

Info

Tool holding fixtures in accordance with JIS B 6339 (MAS-BT)

JIS B 6339

(Japanese standard, formerly MAS-BT).

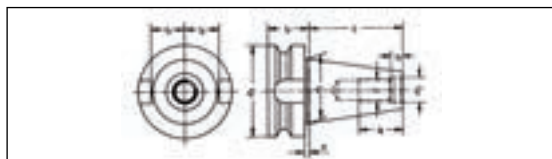
Type

Alloyed case-hardened steel, min. tensile strength 950 N/mm².

Taper angle tolerance more accurate than AT3.

Case-hardened 60-2 HRC.

Functional surfaces ground.



MAS-BT	d1 mm	G	d5 H7 mm	d2 mm	a mm	l1 mm	l2 mm	l3 mm	l5 mm	l6 mm
30	31,75	M 12	12,5	46	2	48,4	22	16,3	7,0	24
40	44,45	M 16	17,0	63	2	65,4	27	22,6	8,2	32
50	69,85	M 24	25,0	100	3	101,8	38	35,3	11,0	47

21192

CNC short chucks

MAS-BT/
JIS B 6339

A

G 6,3
12000
1/min

≤30µm



Type

- Short design
- Wearing parts hardened and ground

Scope of supply:

Incl. of wrench with T-handle for high power.

Use

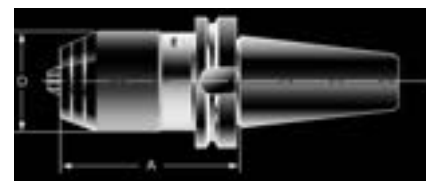
For clockwise and counterclockwise operation.

Note:

Draw-in bolts see cat.-no. 21737 - 21739.



21192



Taper MAS-BT	Clamping range mm	A mm	D mm	21192	...
40	1 - 16	88	50		101

21207

Precision Short Chucks

MAS-BT/
JIS B 6339

A

≤30µm



Type

- Short, stable and slim design
- High clamping forces caused by transmission ratio
- High precision and concentricity precision

Scope of supply:

Incl. of wrench with T-handle for high power.

Use

For clockwise and counterclockwise operation.

Note:

Draw-in bolts see cat.-no. 21737 - 21739.



21207

Taper MAS-BT	with drill chuck mm	l ₁ mm	d ₁ mm	l ₂ mm	21207	...
40	1.0 - 13	95.5	43	103.5		101
40	2.5 - 16	114.5	56	119.5		102
50	1.0 - 13	106.5	43	114.5		103
50	2.5 - 16	125.5	56	130.5		104



21458

Quick-Change Tapping Chucks

MAS-BT/
JIS B 6339

A



Type

- With length compensation in response to compression and tension.

Note:

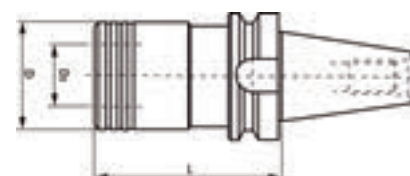
Quick-change sleeves see cat.-no. 21459 - 21460.

Draw-in bolts see cat.-no. 21737 - 21739.



21458

Taper MAS-BT	for Taps	Suitable inserts/size	Length compensation compr./tension mm	L mm	D mm	D ₂ mm	21458	...
40	M 3 - M 12	1	9.0/9.0	68	38	19		101
40	M 6 - M 20	2	15.0/15.0	93	55	31		102
40	M 14 - M 33	3	24.0/24.0	138	79	48		103
50	M 6 - M 20	2	15.0/15.0	102	55	31		105



21514

ER collet chucks

MAS-BT/ JIS B 6339 AD/B AD G 6.3 15000 1/min $\leq 3\mu m$



- Type**
- Precision type.
 - High concentricity precision
 - SK 40 = shape AD/B
 - SK 50 = shape AD

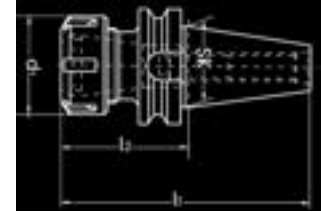
Note:
 Collet sets see cat.-no. 21519.
 Collets see cat.-no. 21520 - 21525
 and 21534 - 21539.
 Draw-in bolts see cat.-no. 21737 - 21739.

Use
 For clamping tools with straight shank in collets
 DIN 6499-shape A and B.

Taper MAS-BT	Clamping range mm	Size	Collets Type	l ₂ mm	l ₁ mm	d ₁ mm	21514	...
40	1 - 16	ER 25	ER 25/430 E	60	125.4	42	101	
40	2 - 20	ER 32	ER 32/470 E	70	135.4	50	102	
40	3 - 26	ER 40	ER 40/472 E	80	145.4	63	103	
50	2 - 20	ER 32	ER 32/470 E	70	171.8	50	104	
50	3 - 26	ER 40	ER 40/472 E	80	181.8	63	105	



21514



21545

OZ collet chucks

MAS-BT/ JIS B 6339 AD G 6.3 15000 1/min $\leq 3\mu m$



- Type**
- Precision type.
 - Cap nut mounted in ball bearing

Note:
 Collets see cat.-no. 21552 - 21554.
 Draw-in bolts see cat.-no. 21737 - 21739.

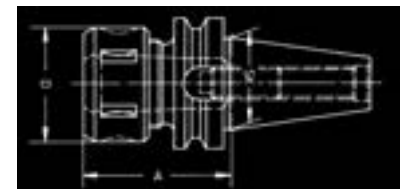
Scope of supply:
 Incl. of clamping nut.

Use
 For the clamping of tools with straight shank in
 collets DIN 6388.

