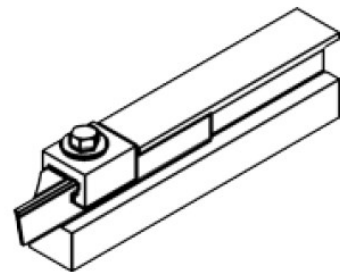
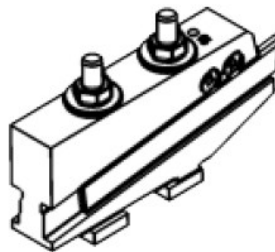
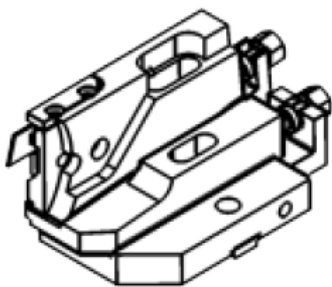




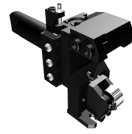
Schlitter
we tool your world

2017

Cutoff Tooling



2017 Cut-Off Tooling



About BME..

BME is a Screw Machine Rebuilder and Custom tooling supplier located in southeast Michigan. We pride ourselves on our quality of work and exceeding our customer's expectations. We provide quality attachments for the screw machine industry through original and innovative design and engineering with proven results. Founded, in 2007, on the principal that quality attachments and accessories can be manufactured and supported right here in our own country, we've been maintaining steady growth ever since. Initially, BME provided attachments for Acme-Gridley's, mainly Flat Generators and Sync attachments, but over the years we've expanded our product line to include attachments for New Britains, Wickmans, Davenport's, and any multi-spindles. Our growth over the years has also led to purchase and integration of Precision Form and Grind, and at the end of 2016, the Schlitter Tool/Genius Inc product line.

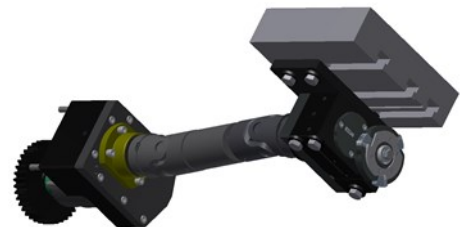
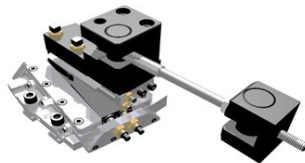
We attribute a majority of this growth to our ability to solve the screw machine industries' challenges, along with our commitment to our customers, meeting their deadlines. Our 15000 square foot facility also contains a variety of CNC manufacturing equipment, that allows us to manufacture a majority of components in house. Our staff includes personnel that have a combined 80 plus years of experience in diagnosing, designing, and debugging a variety of solutions to customer's challenges on screw machines.

Have you ever been told that "you can't do that on a screw machine"? Please give us a call before you respond no!

Why BME?

- Our engineering is unsurpassed, allowing years of experience working on machines and attachments to blend with years of experience in mechanical design.
- The most advanced software is used to create the systems that meet customer's requirements to perform the demanding needs of today's manufacturing.
- We communicate effectively with our customer, which reduces errors and delivers a better, innovative product faster.
- Our attachments save our customers money by allowing complete processing, a part that is manufactured completely in one step without a secondary operation allows an unmatched advantage, increasing profits and quality. The less a part is handled, the more cost effective the process!
- We stand by our product, we won't sell an attachment that we don't feel confident will solve the customer's problem.
- In most applications, we offer a 30 day trial (except custom components) before invoicing.
- Our products are designed and manufactured to have replaceable components, with minimal fitting spacers, for quick replacements.
- Our products are designed and manufactured to endure heavy loading and usage, hardened and ground components, and utilizing spline drives in place of keys.
- Our products are domestically manufactured and stocked on our floor, minimizing lead times for both new purchases and replacement parts.

The following catalogue is a list of common Tool Holders and Attachment, but if you don't see what you are looking for, please contact us! We have been providing more than just tooling to our customers for over 10 years. We provide solutions to the everyday challenges of the multi-spindle user. This is just a fraction of the tooling we supply. Also, please review our website, we are constantly adding new product.



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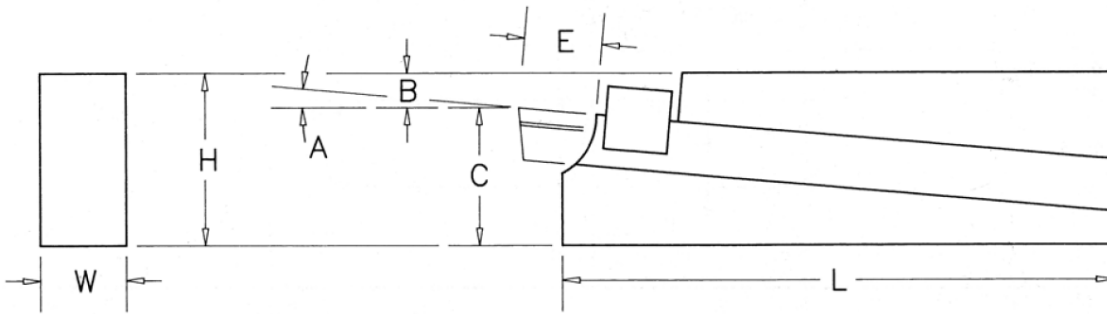
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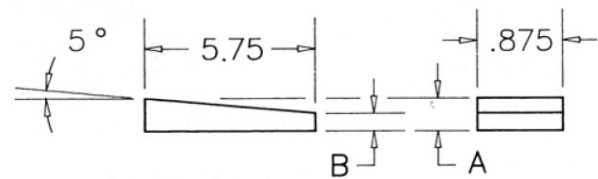
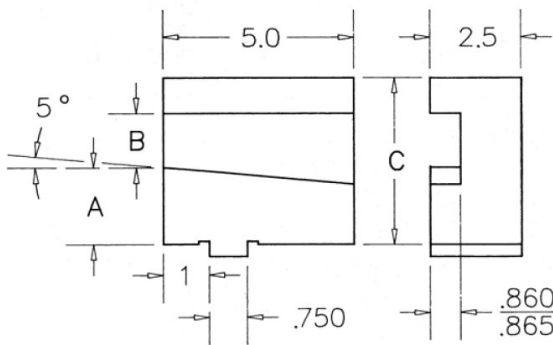
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Acme Holders, Posts & Wedges



