

BIG KAISER

NEWS

2018/19

EN

BIG KAISER – the key to higher performance

Since 1948 BIG KAISER manufactures high performance tooling solutions for the metal cutting industry. The products are developed to meet the highest standards and are fully produced in Switzerland and Japan. As part of the family owned BIG DAISHOWA Group with more than 800 employees, BIG KAISER has corporate headquarters in Switzerland, Germany and the United States.



INNOVATION

Investment of 10% of sales in development and infrastructure

PRODUCTIVITY

500 000 produced collets per year and 320t processed steel per year

GLOBAL

BIG KAISER has more than 200 sales reps and partners

KNOW-HOW

Founded in 1948

QUALITY AND PRECISION

Accuracy of $\varnothing$ 1 μ m

FLEXIBILITY

Batch size 1 – 10 000 as 20 000 standard products and 1 200 special tools

PERFORMANCE

Production area size of 135 000m²

SERVICE

Stock levels at 95%

Content

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Single wrench enables the easy cutting tool exchange on the turret. High precision cutting by the Hydraulic Chuck is achieved on the Automatic Lathe!



Model			Order No.	Ød	ØDS	L	A	B1	B2	W	H max.	E	Weight (kg)	
SL19.05	-HDC4	-60		806.991	4	19.05	60	15	23	15.8	22	65	19	0.17
	-HDC6	-60		806.992	6				25				0.16	
	-HDC8	-60		806.993	8				31				0.15	
SL22	-HDC4	-70		806.994	4	22	70	15	23	15.8	25	75	19	0.24
	-HDC6	-70		806.995	6								25	0.24
	-HDC8	-70		806.996	8								31	0.22

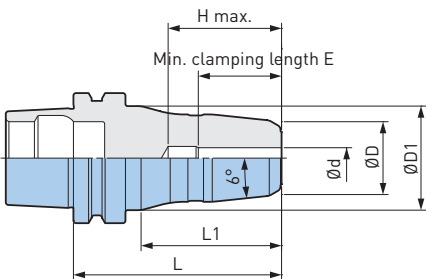
Caution:

- Use only cutting tools that have a shank tolerance within h6.
- Roughing endmills are not recommended for use with hydraulic chucks.
- Do not use with cutting tools made with a flat on the shank. [ie: Weldon Type shank]
- Do not tighten the clamping screw without first inserting a cutting tool into the hydraulic chuck.
- Always insert the cutting tool into the hydraulic chuck beyond min. clamping length E.

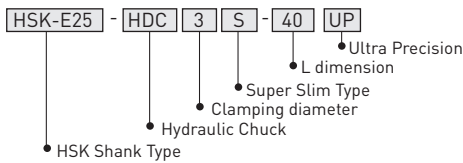


Hydraulic Chuck Ultra Precision Type

Amazing runout accuracy within 1µm at 4D.



Model Description



Ø 3 - 6 mm

Model	Order No.	Clamping Diameter Ød	ØD	ØD1	L	L1	Min. Clamping Length E	H max.	max. min ⁻¹	Weight (kg)
HSK-E25-HDC3S -40UP NEW	806.907	3	14	20	40	27	16	22	60 000	0.09
-HDC4S -40UP NEW	806.908	4						21		
HSK-E32-HDC3S -52UP NEW	806.909	3	14	26	52	29	16	28	45 000	0.19
-HDC4S -52UP NEW	806.910	4			57	34	19			0.20
-HDC6S -57UP NEW	806.911	6					25	33		

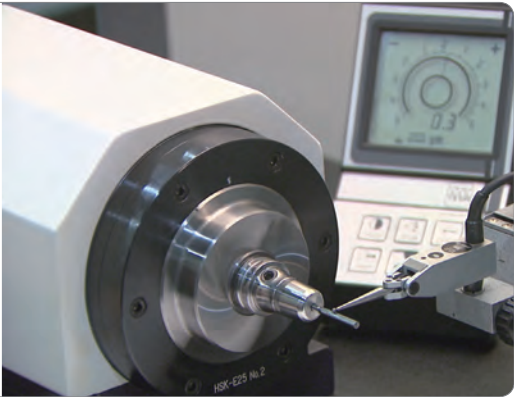
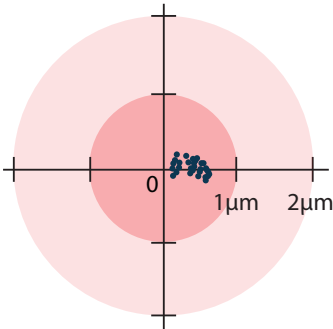
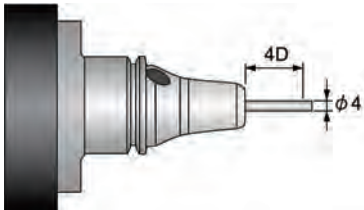
1. Adjusting screw cannot be used.

Caution:

- Use only cutting tools that have a shank tolerance within h6.
- Roughing endmills are not recommended for use with hydraulic chucks.
- Do not use with cutting tools made with a flat on the shank. (ie: Weldon Type shank)
- Do not tighten the clamping screw without first inserting a cutting tool into the hydraulic chuck.
- Always insert the cutting tool into the hydraulic chuck beyond min. clamping length E.

Repeatable runout accuracy

Model: HSK-E32-HDC4S-52UP
Measurement frequency: 30 times
Measurement point: 4D (16mm) tip



Update Hydraulic Chuck with Switchable Coolant Supply

Hydraulic Chuck Jet Through models for Ø 4-12, HDC4J-12J, are updated from "only peripheral coolant supply" to "selectable center or peripheral coolant supply".



