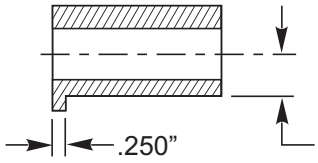
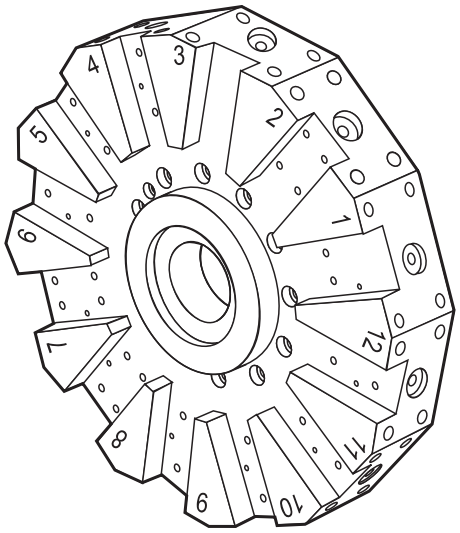
Bolt-On Tool Holders

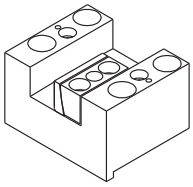
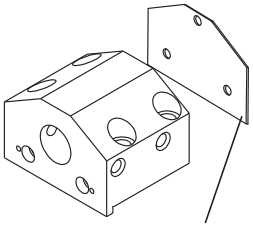
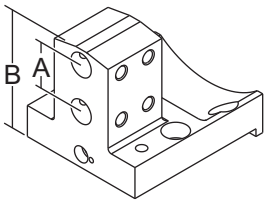
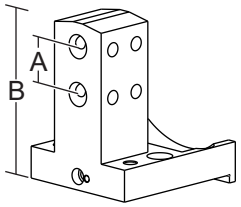
- ST-20 (Y) 12 station turret
- ST-30(Y) 12 station turret
- DS-30(Y) 12 station turret
- SL-40 10 Station Turret
- SL-20/30 10 and 12 station turret
- SL-10 10 station turret (up to Aug 1, 2001)
- TL-series 12 station 6 BOT + 6 VDI

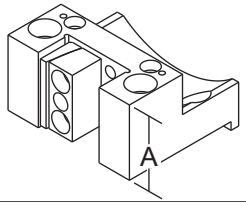
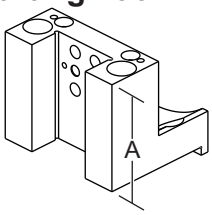
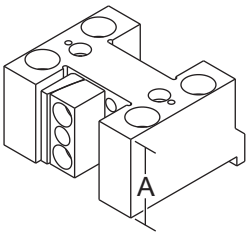
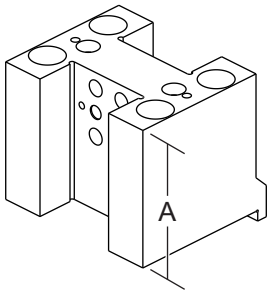
Basic BOT ID Tool Specifications





