

BIG KAISER



HIGH PERFORMANCE TOOLING SOLUTIONS

Runout Adjustable RA Holder

2018-2019

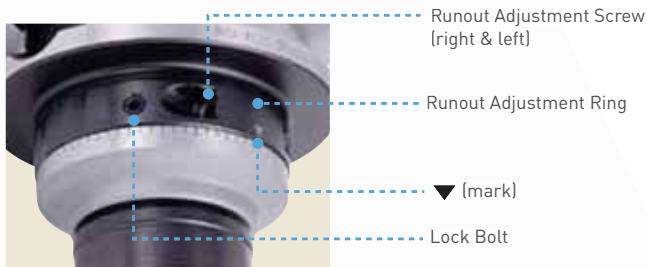


Quick Correction of Spindle Runout by Tool Holder Features

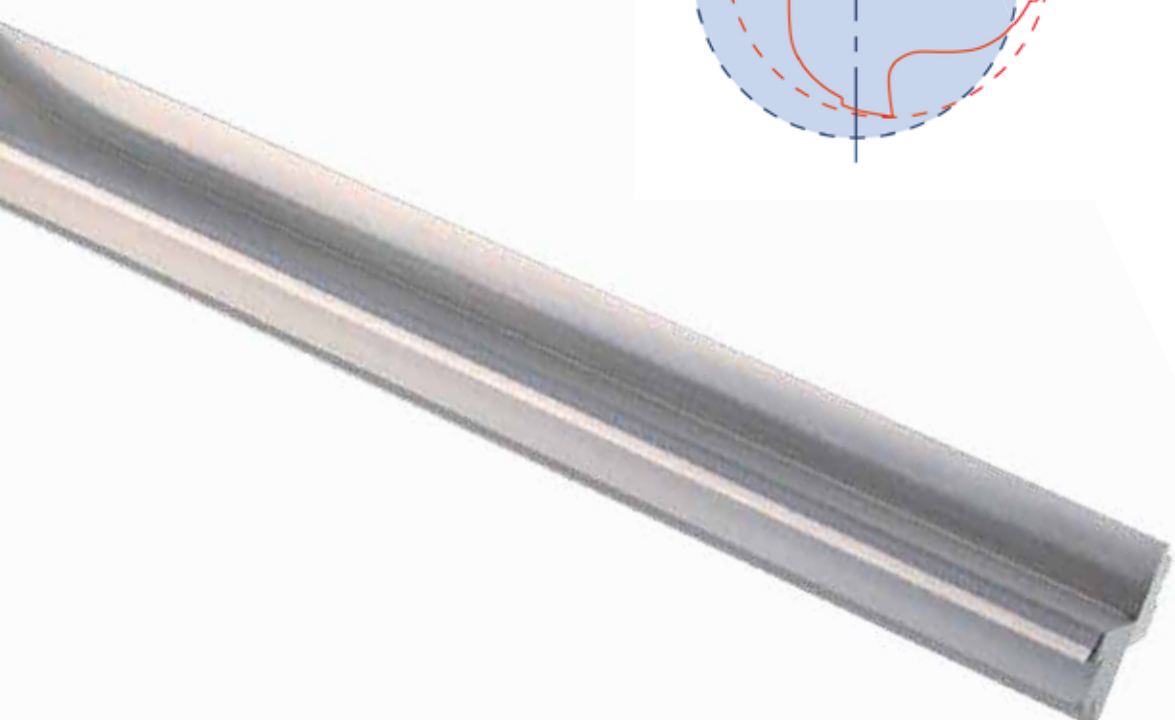
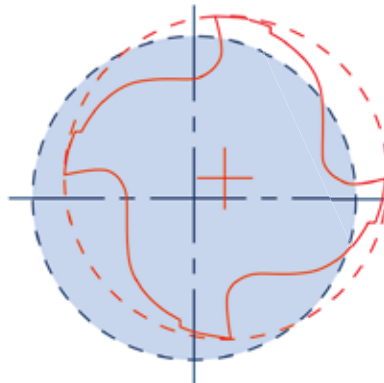
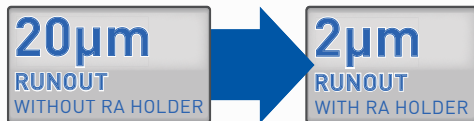
Runout accuracy of machine tool spindles may be decreased after extended use. Long drilling or reaming operations on such machines leads to variations in precision, shortened tool life, etc. The RA Holder is an effective countermeasure to these problems.