IMPROVED

Peripheric

Center Through

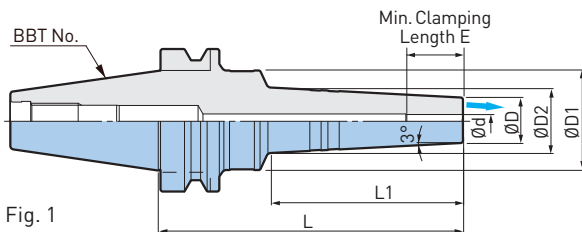
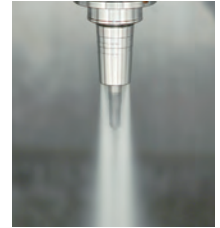
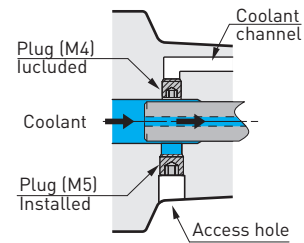
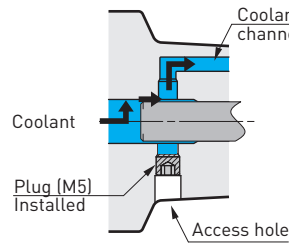


Fig. 1

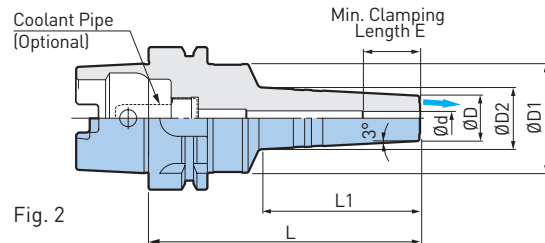


Fig. 2

BIG-PLUS tools can be used in machining centers with conventional BT spindles.

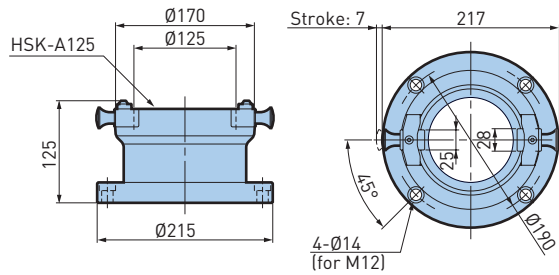
Ø 4 - 12 mm

Model	Order No.	Fig.	Ød	ØD	ØD1	ØD2	L	L1	E	Weight (kg)
BBT30 -HDC4J - 60	805.077	1	4	20	46	23	60	28	19	0.54
-HDC6J - 90	805.078		6		42	26			25	0.69
-HDC8J - 90	805.079		8	22		28	90	50	31	0.71
-HDC10J - 90	805.080		10	24	44	30			33	0.74
-HDC12J - 90	805.081		12	26	46	32			36	0.76
BBT40 -HDC4J - 90	805.082	1	4	20	38	25	90	45	19	1.3
-135	805.549				44	30	135	85		1.5
-HDC6J - 90	805.083		6		38	25	90	45	25	1.3
-135	805.084				44	29	135	85		1.5
-HDC8J - 90	805.085		8	22	40	27	90	45	31	1.3
-135	805.086				46	31	135	85		1.6
-HDC10J - 90	805.087		10	24	42	29	90	45	33	1.3
-135	805.088				48	33	135	85		1.6
-HDC12J - 90	805.089		12	26	44	31	90	45	36	1.3
-135	805.090				50	35	135	85		1.7
BBT50 -HDC6J -120	805.091	1	6	20	48	26			25	4.1
-HDC8J -120	805.092		8	22	50	28	120	55	31	4.1
-HDC10J -120	805.093		10	24	52	30			33	4.2
-HDC12J -120	805.094		12	26	54	32			36	4.2
HSK-A63 -HDC4J - 75	805.477	2	4	20		23	75	29	19	1.0
-HDC6J -120	805.096		6			28			25	1.2
-HDC8J -120	805.097		8	22	48	30	120	70	31	1.2
-HDC10J -120	805.098		10	24		32			33	1.3
-HDC12J -120	805.099		12	26		34			36	1.3

1. Adjusting screw cannot be used.
2. Larger diameter models, HDC16J, 20J are available with only peripheral coolant supply.

HSK-A125 Series

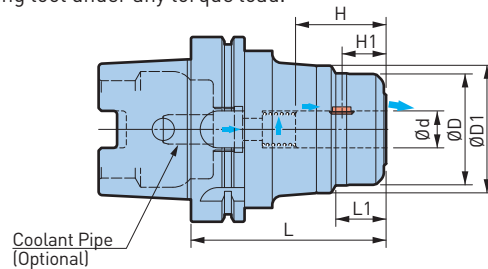
Tooling Fixture



Model	Order No.	Weight (kg)
TMS-HSK-A125 NEW	806.795	10.5

MEGA Perfect Grip

100% security against pulling out of the cutting tool under any torque load.



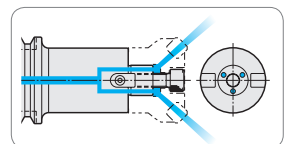
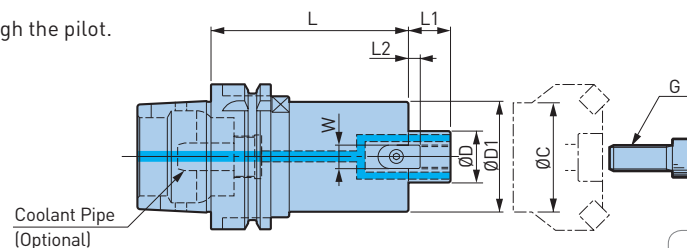
Ø 16 - 32 mm

Model	Order No.	Ød	ØD	ØD1	L	L1	H	H1	MEGA Wrench	Weight (kg)
HSK-A125-MEGA20DPG-135	806.627	20	60	69	135	27	49	24	MGR60L	6.8
-MEGA25DPG-135	806.628	25	70	77		33	55	23	MGR70L	7.2
-MEGA32DPG-135	806.629	32	80	86		41	59		MGR80L	7.9

1. Key grip and spring are included with each holder.
2. MEGA wrench is to be ordered separately.

Face Mill Arbors Type FMH

For cutters that require a coolant hole through the pilot.