LH CL HOLDER SHOWN

Acme Holders								
HOLDER	A	B	C	E	H	L	W	BLADE
350	3°	.250	.968	.562	1.218	6.00	1.00	P-1
351	3°	.250	.968	.562	1.218	6.00	1.00	P-3
352	4°	.469	1.219	.687	1.688	8.50	1.00	P-3
353	4°	.343	1.345	.875	1.688	8.50	1.25	P-5
354	0°	.550	.700	-	1.250	5.00	1.00	P-1
356	0°	.482	1.203	-	1.688	7.00	1.00	P-3
357	5°	.438	1.812	1.375	2.250	9.00	1.50	P-8
359	5°	.218	2.282	1.813	2.250	9.00	1.50	P-8
383	5°	.281	1.594	.875	1.875	6.75	1.25	P-5
384	2°	.281	1.469	1.813	1.750	6.50	1.50	P-8



Posts			
Post	A	B	C
3	.718	2.031	3.625
4	1.875	2.125	4.875
5	.964	2.156	4.125
6	1.840	2.656	5.375
9	1.562	2.062	4.500
10	2.719	2.156	5.750

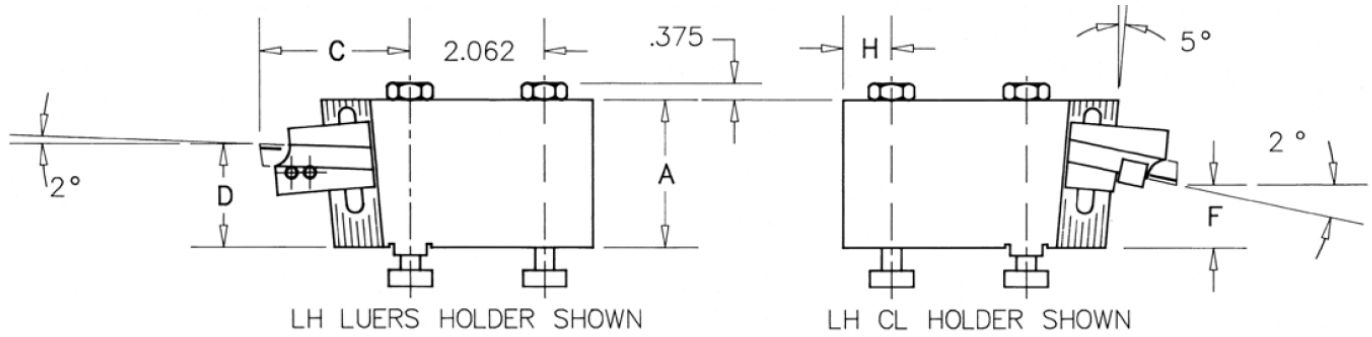
Wedges		
WEDGE	A	B
W-1	.565	.062
W-2	.628	.125
W-3	.721	.218
W-4	.878	.375
W-6	1.128	.625
W-7	1.321	.518
W-9	.784	.281

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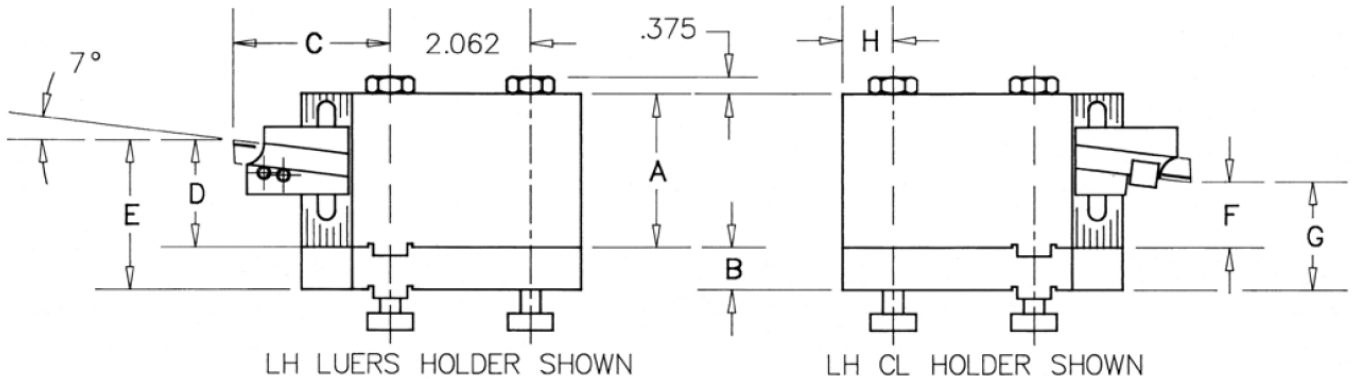
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Acme Holders, Posts & Risers

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380 Post and Riser with X-18A Holder						
A	C	D	F	H	Blade Extension	
2.687	2.89	Min 1.187 Max 2.562	Min .437 Max .812	0.5	9/16	



379 Post & Riser with X-18A Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
9/16"	3.25	0.18	2.53	2.437	3.093	3.625	4.28	0.687	2.343	2.875	3.53	0.53

381 Post & Riser with X-18 Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
1/4"	2.625	0.96	3	0.017	2.392	0.977	3.352	0.343	0.718	0.303	2.678	0.5
1/2"	2.625	0.96	3.25	0.048	4.423	2.008	3.383	0.312	0.687	0.272	2.647	0.5

381 Post & Riser with X-18A Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
1/2"	2.625	0.96	3.62	0.264	2.639	2.224	3.599	0.096	0.47	0.056	2.43	0.5
3/4"	2.625	0.96	3.88	0.295	2.67	2.255	3.63	0.065	0.44	0.205	2.4	0.5

382 Post & Riser with X-18A Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
3/4"	2.687	1.218	3.44 1	1.958	2.583	3.176	3.8	0.728	0.353	0.946	2.57	0.563