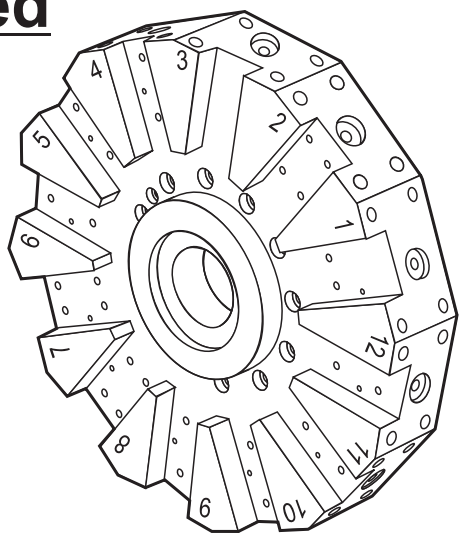
BOLT-ON TOOLS PARTS LIST

	Part No.	Size
Face Grooving 	BOT20F/G BOT20MFG-25 **SL-40 only** BF114 BMF32	1" 25mm 1 1/4" 32mm
Boring Bar  SL20/30 25-0593 SL40 25-6708	BOT 20ID BTS Max bore: 2.0" BOT20ID-1 BOT20MID-25 BOT20ID-1_1/4 BOT20ID-1_1/2 BOT20ID-2 BOT20MID-32 BOT20MID-40 BOT20MID-50 BOT20MID BTS Max bore: 50mm **SL-40 only** B212 BM50	BLANK 1" 1 1/4" 1 1/2" 2" 32mm 40mm 50mm BLANK 2 1/2" 50mm
Twin Bore 	BOT20ID-3/4T* BOT20MID-20T* Dim. A: 1.5" btw. centers (38.1 mm) Dim. B: 3.8" (96.5 mm)	3/4” (2x) 20mm (2x)
Extended Twin Bore 	BOT20EXTID-3/4T* BOT20EXTMID-20T* Dim. A: 1.5" btw. centers (38.1 mm) Dim. B: 5.25" (133.4 mm)	3/4” (2x) 20mm (2x)

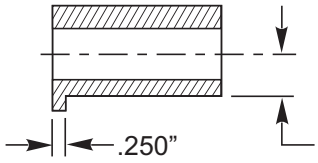
	Part No.	Size
Parting Tool 	BOT20OD-1* BOT20MOD-25* Height (A): 2.15" (54.6 mm)	1” 25mm
Extended Parting Tool 	BOT20EXTOD-1* BOT20EXTMOD-25* Height (A): 3.275" (83.2 mm)	1” 25mm
Twin Turn 	BOT20OD-1T* BOT20MOD-25T* Height (A): 2.15" (54.6 mm)	1” (2x) 20mm(2x)
Extended Twin Turn 	BOT20EXTOD-1T* BOT20EXTMOD-25T* Height (A): 3.275" (83.2 mm)	1” (2x) 20mm(2x)

Bolt-On Tool Holders Continued

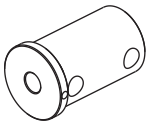
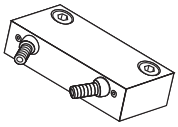
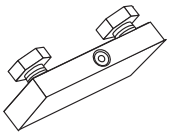
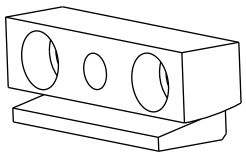
- ST-20 (Y) 12 station turret
- ST-30(Y) 12 station turret
- DS-30(Y) 12 station turret
- SL-40 10 Station Turret
- SL-20/30 10 and 12 station turret
- SL-10 10 station turret (up to Aug 1, 2001)
- TL-series 12 station 6 BOT + 6 VDI



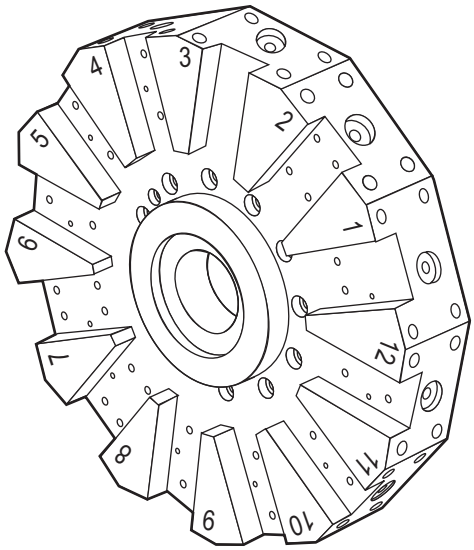
Basic BOT ID Tool Specifications



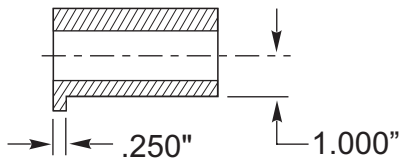
BOLT-ON TOOLS PARTS LIST

	Part No.	Size		Part No.	Size
Boring Bar Sleeve 	**SL-40 only** BS34 BS1 BS114 BS2 BMS 20 BMS25 BMS32 BMS40	 3/4" 1" 1 1/4" 2" 20mm 25mm 32mm 40mm	**Coolant Block** 	CB20 SL10**/20/30 CB40 SL40 CB20M (incl. metric bolts) CB40M (incl. metric bolts)	
			Nozzles	20-0562 90º 20-0689 Str long 20-2077 Plug 20-8730 Str 20-8739 45º	
Turret Face Clamps 	BOT20OD/CLAMP (Clamp Block SL10**/20/30 BOT20MOD/CLAMP BOT40OD/CLAMP (Clamp Block SL40) BOT40MOD/CLAMP	1" 25mm 1 1/4" 32mm	**Wedge Clamp** 	BOT20WEDGE BOT20MWEDGE	INCH METRIC