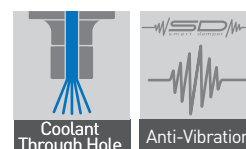
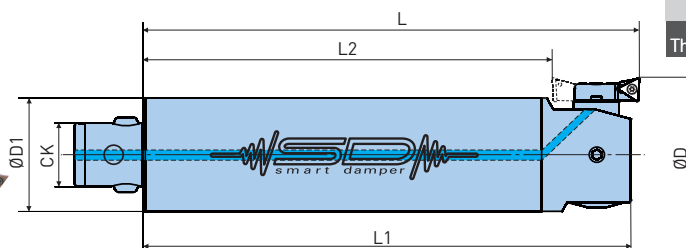
Model	Order No.	ØD (h6)	ØD1	L	L1	Drive Keys		G	ØC min.	Weight (kg)
						L2	W			
HSK-A125 -FMH22A - 49 - 50	806.585	22	49	50	18	5	10	M10	40	4.0
-100	806.586			100						4.8
-150	806.587			150						5.4
-200	806.588			200						6.7
-FMH27A - 60 - 90	806.589			90						5.1
-150	806.590	27	60	150	20	6	12	M12	46	6.3
-FMH32A - 78 - 60	806.591	32	76	60	22	7	14	M16	58	4.8
- 96 - 105	806.592		98	105						7.8
-FMH40A - 80 - 90	806.593	40	80	90	28	8.5	16	M20	70	6.0

1. Hexagon Socket Head Cap Screw is included.
2. By utilizing a clamping bolt with a hole through, coolant is supplied through the bolt.
3. Coolant pipe is to be ordered separately.

For more HSK-A125 models ► BK main catalogue Vol.2 P.133 - 150

Anti vibration boring “Smart Damper” Series

EWN Smart Damper Fine Boring Head, Ø 32 - 150

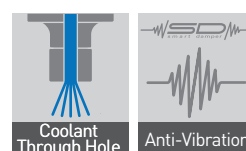
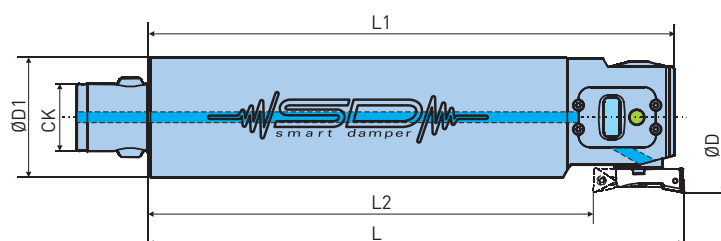


Model	Order No.	CK	Front Bore ØD	Back Bore ØD	L	L1	L2	D1	Weight (kg)
CKB3-EWN32DP-160 NEW	807.016	CKB3	32 - 60	57 - 60 **	160	155	130	31	1.2
CKB4-EWN41DP-185	806.742	CKB4	41 - 74	61 - 74 *	185	181	152	39	2.4
CKB5-EWN53DP-210	806.743	CKB5	53 - 95	74 - 95 *	210	206	172	50	4.5
CKB6-EWN68DP-240	806.744	CKB6	68 - 150	90 - 150	240	236.2	191	64	8.3

1. Insert holder (Type 1) included. Other sizes are available.
2. * Attention: Use insert holders Type 2 or 3 for back boring.
3. ** Attention: Use insert holders Type 3 for back boring.

EWD Smart Damper Digital Fine Boring Heads, Ø 41 - 150

With the new EWD Smart Damper BIG KAISER combines its most advanced technologies to a powerful and highly productive tool: a digital fine boring head with an innovative and patented damping technology.

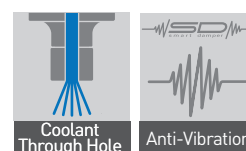
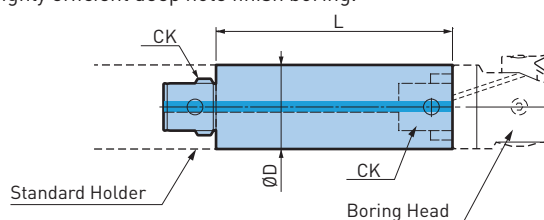


Model	Order No.	CK	Front Bore ØD	Back Bore ØD	L	L1	L2	D1	Weight (kg)
EWD41-74CKB4-200DP	389.395	CKB4	41 - 74	53 - 74	200	196	167	39	2.4
EWD53-95CKB5-225DP	389.396	CKB5	53 - 95	62 - 95	225	221	187	50	4.5
EWD68-150CKB6-260DP	389.397	CKB6	68 - 150	80 - 150	260	241	211	64	9.5

1. Insert holder is to be ordered separately.

Smart Damper Extensions

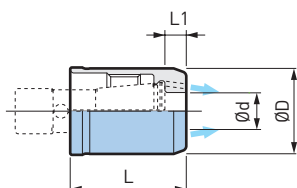
Extension with integrated damping system for highly efficient deep hole finish boring.



Model	Order No.	CK	ØD	L	Weight (kg)
CKB44DP - 120	389.365	CKB4	39	120	1.3
CKB55DP - 150	389.366	CKB5	50	150	2.6
CKB66DP - 180	389.367	CKB6	64	180	5.3

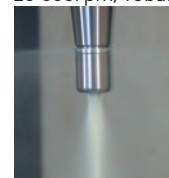
New MEGA Micro Coolant Nut

New MEGA Micro Coolant Nut, only for MEGA Micro Chuck 6S for more efficient coolant supply for micro cutting tool.
Ideal design for high speed micro machining up to $\varnothing 6$.



MGN6S-4J

20'000rpm/15bar



MGN6S-6J

20'000rpm/15bar



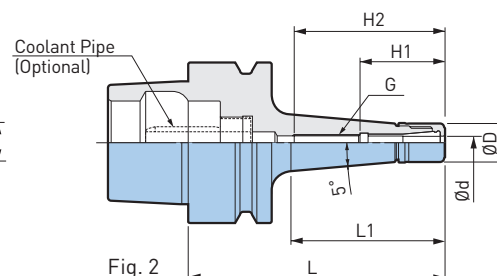
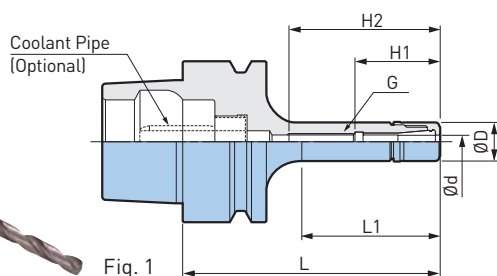
Up to 35% higher tool lifetime according to standard nut.

