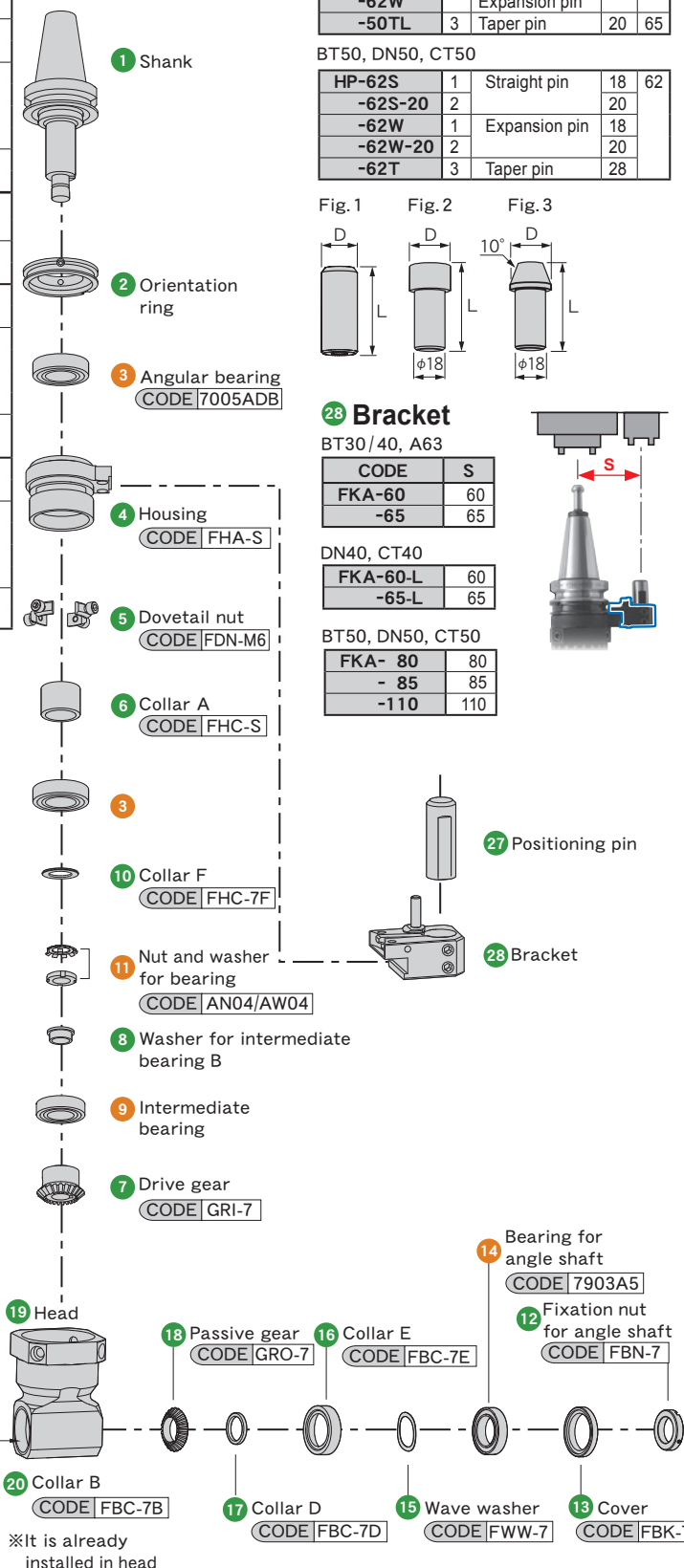
Tap sleeve
(TA4)→P.8

Tap
(M2~8)

25 Draw nut and spring
CODE FR-T4NS

22 Bearing for angle shaft
CODE 71804

24 Angle shaft(for tapping)
CODE FR-T4



27 Positioning pin

BT30/40, A63

CODE	Fig.	Pin type	φD	L
HP-50S	1	Straight pin	18	50
-50W		Expansion pin		
-50T	3	Taper pin	20	

DN40, CT40

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62W		Expansion pin		
-62TL	3	Taper pin	20	65

BT50, DN50, CT50

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62S-20	2		20	
-62W	1	Expansion pin	18	
-62W-20	2		20	
-62T	3	Taper pin	28	

Fig. 1

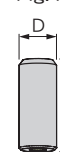


Fig. 2



Fig. 3



28 Bracket

BT30/40, A63

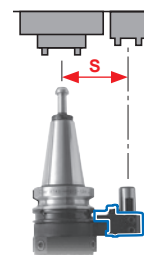
CODE	S
FKA-60	60
-65	65

DN40, CT40

CODE	S
FKA-60-L	60
-65-L	65

BT50, DN50, CT50

CODE	S
FKA-80	80
-85	85
-110	110



HFD7L / HFA10 / HFT4L (BT30)

CODE (Master Holder)
BT30-HFD7L-120
-HFA10-120
-HFT4L-120

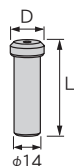
■ Std. Access.

- Fixing spanner (KS-23) (HFD7L)
- Hexagonal wrench set (W-1550S)
- Single-ended wrench (SN-13) (HFD7L/HFA10)
- Fook spanner (FC-32) (HFA10)

※ 3, 4, 9, 15 and 16 are able to use standard commercial items.

28 Positioning pin

CODE	Pin type	φD	L
HP-45S	Straight pin	12	45
HP-E50S	Straight pin	18	50

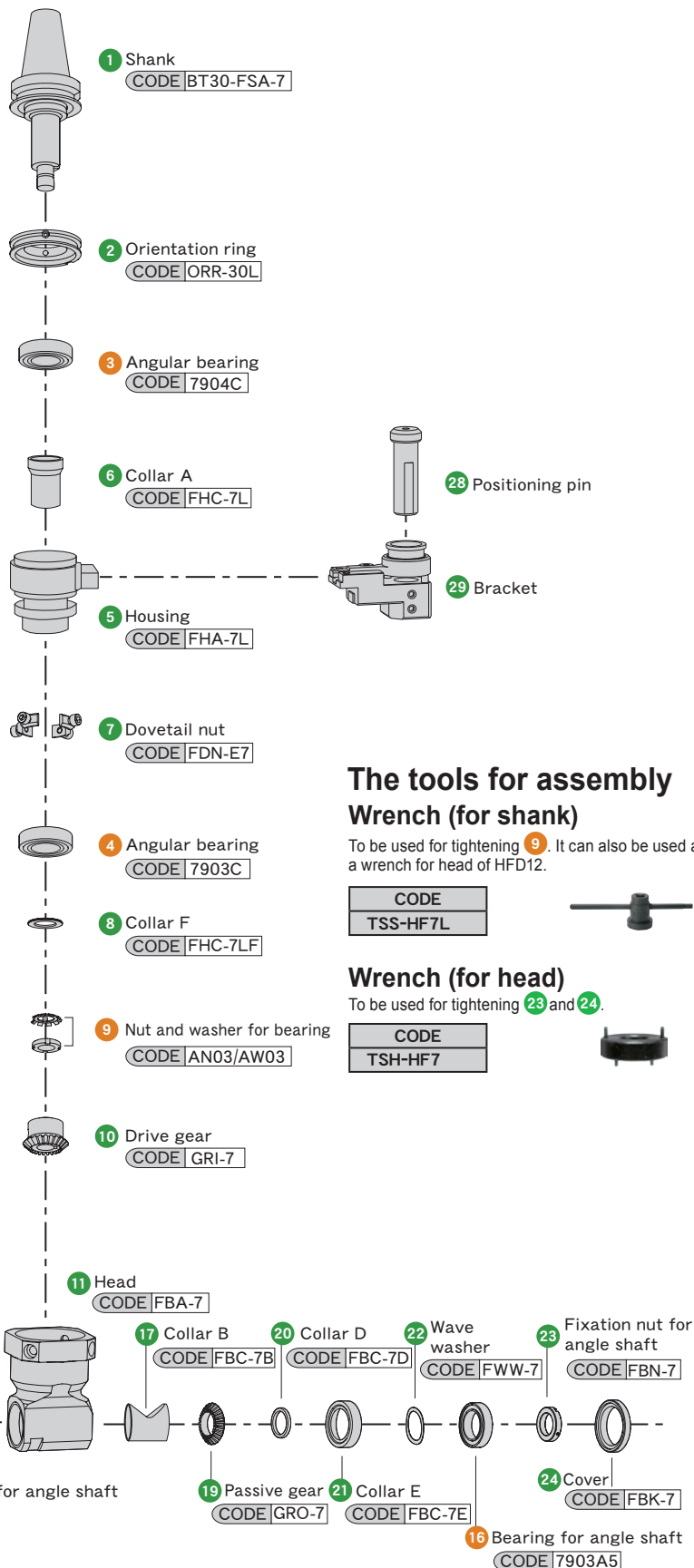
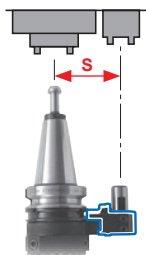


29 Bracket

CODE	S
FKC-50	50
FKC-65	65

■ Note

- Be sure to use positioning pin (HP-45S) and the bracket (FKC-50) in a combination, and the positioning pin (HP-E50S) and the bracket (FKC-65) in combination.



The tools for assembly Wrench (for shank)

To be used for tightening 9. It can also be used as a wrench for head of HFD12.

CODE
TSS-HF7L



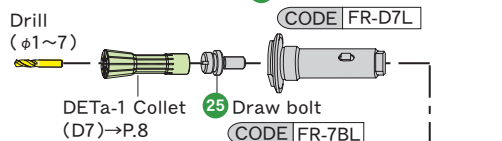
Wrench (for head)

To be used for tightening 23 and 24.

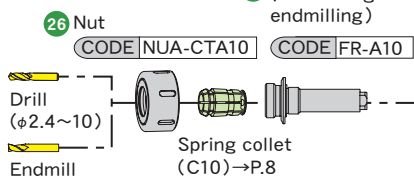
CODE
TSH-HF7



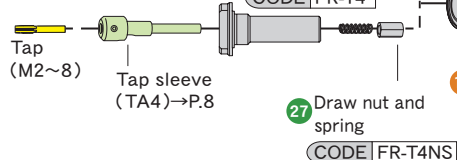
HFD7L



HFA10



HFT4L



HFD12 / HFT6 (BT30/40/50, A63, DN40/50, CT40/50)

CODE (Master Holder)	1 Shank	2 Orientation Ring	3 Angular bearing	4 Housing	6 Collar A	7 Collar AXL	8 Intermediate bearing
BT30 -HFD12-122 -HFT 6-122	BT30 -FSA-12S	ORR-30	7005ADB	FHA-S	FHC-S	-	-
BT40 -HFD12-120 -HFT 6-120	BT40 -FSA-12S	ORR-40		FHA-L	FHC-L		
-HFD12-180 -HFT 6-180	BT40 -FSA-12L			FHA-S	FHC-S		
BT50 -HFD12-135 -HFT 6-135	BT50 -FSA-12S			FHA-L	FHC-L		
-HFD12-195 -HFT 6-195	BT50 -FSA-12L						
-HFD12-255 -HFT 6-255	BT50 -FSA-12XL		7906A5DB	FHA-XL	FHC-XL1 (※)	FHC-XL2 (※)	6005VV
A63 -HFD12-123 -HFT 6-123	A63 -FSA-12S	ORR-40	7005ADB	FHA-S	FHC-S	-	-
-HFD12-183 -HFT 6-183	A63 -FSA-12L			FHA-L	FHC-L		
-HFD12-243 -HFT 6-243	A63 -FSA-12XL		7906A5DB	FHA-XL	FHC-XL1 (※)	FHC-XL2 (※)	6005VV
DN40A-HFD12-135 -HFT 6-135	DN40A-FSA-12S	ORR-40	7005ADB	FHA-S	FHC-S	-	-
-HFD12-195 -HFT 6-195	DN40A-FSA-12L			FHA-L	FHC-L		
DN50A-HFD12-135 -HFT 6-135	DN50A-FSA-12S			FHA-S	FHC-S		
-HFD12-195 -HFT 6-195	DN50A-FSA-12L			FHA-L	FHC-L		
-HFD12-255 -HFT 6-255	DN50A-FSA-12XL		7906A5DB	FHA-XL	FHC-XL1 (※)	FHC-XL2 (※)	6005VV
CT40 -HFD12-135 -HFT 6-135	CT40 -FSA-12S	ORR-40	7005ADB	FHA-S	FHC-S	-	-
-HFD12-195 -HFT 6-195	CT40 -FSA-12L			FHA-L	FHC-L		
CT50 -HFD12-135 -HFT 6-135	CT50 -FSA-12S			FHA-S	FHC-S		
-HFD12-195 -HFT 6-195	CT50 -FSA-12L			FHA-L	FHC-L		
-HFD12-255 -HFT 6-255	CT50 -FSA-12XL		7906A5DB	FHA-XL	FHC-XL1 (※)	FHC-XL2 (※)	6005VV

(※) FHC-XL1/XL2 FHC-XL1/XL2 Set 2pcs-each

■ Std. Access.

- Fixing spanner (KS-30) ● Hexagonal wrench set (W-1550S)
- Single-ended wrench 17mm (SN-17)

※ 3, 8, 10, 13 and 16 are able to use standard commercial items.

The tools for assembly Wrench (for shank)

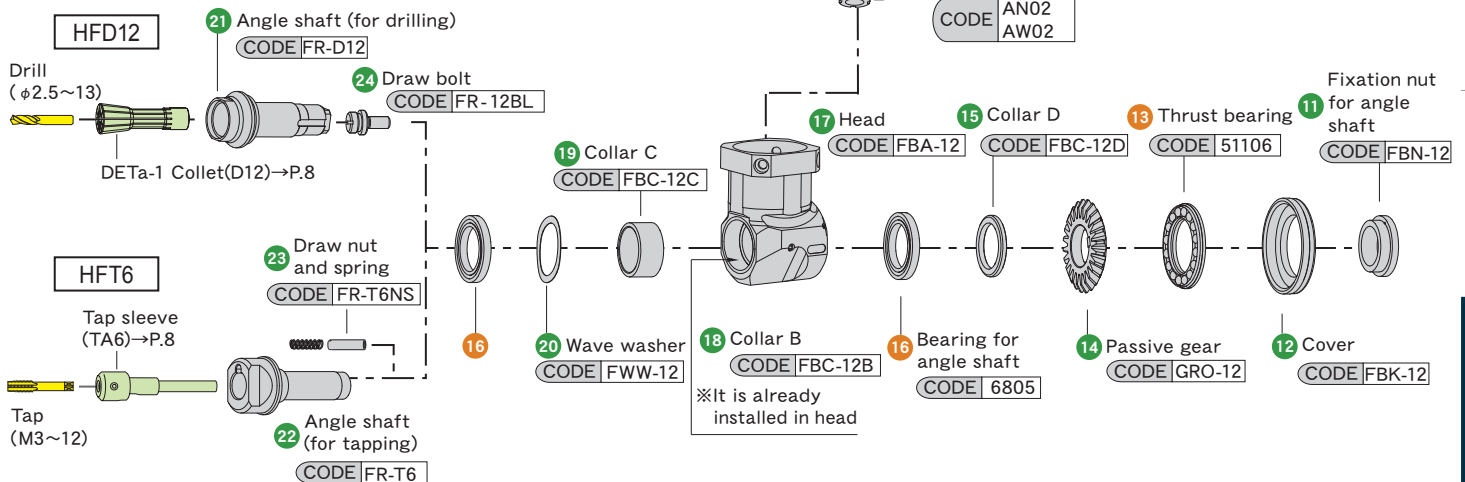
To be used for tightening 10.