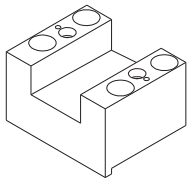
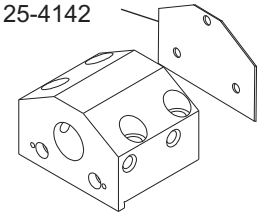
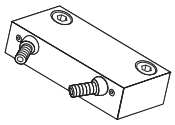
ST-10 / SL-10
12 Station Turret



Basic BOT ID Tool Specifications



BOLT ON TOOLS PARTS LIST

	Part No.	Size
Face Grooving 	BOT10F/G BOT10MF/G	3/4" 20mm
Boring Bar 25-4142 	BOT10ID-1 BOT10ID-1_1/4 BOT10MID-32	1" 1 1/4" 32mm
Cooling Block 	CB10 CB10M	Inch Metric
Turret Face Wedge Clamps	BOT10OD/CLAMP BOT10MOD /CLAMP	Inch Metric
Nozzles	20-0562 90^0 20-0689 Str long 20-2077 Plug 20-8730 Str 20-8739 45^0	

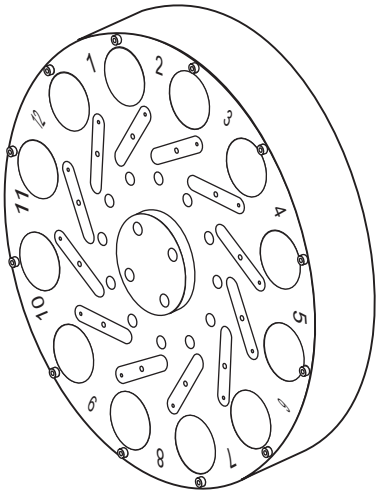
SL-10 Standard Tooling Includes:
1 BOT10 ID-1
1 BOT10 ID-1-1/4
1 BOT 10 F/G
3 BOT 10 OD/Clamp

Kit (Recommended)

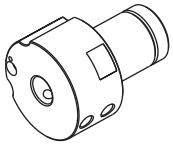
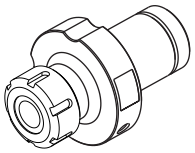
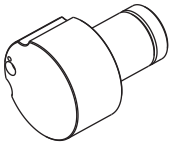
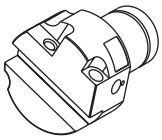
Standard
BOTKIT10
2ea. BOT10ID-1_1/4
2ea. BOT10ID-1
1ea. CB 10
9ea Turret Face Wedge/Clamps

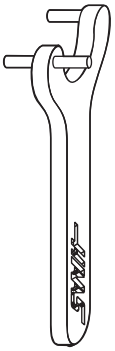
Metric
BOTKIT10M
4ea. BOT10MID-32
1ea CB10M
9ea. Turret face Wedge/Clamps

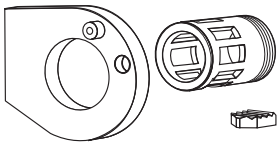
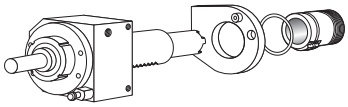
Haas Turret