MEGA6S

Model	Order No.	Cutting Tool shank dia. Ød	ØD	L	L1
MGN6S-2J NEW	806.862	2	14	19	3.5
MGN6S-3J NEW	806.863	3			
MGN6S-4J NEW	806.864	4			
MGN6S-5J NEW	806.865	5		17	1.5
MGN6S-6J NEW	806.866	6			

MEGA Micro Chuck

Micro diameter design is ideal for high speed applications in tight areas.



Ø 0.45 - 6.05 mm

Model	Order No.	Fig.	Ød	ØD	L	L1	H1	H2	G	max. min ⁻¹	Collet Model	Weight (kg)				
HSK-E25 -MEGA6S - 45 *	968.868	1	0.45 - 6.05	14	45	32	28	31	-	50 000	NBC6S-	0.07				
- 45T *	968.874	2				33	28.5					41	M7 P0.75	40 000	0.08	
- 60	968.869	1			60	47		40	0.10							
- 60T	968.875	2				49										
HSK-E32 -MEGA6S - 45 *	968.878	1	0.45 - 6.05	14	45	22	28	-	-	50 000	NBC6S-	0.14				
- 45T *	968.882	2				23						28.5	38	M7 P0.75	40 000	0.15
- 60	968.879	1			60	35	38	M7 P0.75	40 000	0.17						
- 60T	968.883	2				36										
HSK-E40 -MEGA6S - 45 *	968.716	1	0.45 - 6.05	14	45	23	27.5	27	-	50 000	NBC6S-	0.22				
- 60 *	968.757				60	35	28.5	42		40 000		0.23				
- 60T *	968.892	2			75	50		49	M7 P0.75	40 000		0.24				
- 75T	968.893				90	65						0.28				
- 90T	968.894				80	44	28.5	49		40 000		0.32				
HSK-E50 -MEGA6S - 55 *	978.100	1			0.45 - 6.05	14	55	26	28.5	35	-	45 000	NBC6S-	0.44		
- 80	968.760	2					80	44		49	M7 P0.75	40 000		0.46		
- 80T	968.907							49								

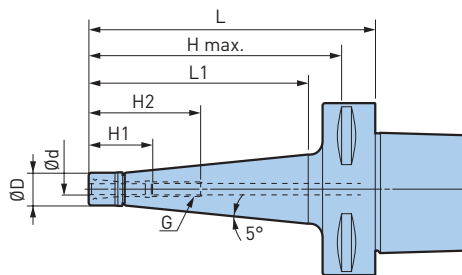
- MEGA nut is included.
- * Internal thread (G) is not available.
- Coolant pipe is to be ordered separately.

For more MEGA Micro Chuck HSK-A models ► BK main catalogue Vol.2 P.128 / 129

New BIG CAPTO C4 Series

MEGA Micro Chuck Type T

Taper-off design minimizes interference and maximizes rigidity.



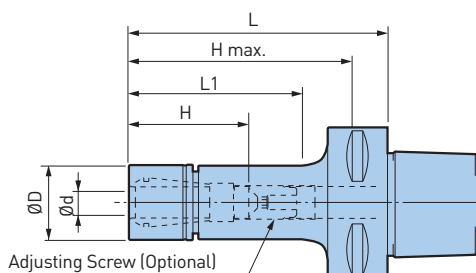
Ø 0.45 - 6.05 mm

Model	Order No.	Ød	ØD	L	L1	H1	H2	H max.	G	Collet Model	Weight (kg)
C4 -MEGA3S - 60T	973.954	0.45 - 3.25	10	60	35	22	38	54	M4 P0.7	NBC3S-	0.3
-MEGA6S - 60T	973.955	0.45 - 6.05	14			28	47	54	M7 P0.75	NBC6S-	0.3
- 90T	805.194			90	65	49	84	0.4			

1. MEGA nut is included.

MEGA New Baby Chuck

Ideal ultra precision collet holders for high speed machining. Wide range of lengths and a variety of collet series covers all machining applications.



Ø 0.25 - 20 mm

Model	Order No.	Ød	ØD	L	L1	H	H max.	Collet Model	Weight (kg)
C4 -MEGA6N - 75	978.196	0.25 - 6	20	75	48	23 - 43	69	NBC6-	0.4
-MEGA8N - 75	978.201	0.5 - 8	25		49	26 - 45	69	NBC8-	0.5
-MEGA10N- 75	978.202	1.5 - 10	30		52	38 - 48	69	NBC10-	0.6
-MEGA13N- 75	978.197	2.5 - 13	35		54	64	64	NBC13-	0.7
-MEGA16N- 55 *	978.203	2.5 - 16	42	55	-	48	48	NBC16-	0.7
-MEGA20N- 60 *	978.204	2.5 - 20	46	60	-	53	53	NBC20-	0.8

1. MEGA nut is included.

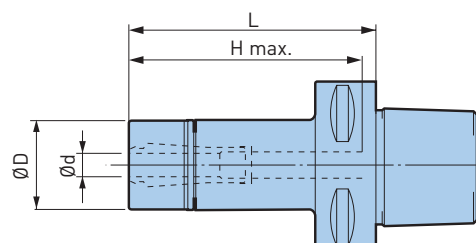
2. "H" indicates the adjustment length with an adjusting screw.

3. * Adjusting screw cannot be used.

4. Nut-less model available up on request.

MEGA E Chuck

Collet chuck designed exclusively for endmilling with high concentricity and rigidity.