CODE
TSS-HF12

Wrench (for head)

To be used for tightening 11 and 12.

CODE
TSH-HF12



25 Positioning pin

BT30/40, A63

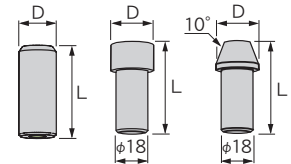
CODE	Fig.	Pin type	φD	L
HP-50S	1	Straight pin	18	50
-50W		Expansion pin		
-50T	3	Taper pin	20	

DN40, CT40

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62W		Expansion pin		
-62TL	3	Taper pin	20	65

BT50, DN50, CT50

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62S-20	2		20	
-62W	1	Expansion pin	18	
-62W-20	2		20	
-62T	3	Taper pin	28	



26 Bracket

BT30/40, A63

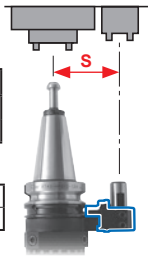
CODE	S
FKA-60	60
-65	65

DN40, CT40

CODE	S
FKA-60-L	60
-65-L	65

BT50, DN50, CT50

CODE	S
FKA-80	80
-85	85
-110	110



HFA20 / HFT12 (BT40/50, A63, DN40/50, CT40/50)

CODE (Master Holder)	1 Shank	3 Needle bearing	5 Angular bearing	6 Collar A	7 Housing	8 Angular bearing
BT40 -HFA20-135	BT40 -FSA-20S	—	7906A5	FHC-20S	FHA-20S	7905A5
-HFT12-135	BT40 -FSA-20L			FHC-20L	FHA-20L	
-HFA20-195	BT40 -FSA-20S			FHC-20S	FHA-20S	
-HFT12-195	BT50 -FSA-20S			FHC-20L	FHA-20L	
BT50 -HFA20-150	BT50 -FSA-20L			FHC-20L	FHA-20L	
-HFT12-150	BT50 -FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
-HFA20-210	BT50 -FSA-20L			FHC-20L	FHA-20L	
-HFT12-210	BT50 -FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
-HFA20-270	BT50 -FSA-20L			FHC-20L	FHA-20L	
-HFT12-270	BT50 -FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
A63 -HFA20-198	A63 -FSA-20L	—	7906A5	FHC-20L	FHA-20L	7905A5
-HFT12-198	A63 -FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
-HFA20-258	A63 -FSA-20L			FHC-20L	FHA-20L	
-HFT12-258	A63 -FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
DN40A-HFA20-150	DN40A-FSA-20S	—	7906A5	FHC-20S	FHA-20S	7905A5
-HFT12-150	DN40A-FSA-20L			FHC-20L	FHA-20L	
-HFA20-210	DN40A-FSA-20L			FHC-20L	FHA-20L	
-HFT12-210	DN40A-FSA-20L			FHC-20L	FHA-20L	
DN50A-HFA20-150	DN50A-FSA-20S			FHC-20S	FHA-20S	
-HFT12-150	DN50A-FSA-20L			FHC-20L	FHA-20L	
-HFA20-210	DN50A-FSA-20L			FHC-20L	FHA-20L	
-HFT12-210	DN50A-FSA-20L			FHC-20L	FHA-20L	
-HFA20-270	DN50A-FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
-HFT12-270	DN50A-FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
CT40 -HFA20-150	CT40 -FSA-20S	—	7906A5	FHC-20S	FHA-20S	7905A5
-HFT12-150	CT40 -FSA-20L			FHC-20L	FHA-20L	
-HFA20-210	CT40 -FSA-20L			FHC-20L	FHA-20L	
-HFT12-210	CT40 -FSA-20L			FHC-20L	FHA-20L	
CT50 -HFA20-150	CT50 -FSA-20S			FHC-20S	FHA-20S	
-HFT12-150	CT50 -FSA-20L			FHC-20L	FHA-20L	
-HFA20-210	CT50 -FSA-20L			FHC-20L	FHA-20L	
-HFT12-210	CT50 -FSA-20L			FHC-20L	FHA-20L	
-HFA20-270	CT50 -FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—
-HFT12-270	CT50 -FSA-20XL	TAF374720	7905A5DB	FHC-20XL	FHA-20XL	—

■ Std. Access.

- Fixing spanner (KS-41) • Hexagonal wrench set (W-1550S)
- Fork spanner (FC-50) (HFA20)

※ 3, 5, 8, 16, 18 and 21 are able to use standard commercial items.

The tools for assembly
Wrench (for shank and head)

To be used for tightening 11 and 17.

CODE
TS-HA20



Assembling tool for needle bearings

To be used for tightening 21.

CODE
TPN-HA20



HFA20

- 24 Nut
CODE | NUT-CTA20
- 23 Angle shaft (for drilling)
CODE | FR-A20
- Drill (φ5.8~20)
- Endmill (φ5.8~20)
- Spring collet (C20) → P.8

HFT12

- 25 Angle shaft (for tapping)
CODE | FR-T12
- Tap (M14, 16) Tap sleeve (TA12) → P.8
- Tap (M3~12) Tap sleeve (TA6) → P.8
- 26 Draw nut and spring
CODE | FR-T12NS

20 Collar B

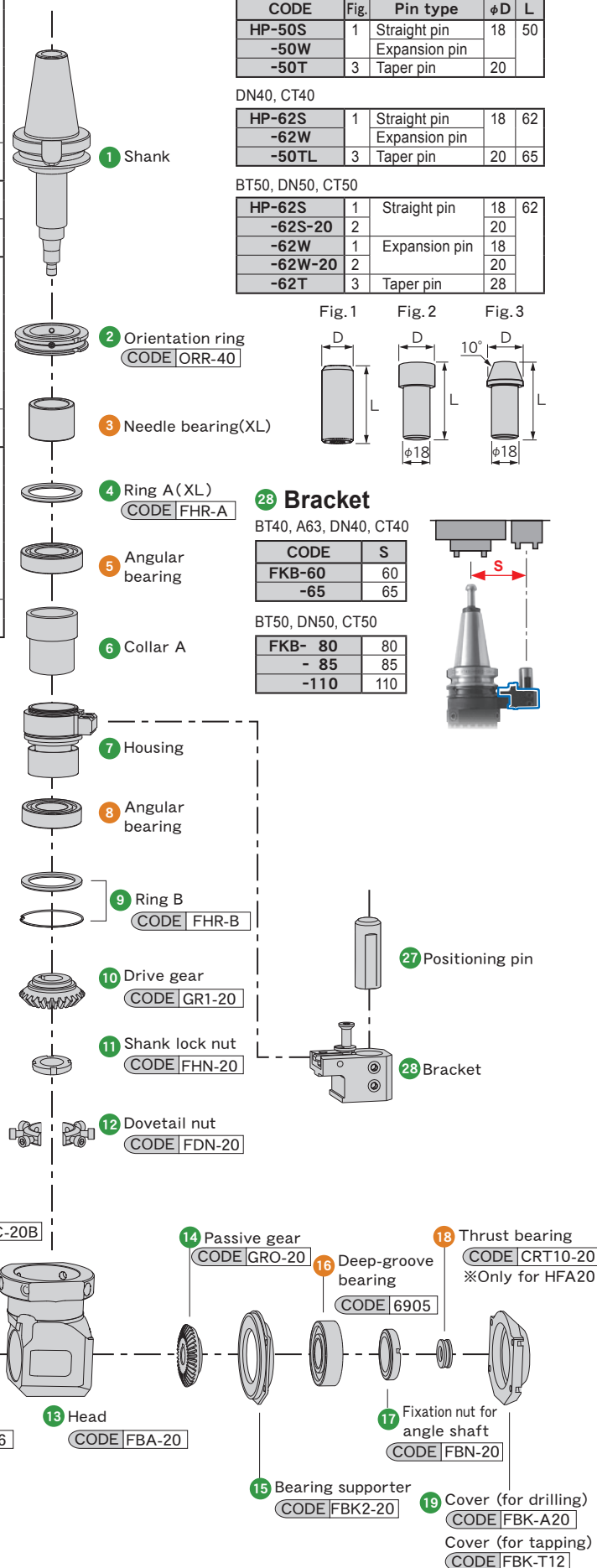
CODE | FBC-20B

22 Collar C

CODE | FBC-20C

21 Needle bearing

CODE | TAF324230P6



HFCS6 (BT30)

CODE(Master Holder)
BT30-HFCS6-155

■Std. Access.

- Fixing spanner(PS-21)
- Hexagonal wrench set (W-1550S)

※ 3, 7, 9, 14, 15 and 20 are able to use standard commercial items.

The tools for assembly

Wrench (for shank)

To be used for tightening 9.
It can also be used as a wrench for head of HFD12.

CODE
TSH-HF12



Pliers for Retaining ring

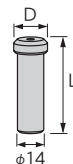
To be used for tightening 28.

CODE
TSH-G6



29 Positioning pin

CODE	Pin type	φD	L
HP-45S	Straight pin	12	45
HP-E50S	Straight pin	18	50

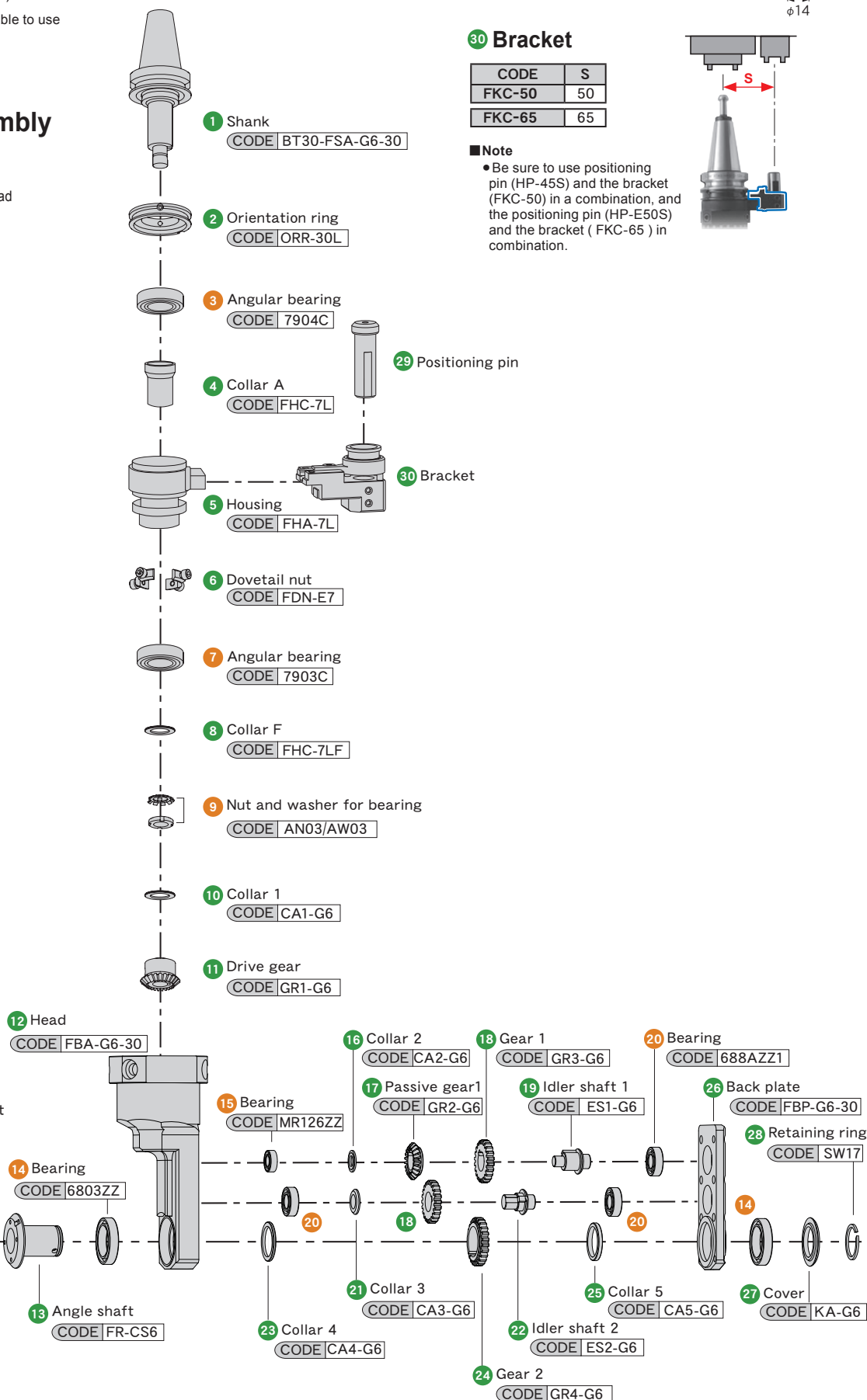
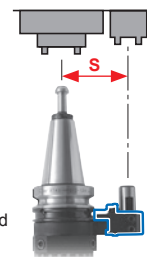


30 Bracket

CODE	S
FKC-50	50
FKC-65	65

■Note

- Be sure to use positioning pin (HP-45S) and the bracket (FKC-50) in a combination, and the positioning pin (HP-E50S) and the bracket (FKC-65) in combination.