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2017 Cut-Off Tooling

Acme Holders Six Spindle

National acme six spindle						
Capacity/Model	Position	Holder	Post	Riser or Wedge	Blade Series	Blade Height
7/16-RA	1	X-18	36W	N/R	P1	1/2"
	2	X-18	36W	N/R		
	3	X-18	36W	36W		
	4	X-18	36W	N/R		
	5	394 WT	N/R	N/R		
	5SS	X-18	36W	36W		
9/16-RA 9/16-RAN 5/8-RN 1"-RA 1"-RAN	6	X-18	36W	36W	P-3	11/16"
	1	X-18A	381	N/R		
	2DD	X-18A	381	N/R		
	2SS	X-18A	381	N/R		
	3	X-18A	381	N/R		
	4	X-18A	381	N/R		
	5	351 *	N/R	N/R		
5SS	X-18A	381	N/R			
1"-RAS , 1-1/4-RA	5DD	X-18A	381	381	P-3	11/16"
	6	X-18A	381	381		
	1	356	7110	W-1		
	2		N/R	N/R		
	2DD		7110	W-1		
	2SS		7110	W-1		
	3		7118	W-3		
	4		7110	W-1		
5	N/R		N/R			
5SS	7118		W-3			
1-5/8-RA 1-5/8-RB 2"-RA 2"-RB	5DD	353	7118	W-3	P-5	7/8"
	6		7118	W-3		
	1		5-LH	W-3		
	2		N/R	N/R		
	2DD		6-LH	W-3		
	2SS		3-LH	W-3		
	3		4-RH	W-1		
	4		3-LH	W-3		
2"-RA 2-1/4-RA 2-5/8-RA	5	N/R	N/R	P-8	1 1/8"	
	5SS	4-RH	W-1			
	5DD	4-RH	W-9			
	6	4-RH	W-9			
	1	384	9-LH			W-2
	2	357	N/R			N/R
	2DD	384	9-LH			W-2
2-5/8-RB	3	384	6-RH	W-2	P-8	1 1/8"
	4	357	3-LH	W-1		
	5	357	N/R	N/R		
	5DD	384	10-RH	W-2		
	6	384	10-RH	W-2		
	1	384	9-LH	W-2		
	2	357	N/R	N/R		
	2DD	384	9-LH	W-2		
3"-RA 3"-RB 3-1/2-RA 3-1/2-RB 4"-RA	2SS	384	7089	W-1	P-8	1 1/8"
	3	384	10-RH	W-2		
	4	384	9-LH	W-2		
	5	359	N/R	N/R		
	5SS	384	7106	W-2		
	5DD	384	10-RH	W-2		
	6	384	10-RH	W-2		
	1	384	9-LH	W-2		
2	359	N/R	N/R			
2DD	384	9-LH	W-2			
2SS	384	7089	W-1			
3	384	10-RH	W-2			
4	384	9-LH	W-2			
5	359	N/R	N/R			
5SS	384	7106	W-2			
5DD	384	10-RH	W-2			
6	384	10-RH	W-2			

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2017 Cut-Off Tooling

Acme Holders Eight Spindle

National Acme Eight Spindle						
Capacity/Model	Position	Holder	Post	Riser or Wedge	Blade Series	Blade Height
3/4-RA	1	X18A	381	N/R	P-3	11/16"
	2DD	X18A	381	N/R		
	3	351	N/R	N/R		
	3SS	X18A	381	N/R		
	4	X18A	381	N/R		
	5	X18A	381	N/R		
	6	351	N/R	N/R		
	6SS	X18A	381	N/R		
1-1/4-RB 1-5/8-RBN	7DD	X18A	381	381	P-3	11/16"
	8	X18A	381	381		
	1	356	7110	W-1		
	2DD	356	7110	W-1		
	3	356	N/R	N/R		
	3SS	356	7110	W-1		
	4	356	7118	W-3		
	5	356	7110	W-1		
1-5/8-RA 1-5/8-RB 1-5/8-RB 2"-RA 2"-RB	6	356	N/R	N/R	P-5	7/8"
	6SS	356	1778	W-3		
	7DD	356	7118	W-3		
	8	356	7118	W-3		
	1	353	5-LH	W-3		
	2DD	353	5-LH	W-3		
	3	353	N/R	N/R		
	3SS	353	7089	W-3		
2-1/4-RA 2-1/4-RB 2-5/8-RA 2-5/8-RB	4	353	6-RH	W-4	P-8	1 1/8"
	5	353	5-LH	W-3		
	6	353	N/R	N/R		
	6SS	353	7123	W-1		
	7DD	353	6-RH	W-4		
	8	353	6-RH	W-4		
	1	384	9-LH	W-2		
	2DD	384	9-LH	W-2		
3-1/2-RB 4"-RB	3	359	N/R	N/R	P-8	1 1/8"
	3SS	384	3-LH	W-1		
	4	384	6-RH	W-2		
	5	384	3-LH	W-1		
	6	359	N/R	N/R		
	6SS	384	6-RH	W-2		
	7DD	384	10-RH	W-2		
	8	384	10-RH	W-2		