Ø 3 - 12 mm

Model	Order No.	Ød	ØD	L	H max.	Collet Model	Weight (kg)
C4 -MEGA13E- 60*	800.678	3 - 12	42	60	50	MEC13-	0.6

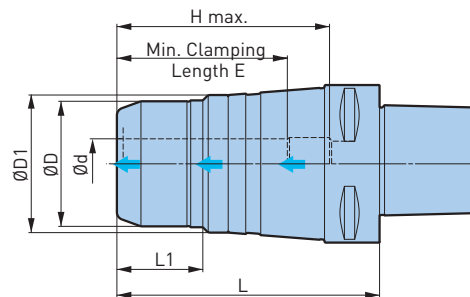
1. MEGA nut is included.

2. * Adjusting screw cannot be used.

3. Nut-less model available up on request.

MEGA Double Power Chuck Type D

Close to integral rigidity and precision of a solid tool holder. Flange contacting nut assures highest rigidity.

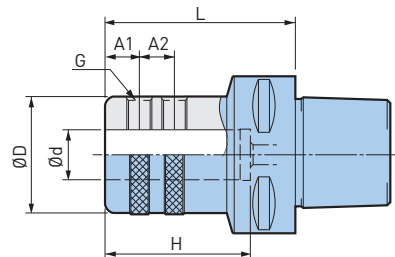


Ø 16 - 20 mm

Model	Order No.	Ød	ØD	ØD1	L	L1	H max.	E	Weight (kg)
C4 -MEGA16D - 70	800.679	16	46	46.7	70	-	64	50	0.8
-MEGA20D - 65*	800.681	20	50	50.7	65	-	59	51	0.8

- * Only the straight collet (C20, OCA20-) can be used.
- Wrench is to be ordered separately.
- "H" is max. tool shank length that can be inserted into the holder.

Side Lock Holders for Drills



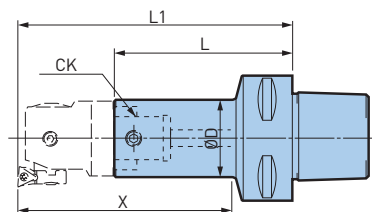
Ø 16 - 25 mm

Model	Order No.	Ød	ØD	L	A1	A2	H	G	Weight (kg)
C4 -TSL16 -56	800.687	16	48	56	14	14	48	M10 P1.25	0.8
-TSL20 -60	800.688	20		60			50		0.7
-TSL25 -77	800.689	25		77	15	20	56	M16 P1.5	0.8

- "H" is the max. tool shank length that can be inserted into the holder.
- Not compatible with Weldon DIN 1835B.

CKB/CKN Shanks with Center Through Coolant

Basic Holder for rough and finish boring heads of the proven BIG KAISER Boring System.

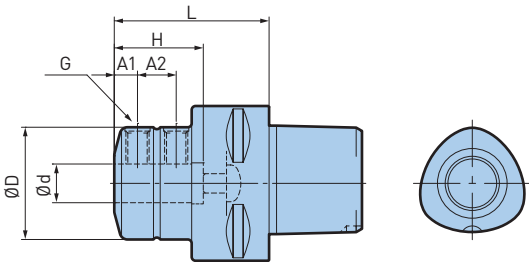


Taper Size	Order No.	CK	ØD	L	L1	X	Weight (Kg)
C4 -CKB1 - 48	806.698	CKB1	19	48	80	55	0.4
-CKB2 - 45	806.699	CKB2	24	45			0.4
-CKB3 - 40	806.700	CKB3	31	40			0.5
-CKB4 - 33	806.701	CKB4	39	33			0.5

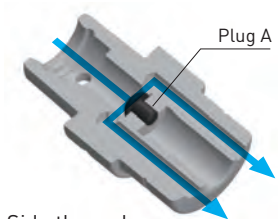
- L1 and X dimensions in the table are the reference values when EWN/EWE head is attached.

New BIG CAPTO C4 Series

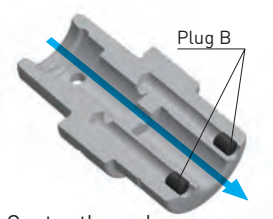
Side Lock Holder for Boring Bar



Model	Order No.	Ød	ØD	L	A1	A2	H	G	Weight (kg)
C4 -BSL 6 - 40 	806.960	6	23	40	5	9	23	M 5P0.8	0.3
-BSL 8 - 40 	806.961	8	25		6	10		M 6P1.0	0.3
-BSL10 - 40 	806.962	10	29					0.3	
-BSL12 - 45 	806.963	12	34	45	8	12	28	M 8P1.0	0.4
-BSL16 - 50 	806.964	16	40	50	10	14	33	M10P1.25	0.5
-BSL20 - 60 	806.965	20	50	60	12	15	43		0.7



Side through



Center through

Body Model	Plug A	Plug B
BSL 6	M5 P0.8	M4 P0.7
8		M5 P0.8
10		
12		M6 P1.0
16		
20		

- Plugs AB are included with the body.
- Plug A is a button head bolt.

Integral Turning Tool / 90° TYPE F



Right hand

Left hand

Right hand

Left hand

Right hand

Left hand

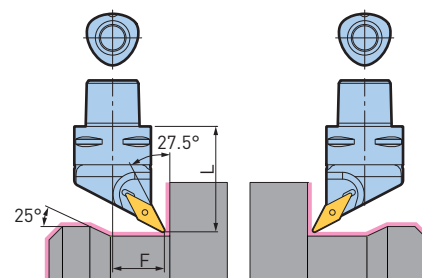
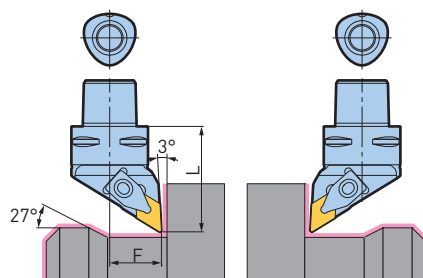
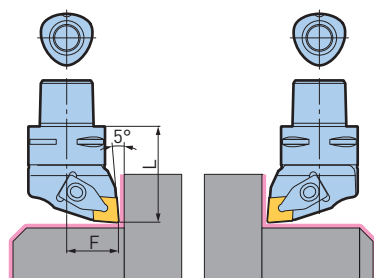