HFCS6 (BT40/50, DN40/50, CT40/50)

CODE (Master Holder)	1 Shank	11 Head	17 Gear 1	Q'ty	18 Gear 3	20 Bearing	Q'ty	21 Collar 3	Q'ty	22 Idler shaft 2	Q'ty	26 Back plate
BT40 -HFCS6-160	BT40 -FSA-G6	FBA-G6	GR3-G6	2	—	688AZZ1	3	CA3-G6	1	ES2-G6	1	FBP-G6
-205		FBA-G6L		3	GR5-G6		7		3		3	FBP-G6L
BT50 -HFCS6-175	BT50 -FSA-G6	FBA-G6		2	—		3		1		1	FBP-G6
-220		FBA-G6L		3	GR5-G6		7		3		3	FBP-G6L
DN40A-HFCS6-175	DN40A-FSA-G6	FBA-G6	GR3-G6	2	—	688AZZ1	3	CA3-G6	1	ES2-G6	1	FBP-G6
-220		FBA-G6L		3	GR5-G6		7		3		3	FBP-G6L
DN50A-HFCS6-175	DN50A-FSA-G6	FBA-G6		2	—		3		1		1	FBP-G6
-220		FBA-G6L		3	GR5-G6		7		3		3	FBP-G6L
CT40 -HFCS6-175	CT40 -FSA-G6	FBA-G6	GR3-G6	2	—	688AZZ1	3	CA3-G6	1	ES2-G6	1	FBP-G6
-220		FBA-G6L		3	GR5-G6		7		3		3	FBP-G6L
CT50 -HFCS6-175	CT50 -FSA-G6	FBA-G6		2	—		3		1		1	FBP-G6
-220		FBA-G6L		3	GR5-G6		7		3		3	FBP-G6L

Std. Access.

- Fixing spanner (PS-21)
- Hexagonal wrench set (W-1550S)

※ 3, 8, 13, 14 and 20 are able to use standard commercial items.

29 Positioning pin

BT40

CODE	Fig.	Pin type	φD	L
HP-50S	1	Straight pin	18	50
-50W		Expansion pin		
-50T	3	Taper pin	20	

DN40, CT40

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62W		Expansion pin		
-50TL	3	Taper pin	20	65

BT50, DN50, CT50

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62S-20	2		20	
-62W	1	Expansion pin	18	
-62W-20	2		20	
-62T	3	Taper pin	28	

30 Bracket

BT40

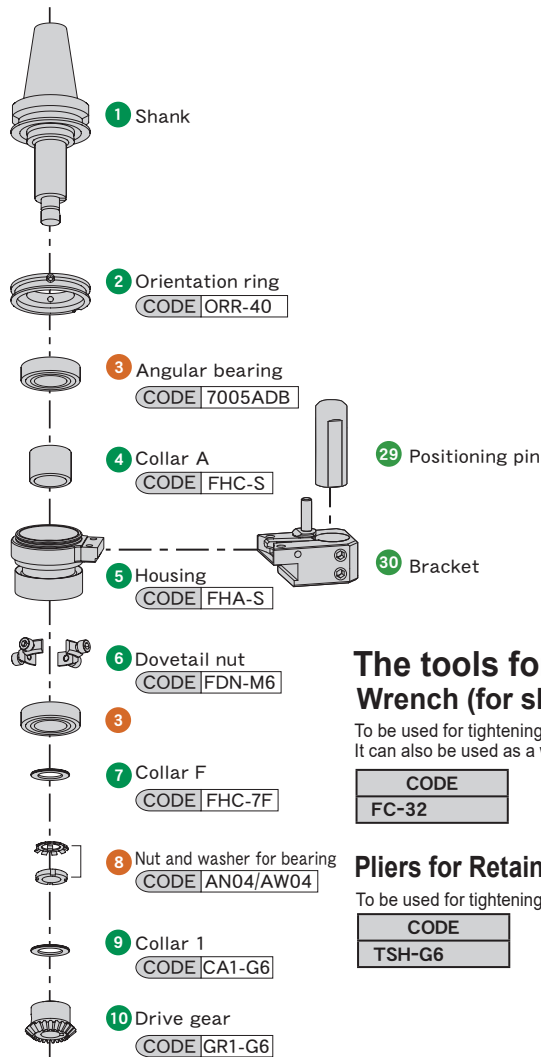
CODE	S
FKA-60	60
-65	65

DN40, CT40

CODE	S
FKA-60-L	60
-65-L	65

BT50, DN50, CT50

CODE	S
FKA-80	80
-85	85
-110	110



The tools for assembly

Wrench (for shank)

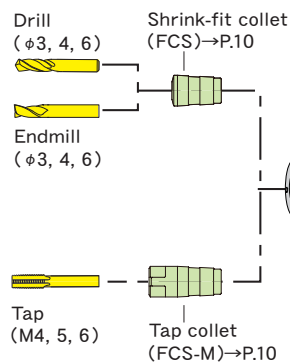
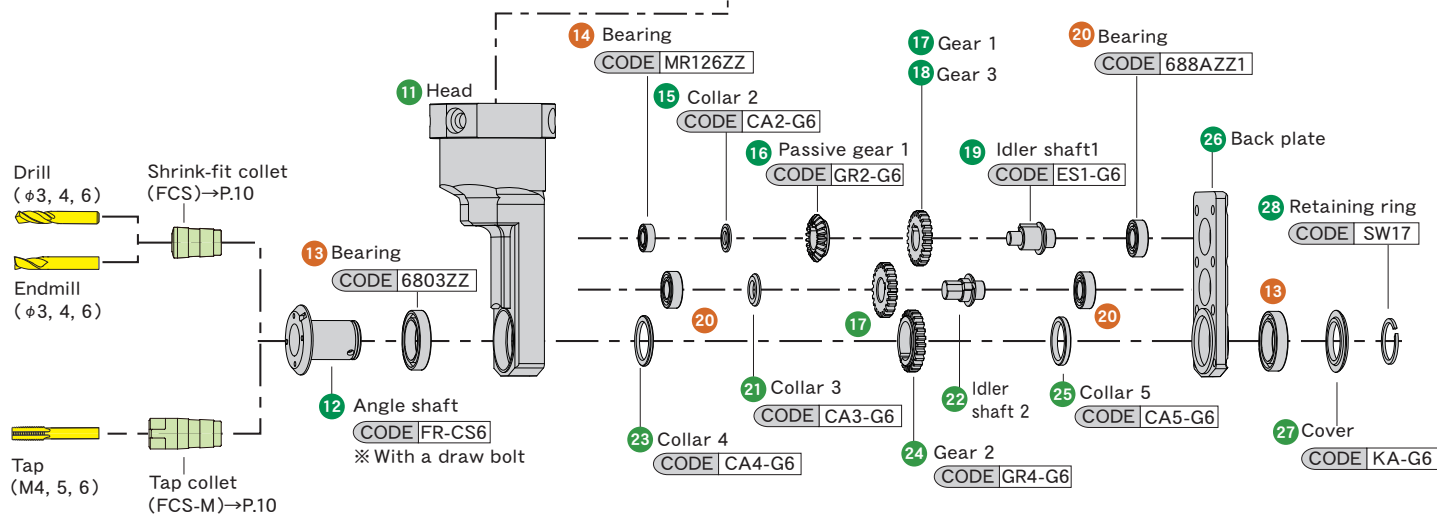
To be used for tightening 8. It can also be used as a wrench for head of HFD12.

CODE
FC-32

Pliers for Retaining ring

To be used for tightening 28.

CODE
TSH-G6



HUD7 / HUT4 (BT30)

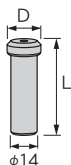
CODE (Master Holder)
BT30-HUD7-102
-HUT4-102

Std. Access.

- Fixing spanner (KS-23) (HUD7)
 - Hexagonal wrench set (W-1550S)
- ※ 3, 4, 17, 23 and 30 are able to use standard commercial items.

32 Positioning pin

CODE	Pin type	φD	L
HP-45S	Straight pin	12	45
HP-E50S	Straight pin	18	50

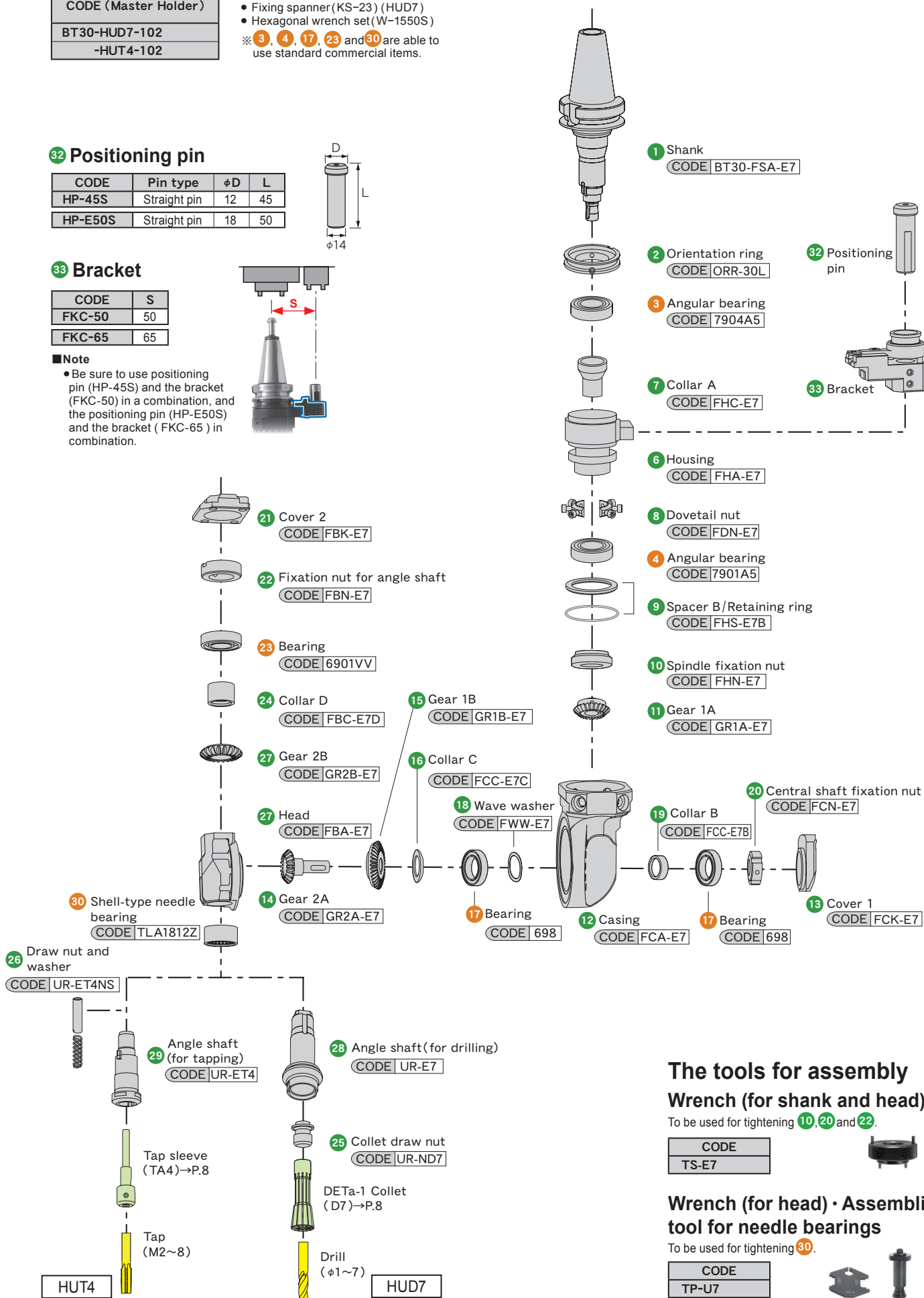
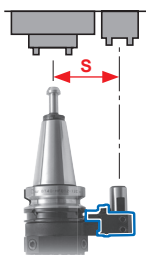


33 Bracket

CODE	S
FKC-50	50
FKC-65	65

Note

- Be sure to use positioning pin (HP-45S) and the bracket (FKC-50) in a combination, and the positioning pin (HP-E50S) and the bracket (FKC-65) in combination.



The tools for assembly Wrench (for shank and head)

To be used for tightening 10, 20 and 22.

CODE
TS-E7



Wrench (for head) • Assembling tool for needle bearings

To be used for tightening 30.

CODE
TP-U7



HUD7 / HUA10 / HUT4 (BT40/50, DN40/50, CT40/50)

CODE (Master Holder)	① Shank
BT40 -HUD 7-135 -HUA10-135 -HUT 4-135	BT40-FSA-U7
BT50 -HUD 7-150 -HUA10-150 -HUT 4-150	BT50-FSA-U7
DN40A-HUD 7-150 -HUA10-150 -HUT 4-150	DN40A-FSA-U7
DN50A-HUD 7-150 -HUA10-150 -HUT 4-150	DN50A-FSA-U7
CT40 -HUD 7-150 -HUA10-150 -HUT 4-150	CT40-FSA-U7
CT50 -HUD 7-150 -HUA10-150 -HUT 4-150	CT50-FSA-U7

■ Std. Access.

- Fixing spanner (KS-21)
- Hexagonal wrench set (W-1550S)
- Fork spanner (FC-32) (HUA10)

※ ③, ⑧, ⑬, ⑯, ⑰ and ⑲ are able to use standard commercial items.

The tools for assembly Wrench (for shank)

CODE	To be used for tightening ⑧.
FC-32	

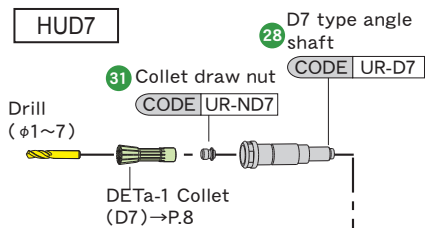
Wrench (for head) ·

Assembling tool for needle bearings

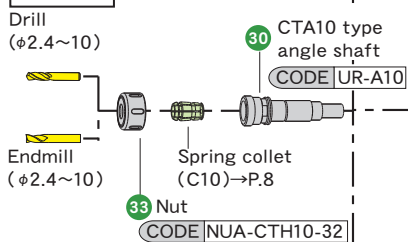
To be used for tightening ⑯, ⑳ and ㉑.