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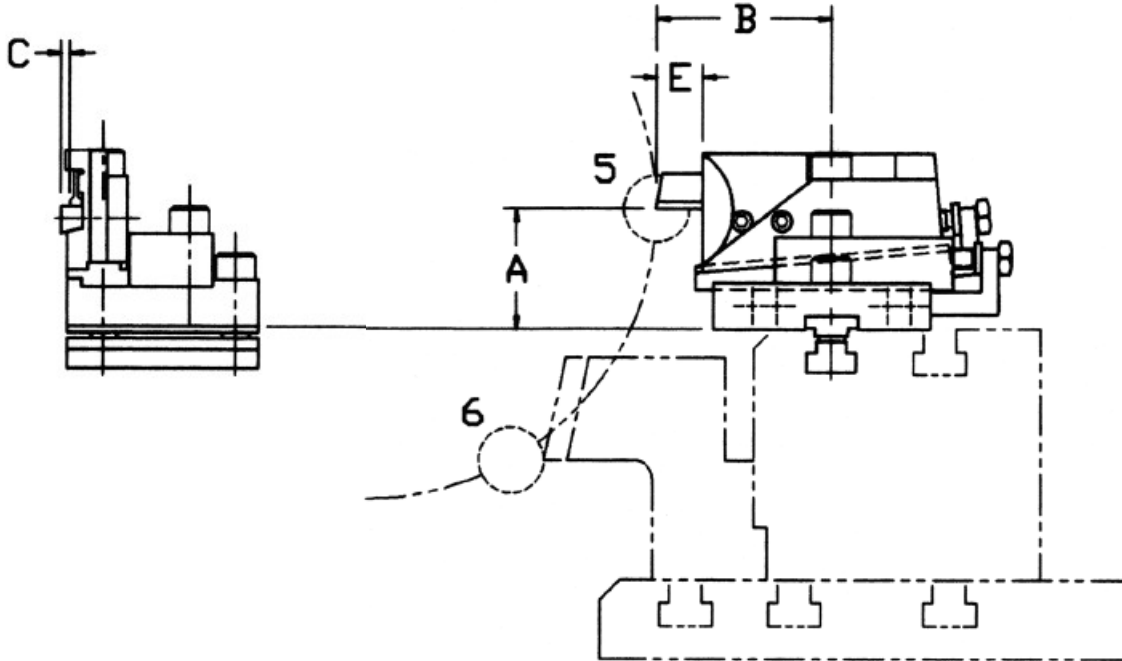
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2017 Cut-Off Tooling

National Acme Pickoff & Back Burr Cutoff Holders



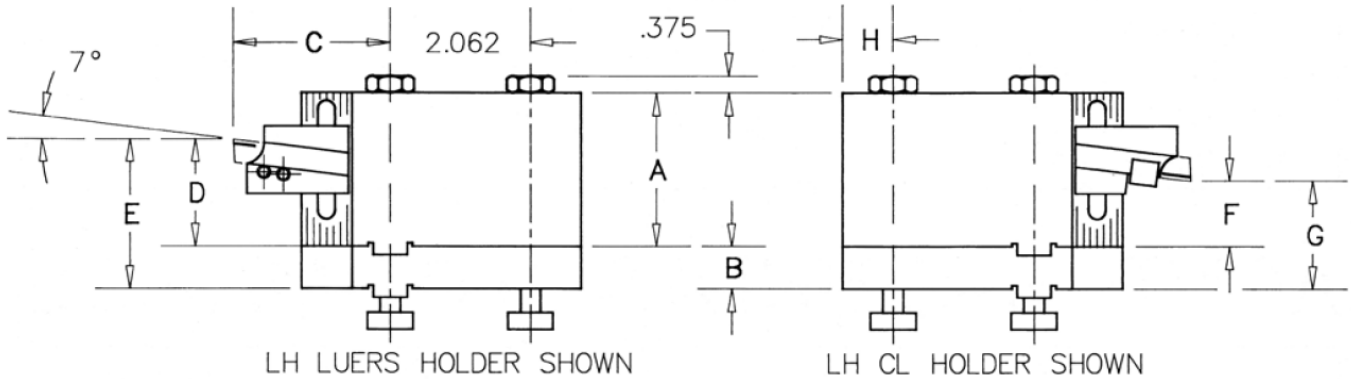
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National Acme Pickoff & Back Burr Cutoff Holder									
MACHINE	POS	A	B		C	E	CLAMP	TOOL SIZES	HOLDER #
			MIN	MAX					
7/16"RA-6	5	1	3.687*	4.187*	0.06	0.375	1738	P1N, P1, P2N, P2, P3S 1216, 1220, 1224, 1230, 1232	70-218-LH
5/8"RN-6 9/16", 1" RA & RAN6	5	2.364	3.125	3.875	0.06	0.562	1741	P1N, P1, P2N, P2, P3S 1216, 1220, 1224, 1230, 1232	70-219-LH
3/4"RA-8	7								
1 1/4"RA-6	5	2.273	3.125	3.875	0.125	0.687	1742	P3N, P3, P4,P5S 1716, 1720,1724,1730,1732, 1740,1747,1750	70-161-LH
1 1/4"RB-8 1 5/8"RBN-8	7		3.312	4.0625		0.875			
1 5/8"RB & RA 6 2"RB & 2"RA 6	5	2.5	4	4.75	0.125	0.875	1742	P3N, P3, P4,P5S 1716, 1720,1724,1730,1732, 1740,1747,1750	70-222-LH
1 5/8"RB-8 2"RB-8	7		4.187	4.937		1.062			
3 1/2"RB-6	5	3.125	4.187	4.937	0.125	1.062	1742	P3N, P3, P4,P5S 1716, 1720,1724,1730,1732, 1740,1747,1750	70-224-LH