Fig. 1

Fig. 2

Fig. 3

Hand	Model	Order No.	Fig.	L	F	Insert	Clamp Piece	Weight (kg)
R	C4-DCLNR-27050-12 NEW	806.950	1	50	27	CN1204 Rhombic 80°	CP2	0.45
L	-DCLNL-27050-12 NEW	806.951						
R	-DDJNR-27055-15 NEW	806.952	2	55	27	DN1504 * (DN1506) Rhombic 55°	CP2	0.42
L	-DDJNL-27055-15 NEW	806.953						
R	-SVQBR-27055-16 NEW	806.954	3	55	27	VB1604 * VC1604 ** Rhombic 35°	M3.5	0.40
L	-SVQBL-27055-16 NEW	806.955						

1. Wrench is to be ordered separately. Inserts are not included.

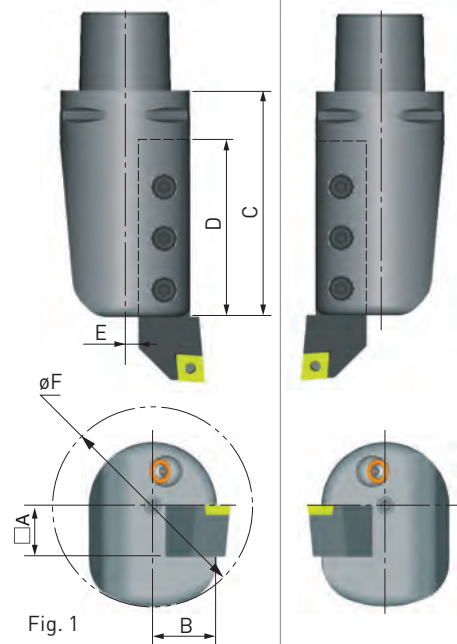
2. * Carbide shim for 4.76 mm thick DIN1504 insert is included as standard. In case of DN1506 insert (thickness of 6.35 mm), please replace the standard carbide shim with DNS1506 (option).

3. ** VB1604 and VC1604 inserts are suitable.

Square Tool Holders

Right hand

Left hand



Hand	Model	Order No.	Fig.	□A	B	B1	B2	C	D	E	ØF	Weight (kg)
R	C4-180 -BH20R-2265 NEW	806.958	1	20	22	-	-	65	40	2	70	0.84
L	-BH20L-2265 NEW	806.959										
R	C4-90 -BH20R-2854 NEW	806.956	2	20	-	28	32	54	34	-	80	0.96
L	-BH20L-2854 NEW	806.957										

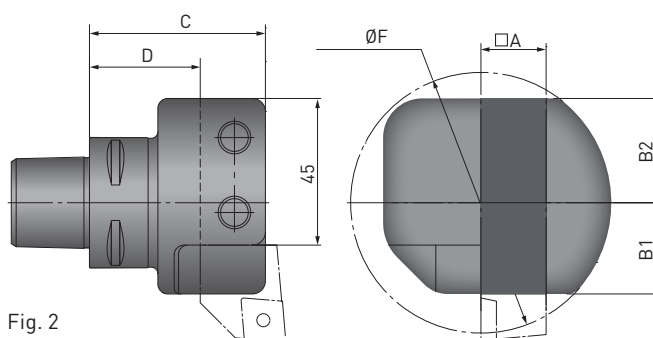


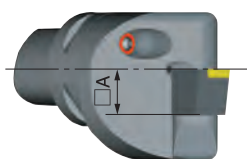
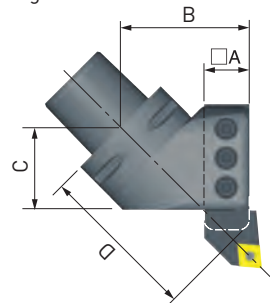
Fig. 2
Right hand

BIG CAPTO Square Tool Holders

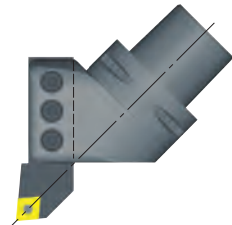


45 Type

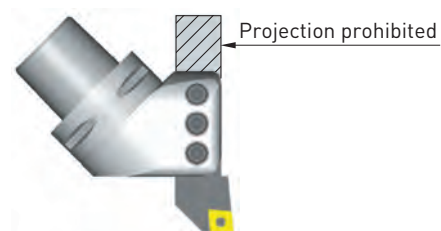
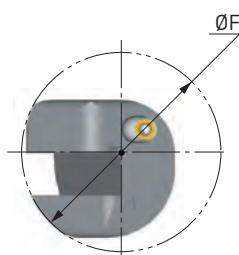
Right hand



Left hand



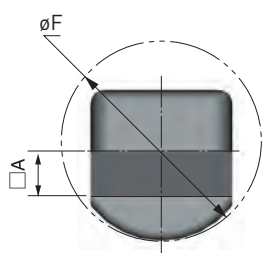
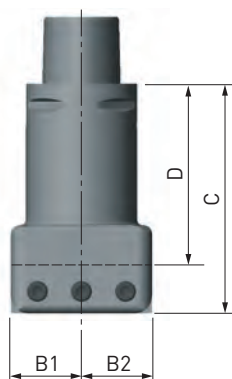
Hand	Model	Order No.	□A	B	C	D	ØF	Weight (kg)
R	C5-45-BH20R-5838	973.026	20	58	38	73	94	1.2
L	-BH20L-5838	973.027						1.2
R	C6-45-BH25R-7752	973.028	25	77	52	100	118	2.5
L	-BH25L-7752	800.776						2.5
R	C8-45-BH32R-85109	973.030	32	85	109	145	135	7.3
L	-BH32L-85109	973.031						7.3



Caution

The excess length of a turning tool must be cut off to avoid interference with an ATC arm.

