



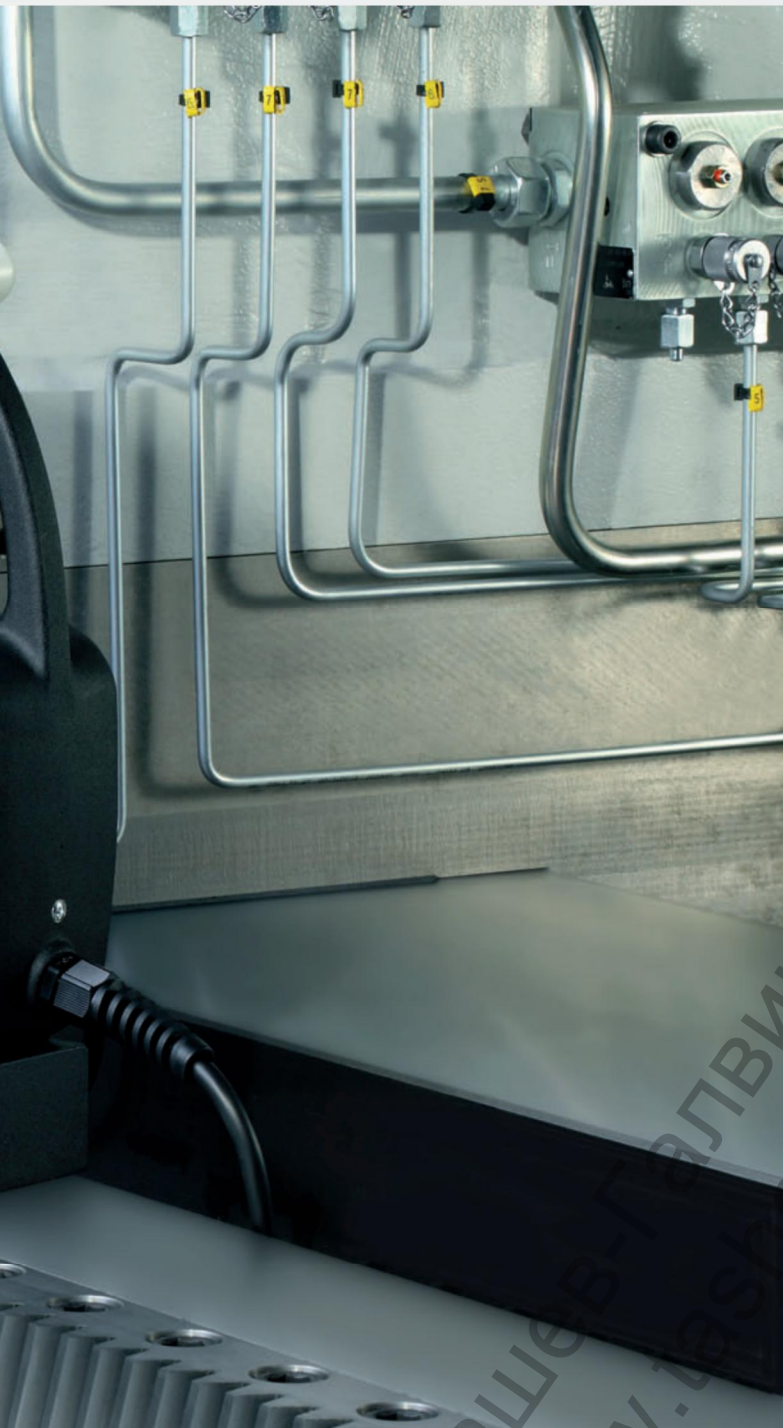
### Quick-change drill chuck and inserts for threads from M 6 to M 42

Magnetic core drilling machines of the ProfiPLUS class are ideally suited for thread cutting. Basic requirements are: CW/CCW operation, full wave control electronics and high motor performance.