* Note: On 7/16 Machine, Holder to be placed in back T-slot on Bridge

2017 Cut-Off Tooling

Brown and Sharp, Posts & Risers



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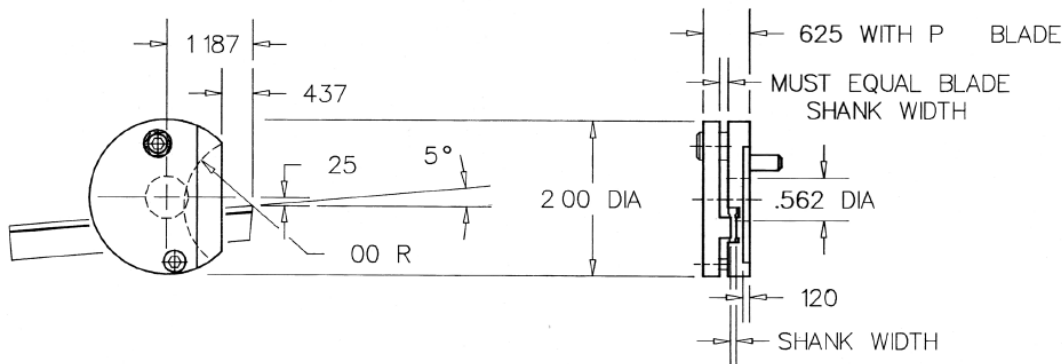
36W Post & Riser with X-18 Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
1/4"	1.250	.875	2.40	1.000	1.355	1.605	2.230	.208	.521	1.083	1.396	.656
1/2"	1.250	.875	2.65	1.031	1.386	1.636	2.261	.177	.490	1.052	1.365	.656
3/4"	1.250	.875	2.89	1.062	1.416	1.666	2.291	.147	.460	1.022	1.335	.656
38 Post & Riser with X-18 Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
1/4"	1.750	.719	2.82	1.024	1.773	1.743	2.492	.190	.939	.910	1.658	1.110
1/2"	1.750	.719	3.07	1.055	1.804	1.774	2.523	.159	.908	.878	1.627	1.110
3/4"	1.750	.719	3.32	1.085	1.834	1.804	2.553	.129	.878	.848	1.597	1.110
39 Post & Riser with X-18 Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
1/4"	1.625	.875	3.39	1.061	1.623	1.684	2.498	.227	.789	1.102	1.664	1.171
1/2"	1.625	.875	3.64	1.092	1.653	1.967	2.529	.196	.758	1.071	1.633	1.171
3/4"	1.625	.875	3.88	1.122	1.684	1.997	2.56	.165	.727	1.040	1.602	1.171
40 Post & Riser with X-18 Holder												
Blade Extension	A	B	C	D		E		F		G		H
				Min	Max	Min	Max	Min	Max	Min	Max	
1/4"	2.656	.875	3.39	1.584	2.686	2.459	3.561	.751	1.852	1.626	2.727	1.171
1/2"	2.656	.875	3.64	1.615	2.717	2.490	3.592	.719	1.821	1.594	2.696	1.171
3/4"	2.656	.875	3.88	1.645	2.748	2.52	3.623	.689	1.791	1.564	2.666	1.171

2017 Cut-Off Tooling

Brown and Sharp Holders

Brown & Sharpe Holders							
Machine	Spindle	Position	Holder	Post	Riser	Blade	
						Series	Height
00,00G 19	Forward	Front	X18	36W	N/R	P-1	1/2"
		Rear			38-B		
	Reverse	Front			38-B		
		Rear			N/R		
0 & OG	Forward	Front	X18	38	N/R		
		Rear			38-B		
	Reverse	Front			38-B		
		Rear			N/R		
2 & 2G Auto	Forward	Front	X18	39	N/R		
		Rear			39-B		
	Reverse	Front			39-B		
		Rear			N/R		
1 Plain	Forward	Front	X18	40	N/R		
		Rear			40-B		
	Reverse	Front			40-B		
		Rear			N/R		
2 Plain	Forward	Front	X18	40	N/R		
		Rear			40-B		
	Reverse	Front			40-B		
		Rear			N/R		

Davenport Holders



Davenport Holders				
Holder	Blade	Width	Height	Shank Width
630 ASSY	P1-N	.040	1/2	0.026
	P-1	1/16		0.037
	P-2N	5/64		0.063
	P-2N	3/32		0.063
	P-3S	1/8		0.089

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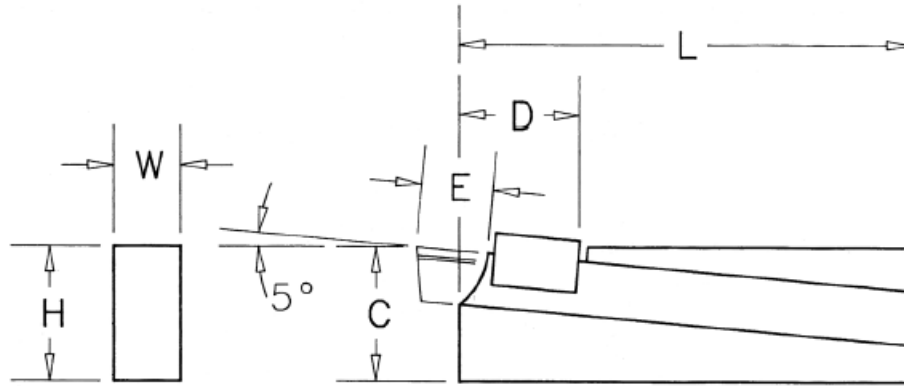
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Cone Holders



LH CL HOLDER SHOWN

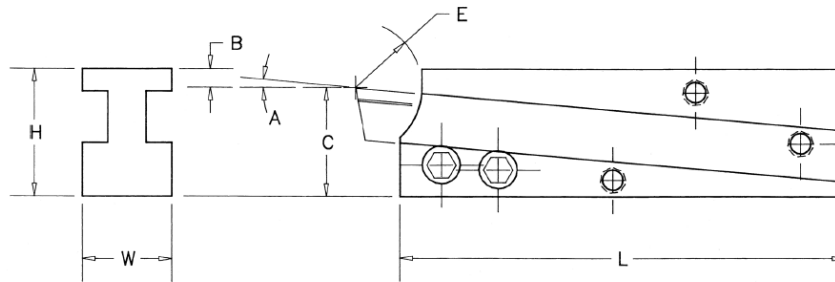
Cone Holders							
Holder	C	D	E	H	L	W	Blade
274	1.750	2.12	1.125	1.750	7.00	1.21	P-5
275	0.500	.56	0.625	1.500	5.75	0.96	P-3
276	1.750	.56	0.785	1.750	7.00	0.96	P-3
277	2.500	2.06	1.437	2.500	8.93	1.46	P-5
278	3.000	2.37	1.437	3.000	9.00	1.46	P-8

Type	Capacity	Holder
4 Spindle	7/8	275
	1-1/4	276
	1-1/2	276
	2	274
	2-1/4 2-5/8 3-1/2 4-1/4	278
Automatic 4 Spindle	3-1/2 4-3/8	278
Vertical 4 Spindle	1 1-1/4 1-1/2	276
	2-1/4 2-5/8	277
Conopmatic 6 Spindle	1	275
	1-1/4 1-1/2 1-5/8	276
	1-7/8 2	274
	2-1/4 2-5/8	277
	3-1/2	278
Conopmatic 8 Spindle	1-1/4 1-1/2	276
	1-5/8 1-7/8	274
	2-1/4 2-5/8 3	278
G & C	2-1/4 2-5/8	277