Taper MAS-BT	Clamping range mm	for collets Type	A mm	D mm	21545	...
40	2 - 25	462 E	70	60	101	
40	4 - 32	467 E	90	72	102	



21545



21578

Power chucks

MAS-BT/ JIS B 6339 AD/B G 6.3 12000 1/min $\leq 5\mu m$



- Type**
- Clamping nut with needle roller cage
 - Robust design
 - Simple pre-setting and application
 - High concentricity precision, torque transmission and stability
 - With reduction can be used from 3 - 32 mm

Use
 For clamping tools with straight shank.
 Also suitable for clamping Weldon shanks.
 Particularly suited for roughing.

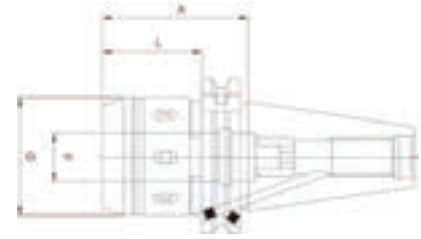
Note:
 Reduction sleeves see cat.-no. 21582.
 Clamping wrench see cat.-no. 50650.
 Draw-in bolts see cat.-no. 21737 - 21739.

Scope of supply:
 Incl. of clamping nut.

Taper MAS-BT	d mm	D mm	A mm	L mm	21578	...
40	20	48	63	36	101	
40	32	66	90	53	102	
50	20	48	85	47	103	
50	32	66	95	57	104	



21578



21602

Tool holder for drill chuck

MAS-BT/ JIS B 6339 A G 6.3 15000 1/min $\leq 5\mu m$



- Type**
- Precision type

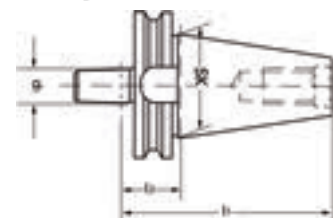
Note:
 Draw-in bolts see cat.-no. 21737 - 21739.

Use
 For mounting drill chucks in milling machines.

Taper MAS-BT	Mount d ₁ DIN 238	l ₂ mm	l ₁ mm	21602	...
40	B 16	-	32	401	



21602



21611

Taper sleeves

MAS-BT/
JIS B 6339

AD/B

AD



G 6.3
15000
1/min



Type

- Precision type
- BT 40 = shape AD/B
- BT 50 = shape AD

Use

For mounting tools with MT shank and drive tang.

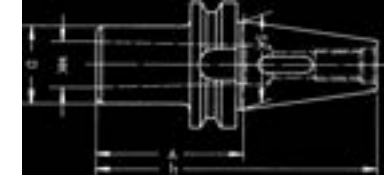
Note:

Draw-in bolts see cat.-no. 21737 - 21739.

External taper MAS-BT	Internal taper MT	A mm	l ₁ mm	D mm	21611	...
40	1	50	115.4	25		101
40	2	50	115.4	32		102
40	3	70	135.4	40		103
40	4	95	160.4	48		104
50	2	60	161.8	32		106
50	3	65	166.8	40		107
50	4	95	196.8	48		108



21611



21633

Milling cutter mounts



Type

- Precision type
- Bore tolerance < 0.004 mm

Use

For clamping tools with lateral Driving face in compliance with DIN 1835 B and DIN 6535 HB.

Note:

Draw-in bolts see cat.-no. 21737 - 21739.

Taper MAS-BT	for milling cutter shank Ø d mm	A mm	D mm	21633	...
40	6	50	25		111
40	8	50	28		112
40	10	63	35		113
40	12	63	42		114
40	14	63	44		115
40	16	63	48		116
40	18	63	50		117
40	20	63	52		118
40	25	90	63		120
40	32	100	72		121

Taper MAS-BT	for milling cutter shank Ø d mm	A mm	D mm	21633	...
50	6	63	25		211
50	8	63	28		212
50	10	63	35		213
50	12	80	42		214
50	14	80	44		215
50	16	80	48		216
50	18	80	50		217
50	20	80	52		218
50	25	100	63		220
50	32	105	72		221
50	40	110	80		222

MAS-BT/
JIS B 6339

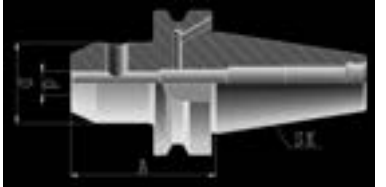
AD/B



G 6.3
15000
1/min



21633



21651

Combination milling cutter arbors



Type

- Precision type
- Flat-ground supporting surfaces (precision < 0.003 mm)

Scope of supply:

Incl. of feather key, driving ring and draw-in screw.

Use

With feather key for milling cutters with longitudinal

keyway e.g. DIN 841 and driving ring for milling cutters with transverse slot DIN 1880 and milling heads DIN 1830.

Note:

Draw-in bolts see cat.-no. 21737 - 21739.

Driver rings, see cat.-no. 21655.

Draw-in screws, see cat.-no. 21656 and 21659.

Draw-in screw wrench, see cat.-no. 21657.

Taper MAS-BT	d ₂ mm	l ₄ mm	l ₃ mm	d ₁ mm	l ₅ mm	l ₂ mm	21651	...
40	16	55	45	32	17	27		302
40	22	55	43	40	19	31		303
40	27	55	43	48	21	33		304
40	32	60	46	58	24	38		305
40	40	60	46	70	27	41		306
50	22	70	58	40	19	31		403
50	27	70	58	48	21	33		404
50	32	70	56	58	24	38		405
50	40	70	56	70	27	41		406

MAS-BT/
JIS B 6339

A

G 6.3
15000
1/min



21651

