

Thread cutting systems

For magnetic core drilling machines of the ProfiPLUS category.

DRILLING, COUNTERSINKING AND CUTTING QUICK AND SAFE

Quick-change drill chucks and inserts for threads from M6 to M42

Magnetic core drilling machines of the ProfiPLUS category are ideal for thread cutting.

The basic requirements for this are: Clockwise/anticlockwise rotation, solid shaft control electronics and high motor output.

Quick-change drill chucks

Sizes MT 2, MT 3 and MT 4

The large stroke range of the BDS magnet core drilling machines combined with the quick-change drill chuck allows quick and efficient working without having to realign and centre after changing tools. The quick-change drill chuck is designed for universal use when using quick-change inserts with and without a safety friction clutch.



Version 1: Quick-change inserts with safety friction clutch

Thread from M6 to M42 –

BDS inserts with a safety friction clutch allow precise cutting of through-hole and blind-hole threads.

The safety friction clutch prevents the machine screw tap hitting the floor of the drill hole and shearing.

Version 2:

Standard quick-change inserts

Threads from M6 to M30 – BDS inserts for machine screw taps are suitable for accommodating machine screw taps for through-hole threads.



Which machine, which thread?

Assignment of possible thread diameter to size of quick-change base holders and inserts.

PRECISION WITH BDS SYSTEM ACCESSORIES

Thread cutting systems

GSW quick-change drill chucks:

In MT 2, MT 3 and MT 4 versions.

To accommodate GSE or GSS quick-change inserts

GSW 222 size 2 MT 2

GSW 331 size 1 MT 3

GSW 332 size 2 MT 3

GSW 333 size 3 MT 3

GSW 442 size 2 MT 4

GSW 443 size 3 MT 4

GSW 444 size 4 MT 4



GSE standard quick-change insert
Sizes 1, 2, 3



GSS quick-change insert with safety friction clutch
sizes 2, 3, 4

ORDER NO.

GSW 222 quick-change drill chuck

GSW 331 quick-change drill chuck

GSW 332 quick-change drill chuck

GSW 333 quick-change drill chuck

GSW 442 quick-change drill chuck

GSW 443 quick-change drill chuck

GSW 444 quick-change drill chuck

GSE 103 - GSE 114 per unit

GSE 205 - GSE 222 per unit

GSE 314 - GSE 330 per unit

GSS 205 - GSS 222 per unit

GSS 312 - GSS 330 per unit

GSS 420 - GSS 442 per unit



Machine screw tap adapter with Weldon shank

ORDER NO.	THREAD	SHANK Ø	SQUARE
ZGA 010	M10 DIN 376	7	5.5
ZGA 012	M12 DIN 376	9	7
ZGA 014	M14 DIN 376	11	9
ZGA 016	M16 DIN 376	12	9
ZGA 018	M18 DIN 376	14	11
ZGA 020	M20 DIN 376	16	12
ZGA 022	M22 DIN 376	18	14.5
ZGA 024	M24 DIN 376	18	14.5
ZGA 027	M27 DIN 376	20	16
ZGA 030	M30 DIN 376	22	18

Up to ZGA 020 with 19 mm Weldon shank (¾")

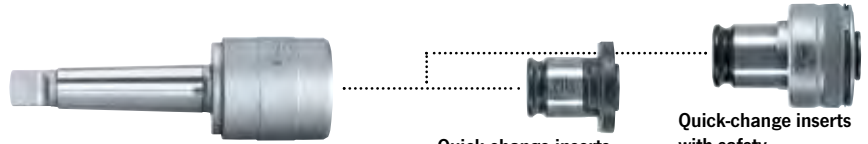
From ZGA 022 with 32 mm Weldon shank (1 ½")

Machine screw tap adapters – making an affordable start

The machine screw tap is accommodated directly in the 19 mm or 32 mm Weldon system with an adapter. Only suitable for through-hole threads!



THREAD CUTTING SYSTEMS



Quick-change drill chucks GSW

**Quick-change inserts
Standard GSE**

**Quick-change inserts
with safety
friction clutch GSS**

MAB 1300	MAB 825 MAB 845	MAB 485 MAB 485 SB	MAB 525 MAB 525 SB	Order No. Quick-change drill chuck	Thread	Order No.	ø x square	Order No.	ø x square	
				GSW 222 Size 2 MT 2	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9	
					M6					GSS 206
					M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2	
					M8					GSS 205
					M10	GSE 210-DIN 371	10 / 8	GSS 210	7 / 5.5	
					M10					GSE 210
					M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0	
					M14					GSE 214
					M16	GSE 216	12 / 9.0	GSS 216	12 / 9.0	
				GSW 331 Size 1 MT 3	M4	GSE 104	4.5 / 3.4			
					M5/M6	GSE 105	6 / 4.9			
					M8	GSE 108	8 / 6.2			
					M10	GSE 110	10 / 8.0			
					M12	GSE 112	9 / 7.0			
					M14	GSE 114	11 / 9.0			
				GSW 332 Size 2 MT 3	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9	
					M6					GSS 206
					M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2	
					M8					GSS 205
					M10	GSE 210.1	10 / 8	GSS 210	7 / 5.5	
					M10					GSE 210
					M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0	
					M14					GSE 214
					M16	GSE 216	12 / 9	GSS 216	12 / 9	
					M18					GSE 218
					M20	GSE 220	16 / 12	GSS 220	16 / 12	
					not suitable for MAB 525					M22/M24
					GSW 333 Size 3 MT 3	M12			GSS 312	9 / 7.0
				M14		GSE 314	11 / 9	GSS 314	11 / 9	
				M16		GSE 316	12 / 9	GSS 316	12 / 9	
				M18		GSE 318	14 / 11	GSS 318	14 / 11	
				M20		GSE 320	16 / 12	GSS 320	16 / 12	
						M22/M24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
						M30	GSE 330	22 / 18	GSS 330	22 / 18
				GSW 442 Size 2 MT 4		M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
					M6	GSS 206				
					M8		GSE 208	8 / 6.2	GSS 208	8 / 6.2
					M8	GSS 205				
					M10		GSE 210-DIN 371	10 / 8.0	GSS 210	7 / 5.5
					M10	GSE 210				
					M12		GSE 212	9 / 7.0	GSS 212	9 / 7.0
					M14	GSE 214				
					M16		GSE 216	12 / 9	GSS 216	12 / 9
					M18	GSE 218				
					M20		GSE 220	16 / 12	GSS 220	16 / 12
					M22/24	GSE 222				
					GSW 443 Size 3 MT 4	M12			GSS 312	9 / 7.0
				M14		GSE 314	11 / 9	GSS 314	11 / 9	
				M16		GSE 316	12 / 9	GSS 316	12 / 9	
				M18		GSE 318	14 / 11	GSS 318	14 / 11	
				M20		GSE 320	16 / 12	GSS 320	16 / 12	
				M22/24		GSE 322	18 / 14.5	GSS 322	18 / 14.5	
				M27		GSE 327	20 / 16	GSS 327	20 / 16	
				M30		GSE 330	22 / 18	GSS 330	22 / 18	
				GSW 444 Size 4 MT 4	M20			GSS 420	16 / 12	
					M22/24			GSS 422	18 / 14.5	
					M27			GSS 427	20 / 16	
					M30			GSS 430	22 / 18	
					M33			GSS 433	25 / 20	
					M36			GSS 436	28 / 22	
					M39/42			GSS 442	32 / 24	

Arbors
and adapters

Accessories and
consumables

Drills

About BDS