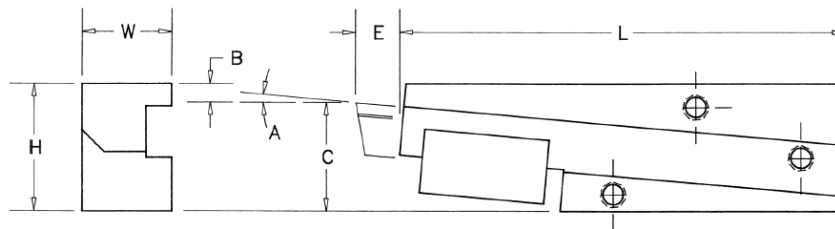
MADE IN USA

2017 Cut-Off Tooling

New Britain Holders



226 & 227 LUERS HOLDER SHOWN



226-CL-LH HOLDER SHOWN

MADE IN USA

New Britain Cut Off Holders											
Model	Machine		Holder	A	B	C	E	H	L	W	Blade
	Size										
41	1 3/8" & 1 5/8"		226	5 deg	0.078	1.359	0.965	1.437	5.75	0.87	P3
52	1 1/4"										
60	5/8" & 1"										
61	1 3/8" & 1 5/8"		226-CL*	5 deg	0.078	1.359	0.875	1.437	5.75	0.97	P3
62	1 1/4"										
60	5/8"		227**	10 deg	0.078	1.359	0.875	1.437	5.75	0.87	P1
635	3 1/2"		384-CL***	2 deg	0.281	1.469	1.813	1.75	6.5	1.5	P8
A26	2 5/8"										
450	5"										

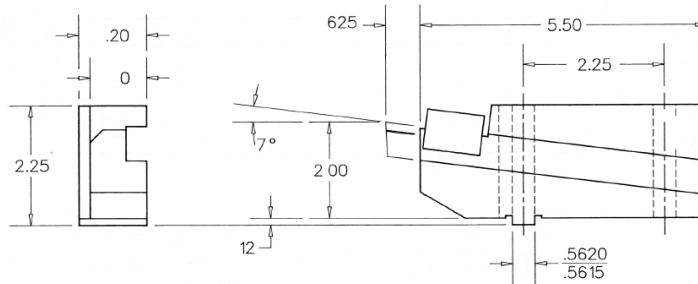
* Available in RH & LH CL

**Available in Luers Holder Only

***Available in RH and LH CL,

2017 Cut-Off Tooling

Wickman Holders



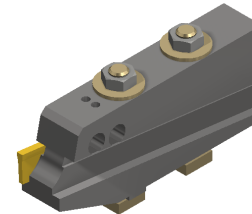
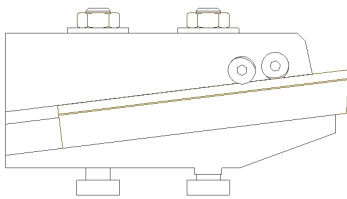
66 1-CL-LH HOLDER STANDARD AS SHOWN

Wickman Cut Off Holders					
Machine	Position	Holder	Post	Wedge	Blade
1"6	1,4 & 6	6611-CL-LH	N/R	N/R	P3
2 5/8"6	1,4 & 6	384-CL*	9LH	W2	P8
3 1/4"6	2,3 & 5		10RH		
3 1/2"4	1 & 3		9LH		
4 1/8"4	2 & 4		10RH		

* Available in RH and LH Luers & CL

Wickman Low Profile Reversible Holders

- Luers Style Low Profile Design allows for mounting extremely close to the spindle.
- Dual pocket design allows for mounting in various positions.

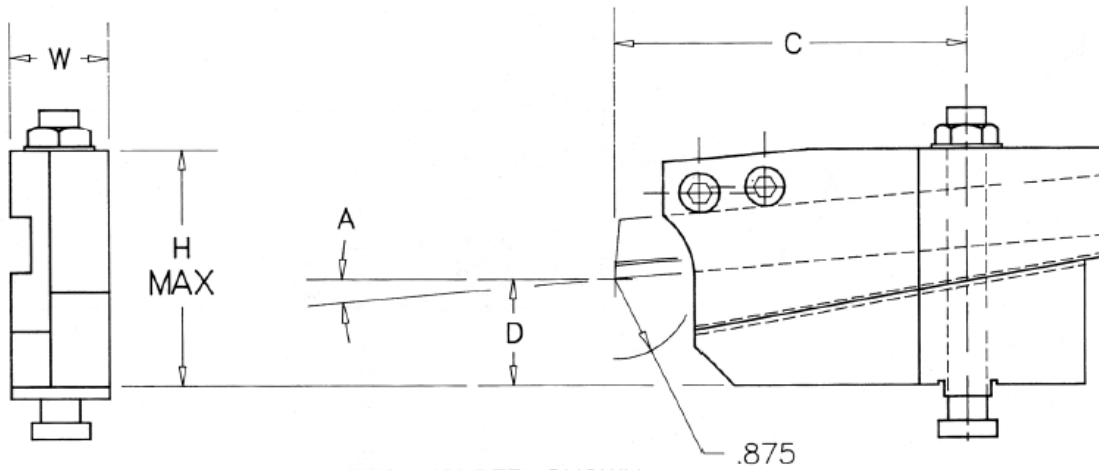


Wickman Luers Reversible Cutoff Holders		
Machine	Holder	Blade
FRAME 1	1213-LH-RH LUERS	P5
FRAME 2	1214-LH-RH LUERS	P5
FRAME 3	1216-LH-RH LUERS	P5

MADE IN USA

2017 Cut-Off Tooling

Traub Holders



707-A-LH LUERS HOLDER SHOWN

Traub Cut Off Holders

Machine	Position	Holder	A	C		D		H	W	Blade
				MIN	MAX	MIN	MAX			
A15	REAR SLIDE	701-A *	0 deg	0.285	0.326	0.85	0.92	1.87	0.968	P1
A20										
A25										
A36	REAR SLIDE	707-A **	5 deg	3.2	3.65	1.53	1.62	3.12	1.375	P3
A42										
A56										
A60										
TB42/42T										
TB60/60T										