CODE	
TP-U7	

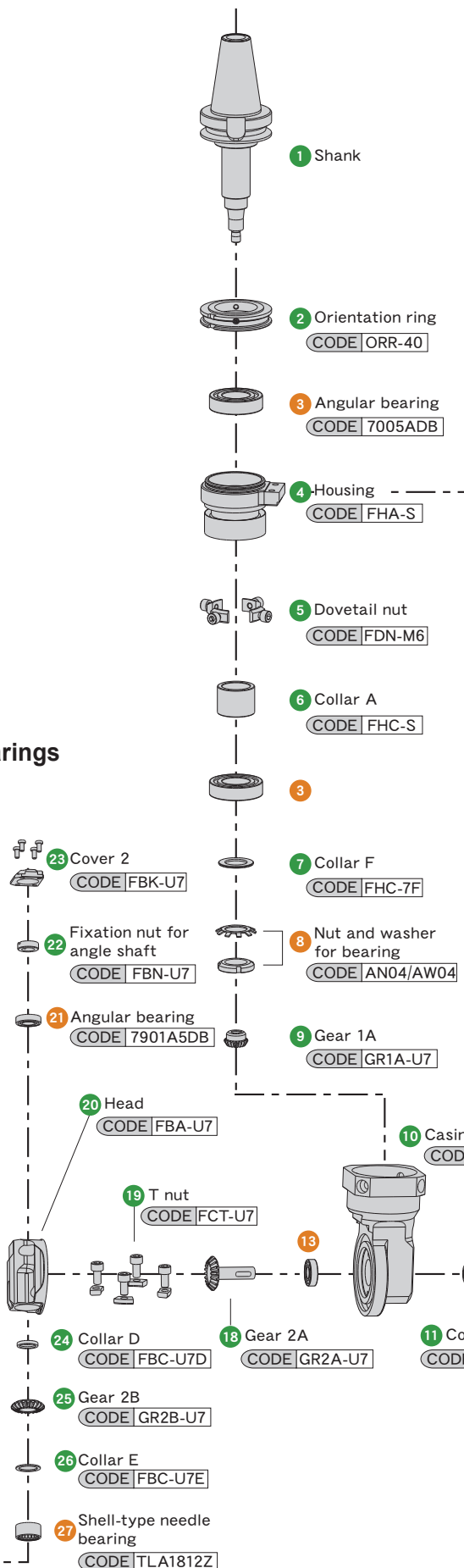
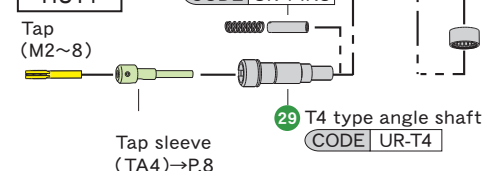
HUD7



HUA10



HUT4



34 Positioning pin

BT40

CODE	Fig.	Pin type	φD	L
HP-50S	1	Straight pin	18	50
-50W		Expansion pin		
-50T	3	Taper pin	20	

DN40, CT40

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62W		Expansion pin		
-50TL	3	Taper pin	20	65

BT50, DN50, CT50

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62S-20	2		20	
-62W	1	Expansion pin	18	
-62W-20	2		20	
-62T	3	Taper pin	28	

Fig. 1



Fig. 2

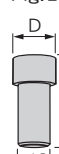
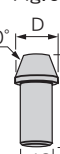


Fig. 3



35 Bracket

BT40

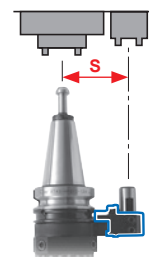
CODE	S
FKA-60	60
-65	65

DN40, CT40

CODE	S
FKA-60-L	60
-65-L	65

BT50, DN50, CT50

CODE	S
FKA- 80	80
- 85	85
-110	110



34 Positioning pin

35 Bracket

16 Nut and washer for bearing
CODE AN00/AW00

HUA20 / HUT6 (BT40/50, DN40/50, CT40/50)

CODE (Master Holder)	1 Shank
BT40 -HUA20-135 -HUT 6-135	BT40 -FSA-U20
BT50 -HUA20-150 -HUT 6-150	BT50 -FSA-U20
DN40A-HUA20-150 -HUT 6-150	DN40A-FSA-U20
DN50A-HUA20-150 -HUT 6-150	DN50A-FSA-U20
CT40 -HUA20-150 -HUT 6-150	CT40 -FSA-U20
CT50 -HUA20-150 -HUT 6-150	CT50 -FSA-U20

■ Std. Access.

- Fixing spanner (KS-33)
- Hexagonal wrench set (W-1560S)
- Fook spanner (FC-50) (HUA20)

※ 3, 7, 10, 14, 17, 25, 27 and 29 are able to use standard commercial items.

35 Positioning pin

BT40

CODE	Fig.	Pin type	φD	L
HP-50S	1	Straight pin	18	50
-50W		Expansion pin		
-50T	3	Taper pin	20	

DN40, CT40

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62W		Expansion pin		
-50TL	3	Taper pin	20	65

BT50, DN50, CT50

CODE	Fig.	Pin type	φD	L
HP-62S	1	Straight pin	18	62
-62S-20	2		20	
-62W	1	Expansion pin	18	
-62W-20	2		20	
-62T	3	Taper pin	28	

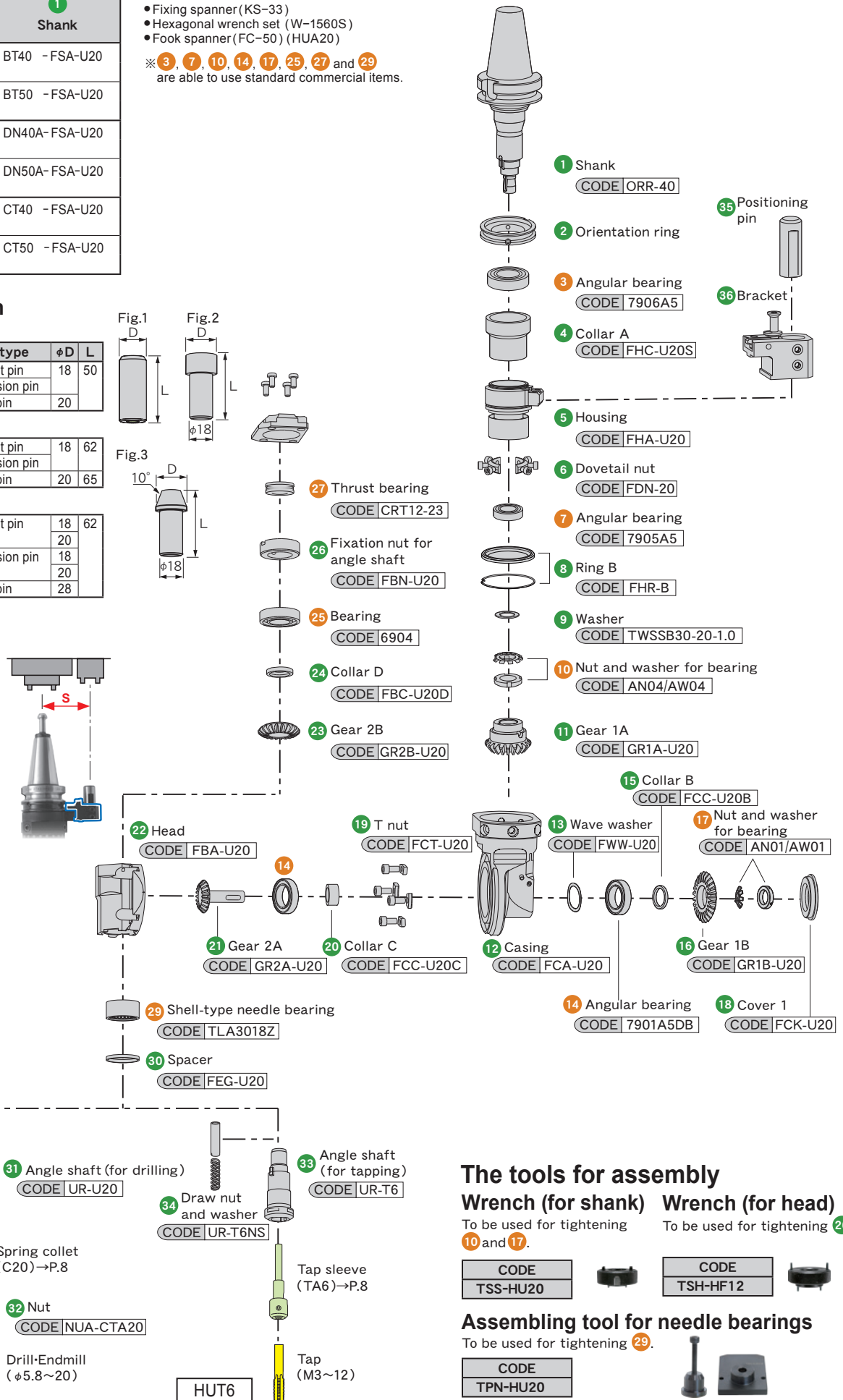
36 Bracket

BT40, DN40, CT40

CODE	S
FKB-60	60
-65	65

BT50, DN50, CT50

CODE	S
FKB- 80	80
- 85	85
-110	110



The tools for assembly

Wrench (for shank) Wrench (for head)

To be used for tightening 10 and 17.

To be used for tightening 25.

CODE
TSS-HU20

CODE
TSH-HF12

Assembling tool for needle bearings

To be used for tightening 29.

CODE
TPN-HU20



Technical support

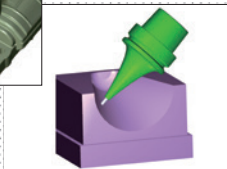
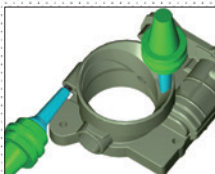
At MST, we provide the long-term support that allows you to use our products safely and to maintain the high accuracy of our products for your machining.

1. Pre-sales

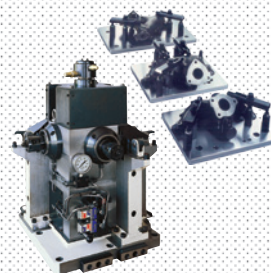
Provide wide-ranging technical support.



Tool selection



Interference check with 3D drawings



Designing manufacturing jig fixtures

2. On delivery

You will receive instructions.



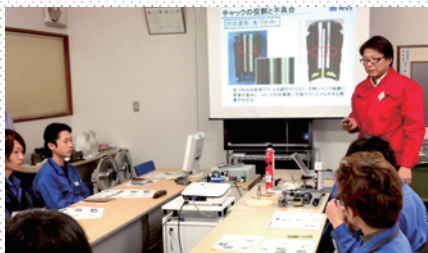
Instructions for a heater



Maintenance instruction

3. Post-sales

Our Tool Clinic experts can visit your factory to demonstrate the correct usage, maintenance and give seminars.



Seminar



Evaluation



Consulting

Substantial peripheral equipment



Work table
6S DESK
➡ P.86



Holder,
Tool washing machine
CLEAN BOX
➡ P.88

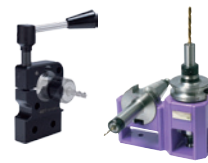
TOOL CAP
➡ P.91



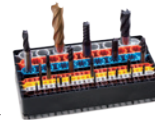
Tool holder
storage cabinet
➡ P.98



Tool set up stand
➡ P.94



Cutter protection box
ENDMILL HOUSE
➡ P.97



Test bar
CHECKMATE
➡ P.90



Cleaning tool
➡ P.31



Instructions for use

To ensure optimum, trouble-free performance, please read this operation manual carefully before using the unit. Please contact us if your holder is damaged. We are ready to help you.

Instructions for using tool holder

Pay attention to scratches and rust.

Before using, be sure to remove anti-rust oil on the holder. Scratches and dust can reduce performance and accuracy. Please keep your holders clean with rags. Our CLEAN BOX is available for your cleaning needs.



CLEAN BOX
➔ P. 88

Storage.

Please use tool protection covers if you store holders with cutters. Cutting edges may be damaged by coming in contact with each other, and you may get injured by sharp cutting edges.



TOOL CAP
➔ P. 91



Tool holder shank.

If you insert holder shanks with scratches and dust into machine spindles, the accuracy of the spindle is reduced and the spindle can be damaged. For shank maintenance, use an oil grinding stone or sandpaper to remove scratches and rust. We cannot re-grind shank since it changes the position of gauge line, so we recommend you to purchase new holders.



Retention knob is consumable.

Exchange the retention knob regularly. (Usage period is depend on the frequency and cutting condition. Approximately 6 months for heavy duty cutting. 18 months for standard cutting.)



ANGLE HEAD

- The gear and bearing in the angle head are consumables. Periodic maintenance is required. The inside of the head can be checked by taking off the aluminum cover and the name plate.
- Be careful about the spindle rotating direction. If used in a wrong rotating direction, it will damage the gears.



DETa-1 Collet Holder

Tighten with the proper torque.

- Excessive tightening will reduce the accuracy and damage the internal components.
- An adjustable torque wrench, which can tighten the nut with the appropriate torque, is available for DTA type holders.



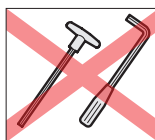
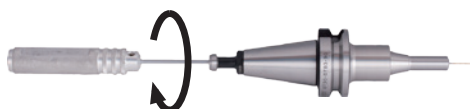
Adjustable torque wrench



The nut-tightening torque can be adjusted more properly.

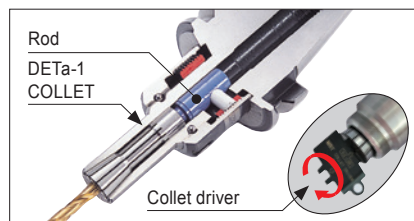
➔ P. 31

- For the DTB3, the torque is adequate when the wrench starts to bend. Do not use T-type or L-type wrenches for tightening. If a commercially-available torque wrench is used, use a screwdriver type.



Firmly attach the DETa-1 collet to a rod.

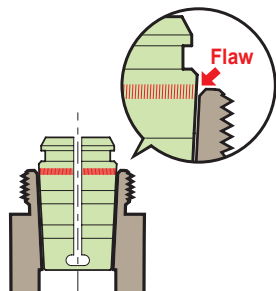
Use a collet driver when screwing in the collet all the way until it stops. If the collet is not screwed in enough, the rod might break. The rod is replaceable.



COLLET HOLDER

Do not use a collet that has a notch or nick (flaw) on its tapered surface.

In order to maintain the accuracy of the main unit, the hardness of the collet is less than that of the main unit. If the collet is used with its tapered surface having a notch or nick (flaw) in it, poor accuracy or insufficient tightening can cause an accident. Replacing the collet will allow you to restore the holder to more or less its initial precision level.