- Uniform hole diameter
- Improves surface roughness
- Extends tool life

Simple Design & Easy Adjustment



1. Rotate the runout adjustment screw and align the ▼ (mark) with the peak runout
2. Fix the runout adjustment ring by tightening (3) lock bolts
3. Adjust runout by rotating the runout adjustment screw



NEW BABY CHUCK

CLAMPING RANGE: ϕ .5-20mm

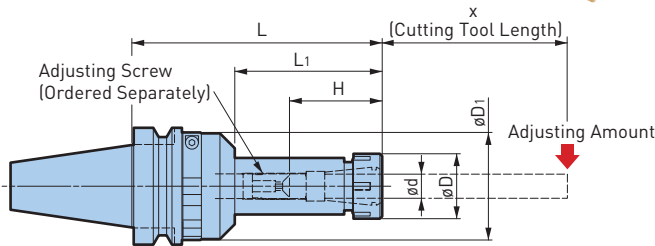
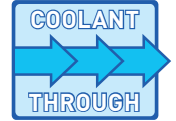


Fig. 1

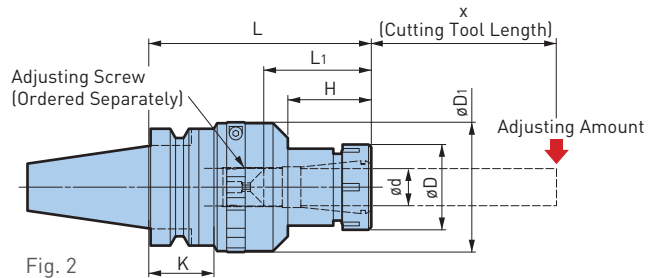


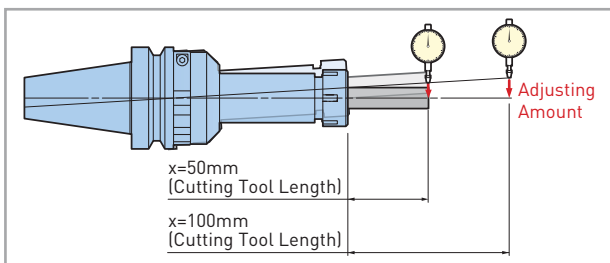
Fig. 2

Catalog Number	Fig.	ϕd	ϕD	ϕD_1	L	L1	K	H	Collet	Adjustment		Weight (lbs.)
										x=50mm	x=100mm	
BBT30-NBS8-75NRA	1	.5-8mm	.984	1.772	2.95	1.10	—	.91-1.66	NBC8-□	20 μ m	31 μ m	1.5
-NBS13-110NRA	2	2.5-13mm	1.378	2.283	4.33	1.34	1.38	1.61-2.36	NBC13-□	18 μ m	27 μ m	3.1
BBT40-NBS8-90NRA	1	.5-8mm	.984	1.772	3.54	1.46	—	.91-1.65	NBC8-□	22 μ m	33 μ m	2.9
-NBS13-90NRA	1	2.5-13mm	1.378	2.283	3.54	1.34	—	1.61-2.36	NBC13-□	18 μ m	27 μ m	3.5
-135NRA					5.32	3.11				25 μ m	34 μ m	4.2
-NBS20-120NRA	2	2.5-20mm	1.811	2.756	4.72	1.77	1.38	1.89-2.56	NBC20-□	17 μ m	25 μ m	5.5
-150NRA					5.91	2.56				1.77	21 μ m	29 μ m
BBT50-NBS13-105NRA	1	2.5-13mm	1.378	2.283	4.13	1.50	—	1.61-2.36	NBC13-□	19 μ m	28 μ m	9.3
-135NRA					5.32	2.68				24 μ m	33 μ m	9.7
-165NRA					6.50	3.86				30 μ m	39 μ m	9.9
-NBS20-120NRA	1	2.5-20mm	1.811	2.756	4.72	1.89	—	1.89-2.56	NBC20-□	17 μ m	25 μ m	10.4
-150NRA					5.91	3.07				22 μ m	30 μ m	11.0

- Collet, wrench and adjusting screw must be ordered separately
- "H" indicates the adjustment length with an adjusting screw
- BCV available upon request

Runout Adjustment Amount

The adjustment amount depends on the length of the holder and the tool projection length. The maximum adjustment amount possible for 50mm and 100mm tool projection lengths is listed in the table. The maximum adjustment amount is a reference figure available when the Adjusting Screw is tightened with the listed allowable torque.