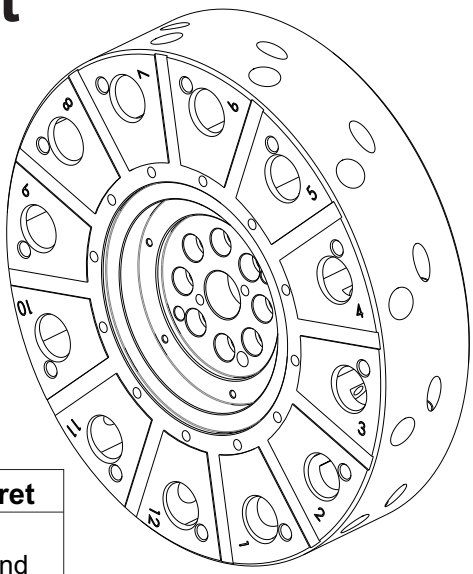
HAAS TURRET TOOLS PARTS LIST

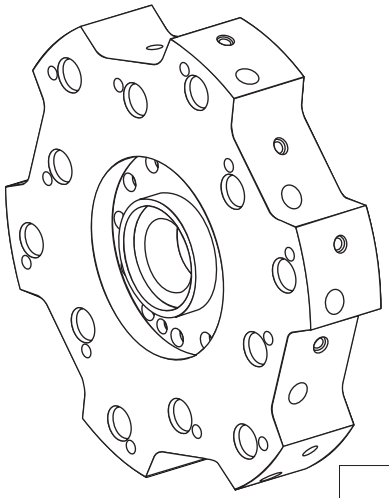
	Part No.	Size
	THID-1/2 THID-3/4 THID-1 THID-1_1/4 THID-1_1/2 THID-1_3/4 THID-2 THID-20MM THID-25MM THID-32MM THID-40MM	1/2" 3/4" 1" 1 1/4" 1 1/2" 1 3/4" 2" 20mm 25mm 32mm 40mm
	THER32	ER32
	THBLK Max bore:2" (40mm)	BLANK
	THOD-3/4 THOD-3/4 LH THOD-1 THOD-1LH THOD-1_1/4 THOD-1_1/4_LH THOD-1X THOD-25MM THOD-25MMLH	3/4" 3/4"LH 1" 1" 1 1/4" 1 1/4"LH 1" (Extended) 25mm 25mmLH

Tool Wrench	Part No.
	TW (30-9560)

Eccentric Adaptor	
	VDIEA
Used for fine adjustment of standard 40mm VDI tools in the Haas Turret.	
	VDIA
VDI Tools not included	

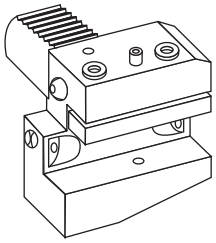
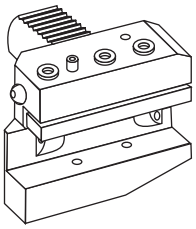
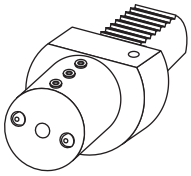
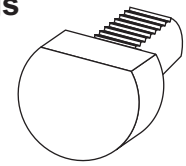
VDI Turret





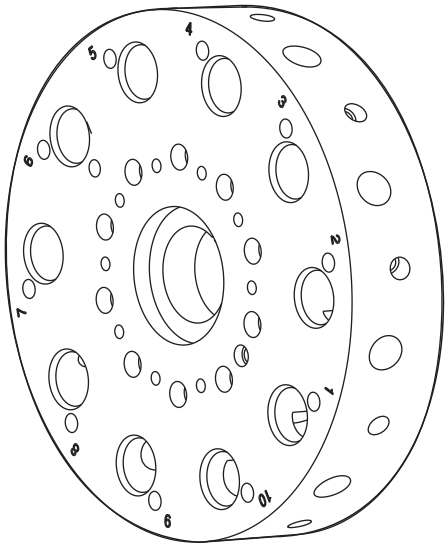
Haas VDI Turret
DIN 69880 VDI 40 Left Hand (Type B2, B4, B6, B8) SL-20/30/40, ST 20/30

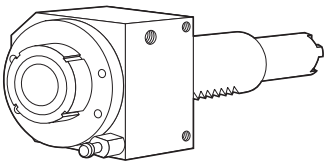
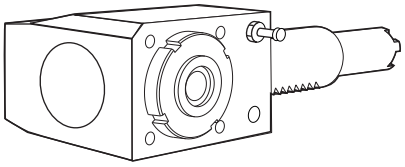
Haas VDI Turret
DIN 69880 VDI 30 Left Hand (SL-10) VDI 40 Left Hand (ST-10) (Type B2, B4, B6, B8)

VDI TURRET TOOLS PARTS LIST		
	Part No.	QTY.
1" Short Turn 	*VDITHKIT	2
1" Long Turn 		1
1 1/4" Boring 		3
Plugs 		2

* Not sold individually

Live Tooling



LIVE TOOLING OPTION PARTS LIST		
Axial Mill/Drill 	Part No.	Max Tool Size
	HLT-AHTH [1,2,5] HLT-AVTH [3] HLT-AHLT40BV [4]	ER-32 Collet 3/4" (20mm)
Radial Mill/Drill 	HLT-RHTH [1,2,5] HLT-RVTH [3] HLT-RHLT40BV [4]	3/4" 20mm ER-32