* Available in LH Luers & LH CL

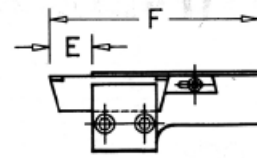
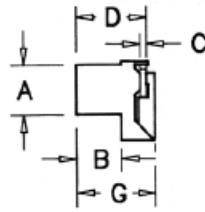
**Available in Luers LH only

MADE IN USA

2017 Cut-Off Tooling

NC/CNC Holders

Clamp Lock



LEFTHAND HOLDER SHOWN

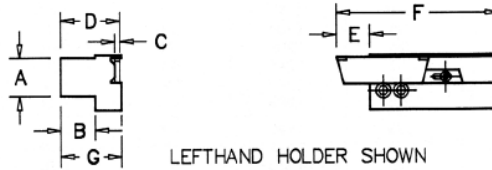
MADE IN USA

NC/CNC Holders - Clamp Lock (*RH available upon request)									
Holder	A	B	C	D	E	F	G	Clamp	Blade
NC-525-WL	0.628	0.674	0.062	1.027	0.47	3.46	1.3	25509-16	1716
			0.079	1.043	0.47	3.46		25509-20	1720
			0.118	1.083	0.71	3.7		25509-30	1730
			0.125	1.086	0.71	3.7		25509-30	1732
			0.158	1.122	0.94	3.93		25509-40	1740
NC-516-WL	0.75	0.847	0.062	1.186	0.47	4.05	1.46	25509-16	1216
			0.079	1.202	0.47	4.05		25512-20	1220
			0.118	1.241	0.71	4.29		25512-30	1230
			0.125	1.245	0.71	4.29		25512-30	1232
NC-515-WL	0.75	0.847	0.062	1.184	0.47	4.05	1.46	25509-16	1716
			0.079	1.2	0.47	4.05		25509-20	1720
			0.118	1.239	0.71	4.29		25509-30	1730
			0.125	1.243	0.71	4.29		25509-30	1732
			0.158	1.279	0.94	4.52		25509-40	1740
			0.187	1.308	1.18	4.76		25509-47	1747
NC-508-WL	1	1.098	0.062	1.358	0.47	4.05	1.67	25509-16	1716
			0.079	1.374	0.47	4.05		25509-20	1720
			0.118	1.413	0.71	4.29		25509-30	1730
			0.125	1.417	0.71	4.29		25509-30	1732
			0.158	1.453	0.94	4.52		25509-40	1740
			0.187	1.482	1.18	4.76		25509-47	1747
NC-510-WL	1	1.098	0.062	1.358	0.47	4.05	1.67	25509-16	1716
			0.079	1.374	0.47	4.05		25509-20	1720
			0.118	1.413	0.71	4.29		25509-30	1730
			0.125	1.417	0.71	4.29		25509-30	1732
			0.158	1.453	0.94	4.52		25509-40	1740
			0.187	1.482	1.18	4.76		25509-47	1747
NC-509-WL	1.25	1.028	0.062	1.381	0.47	4.05	1.65	25509-16	1716
			0.079	1.397	0.47	4.05		25509-20	1720
			0.118	1.436	0.71	4.29		25509-30	1730
			0.125	1.44	0.71	4.29		25509-30	1732
			0.158	1.476	0.94	4.52		25509-40	1740
			0.187	1.505	1.18	4.76		25509-47	1747
NC-511-WL *	1.25	1.028	0.062	1.381	0.47	4.05	1.65	25509-16	1716
			0.079	1.397	0.47	4.05		25509-20	1720
			0.118	1.436	0.71	4.29		25509-30	1730
			0.125	1.44	0.71	4.29		25509-30	1732
			0.158	1.476	0.94	4.52		25509-40	1740
			0.187	1.505	1.18	4.76		25509-47	1747
NC-524-WL *	1.25	1.26	0.062	1.381	0.47	4.05	1.65	25509-16	1716
			0.079	1.397	0.47	4.05		25509-20	1720
			0.118	1.436	0.71	4.29		25509-30	1730
			0.125	1.44	0.71	4.29		25509-30	1732
			0.158	1.476	0.94	4.52		25509-40	1740
			0.187	1.505	1.18	4.76		25509-47	1747

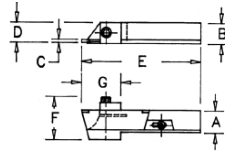
2017 Cut-Off Tooling

NC/CNC Holders

Cam Lock



NC/CNC Holders - Cam Lock									
Holder	A	B	C	D	E	F	G	Cam	Blade
NC-60-207-LH/RH	0.75	0.83	0.062	1.395	0.47	4.05	1.53	4014	1716
			0.079	1.411	0.47	4.05			1720
			0.118	1.451	0.71	4.29			1730
			0.125	1.454	0.71	4.29			1732
			0.158	1.490	0.94	4.52			1740
			0.187	1.520	1.18	4.76			1747
			0.197	1.529	1.18	4.76			1750
NC-60-208-LH	1	1.10	0.062	1.645	0.47	4.05	1.78	4013	1716
			0.079	1.661	0.47	4.05			1720
			0.118	1.701	0.71	4.29			1730
			0.125	1.704	0.71	4.29			1732
			0.158	1.740	0.94	4.52			1740
			0.187	1.770	1.18	4.76			1747
			0.197	1.779	1.18	4.76			1750