Tighten with the proper torque.

Excessive tightening will damage the holder. Clean the tool holder thoroughly inside and out when setting it up. When coolant or chips remain on the thread of the tool holder or the nut, the frictional resistance decreases. This will cause the torque to be similar to the torque experienced when over-tightening. Therefore, even if the tightening torque is correct, it might lead to breakage.



Adjustable torque wrench



The nut-tightening torque can be adjusted more properly.

➡ P.38

Hi-ART MILLING CHUCK

Do not tighten the collet without inserting a cutting tool.

Tightening the nut without inserting a cutter will cause the clamping portion of the holder to change shape and make it difficult to insert a cutter.



Be sure to insert the cutter shank deeper than the minimum clamping depth.

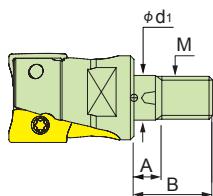
If the internal bore gets damaged, accuracy degradation, gripping torque degradation and unable insertion of the cutter might occur. Refer to "Cutter insertion length" on the chart.

Cutter shank dia.	Min. holding length	
	ART32	ART42
φ 6, 8	30	35
φ 10, 12	40	45
φ 16, 20	50	55
φ 25		55
φ 32	66	60
φ 42	-	76

RED screw arbor

Confirm if a screw-in tool can be used.

Some of the screw-in end mills cannot be attached to the RED screw arbor. Please check your screw-in end mills for conformance to the dimensions, or please contact MST.



Holder type	M	φd1	A	B
RSG8	M 8	8.5	10	18
RSG10	M10	10.5	10	22
RSG12	M12	12.5	10	22
RSG16	M16	17	10	25

Precautions for collet tightening.

First set the collet into the nut. Do not first put the collet into the tool holder. The collet might get stuck in the tool holder when tightened by the nut.



Be sure to keep the clamping length of the cutter insertion to a minimum.

Not clamping the cutter with the entire clamping length will cause degradation of accuracy, slipping out of the cutter, and breakage of the tool holder and the nut.

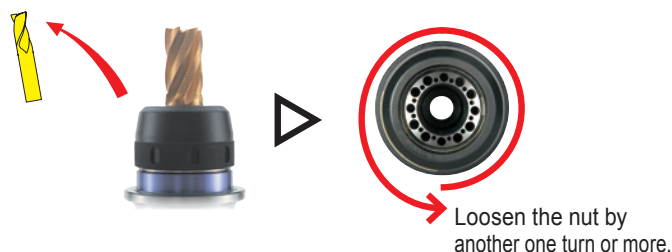
Collet inner diameter	Min. holding length	HOLDER CODE
φ 2.6 ~ 10	20	CTA10, CTH10
φ 6 ~ 20	40	CTA20, CTH20
φ 6 ~ 9.5	38	CTA25, CTH25
φ 10 ~ 15	48	
φ 15.5 ~ 25	57	CTA32, CTH32
φ 25, 28, 30, 32	68	
φ 32, 40, 42	70	CTA40

Use the holder within the allowable spindle speed.

HOLDER	MAX.min ⁻¹
BT40, A 63-ART32	6000
BT50, A100-ART32	5000
BT50, A100-ART42	3000

After removing the tool, loosen the nut by another one turn or more.

Otherwise, the next time the tool is clamped, the component of the nut might be damaged. This will also prevent you from being able to grip the tool with sufficient strength, causing the tool to slip during machining.

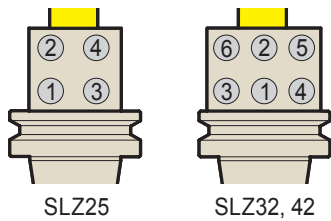


Loosen the nut by another one turn or more.

SUMMIT

Tighten the all bolts at least twice.

Tighten the bolts in the order of the numbers marked on them.



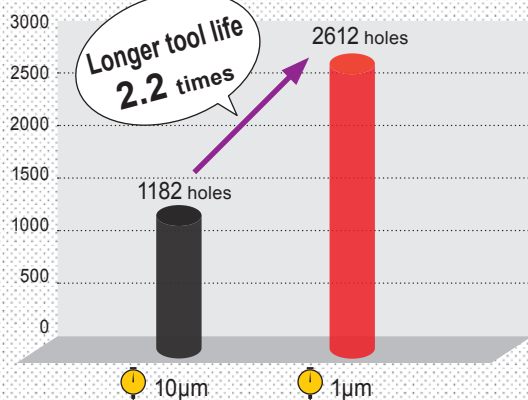
Precautions for tightening the bolts.

If you are unable to loosen the last one or two bolts, tighten all the bolts again and then try to loosen all the bolts again little by little. (This occurs when the bolts are not loosened equally and little by little from the first step.)

When loosened slowly, the wrench might bend, so loosen the bolts with instantaneous torque.

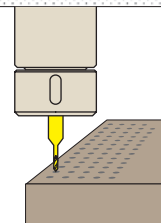
Cutter life comparison depending on different run-out accuracy

When the cutter run-out accuracy is $10\mu\text{m}$, cutter life is 2.2 times longer than with $40\mu\text{m}$ run-out accuracy.



Cutting condition

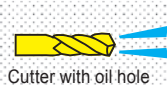
Cutting tool : $\phi 0.1\text{ mm}$ drill
 Material : NAK80(40HRC)
 Coolant : Water solubility coolant
 Revolution : $20,000\text{min}^{-1}$
 Feed : 60 mm/min
 Step feed : Non-step
 Depth : 0.4 mm



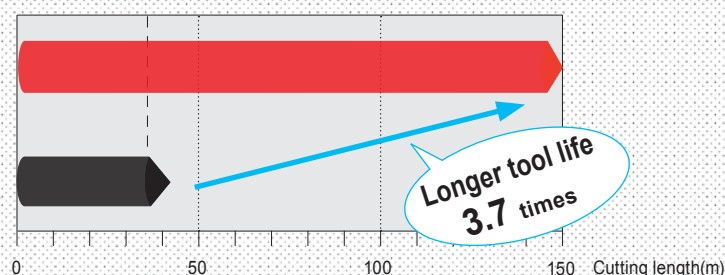
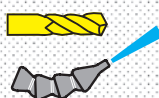
Cutter life comparison when using cutter-through coolant and external coolant

Applying the cutter-through coolant improves the tool life 3.7 times higher than when external coolant is used.

Cutter-through coolant



External coolant

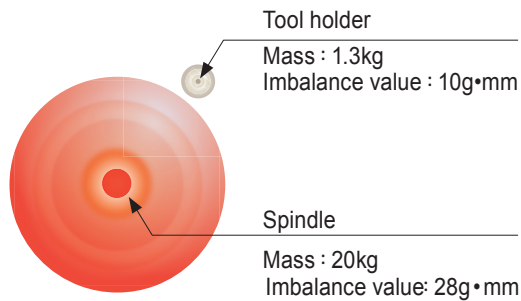
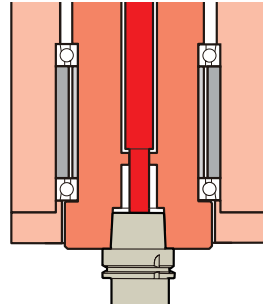
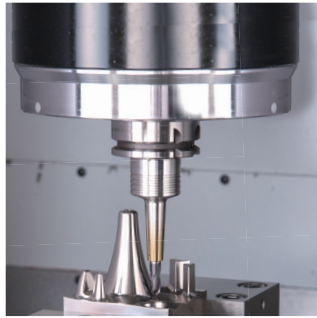


For high-speed spindle rotation

Imbalance value of a machine tool spindle and a tool holder

A tool holder imbalance value (G grade) focuses at high-speed spindle rotation of a machining center. However, it is important to consider the entire rotation body, including the spindle, holder and cutter to determine the high-speed spindle rotation. This is because the holder and cutter weight is much lighter than the spindle weight (less than approx. 1/20th), and thus the effect of a tool holder on the spindle rotating equipment (spindle, tool holder and cutter) becomes significantly smaller.

Spending time and money on balance corrections to the holder alone will not result in significant improvement.



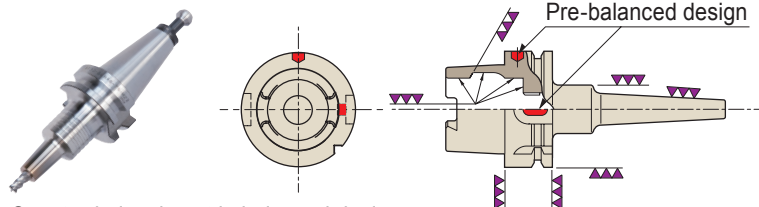
Achieving high-speed, high-efficiency machining requires more than just good balance.

- What is the run-out accuracy of the machine spindle, tool holder and cutting tool?
- Is there taper contact between the machine spindle and tool holder?
- What is the diameter of the cutting tool?
- What is the cutting speed? Spindle rotation?

MST considers these points carefully and produces a tool holder according to our own pre-balanced design concept.

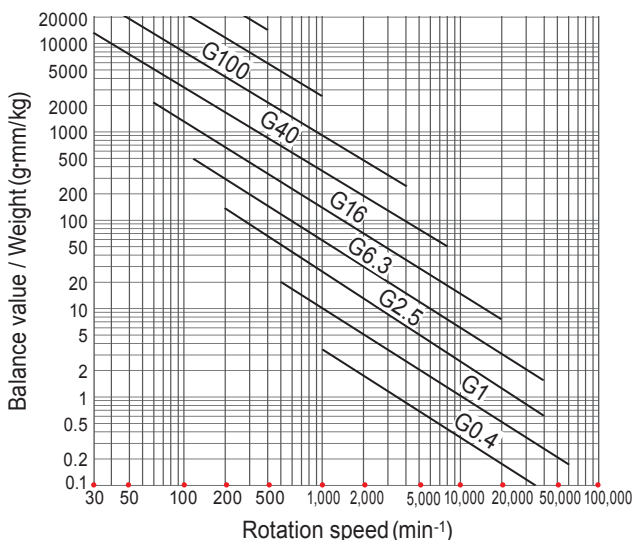
Pre-balanced design

MST has applied our original pre-balancing to make the tool holders applicable for high-speed spindle rotation. Balancing corrections for our products is not required.



- Counter-balancing at imbalanced design areas.
- O.D finish grinding after heat treatment.

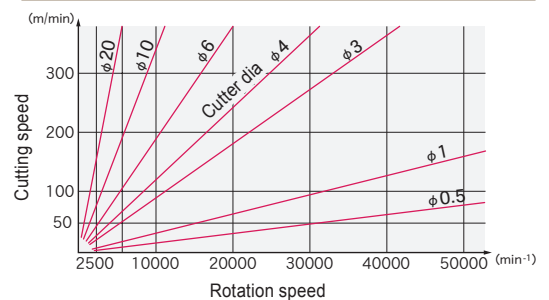
Unbalancing in terms of tolerable residual ration against the balancing grade(G grade value)



Points to keep in mind at high-speed rotation.

- Minimize the length of a tool holder and cutting tool as short as possible.
- Use high accuracy and compact design tool holders.
- Optimize the cutting condition(rpm, feed and depth of cut).

Relationship between a cutter diameter and spindle rotation



<<Reference>>

Recommend various of G grade of a rotating body

G grade	G	Rotating body
G40	~40	The car wheel
G16	~16	The parts of agricultural machines The parts of truck
G 6.3	~ 6.3	Machine tools and aviation gas- turbine rotors after assembling general mechanical parts
G 2.5	~ 2.5	The spindle of machine tool Gas turbine Steam turbine
G 1	~ 1	The grinding wheel spindle of grinding machine
G 0.4	~ 0.4	The grinding wheel spindle of precise grinding machine Gyroscope

Determining tool holder G grade

$$G = \frac{\text{Imbalance value(g·mm)}}{\text{Weight (kg)}} \times \frac{\text{Spindle rotation speed}}{9,550}$$

Holders for high-speed operation include "Imbalance value" and "holder weight" columns in the dimensions table.

Determining G grade of rotating equipment (spindle · tool holder · cutting tool)

$$G = \frac{\left(\frac{\text{Spindle + Holder + Cutter}}{\text{Imbalance value(g·mm)}} \right) \times \frac{\text{Spindle rotation speed}}{9,550}}{\text{Weight (kg)}}$$

HSK SHANK

MST uses DIN-HSK standard shanks, which are widely used in Japan and other countries as “2-face contact tooling” for high-speed, high-efficiency machining.

- ▷ The close contact of the end faces (2-face contact) of the HSK shank results in high rigidity for transverse feed, which minimizes vibrations during machining and improves the operating life of the cutting tool and the finished surface.
- ▷ Even if the spindle expands during high-speed rotations, the tapered hollow portion comes up with that expansion, thereby maintaining high precision.



A type

The most common type in use today.



E type

This type has no drive keyway and is suitable for high-speed machining.



F type

This type uses a combination of different sizes of tapers and flanges.



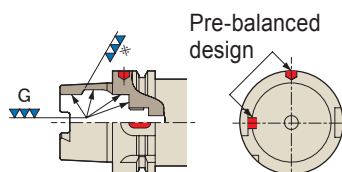
T type

This type is for turning with multiple machining

Pre-Balanced design

The HSK-A-type shank is unbalanced in its standard form, but at MST we have applied our original pre-balancing to make the tool holders applicable for high-speed machining. According to DIN standards, only the area marked with ※ in the hollow shank needs to be finished. However, MST provides perfect finishing for all areas after heat treatment in order to improve balance.

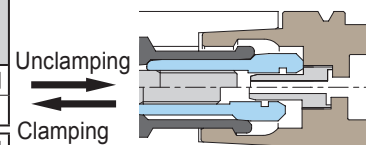
	MST	DIN standard
A63	15 g·mm	75 g·mm
A100	28 g·mm	170 g·mm



Three times stronger clamping force

HSK uses a clamping mechanism, which utilizes the wedge effect, to provide a tool gripping power 2.5 to 3.0 times greater than in the retention knob system (BT40 and BT50), thereby increasing rigidity.

	Tensile strength of draw bar	Tool clamping force
BT40	10~15kN	10~15kN
A63	5.8kN	18.4kN
BT50	20~25kN	20~25kN
A100	14.5kN	45.9kN



Rigidity comparison with BT shank

The HSK shank is effective when longer overhang or higher transverse feed rigidity is required. The higher rigidity greatly contributes to improve the operating life of the cutting tool and the smoothness of the finished surface.