[1] Haas Turret SL-20/30

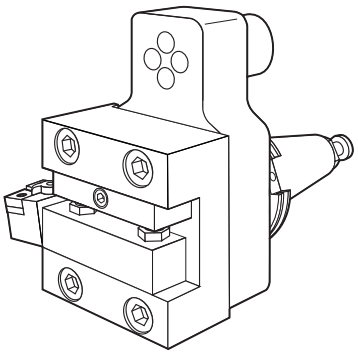
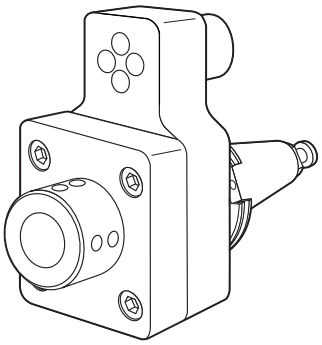
[2] VDI SL-40, TL-series ST 20/30 (SS/Y), DS-30 (SS/Y)

[3] VDI SL-20/30

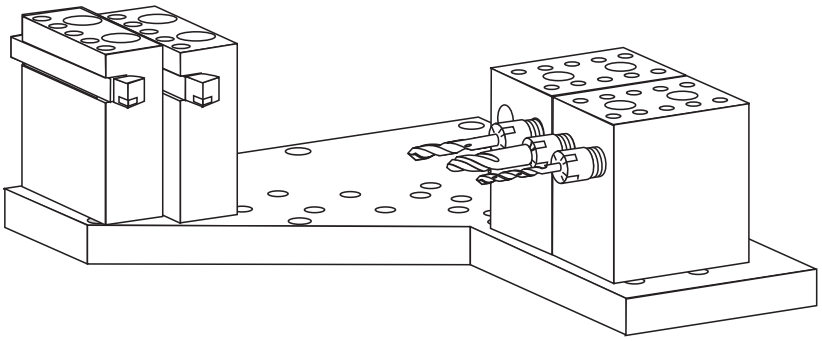
[4] Haas Turret / VB SL-40

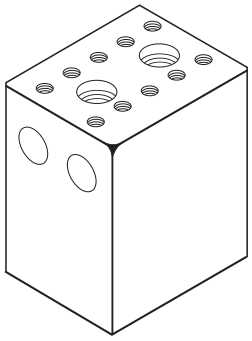
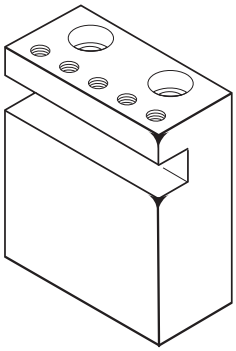
[5] VB/ VB24 ST-20/30 (SS/Y), DS-30 (SS/Y), SL-20/30, TL-15/25

VTC Tools

VTC TOOLS PARTS LIST		
Turning Facing Tool 	Part No.	Size
	THV125T	1.25"
Boring Tool 	THV175B	1.75”

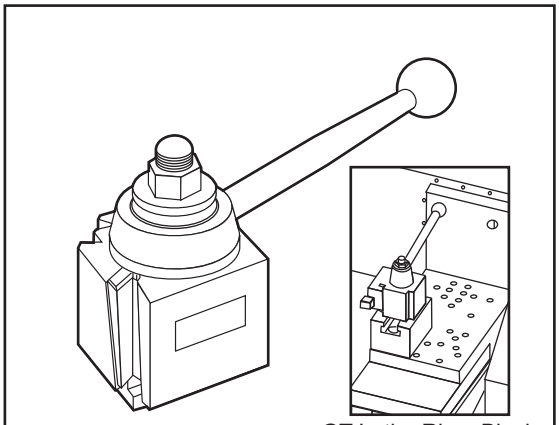
Mini Lathe Tool Holders



MINI LATHE TOOL HOLDERS		
Twin Tool Boring Holder 	**Part No.**	**Size**
	MLTID-3/4T MLTMID-20T	3/4”(2x) 20mm(2x)
O.D. Tool holder 	MLTOD-1/2 MLTMOD-12	1/2” 12mm

Toolroom and GT Lathe Tool Holders

Kit includes a quick-change tool post (mounting hardware included),
4 turn/face tool holders and 1 boring bar holder



