

BT SHRINK FIT CHUCK

High precision: Shank run-out accuracy: $\leq 0.002\mu\text{m}$ Dynamic balancing grade: $\leq G1$.

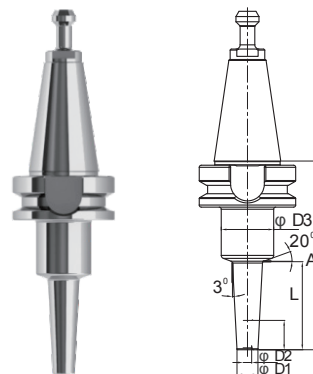
With a simple structure, the cutter can be loaded and unloaded quickly.

It is suitable for a machining center with a relatively high speed.

Compared with the traditional carrier shank with the chuck, the shrink-fit shank has the following advantages:

1. Compact structure and high rigidity: The inner hole of the shank is directly connected with the cutter, without a middle carrier.
2. Large transmission torque: It can achieve a torque out put 2 times or above that of an ordinary shank with ER chuck.
3. Wide adaptability and good machining surface quality: It is suitable for various kinds of rough and fine machining, with good machining surface quality.
4. High clamping accuracy: Generally, the clamping precision of the shank with the high-precision grade chuck is $\leq 0.005\text{mm}$ (at 4D position); but the run-out precision of the shrink-fit shank is $\leq 0.002\text{mm}$ (at 4D position).
5. Note:
 - The precision at the cutter shank is required to be H6.
 - The cutter is required to be made of tungsten steel, hard alloy, etc.
 - Adaptive induction heating type thermal shrinkage machine.

BT CHUCK FEATURES



Run-out accuracy $\leq 0.002\text{mm}$ (direct clamping) Test standard: Run-out accuracy shall be $\leq 0.002\text{mm}$ (standard test rod: the length is 4 times of diameter); high accuracy run-out can improve the smoothness of the machined surface and prolong the service of cutter.

APPLICATION TYPE



Drilling



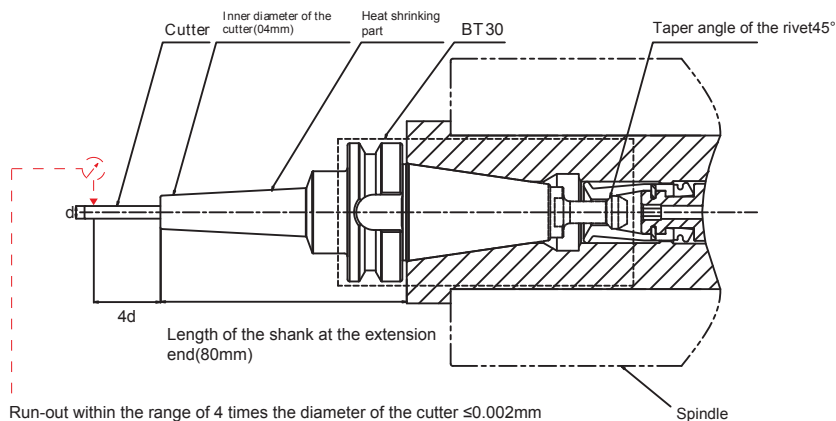
Reaming



Milling and cutting

DSFBT30-45-04-080

Schematic Diagram



NAMING RULE:

DSFBT30-45-04-080

ENTERPRISE CODE: _____
DAKE, an abbreviation of initial letters

SHRINK-FIT SHANK CODE _____

SHANK TYPE _____
BT30
BT40
BT50

Taper angle
of the shank rivet

LENGTH OF THE SHANK AT THE
EXTENSION END /mm
(THREE-DIGIT NUMBER)

04: INNER DIAMETER OF THE
CUTTER/mm (TWO-DIGIT NUMBER)

60: 60° TAPER ANGLE
45: 45° TAPER ANGLE
Blank: DEFAULT SETTING

BT SHRINK FIT CHUCK

TECHNICAL PARAMETERS

Chuck Type	Order type	Dimensions						Diameter of the cutter to be used	Requirement for the precision of the cutter shank diameter	Applicable speed
		D	D1	D2	L	L1	clamping depth L2			
BT30	DSFBT30-03-080	3	13	20	80	22	47	φ3	H6	36000RPM
	DSFBT30-03-090				90					
	DSFBT30-04-080	4	21	27	80		20	φ4		
	DSFBT30-04-090				90		47			
	DSFBT30-06-080	6	21	27	80		38	φ6		
	DSFBT30-06-090				90					
	DSFBT30-08-080	8	21	27	80		36	φ8		
	DSFBT30-08-090				90					
	DSFBT30-10-080	10	24	32	80		42	φ1 0		
	DSFBT30-10-090				90					
	DSFBT30-12-080	12	24	32	80		47	φ1 2		
	DSFBT30-12-090				90					
	DSFBT30-14-080	14	27	34	80		47	φ1 4		
	DSFBT30-14-090				90					
BT40	DSFBT40-04-090	4	10	10	90	27	12	φ4	H6	25000RPM
	DSFBT40-04-130				130		18000RPM			
	DSFBT40-06-090	6	21	27	90		36	φ6		25000RPM
	DSFBT40-06-130				130					18000RPM
	DSFBT40-08-090	8	21	27	90		36	φ8		25000RPM
	DSFBT40-08-130				130					18000RPM
	DSFBT40-10-090	10	24	32	90		42	φ1 0		25000RPM
	DSFBT40-10-130				130					18000RPM
	DSFBT40-12-090	12	24	32	90		47	φ1 2		25000RPM
	DSFBT40-12-130				130					18000RPM
	DSFBT40-14-090	14	27	34	90		47	φ1 4		25000RPM
	DSFBT40-14-130				130					18000RPM
BT50	DSFBT50-04-090	4	10	10	90	38	12	φ4	H6	18000RPM
	DSFBT50-04-130				130					
	DSFBT50-06-090	6	21	27	90		36	φ6		
	DSFBT50-06-130				130					
	DSFBT50-08-090	8	21	27	90		36	φ8		
	DSFBT50-08-130				130					
	DSFBT50-10-090	10	24	32	90		42	φ1 0		
	DSFBT50-10-130				130					
	DSFBT50-12-090	12	24	32	90		47	φ1 2		
	DSFBT50-12-130				130					
	DSFBT50-14-090	14	27	34	90		47	φ1 4		
	DSFBT50-14-130				130					