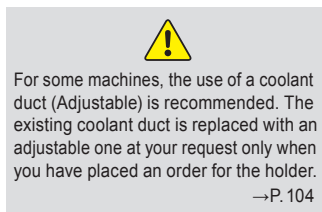
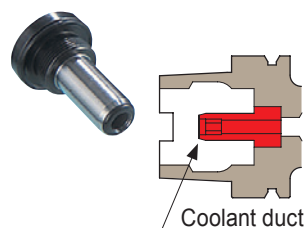
Taper gauge

MST establishes the optimal value within the tolerance in accordance with the DIN standard and manufacturers master gauges for tool shanks and those for spindle tapers accordingly.



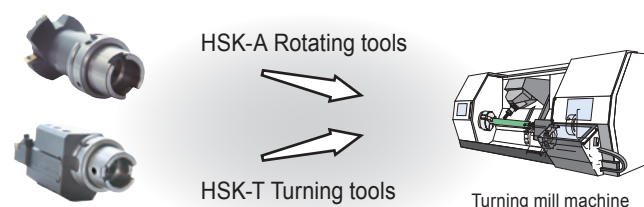
Coolant duct

This is a coolant feed part exclusively for the HSK-A type. MST's HSK-A type holder comes standard with each coolant duct.



TOOLING SYSTEMS for HSK-T

Collaborative development with 17 Japanese manufacturers has resulted in an interface for mill-turning machines based on the HSK-A type. With its 2008 ISO accreditation, it has become popular standard around the world.

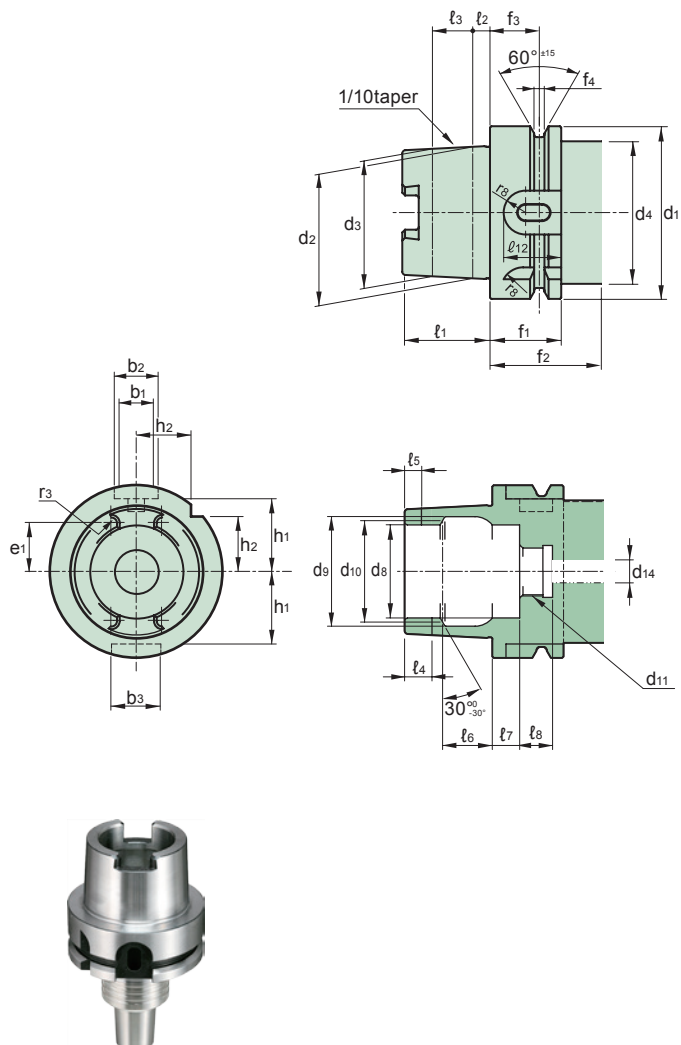


Technical data

The shank dimensions

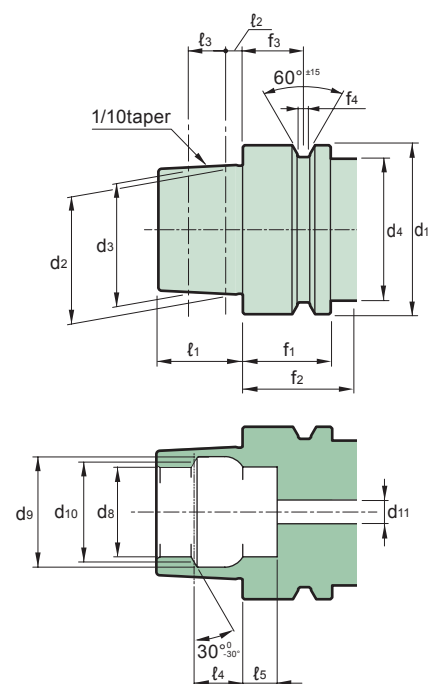
HSK-A (Extracts from DIN 69893-1;1993-07)

Shank	A40	A50	A63	A100	A125
b₁ (H10)	8	10.5	12.5	20	25
b₂ (H10)	9	12	16	20	25
b₃ (H10)	11	14	18	22	28
d₁ (h10)	40	50	63	100	125
d₂	30	38	48	75	95
	+0.007 +0.005	+0.009 +0.006	+0.011 +0.007	+0.015 +0.009	+0.018 +0.011
d₃	29.05	36.9	46.53	72.6	91.95
	+0.005 +0.003	+0.006 +0.003	+0.007 +0.003	+0.009 +0.003	+0.011 +0.004
d₄ (Max.)	34	42	53	85	105
d₈ (H10)	21	26	34	53	67
d₉ (H11)	25.5	32	40	63	80
d₁₀	23	29	37	58	73
d₁₁	M12 × 1	M16 × 1	M18 × 1	M24 × 1.5	M30 × 1.5
d₁₄ (Max.)	5	6.8	8.4	12	14
e₁	10.88	13.797	17.862	27.329	35.324
f₁ (- ⁰ _{-0.1})	20	26	26	29	29
f₂ (min.)	35	42	42	45	45
f₃ (± 0.1)	16	18	18	20	20
f₄ (+ ^{0.15} ₀)	2	3.75	3.75	3.75	3.75
h₁ (- ⁰ _{-0.2})	17	21	26.5	44	55.5
h₂ (- ⁰ _{-0.3})	12	15.5	20	31.5	39.5
ℓ₁ (- ⁰ _{-0.2})	20	25	32	50	63
ℓ₂	4	5	6.3	10	12.5
ℓ₃	9.5	11	14.7	24	30.5
ℓ₄ (+ ^{0.2} ₀)	6	7.5	10	15	19
ℓ₅ (+ ^{0.2} ₀)	3.5	4.5	6	10	12
ℓ₆ (JS10)	11.42	14.13	18.13	28.56	36.27
ℓ₇ (- ⁰ _{-0.1})	8	10	10	12.5	16
ℓ₈ (- ⁰ _{-0.3})	8	10	12	16	18
ℓ₁₂	12	19	21	24	24
r₃ (+ ^{0.05} _{-0.05})	1.88	2.38	2.88	4.88	5.88
r₈	4.5	6	8	10	5



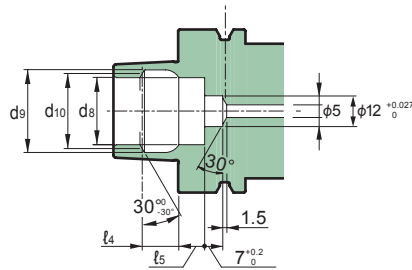
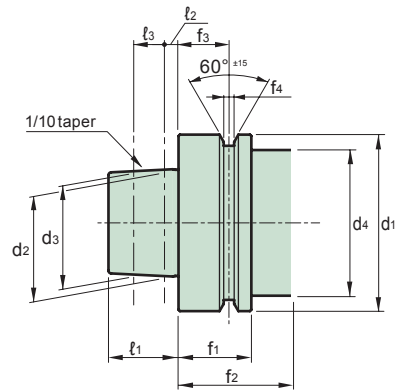
HSK-E (Extracts from DIN V 69893-5;1996-01)

Shank	E25	E32	E40	E50
d₁ (h10)	25	32	40	50
d₂	19	24	30	38
	+0.006 +0.004	+0.007 +0.005	+0.007 +0.005	+0.009 +0.006
d₃	18.15	23.27	29.05	36.90
	+0.004 +0.002	+0.005 +0.003	+0.005 +0.003	+0.006 +0.003
d₄ (Max.)	20	26	34	42
d₈ (H10)	14	17	21	26
d₉ (H11)	16.4	21	25.5	32
d₁₀	15	19	23	29
d₁₁ (Max.)	3	4.2	5	6.8
ℓ₁ (- ⁰ _{-0.2})	13	16	20	25
ℓ₂	2.5	3.2	4	5
ℓ₃	8.5	7.3	9.5	11
ℓ₄ (JS10)	7.21	8.92	11.42	14.13
ℓ₅ (- ⁰ _{-0.1})	6	8	8	10
f₁ (- ⁰ _{-0.1})	10	20	20	26
f₂ (min.)	20	35	35	42
f₃ (± 0.1)	4.5	16	16	18
f₄ (+ ^{0.15} ₀)	2	2	2	3.75



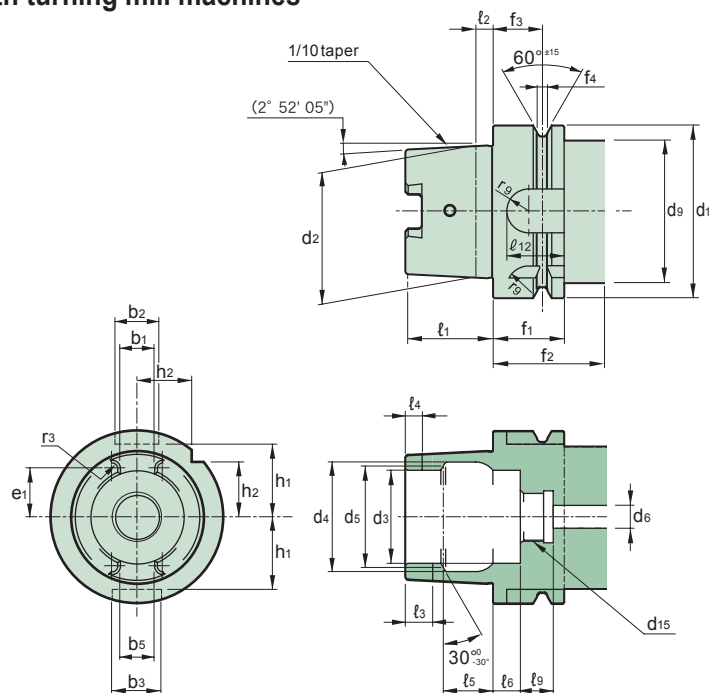
HSK-F (Extracts from DIN 69893-1;1993-07)

Shank	F63	F80
d1 (h10)	63	80
d2	38 +0.009 +0.006	48 +0.011 +0.007
d3	36.9 +0.006 +0.003	46.53 +0.007 +0.003
d4 (Max.)	53	67
d8 (H10)	26	34
d9 (H11)	32	40
d10	29	37
f1 (-0.1)	26	26
f2 (min.)	42	42
f3 (± 0.1)	18	18
f4 (+0.15 0)	3.75	3.75
ℓ1 (-0.2)	25	32
ℓ2	5	6.3
ℓ3	11	14.7
ℓ4 (Js10)	14.13	18.13
ℓ5 (-0.1)	10	10
f1 (-0.1)	26	26
f2 (min.)	42	42
f3 (± 0.1)	18	18
f4 (+0.15 0)	3.75	3.75



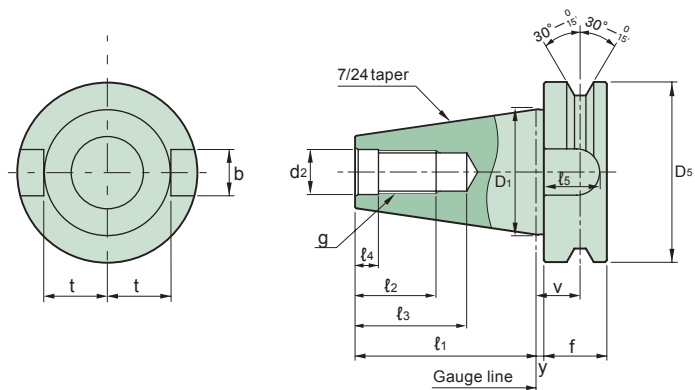
HSK-T (Extracts from DIN 69893-1;1993-07) For turning with turning mill machines

Shank	T40	T50	T63	T100	T125
b1 (±0.04)	8.05	10.54	12.54	20.02	25.02
b2 (H10)	9	12	16	20	25
b3 (H10)	11	14	18	22	28
b5	7.932 +0.03 0	10.425	12.425	19.91	24.915
d1 (h10)	40	50	63	100	125
d2	30.007	38.009	48.010	75.013	95.016
d3 (H10)	21	26	34	53	67
d4 (H11)	25.5	32	40	63	80
d5	23	29	37	58	73
d6 (Max.)	5	6.8	8.4	12	14
d9 (Max.)	39	49	62	99	124
d15	M12 × 1	M16 × 1	M18 × 1	M24 × 1.5	M30 × 1.5
e1	11	13.88	17.99	27.37	35.37
f1 (-0.1)	20	26	26	29	29
f2 (min.)	23	30	30	34	34
f3 (± 0.1)	16	18	18	20	20
f4 (+0.15 0)	2	3.75	3.75	3.75	3.75
h1 (-0.2)	17	21	26.5	44	55.5
h2 (-0.2)	12	15.5	20	31.5	39.5
ℓ1 (-0.2)	20	25	32	50	63
ℓ2	4	5	6.3	10	12.5
ℓ3 (±0.2)	6	7.5	10	15	19
ℓ4 (-0.2)	3.5	4.5	6	10	12
ℓ5 (Js10)	11.42	14.13	18.13	28.56	36.27
ℓ6 (-0.1)	8	10	10	12.5	16
ℓ9 (-0.1)	8	10	12	16	18
ℓ12	12	19	21	24	24
r3 (± 0.05 0)	1.88	2.38	2.88	4.88	5.88
r9	4.5	6	8	10	5