### Quick-change drill chuck size MK 2, MK 3 and MK 4

The large stroke range of the BDS magnetic core drilling machines, in conjunction with the quick-change chuck, facilitates fast and efficient working without having to repeat the aligning and centring when changing the tool. The quick-change drill chuck can be universally used for the quick-change inserts with and without safety friction clutch.





# Thread cutting systems

For magnetic core drilling machines of the ProfiPLUS class.



Drilling, countersinking and thread cutting with a magnetic core drilling machine from BDS. Quickly, easily and with high precision.

## Option 1: Quick-change inserts with safety friction clutch

Threads from M 6 to M 42 – BDS inserts with safety friction clutch allow for precise threading of through-hole threads and blind-hole threads.

The safety friction clutch prevents tap fracture by contacting the bottom of the borehole.



## Option 2: Standard quick-change inserts

Threads from M 6 to M 30 – BDS inserts are suited for taking up of taps for through-hole threads.

# Which Machine? Which thread?

Assignment of machines of the ProfiPLUS class and the possible thread diameter to the size of the basic quick-change drill chucks and inserts.

## THREAD CUTTING SYSTEMS

### GSW Quick-change drill chucks:

In the versions MK 2, MK 3, MK 4. For taking up quick-change inserts GSE or GSS.

GSW 222 Size 2 MK 2

GSW 331 Size 1 MK 3

GSW 332 Size 2 MK 3

GSW 333 Size 3 MK 3

GSW 442 Size 2 MK 4

GSW 443 Size 3 MK 4

GSW 444 Size 4 MK 4



GSE  
Standard quick-change insert  
Size 1, 2, 3

GSS  
GSS Quick-change insert  
with safety friction clutch  
Size 2, 3, 4

## OVERVIEW

### 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 each

GSE 205 – GSE 222 each

GSE 314 – GSE 330 each

GSS 205 – GSS 222 each

GSS 312 – GSS 330 each

GSS 420 – GSS 442 each

GSE 100 Set of quick-change inserts size 1, M3 – M14

GSE 200 Set of quick-change inserts size 2, M5 – M24

GSE 300 Set of quick-change inserts size 3, M14 – M30

## Tap adapters – getting started economically

By means of the adapter, the taps are taken up directly into the 19 mm or 32 mm Weldon system. Suitable for through-hole threads only!



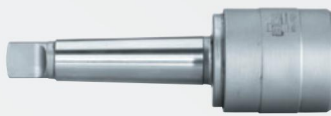
### TAP ADAPTER WITH WELDON SHANK

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 ( $\frac{3}{4}$ "

from ZGA 022 with 32 mm Weldon shank ( $1 \frac{1}{4}$ "

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 525	MAB 485	Order No.	Quick-change drill chuck	Thread	Order No.	ø x square	Order No.	ø x square
				GSW 222	Size 2 MK 2	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
						M8/M10	GSE 208	8 / 6.2	GSS 208	8 / 6.2
						M10	GSE 210	10 / 8.0	GSS 210	7 / 5.5
						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
						M14	GSE 214	11 / 9.0	GSS 214	11 / 9.0
						M16	GSE 216	12 / 9.0	GSS 216	12 / 9.0
				GSW 331	Size 1 MK 3	M3	GSE 103	3.5 / 2.7		
						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 MK 3	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
						M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
						M10	GSE 210	10 / 8	GSS 210	7 / 5.5
						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
						M14	GSE 214	11 / 9	GSS 214	11 / 9
						M16	GSE 216	12 / 9	GSS 216	12 / 9
						M18	GSE 218	14 / 11	GSS 218	14 / 11
						M20	GSE 220	16 / 12	GSS 220	16 / 12
					*not suitable for MAB 525	M22/M24*	GSE 222	18 / 14.5	GSS 222	18 / 14.5
				GSW 333	Size 3 MK 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
						M27	GSE 327	20 / 16	GSS 327	20 / 16
						M30	GSE 330	22 / 18	GSS 330	22 / 18
				GSW 442	Size 2 MK 4	M5/M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
						M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
						M10	GSE 210	10 / 8.0	GSS 210	7 / 5.5
						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
						M14	GSE 214	11 / 9	GSS 214	11 / 9
						M16	GSE 216	12 / 9	GSS 216	12 / 9
						M18	GSE 218	14 / 11	GSS 218	14 / 11
						M20	GSE 220	16 / 12	GSS 220	16 / 12
						M22/24	GSE 222	18 / 14.5	GSS 222	18 / 14.5
				GSW 433	Size 3 MK 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 MK 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