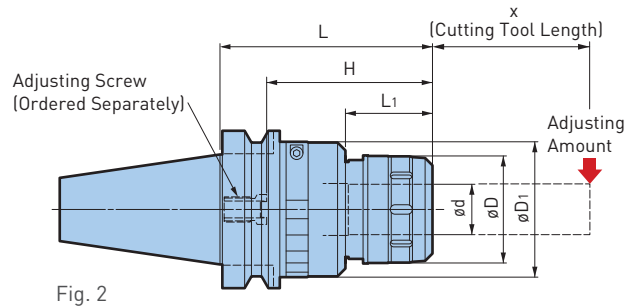
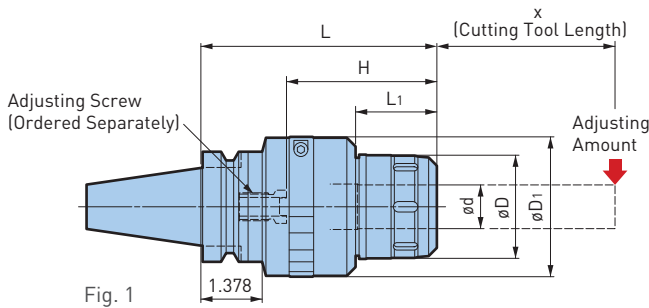
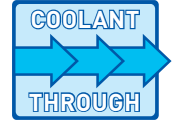


Allowable Torque for Adjusting Screw

NEW BABY CHUCK	Wrench (Optional)	Allowable Torque (N·m)
NBS8-NRA	CK-T2.5	3
NBS13-NRA	CK-T3	6
NBS20-NRA		

Hi-POWER MILLING CHUCK

CLAMPING RANGE: $\varnothing 20$ -32mm

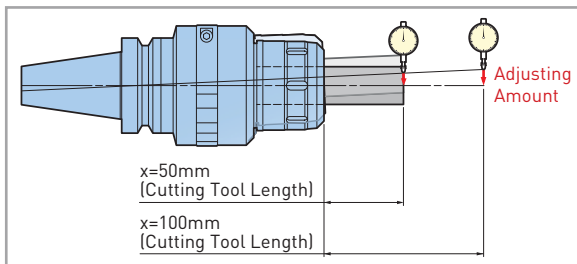


Catalog Number	Fig.	$\varnothing d$	$\varnothing D$	$\varnothing D_1$	L	L ₁	K	H	Min Clamping	Adjustment		Wrench	Weight (lbs.)
										x=50mm	x=100mm		
BBT40-HMC20S-130NRA	1	20mm	1.969	2.835	5.12	1.81	2.72-3.11	3.35	1.77	23 μ m	33 μ m	FK45-50L	6.4
-HMC25S-135NRA		25mm	2.323	3.150	5.32	1.81	2.95-3.35	3.54	1.77	21 μ m	30 μ m	FK58-62L	7.7
-HMC32S-145NRA		32mm	2.677	3.386	5.71	2.17	3.35-3.74	4.13	2.17	20 μ m	28 μ m	FK68-75L	8.4
BBT50-HMC20S-125NRA	2	20mm	1.969	2.835	4.92	1.81	2.72-3.11	3.35	1.77	23 μ m	33 μ m	FK45-50L	11.5
-HMC25S-125NRA		25mm	2.323	3.150	4.92	1.81	2.95-3.35	3.54	1.77	21 μ m	30 μ m	FK58-62L	12.3
-HMC32S-135NRA		32mm	2.677	3.386	5.32	2.17	3.35-3.74	4.13	2.17	20 μ m	28 μ m	FK68-75L	13.2

- Collet, wrench and adjusting screw must be ordered separately
- "H" indicates the adjustment length with an adjusting screw
- BCV available upon request

Runout Adjustment Amount

The adjustment amount depends on the length of the holder and the tool projection length. The maximum adjustment amount possible for 50mm and 100mm tool projection lengths is listed in the table. The maximum adjustment amount is a reference figure available when the Adjustment Screw is tightened with the listed allowable torque.

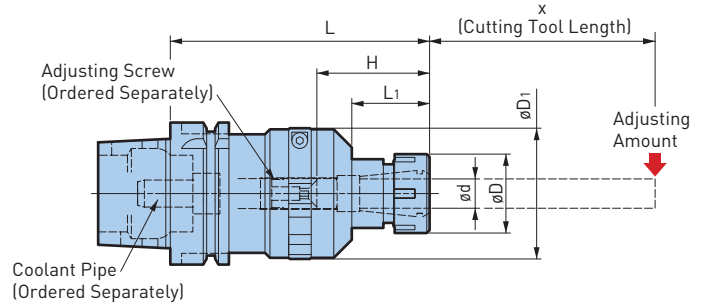
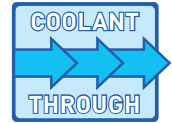


Allowable Torque for Adjusting Screw

NEW Hi-POWER MILLING CHUCK	Wrench (Optional)	Allowable Torque [N-m]
HMC20S-NRA	CK-T4	8
HMC25S-NRA		
HMC32S-NRA		