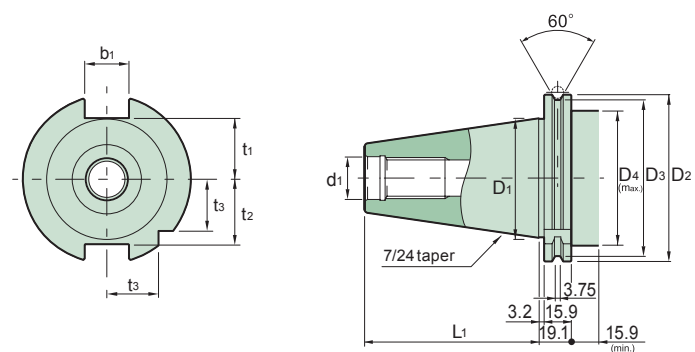
BT (Extracts from MAS 403)

Shank	BT30	BT40	BT50
D ₁	31.75	44.45	69.85
ℓ ₁ (± 0.15)	48.4	65.4	101.8
d ₂ (H8)	12.5	17	25
g (6H)	M12	M16	M24
ℓ ₂ (min.)	24	30	45
ℓ ₃ (min.)	34	43	62
ℓ ₄	7	9	13
b (H12)	16.1	16.1	25.7
ℓ ₅ (min.)	17	21	31
t (- 0.2)	16.3	22.6	35.4
D ₅ (h8)	46	63	100
f	20	25	35
v (± 0.1)	13.6	16.6	23.2
y (± 0.4)	2	2	3



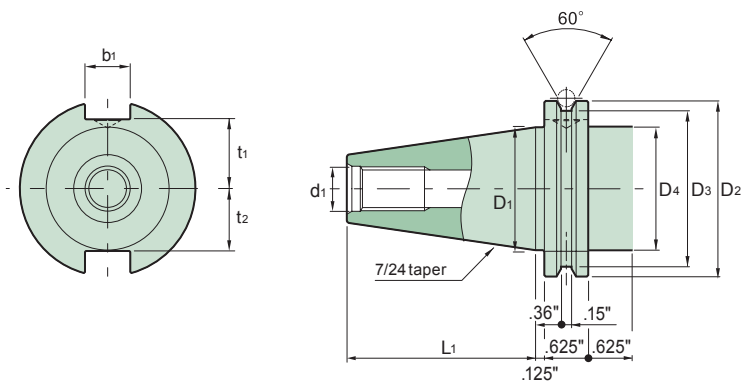
DIN (DIN69871-1)

Shank	DN40	DN50
D ₁	44.45	69.85
D ₂	63.55	97.5
D ₃	56.25	91.25
D ₄	50	80
L ₁	68.4	101.75
L ₃	3.75	6.495
b ₁	16.1	25.7
d ₁	17	25
t ₁	22.8	35.5
t ₂	25	37.7
t ₃	18.5	30

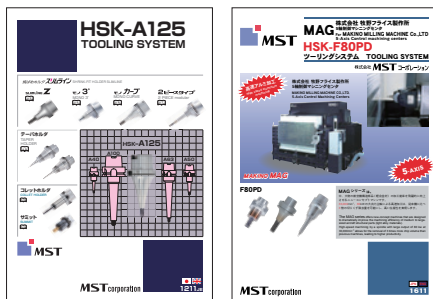


CAT.

Shank	CT40	CT50
D ₁	1.75	2.75
D ₂	2.5	3.88
D ₃	2.22	3.59
D ₄	1.75	2.75
L ₁	2.69	4
b ₁	.65	1.06
d ₁	.64	1.03
t ₁	.99	1.49
t ₂	.84	1.39



HSK-A125/ F80PD are also available as standard products.



If you would like more detailed information, please contact MST and ask for a catalog.

Drill hole size in metric coarse screw thread

Nominal size x pitch	Drill hole dia.
M 1 ×0.25	0.75
M 1.2×0.25	0.95
M 1.6×0.35	1.25
M 2 ×0.4	1.6
M 2.5×0.45	2.1
M 3 ×0.5	2.5
M 4 ×0.7	3.3
M 5 ×0.8	4.2
M 6 ×1	5
M 8 ×1.25	6.8
M10 ×1.5	8.5
M12 ×1.75	10.3
M16 ×2	14
M20 ×2.5	17.5
M24 ×3	21
M30 ×3.5	26.5
M33 ×3.5	29.5
M36 ×4	32
M39 ×4	35
M42 ×4.5	37.5
M45 ×4.5	40.5
M48 ×5	43

Drill hole size in unified screw threads

Nominal size x pitch	Drill hole dia.
NO. 1 - 64UNC	1.55
NO. 2 - 56UNC	1.8
NO. 3 - 48UNC	2.1
NO. 4 - 40UNC	2.3
NO. 5 - 40UNC	2.6
NO. 6 - 32UNC	2.8
NO. 8 - 32UNC	3.4
NO.10 - 24UNC	3.9
NO.12 - 24UNC	4.5
1/4 - 20UNC	5.1
5/16 - 18UNC	6.6
3/8 - 16UNC	8
7/16 - 14UNC	9.4
1/2 - 13UNC	10.8
9/16 - 12UNC	12.2
5/8 - 11UNC	13.6
3/4 - 10UNC	16.5
7/8 - 9UNC	19.5
1 - 8UNC	22.2
1 1/8 - 7UNC	25
1 1/4 - 7UNC	28.2
1 3/8 - 6UNC	30.8
1 1/2 - 6UNC	34
1 3/4 - 5UNC	39.5

Drill hole size in screw for pipe

Nominal size	Rc(PT)	Rp(PS)	G(PF)
1/8	8.2	8.5	8.8
1/4	10.9	11.4	11.87
3/8	14.4	14.9	15.38
1/2	18	18.5	19.1
5/8	—	—	21
3/4	23	24	24.6
7/8	—	—	28.3
1	29	30	30.9
1 1/8	—	—	35.5
1 1/4	38	39	39.4
1 1/2	44	45	45.4

Dia. of tap shank



Metric screw threads	Unified screw threads	Gas screw threads	φ D2
φ D1			
M 1~M 2.6	UNo. 0~ 4		3
M 3~M 3.5	UNo. 5 ~ 6		4
M 4~M 4.5	UNo. 8		5
M 5~M 5.5	UNo.10 ·12		5.5
M 6	U 1/ 4		6
	U 5/16		6.1
M 7~M 8			6.2
M 9~M10	U 3/ 8		7
M11	U 7/16	P1/16·1/8	8
M12			8.5
	U 1/ 2		9
M13			9.5
M14~M15	U 9/16		10.5
		P 1/4	11
	U 5/ 8		12
M16			12.5
M17			13
M18	U 3/ 4	P 3/8	14
M20			15
M22	U 7/ 8		17
		P 1/2	18
M24~M25		P 5/8	19
M26~M27	U1		20
M28			21
	U1 1/ 8		22
M30		P 3/4	23
M32	U1 1/ 4	P 7/8	24
M33			25
M35	U1 3/ 8	P1	26
M36~M38		P1 1/8	28
M39~M40	U1 1/ 2		30
M42	U1 5/ 8	P1 1/4	32
M45	U1 3/ 4	P1 3/8	35
M48		P1 1/2	38
M50	U2	P1 5/8	40
M52		P1 3/4	42

Dimensional tolerance of typically used mating (JIS B 0401)

The class of dimension(mm)		The tolerance of the hole dimension(μ m)						The tolerance of the shaft dimension(μ m)					
More than	Less than	H4	H5	H6	H7	H8	H9	h4	h5	h6	h7	h8	h9
—	3	+3 0	+4 0	+6 0	+10 0	+14 0	+25 0	0 -3	0 -4	0 -6	0 -10	0 -14	0 -25
3	6	+4 0	+5 0	+8 0	+12 0	+18 0	+30 0	0 -4	0 -5	0 -8	0 -12	0 -18	0 -30
6	10	+4 0	+6 0	+9 0	+15 0	+22 0	+36 0	0 -4	0 -6	0 -9	0 -15	0 -22	0 -36
10	18	+5 0	+8 0	+11 0	+18 0	+27 0	+43 0	0 -5	0 -8	0 -11	0 -18	0 -27	0 -43
18	30	+6 0	+9 0	+13 0	+21 0	+33 0	+52 0	0 -6	0 -9	0 -13	0 -21	0 -33	0 -52
30	50	+7 0	+11 0	+16 0	+25 0	+39 0	+62 0	0 -7	0 -11	0 -16	0 -25	0 -39	0 -62
50	80	+8 0	+13 0	+19 0	+30 0	+46 0	+74 0	0 -8	0 -13	0 -19	0 -30	0 -46	0 -74
80	120	+10 0	+15 0	+22 0	+35 0	+54 0	+87 0	0 -10	0 -15	0 -22	0 -35	0 -54	0 -87
120	180	+12 0	+18 0	+25 0	+40 0	+63 0	+100 0	0 -12	0 -18	0 -25	0 -40	0 -63	0 -100
180	250	+14 0	+20 0	+29 0	+46 0	+72 0	+115 0	0 -14	0 -20	0 -29	0 -46	0 -72	0 -115
250	315	+16 0	+23 0	+32 0	+52 0	+81 0	+130 0	0 -16	0 -23	0 -32	0 -52	0 -81	0 -130
315	400	+18 0	+25 0	+36 0	+57 0	+89 0	+140 0	0 -18	0 -25	0 -36	0 -57	0 -89	0 -140
400	500	+20 0	+27 0	+40 0	+63 0	+97 0	+155 0	0 -20	0 -27	0 -40	0 -63	0 -97	0 -155

Conversion table for International System of Units

Force

N	kgf
1	1.01972×10 ⁻¹
9.80665	1

Pressure

Pa	kgf/cm ²
1	1.01972×10 ⁻⁵
9.80665×10 ⁴	1

Stress

Pa	kgf/mm ²
1	1.01972×10 ⁻⁷
9.80665×10 ⁶	1

INDEX

CODE	NAME	Page
AB - 15	Semi-finished positioning block	19
ABF005	Positioning block for machines	7
BT40 - AHA20 - 160	ANGLE HEAD SOLID type	16
F190 - AHA20 - 200	ANGLE HEAD FLANGE type	17
BT50 - AHB5 - 225	ANGLE HEAD MODULAR type	15
BT50 - AHC10 - 245		
BT50 - AHA25 - 250	ANGLE HEAD SOLID type	16
BT50 - AHD30 - 195		
BT40 - AHU10 - 175	ANGLE HEAD UNIVERSAL type	18
AJB - M6 - L	Adjust bolt(WIRE CUT UNIT)	102
AJC - M14	Adjust screw(COLLET HOLDER)	37
AJN - M18L	Adjust screw(Hi-ART Milling chuck)	44
AP40 - T30V	Adapter(Petit Ball / MY CUBE)	95
BT50 - ART32 - 105	Hi-ART Milling chuck	42, 104
AW - 1	Adjustable torque wrench	31,38,103
A		
T50 - BL40 - 42	BLANK TOOL (Tool for turning mill)	72
B		
C10 - 6	SPRING COLLET	8, 38
C10 - A set	SPRING COLLET Standard set	38
C10 - RM	Collet remover	38
T63 - CAAX52 - 150	CHECKING ARBOR	72
CAP2022	Cap dispenser	92
CBX - 01	CLEAN BOX	88
T63 - CC32 - 90	Set screw holders for Round shank	69
CCD094 - PA	Insert	62
CD40 - 01	Coolant duct(fixed)	104
CD50 - A1	Coolant duct(Dummy duct)	104
CD63 - 01F	Coolant duct(Adjustable)	104
CE - CTS10	Collet remover	38
ST6 - CEB102	Centering bar	84
C		
CF12 - 4 - 35	SLIMLINE collet	※
CLP - 7E	Coolant cap	30
CLP - 101	Clamper(WIRE CUT UNIT)	102
NT30 - CMA - 20 - 125	TEST BAR CHECKMATE	90
HSK32 - CMB - 25 - 175		
CN - 103	Container box	98
T100 - CN40 - 115	Set screw holders for Round shank	69
CP - 14M	Coolant screw	39
CR12.6.55	SLIMLINE collet	※
CS12.3.80		
CSA - M14	Coolant screw	39
CSR - 14	Coolant screw(COLLET HOLDER)	39
BT30 - CTA10 - 45	COLLET HOLDER	36
BT50 - CTH10 - 105	COLLET HOLDER	34
E32 - CTS10 - 50	for high-speed	35
D		
D7 - 1.5	DETA-1 COLLET	31
A40 - DOC17.5 - 55	Dovetail clamping (SMART GRIP)	78
A63 - DOV110I	Dovetail vise (SMART GRIP)	79
DR - 1	Collet driver	31
BT40 - DTA3 - 95	DETA-1 COLLET HOLDER A type	24
BT50 - DTB7 - 75	DETA-1 COLLET HOLDER B type	26
A50 - DTE7 - 105	DETA-1 COLLET HOLDER E type	28
DW - 2.5 - 110	Wrench	31, 103
E		
7EA - 3.5 - 3	Spacer	30
12EBF - BL - 5		
12EBM - 3 - 3		
12EBS - 3.6 - 3		
EMO - STD3 - 2	ENDMILL HOUSE	97
ER8 - 4	SPRING COLLET	19
7ES - A	Spacer set	30
ESX12 - 6	SPRING COLLET	19