GT Lathe Riser Block

Tool Post

TL-1 and TL-2

TP 3/4 (Includes: (4) 3/4" Turn/Face Holders
(1) 1" Boring Bar Holder

TP 3/4-GT (TP 3/4 + Riser for GT Lathes)

TP20 (Includes: (4) 20mm Turn/Face Holders
(1) 25mm Boring Bar Holder

TP20-GT (TP20 + Riser for GT Lathes)

TL-3 and TL-3W

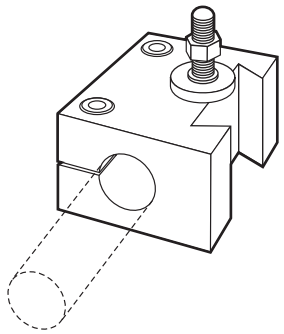
TP1 (Includes: (4) 1" Turn/Face Holders
(1) 1-1/4" Boring Bar Holder

TP25 (Includes: (4) 25mm Turn/Face Holders
(1) 32 Boring Bar Holder

TL-3B

TP1-1/2 (Includes: (4) 1-1/2" Turn/Face Holders
(1) 2" Boring Bar Holder

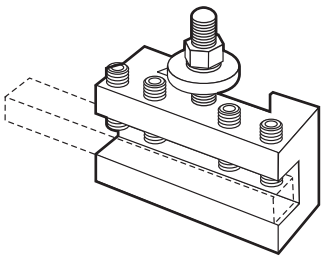
TP40 (Includes: (4) 40mm Turn/Face Holders
(1) 50mm Boring Bar Holder



Boring Bar Tool Holder

Available Sizes:

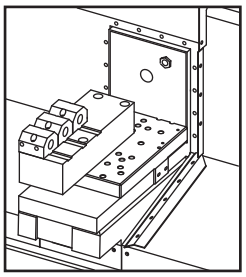
1" (Fits TP3/4)
1 1/4" (Fits TP1)
2" (Fits TP1-1/2)
25mm (Fits TP25)
32mm (Fits TP25)
50mm (Fits TP40)

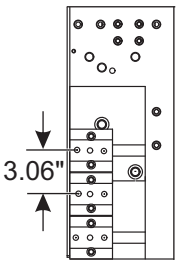


Turn/Face Tool Holder

Available Sizes:

3/4" (Fits TP3/4)
1" (Fits TP1)
1-1/2" (Fits TP1-1/2)
20mm (Fits TP20)
25mm (Fits TP25)
40mm (Fits TP40)





Gang Tooling
Top View

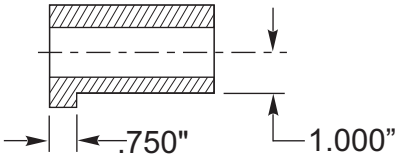
Gang Tooling (GT-20 Only)

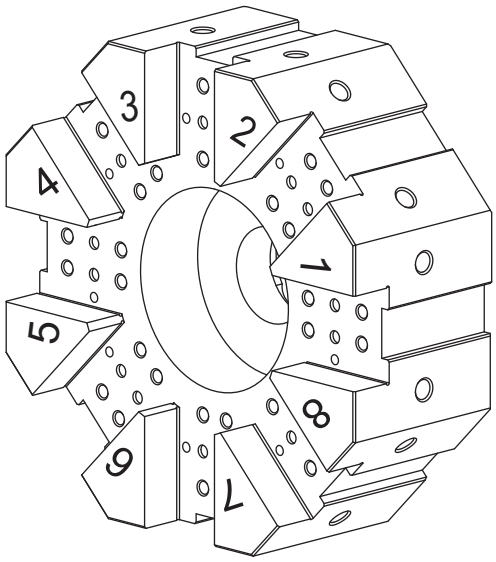
Available Sizes:

GTK1
1" (BOT5ID-1)
GTK25
25mm (BOT5MID-25)

TT20
8 Station Turret

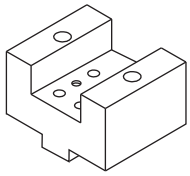
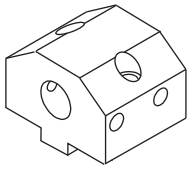
Basic BOT ID Tool Specifications





TT20 fits GT-10, GT-20
TT20-3 fits TL-3, TL-3CE, TL-3HE*
*TT20-3 does not fit TL-3W