NEW BABY CHUCK

CLAMPING RANGE: \varnothing .5-20mm

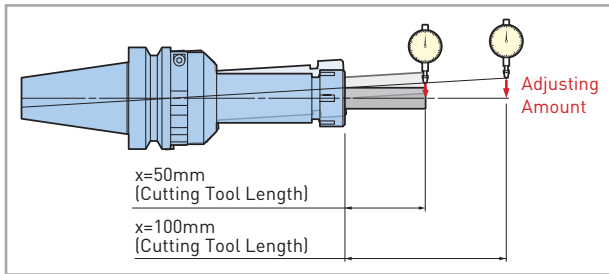


Catalog Number	$\varnothing d$	$\varnothing D$	$\varnothing D_1$	L	L ₁	H	Collet	Adjustment		Weight (lbs.)
								x=50mm	x=100mm	
HSK-A63-NBS8-105NRA	.5-8mm	.984	1.772	4.13	1.69	.91-1.65	NBC8-□	23 μ m	34 μ m	2.6
-NBS13-115NRA	2.5-13mm	1.378	2.283	4.53	1.38	1.61-2.36	NBC13-□	18 μ m	27 μ m	4.0
-NBS20-135NRA	2.5-20mm	1.811	2.756	5.32	1.77	1.89-2.56	NBC20-□	17 μ m	25 μ m	5.3

- MEGA NEW BABY NUT is included, coolant pipe, collet, wrench and adjusting screw must be ordered separately
- "H" indicates the adjustment length with an adjusting screw

Runout Adjustment Amount

The adjustment amount depends on the length of the holder and the tool projection length. The maximum adjustment amount possible for 50mm and 100mm tool projection lengths is listed in the table. The maximum adjustment amount is a reference figure available when the Adjustment Screw is tightened with the listed allowable torque.

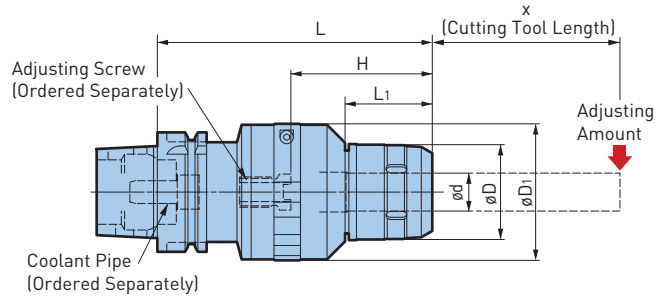
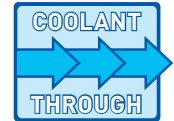


Allowable Torque for Adjusting Screw

NEW BABY CHUCK	Wrench (Optional)	Allowable Torque (N·m)
NBS8-NRA	CK-T2.5	3
NBS13-NRA	CK-T3	6
NBS20-NRA		

Hi-POWER MILLING CHUCK

CLAMPING RANGE: \varnothing 20-32mm

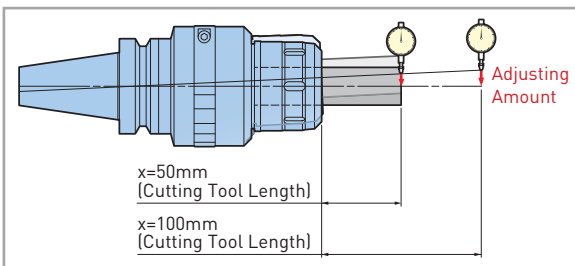


Catalog Number	$\varnothing d$	$\varnothing D$	$\varnothing D1$	L	L1	H	H Max	Min Clamping	Adjustment		Wrench	Weight (lbs.)
									x=50mm	x=100mm		
HSK-A63-HMC20S-145NRA	20mm	1.969	2.835	5.71	1.81	2.72-3.11	3.35	1.77	23 μ m	33 μ m	FK45-50L	6.4
-HMC32S-155NRA ❖	32mm	2.677	3.386	6.10	2.17	—	4.72	2.09	20 μ m	28 μ m	FK68-75L	8.6

- Coolant pipe, collet, wrench and adjusting screw must be ordered separately
- "H" indicates the adjustment length with an adjusting screw
- Adjusting screws cannot be used with models marked ❖

Runout Adjustment Amount

The adjustment amount depends on the length of the holder and the tool projection length. The maximum adjustment amount possible for 50mm and 100mm tool projection lengths is listed in the table. The maximum adjustment amount is a reference figure available when the Adjustment Screw is tightened with the listed allowable torque.



Allowable Torque for Adjusting Screw

NEW Hi-POWER MILLING CHUCK	Wrench (Optional)	Allowable Torque (N·m)
HMC20S-NRA	CK-T4	8
HMC32S-NRA		

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A Member of the BIG DAISHOWA Group

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