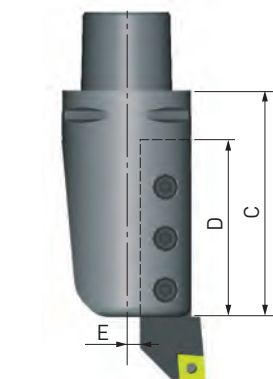
90 Type



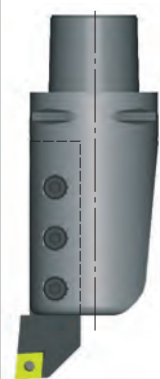
Hand	Model	Order No.	□A	B1	B2	C	D	ØF	Weight (kg)
N	C5-90-BH20N-32058	978.476	20	32	32	58	38	80	0.9
	-32105	801.653				105	85		2.2
N	C6-90-BH20N-32060	800.777	20	32	32	60	40	80	2.4
	-32115	800.778				115	95		3.4
	-BH25N-40071	800.779	25	40	40	71	46	100	3.3
	-40130	801.664				130	105		4.2
N	C8-90-BH25N-40071	328.380 NEW	25	40	40	71	45	100	3.3
N	C8-90-BH32N-51085	800.889	32	51	51	85	53	128	6.0
	-51165	801.665				165	133		8.7



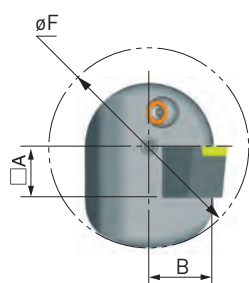
Right hand



Left hand



Hand	Model	Order No.	□A	B	C	D	E	ØF	Weight (kg)
R	C5-180 -BH20R -2590	973.032	20	25	90	65	5	80	1.6
L	-BH20L -2590	973.033							
R	C6-180 -BH20R -32100	973.753	20	31.5	100	65	11.5	80	2.6
L	-BH20L -32100	801.663							
R	-BH25R -32120S	973.034	25	29.5	120	80	4.5	90	3.1
L	-BH25L -32120S	973.035							
R	C8-180 -BH25R -32120 NEW	328.378	25	38	120	82	13	100	5.1
L	-BH25L -32120 NEW	328.379	25	38	120	82	13	100	5.1
R	C8-180 -BH32R -40125	973.038	32	40	125	85	8	128	6.0
L	-BH32L -40125	973.039							



New BIG CAPT0 C8 Side Lock Holders for Weldon

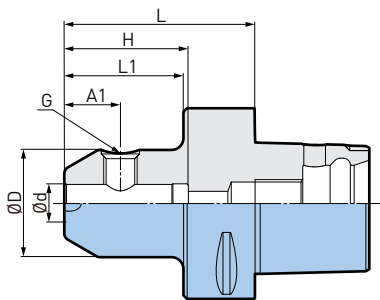


Fig. 1 (with jet through coolant / resealable)

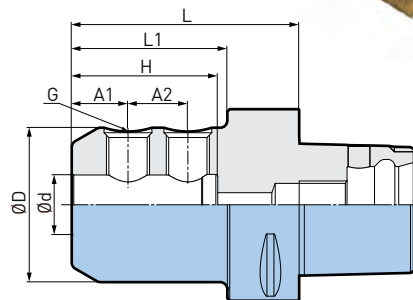


Fig. 2 (without jet through coolant)

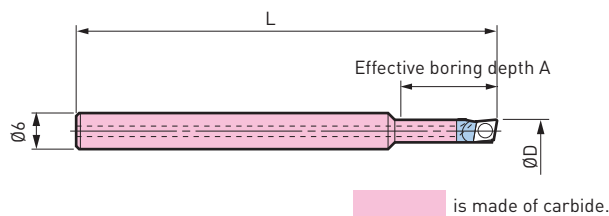
Ø 6 - 40 mm

Model	Order No.	Fig.	Ød	ØD	L	L1	A1	A2	H	G	Weight (kg)
C8 -ISL6 - 80 NEW	328.370	1	6	24	80	50	17.5	-	40	M6	1.9
C8 -ISL8 - 80 NEW	328.371		8	26			17.5		40	M8	
C8 -ISL10 - 80 NEW	328.372		10	32			19.5		44	M10	2.0
C8 -ISL12 - 80 NEW	328.373		12	38			22		49	M12	2.1
C8 -ISL14 - 80 NEW	328.374		14	40			23.5		52	M14	2.2
C8 -ISL16 - 80 NEW	328.375		16	45			23.5		54	M16	2.4
C8 -ISL18 - 80 NEW	328.376		18	47			24.5		54	M16	2.4
C8 -ISL20 - 85 NEW	328.419	2	20	52	85	55	24.5	25	54	M16	2.4
C8 -ISL25 - 95 NEW	328.420		25	64.4	95	65	23.5		61	M18xP2	3.1
C8 -ISL32 - 95 NEW	328.421		32	71.5			23.5		65	M20xP2	3.3
C8 -ISL40 - 105 NEW	328.422		40	80	105	-	29.5		75	M20xP2	3.9

1. "H" is the max. tool shank length that can be inserted into the holder.
2. Use a cutting tool in accordance to DIN 1835 B/DIN 6535 HB.

Carbide Cylindrical Insert Holder

Indexable insert offered in the minimal diameter. Stable cutting achieved by the integral carbide insert holder.



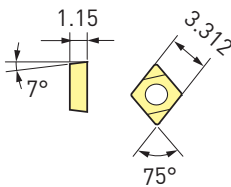
Ø 4 - 6 mm

Model	Order No.	ØD	A	L	Insert
ST06W -EB4 -16 NEW	807.019	4.0 - 5.0	16	70	EC03
-EB5 -20 NEW	807.020	5.0 - 6.0	20	75	

- 1. Inserts must be ordered separately.
- 2. An exclusive straight collet is required when used with a boring head.