BOLT ON TOOLS PARTS LIST

	Part No.	Size
Face Grooving 	BOT5F/G BOT5MF/G	3/4" 20mm
Boring Bar 	BOT5ID-1 BOT5MID-25	1" 25mm
Turret Face Wedge Clamps	BOT10OD/CLAMP BOT10MOD /CLAMP	Inch Metric

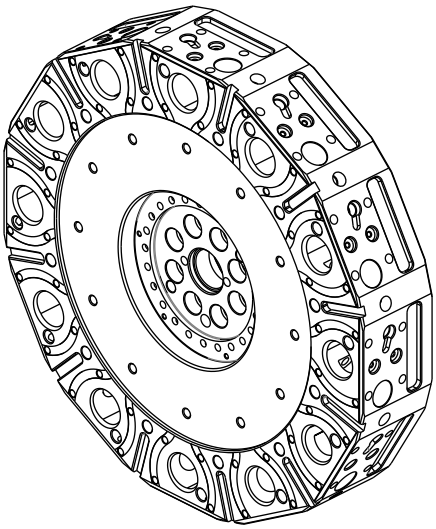
TT20 Standard Tooling Includes:
3 BOT5ID-1
5 BOT 10 OD/Clamp

Kit (Recommended)

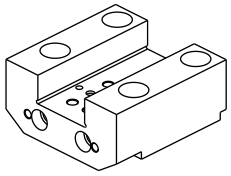
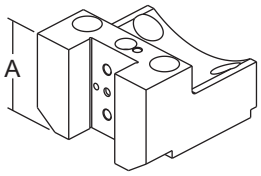
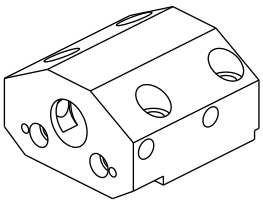
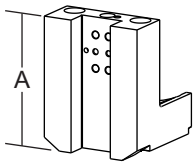
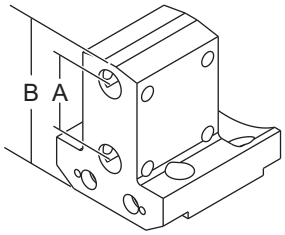
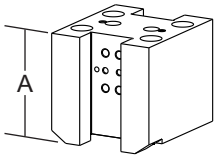
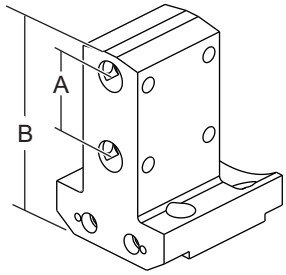
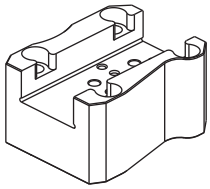
Standard
BOTKIT5
3ea. BOT5ID-1
1ea. BOT5F/G
3ea. Turret Face Wedge/Clamps

Metric
BOTKIT5M
3ea. BOT5MID-25
1ea. BOTFMF/G
3ea. Turret face Wedge/Clamps

VB24



BOLT-ON TOOLS PARTS LIST

	Part No.	Size		Part No.	Size
Face Grooving 	BOT24FG-3/4 BOT24MFG-3/4	3/4" 20 mm	**Parting Tool** 	BOT24OD-3/4 BOT24MOD-20 Height(A): 2.3" (58.4 mm)	3/4” 20 mm
Boring Bar 	BOT24ID-1 BOT24MID-25 BOT24ID-1_1/4 BOT24MID-32	1" 25 mm 1-1/4" 32 mm	**Extended Parting Tool** 	BOT24EXTOD-3/4 BOT24EXTMOD-20 Height (A): 4.55" (115.6 mm)	3/4” 20 mm
Twin Bore 	BOT24ID-3/4T BOT24MID-20T Dim. A: 2.15" btw. centers 54.6 mm Dim. B: 4.2" 106.7 mm	3/4” 20mm	**Extended Twin Turn** 	BOT24EXTOD-3/4T BOT24EXTMOD-20T Height (A): 3.525" (89.5 mm)	3/4" 20 mm
Extended Twin Bore 	BOT24EXTID-3/4T BOT24EXTMID-20T Dim. A: 2.15" btw. centers 54.6 mm Dim. B: 5.325" 135.3 mm	3/4” 20mm	**Facing** 	BOT24ODF-3/4 BOT24MODF-20	3/4" 20 mm
			Tool Kits	BOTKIT24 BOTKIT24M	Inch Metric