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### Quick Change Drill Chuck For Taps (Tapping Attachment)

#### Order. No. Description

GSW

In the MT 2, MT 3, MT 4 versions To accommodate quick-change inserts GSE or GSS

The large stroke range of the BDS magnetic core drilling machines in conjunction with the quick-change chuck enables quick and economical work without having to realign and center when changing tools.

The quick-change chuck can be used universally for the use of quick-change inserts with and without a safety slip clutch.

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 433 size 3 MT 4

GSW 444 size 4 MT 4

In the versions MT 2, MT 3, MT 4. For taking up quick-change inserts GSE or GSS.

The GSW Tapping Attachment Is Quick Change Type And Is Also Called As Quick-Change Drill Chuck For Tapping. The GSW Tapping Attachment Is Ideal For Use With Magnetic Drilling Machines With A Reversible Motor Which Can Rotate Clock And Anti-Clockwise Direction. Moreover, The GSW Tapping Attachment Comes With Morse Taper In An Option For MT 2, 3 Or 4. The GSW Tapping Attachment Is Used With GSE Quick Change Tapping Insert For Through-Hole Tapping Only Or With GSS Quick-Change Insert "With Friction Clutch" For Blind Hole & Through Hole Tapping. The GSW Tapping Attachment Comes With Different Sizes Depending On The Size Of Tap To Be Made. For More Information, We Recommend You To Download The Data Sheet.

**Quick Change Insert With Friction Clutch For BLIND HOLE Tapping****Order. No. Description**

GSS

Threads from M6 to M42 - BDS inserts with safety slip clutch enable the precise cutting of through and blind hole threads.

The safety slip clutch prevents the tap from hitting the bottom of the hole and breaking off.

**GSS 205** size 2 M5/M6

**GSS 208** size 2 M8

**GSS 210** size 2 M10

**GSS 212** size 2 M12

**GSS 216** size 2 M16

**GSS 218** size 2 M18

**GSS 220** size 2 M20

**GSS 222** size 2 M22

**GSS 312** size 3 M12

**GSS 314** size 3 M14

**GSS 316** size 3 M16

**GSS 318** size 3 M18

**GSS 320** size 3 M20

**GSS 322** size 3 M22/M24

**GSS 327** size 3 M27

**GSS 330** size 3 M30

**GSS 420** size 4 M20

**GSS 422** size 4 M22/M24

**GSS 427** size 4 M27

**GSS 430** size 4 M30

**GSS 433** size 4 M33

**GSS 436** size 4 M36

**GSS 442** size 4 M42

GSS Quick-change insert with safety friction clutch Size 2, 3, 4

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The GSS Quick Change Tapping Insert With Friction Clutch Is Used Blind Hole Tapping As Well As For Through Hole Tapping. The GSS Blind Hole Tapping Collets Is Equipped With A Friction Clutch Which Once The Tap Head Reached The Bottom Of The Blind Hole, The Friction Clutch Of The Quick Change Insert Will Get Activated And The Tap Will Stop To Penetrate More. Thus, The Tap Does Not Break. The GSS Collets For Blind Hole Tapping Are Used In Combination With GSW Quick Change Drill Chuck. The GSS Quick Change Inserts For Tapping Are Available From M5 To M24 Threading Size. For More Information Please Download The Data Sheet.

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