Insert

ECGM03

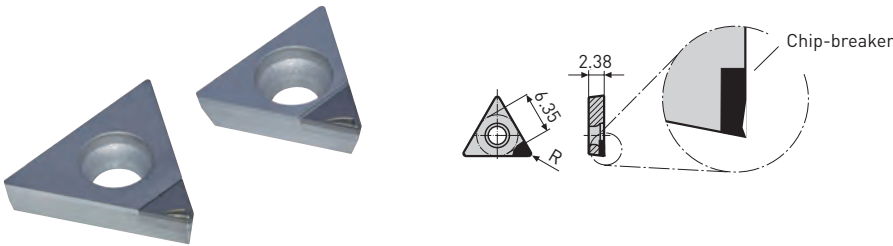


Model	Order No.	Radius	Workpiece	Grade	Material
ECGM03X102ELA NEW	807.017	0.2	Carbon Steel, Alloy Steel	T1500A	Cermet
ECGM03X102ELA NEW	807.018		Aluminium	H1	Carbide (K10)

- 1. Inserts are available in a packet of 10 pcs.

New PCD Insert with FLM Breaker

Superior cutting chip control achieved with aluminum finish boring.



Insert						Work Piece Material						Machining				
Model	Order No.	Radius [mm]		Rake Angle γ	Grade	Cast Iron GG	Cast Iron GGG	AL / Non-Ferrous Metals	Hardened Steel ≥ 52 HRC	NiCo Alloys/Titanium	Carbon Fiber	High Volume Machining	Unfavorable Conditions	Slightly Interrupted Cut	Heavily Interrupted Cut	HSC
TCGT 110202	948.373	0.2	FL	8°	PCD			++			++	++		+		++
TCGT 110204	948.374	0.4	FL	8°	PCD			++			++	++		+		++
TCGT 110208 NEW	948.375	0.8	FL	8°	PCD			++			++	++		+		++

1. One cutting edge made with PCD.

Original breaker design avoids problems with cutting chips

Insert Model	TCGT110204FLM
Workpiece	A2017
Cutting speed Vc (m/min)	800
Feed f (mm/rev)	0.1
Cutting depth (mm/Ø)	0.2
Coolant	Water-soluble coolant

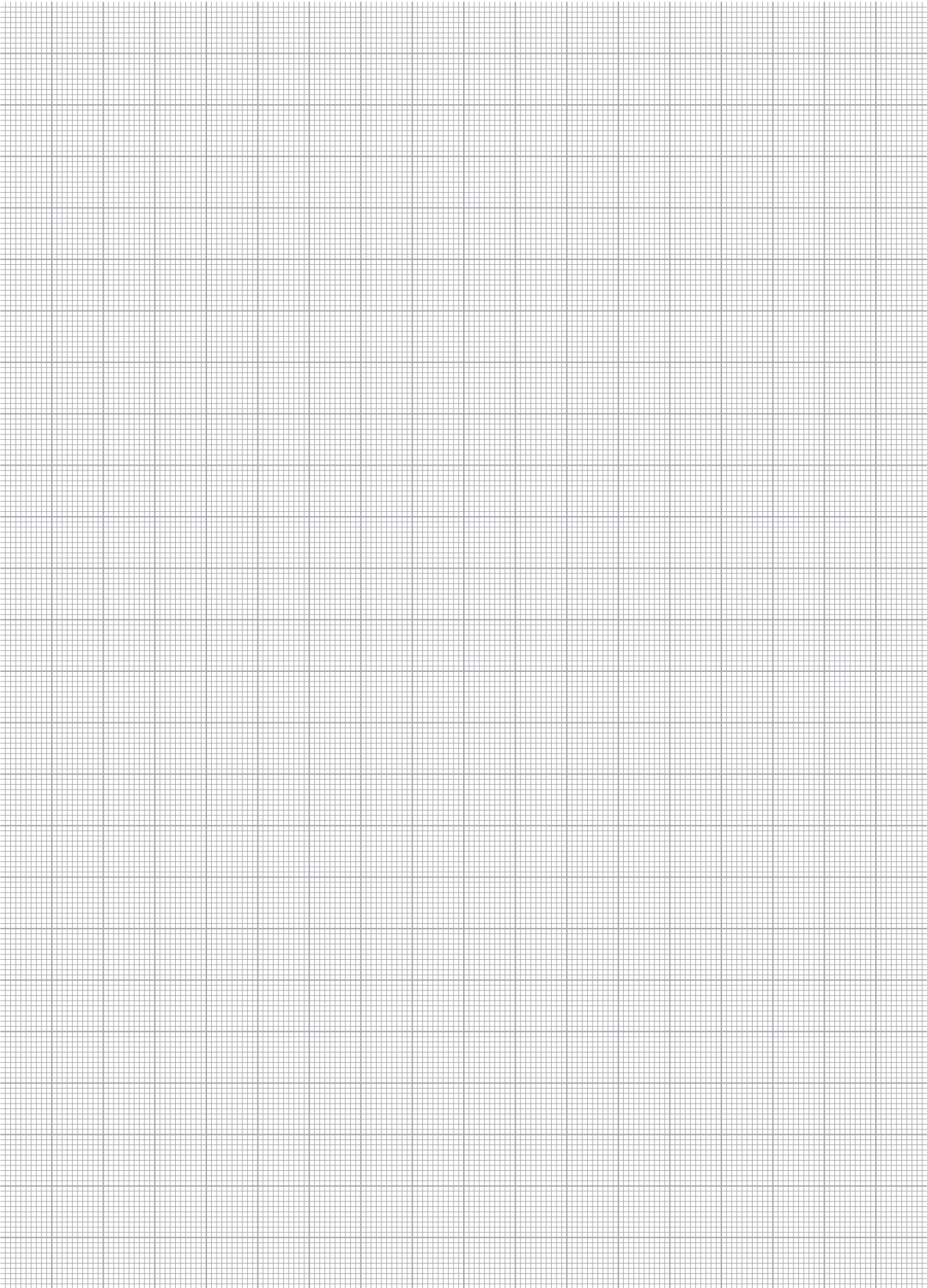
FLM Breaker



No Breaker



Notes



The complete product overview and accessories can be found in the BIG KAISER main catalog.



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