CODE	NAME	Page
F - 38	Spanner	38, 103
F - 38AW	Spanner for torque wrench	31, 103
F160H32 - A40	Mounting plate(SMART GRIP)	78
F100H21 - A40 - 50	The Manual clamping head (SMART GRIP)	78
F100S65 - A63 - 89	The Automation clamping head (SMART GRIP)	81
F		
FC - 32	Spanner	38, 103
FC - 36AW	Spanner for torque wrench	38, 103
FCS6 - 3	Shrink-fit collet	10
FCS6 - M4	Tap collet	10
FKA - 60	Stationary bracket (ANGLE HEAD HALF)	105 ~
FKB - 60		
FKC - 50		
FM - 72	Spanner with ejection hook (Hi-ART MILLING CHUCK)	42, 103
BT40 - FMH16 - 29 - 45	Cutter arbor with spindle-through coolant	53
BT50 - FMH22 - 47 - 165H	FMH RIGID type	47
A40 - FP40-35	Flange clamping(SMART GRIP)	79
G		
GRP - 002	Grip	102
H		
HB - 01	Semi-finished positioning block (ANGLE HEAD HALF)	7
HBX - A40	TOOL HOLDER STORING CABINET	98
HF - BT30	Tool set up stand (Vice clamping type)	95
BT30 - HFA10 - 120	ANGLE HEAD HALF 90°type	9
BT30 - HFCS6 - 155	ANGLE HEAD HALF mini type	10
BT40 - HFD7 - 120	ANGLE HEAD HALF 90°type	9
BT30 - HFT4 - 122		
HP-50S	Positioning pin (ANGLE HEAD HALF)	105 ~
BT40 - HUA10 - 135	ANGLE HEAD HALF UNIVERSAL type	12
BT30 - HUD7 - 102		
BT30 - HUT4 - 102		
I		
IR 15 - A40FP	Positioner boss (SMART GRIP)	79
J		
JAE - 501	Extension Jaw	100
K		
KJ - 45	Insert and insert holder set	62
M		
MB5 - 112	Head	15
MBF-M12	Clamp bolt(Cutter arbor with spindle-through coolant)	54
BT40 - MBH50 - 150	MICRO HEAD MBH type	59
BT30 - MBJ45 - 120	MICRO HEAD MBJ45 type	61
BT50 - MBJ70 - 165	MICRO HEAD MBJ70 type	62
MC10 - 132	Head	15
MDV - 501	MIDDLE VISE	99
BT50 - MFA20 - 165	MICRO HEAD MFA type	57
BT40 - MS - 98	Shank	15
MS2 - 30	Extension	57
MU - S6H	UNIVERSAL FACING BORING HEAD	73
MY CUBE50	MY CUBE	95
N		
NOZ - M6 - 12	Nozzle	42,44,103
NUA - CTA10	Nut	37, 104
NUB - CTH10 - 3.6	SUKIMA nut	39, 104
P		
P30T - 1	Retention knob	64
P - 445		
P - 535/538	Retention knob(BT30-DTB12)	27
PA - R - 1	PALETTE	96
PCT01 - 10	Cleaning tool felt type	31
PETIT BALL40	Petit Ball	95
PJ - 45	Insert and insert holder set	62
PR - DTA3	Rod (DETA-1 COLLET HOLDER DTA3 type)	25
PTC10	Cartridge (MICRO HEAD MBH type)	60
PTE - 001	Extension Plate	101
R		
RC - 26	CTS Special wrench	38, 103
RS - A63 - A40	Adapter (SMART GRIP)	79
BT40 - RSG8 - 105 - M25	RED SCREW arbor	49

	CODE	NAME	Page
S	S42 – 6F	Straight collet	42
	S – STA12	Insert holder	62
	S – STV1822		
	T63 – SA2525 – 105	Insert holders for Square-shank	70
	T63 – SB2525 – 95		71
	T50 – SC2020R – 95		
	T40 – SH2020 – 75		72
	A40 – SCD20 – 55	Side clamp B(SMART GRIP)	80
	A40 – SCS10 – 40	Side clamp A(SMART GRIP)	80
	BT50 – SLFB4 – 90 – M22	SLIMLINE MONO series	※
	BT50 – SLK12 – 75	SLIMLINE 2PIECE type Master holder	※
	BT50 – SLRA4 – 110 – M42	SLIMLINE MONO series SLIMLINE STRAIGHT ARBOR	※
	BT50 – SLRB8 – 110 – M42		
	BT50 – SLSA4 – 140 – M42		
	BT50 – SLSB8 – 140 – M42		
	A100 – SLZ25 – 135	SUMMIT	44
	T50 – SN2020R – 110	Insert holders for Square-shank	71
	SRC – 501	Clamp on Slider	100
	SRL – 501	L Slider	
	SRS – 501	Sandwich Slider	
	SRV – 501	V Slider	
	SRV – 01	Dedicated bracket	92
	SS32 – 8	Sleeve for a set screw holders	69
	STB – M6 – L	Stud bolt	102
	STGP10	Cartridge	60
	STH18	Insert holder	62
	STV – C12055		61
	T40 – SV2020R – 90	Insert holders for Square-shank	70
T	TA4 – M2	Tap sleeve	8
	TBU10	Test bar	18
	TCA2022 – 10	TOOL CAP TCA type	92
	TCB0820 – 10	TOOL CAP TCB type	
	TCC0607 – 50	TOOL CAP TCC type	93
	TCC – F	Variety set	93
	TNB114 – PB	MICRO HEAD MBH type	60
	TPA082 – PA	MICRO HEAD MFA type	57
	TPC112 – PA	MICRO HEAD MBJ/MBH type	62
	TPE042 – PA	MICRO HEAD MBJ type	61
	TR – 5	Tap rod (DETA-1 COLLET HOLDER type)	30
W	TW – 4	Wrench	31, 103
	W – 206	Wrench	44, 103
	W – 135DR	Spanner · Wrench	31, 103
	WCU – A	WIRE CUT UNIT	101
Z	BT40 – ZPB – 200	Goo CHECKER (Set up the original point on the Z axis / measuring tool for reference position)	83
	BT40 – ZPM – 150		
123	6SD – 01	6S DESK	86

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INDEX

	NAME	CODE	Page
ANGLE HEAD	Adapter(Petit Ball / MY CUBE)	AP40 – T30V	95
	Adapter(SMART GRIP)	RS – A63 – A40	79
	Adjust bolt (WIRE CUT UNIT)	AJB – M6 – L	102
	Adjust screw (SUMMIT)	AJN – M18L	44
	Adjust screw (COLLET HOLDER)	AJC – M14	37
	Adjustable torque wrench	AW – 1	103
	ANGLE HEAD HALF 90°type	BT30 – HFA10 – 120	9
		BT40 – HFD7 – 120	
		BT30 – HFT4 – 122	
	ANGLE HEAD HALF mini type	BT30 – HFC6 – 155	10
	ANGLE HEAD HALF UNIVERSAL type	BT40 – HUA10 – 135	12
		BT30 – HUD7 – 102	
		BT30 – HUT4 – 102	
M/C Tool	ANGLE HEAD FLANGE type	F190 – AHA20 – 200	17
	ANGLE HEAD MODULAR type	BT50 – AHB5 – 225	15
		BT50 – AHC10 – 245	
	ANGLE HEAD SOLID type	BT40 – AHA20 – 160	16
		BT50 – AHD30 – 195	
	ANGLE HEAD UNIVERSAL type	BT40 – AHU10 – 175	18
	The Automatic clamping head (SMART GRIP)	F100S65 – A63 – 89	81
HSK-T Tooling Systems for Turning Mill	B BLANK TOOL (Tool for turning mill)	T50 – BL40 – 42	72
	Cap dispenser	CAP2022	92
	Cartridge (MICRO HEAD MBH type)	PTC10	60
		STGP10	
	Centering bar	ST6 – CEB102	84
	CHECKING ARBOR	T63 – CAAX52 – 150	72
	Clamp bolt (Cutter arbor with spindle-through coolant)	MBF – M12	54
	Clamper (WIRE CUT UNIT)	CLP – 101	102
	CLEAN BOX	CBX – 01	88
	Cleaning tool wiper type	PCT01 – 10	31
	Collet driver	DR – 1	31
	COLLET HOLDER	BT30 – CTA10 – 45	36
General Purpose Tool	C COLLET HOLDER for high-speed	BT50 – CTH10 – 105	34
		E32 – CTS10 – 50	35
		CE – CTS10	38
	Collet remover	C10 – RM	
	Container box	CN – 103	98
	Coolant screw (COLLET HOLDER)	CSA – M14	39
		CP – 14M	
		CSR – 14	
	Coolant cap	CLP – 7E	30
	Coolant duct (Adjustable)	CD63 – 01F	104
	Coolant duct (Dummy duct)	CD50 – A1	
	Coolant duct (fixed)	CD40 – 01	
JIG	Cutter arbor with spindle-through coolant	BT40 – FMH16 – 29 – 45	53
	Dedicated bracket (TOOL CAP TCA type)	SRV – 01	92
	DETA-1 COLLET	D7 – 1.5	31
	DETA-1 COLLET HOLDER A type	BT40 – DTA3 – 95	24
	DETA-1 COLLET HOLDER B type	BT50 – DTB7 – 75	26
	DETA-1 COLLET HOLDER E type	A50 – DTE7 – 105	28
	Dovetail clamping (SMART GRIP)	A40 – DOC17.5 – 55	78
	Dovetail vise A,B (SMART GRIP)	A63 – DOV110I	79
	E ENDMILL HOUSE	EMO – STD3 – 2	97
	Extension (MICRO HEAD MFA type)	MS2 – 30	57
	Extension Jaw (MIDDLE VISE)	JAE – 501	100
	Extension Plate (WIRE CUT UNIT)	PTE – 001	101
Measuring Equipment	F Flange clamping (SMART GRIP)	A40 – FP40-35	79
		BT50 – FMH22 – 47 – 165H	47

	NAME	CODE	Page
G	Goo Checker	BT40 – ZPB – 200	83
		BT40 – ZPM – 150	
	Grip	GRP – 002	102
H	Head (ANGLE HEAD MODULAR type)	MB5 – 112	15
		MC10 – 132	
	Hi-ART MILLING CHUCK	BT50 – ART32 – 105	41
I	Insert holder(MICRO HEAD)	S – STA12	62
		STH18	
		STV – C12055	
		s-STV1822	61
			62
	Insert and insert holder set (MICRO HEAD)	KJ – 45	62
		PJ – 45	
	Insert holders for Square-shank	T63 – SA2525 – 105	70
		T63 – SB2525 – 95	71
		T50 – SC2020R – 95	
		T40 – SH2020 – 75	72
		T50 – SN2020R – 110	71
		T40 – SV2020R – 90	70
M	MICRO HEAD MBH type	BT40 – MBH50 – 150	59
		TNB114 – PB	60
	MICRO HEAD MBJ45 type	BT30 – MBJ45 – 120	61
		TPE042 – PA	
	MICRO HEAD MBJ70 type	BT50 – MBJ70 – 165	62
	MICRO HEAD MBJ/MBH type	TPC114 – PA	62
	MICRO HEAD MFA type	BT50 – MFA20 – 165	57
		TPA082 – PA	
	MIDDLE VISE	MDV – 501	99
	Mounting plate (SMART GRIP)	F160H32 – A40	78
	MY CUBE	MY CUBE50	95
N	Nozzle	NOZ – M6 – 12	42, 44, 103
	Nut (COLLET HOLDER)	NUA – CTA10	37, 104
P	PALETTE (Collet stand)	PA – R – 1	96
	PETIT BALL	PETIT BALL40	95
	Positioner boss (SMART GRIP)	IR15 – A40FP	79
	Positioning block (ANGLE HEAD HALF)	ABF005	7
	Positioning pin (ANGLE HEAD HALF)	HP – 50S	105 ~
R	RED SCREW arbor	BT40 – RSG8 – 105 – M25	49
	Retention knob	P30T – 1	64
		P – 455	
	Rod (DETA-1 COLLET HOLDER DTA3 type)	PR – DTA3	25
	Retention knob (BT30-DTB12)	P – 535/538	27
S	Semi-finished positioning block	AB – 15	19
	Semi-finished positioning block (ANGLE HEAD HALF)	HB – 01	7
	Set screw holders for Round shank	T63 – CC32 – 90	69
		T100 – CN40 – 115	
	Shank (ANGLE HEAD)	BT40 – MS – 98	15
	Shrink-fit collet (ANGLE HEAD HALF mini type)	FCS6 – 3	10
	Side clamp A (SMART GRIP)	A40 – SCS10 – 40	80
		A40 – SCD20 – 55	
	Sleeve for a set screw holder	SS32 – 8	69
	Slider (MIDDLE VISE)	SRC/SRL/SRS/SRV	100
	SLIMLINE 2PIECE type Master holder	BT50 – SLK12 – 75	※
	SLIMLINE collet	CF12 – 4 – 35	
		CR12-6-55	
		CS12-3-80	
	SLIMLINE MONO series	BT50 – SLFB4 – 90 – M22	30
	SLIMLINE MONO series SLIMLINE STRAIGHT ARBOR	BT50 – SLRA4 – 110 – M42	
		BT50 – SLRB8 – 110 – M42	
		BT50 – SLSA4 – 140 – M42	
		BT50 – SLSB8 – 140 – M42	
	Spacer (DETA-1 COLLET HOLDER DTE type)	7EA – 3.5 – 3	30
		12EBF – BL – 5	
		12EBM – 3 – 3	
F	Spacer set (DETA-1 COLLET HOLDER DTE type)	12EBS – 3.6 – 3	30
		7ES – A	

	NAME	CODE	Page
	Spanner	F/FC/FF/FM	103
	SPRING COLLET (COLLET HOLDER)	C10 – 6	8, 38
		ER8 – 4	19
		ESX12 – 6	
	SPRING COLLET Standard set (COLLET HOLDER)	C10 – A set	38
S	Stationary bracket (ANGLE HEAD HALF)	FKA – 60	105 ~
		FKB – 60	
		FKC – 50	
	Straight collet (Hi-ART MILLING CHUCK)	S42 – 6F	42
	Stud bolt (WIRE CUT UNIT)	STB – M6 – L	102
	Sukima nut (COLLET HOLDER)	NUB – CTH10 – 3.6	39, 104
	SUMMIT	A100 – SLZ25 – 135	44
T	Tap collet (ANGLE HEAD HALF mini type)	FCS6 – M4	10
	Tap rod (DETA-1 COLLET HOLDER DTE type)	TR – 5	30
	Tap sleeve (ANGLE HEAD HALF)	TA4 – M2	8
	TEST BAR (ANGLE HEAD UNIVERSAL type)	TBU10	18
	TEST BAR CHECKMATE	NT30 – CMA – 20 – 125	90
		HSK32 – CMB – 25 – 175	
	The Manual clamping head (SMART GRIP)	F160H32 – A40 – 50	78
	Throw-away tip (MICRO HEAD MBJ type)	CCD094 – PA	62
	TOOL CAP TCA type	TCA2022 – 10	92
	TOOL CAP TCB type	TCB0820 – 10	
	TOOL CAP TCC type	TCC0607 – 50	93
	TOOL HOLDER STORING CABINET	HBX – A40	98
	Tool set up stand (Vice clamping type)	HF – BT30	95
U	UNIVERSAL FACING BORING HEAD	MU – S6H	73
V	Variety set (TOOL CAP TCC type)	TCC – F	93
W	WIRE CUT UNIT	WCU – A	101
	Wrench	DW/RC/TW/W	103
123	6S DESK	6SD – 01	86

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