Pinch Lock

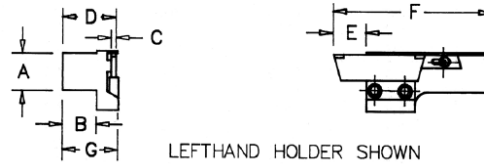
NC/CNC Holders - Pinch Lock (*RH available upon request)									
Holder	A	B	C	D	E	F	G	Screw	Blade
60-293-LH-NC	.312	.312	0.062	.246	3.131	.84	.78	FAS-442	716
			0.079	.262					720
			0.118	.302					730
			0.125	.305					732
			0.125	.305					732
60-276-LH-NC	.375	.375	0.062	.309	3.125	.88	.76	FAS-343	716
			0.079	.325					720
			0.118	.365					730
			0.125	.368					732
60-277-LH-NC	.500	.500	0.062	.434	5.437	1.22	1.43	FAS-406	1216
			0.079	.450					1220
			0.118	.490					1230
			0.125	.493					1232
60-278-LH-NC	.625	.625	0.062	.559	5.437	1.28	1.43	FAS-150	1216
			0.079	.575					1220
			0.118	.615					1230
			0.125	.618					1232
60-279-LH-NC	.75	.75	0.062	.605	5.437	1.56	1.43	FAS-150	1716
			0.079	.621					1720
			0.118	.660					1730
			0.125	.664					1732
			0.158	.700					1740
			0.187	.729					1747
			0.197	.739					1750
60-280-LH-NC	1.00	1.00	0.062	.855	5.437	1.56	1.43	FAS-443	1716
			0.079	.871					1720
			0.118	.910					1730
			0.125	.914					1732
			0.158	.950					1740
			0.187	.979					1747
			0.197	.989					1750

MADE IN USA

2017 Cut-Off Tooling

NC/CNC Holders

Wedge Lock



MADE IN USA

NC/CNC Holders - Wedge									
Holder	A	B	C	D	E	F	G	Clamp	Blade
70-104-LH-NC	0.375	0.49	0.062	1.04	0.47	2.97	1.1	37 WT	1216
			0.079	1.056					1220
			0.118	1.096	0.71	3.21			1230
			0.125	1.099					1232
70-107-LH-NC	0.5	0.6	0.062	1.149	0.47	3.47	1.23	63 WT	1716
			0.079	1.165					1720
			0.118	1.204	0.71	3.71			1730
			0.125	1.208					1732
			0.158	1.244	0.94	3.94			1740
			0.187	1.273					1.18
			0.197	1.283	1750				
70-080-LH-NC	0.625	0.72	0.079	1.29	0.47	3.46	1.35	63 WT	1720
			0.118	1.329					1730
			0.125	1.333	0.71	3.7			1732
60-210-LH-NC	0.75	0.85	0.079	1.431	0.47	4.05	1.48	37 WT	1720
			0.118	1.471					0.71
			0.125	1.474	1732				
60-212-LH-NC	0.75	0.85	0.079	1.415	0.47	4.05	1.48	63 WT	1720
			0.118	1.454					0.71
			0.125	1.458	1732				
60-211-LH-NC	1	1.1	0.079	1.665	0.47	4.05	1.73	63 WT	1720
			0.118	1.704					0.71
			0.125	1.708	1732				
70-147-LH-NC	1	1.1	0.118	1.954	0.71	5.71	2.05	63 WT	2830
			0.125	1.958					2832
			0.158	1.994	0.94	5.94			2840
			0.187	2.023					1.18

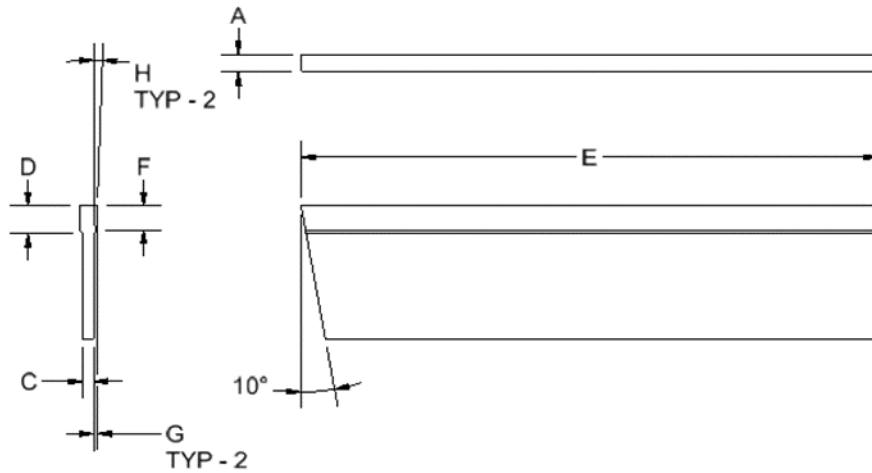
Holders designed to hold Twin-Tip tools and "T" Type Blades, specify blade when ordering

NOTE: P1, P3, P5 & P8 Series blades can be used in place of 12mm, 17mm, 22mm & 28mm Blades respectively

2017 Cut-Off Tooling

Solid Carbide Cut Off Blades

- Quality Grade Carbide
- Coating Available



Solid Carbide Parallel Cut Off Blades

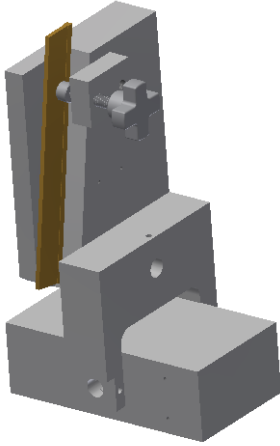
Blade No	A	B	C	D	E	F	G	H (DEG)	
P1N	.041/.039	.477/.475	.025/.027	0.092	4.50	.100/.090	.009/.005	1/5	
PM1	.065/.063		.038/.036	0.086			.015/.011	2/1	
P2N	.079/.077		.0095/.0055	0.091			.017/.013	3/2	
P2	.094/.092		.064/.062	0.085					
PM2	.099/.097		.019/.015	.090/.088			0.083	.016/.012	4/3
PM3S	.119/.117		.020/.016						
P3S	.126/.124	.677/.675	.025/.027	0.113	5.00	.128/.118	.009/.005	1/5	
PM3N-1.5	.060/.058		.048/.046	0.122			.008/.004		
MP3N-1.6	.065/.063		.010/.006	0.120			.009/.005	2/1	
PM3N-2	.079/.077		.064/.062	0.112					
P3N	.094/.092		.080/.078	0.120			.016/.012	3/2	
PM3N	.099/.097		.090/.088	0.111					
PM3	.119/.117		.020/.016	.100/.098			0.102	.030/.026	
P3	.126/.124								
P4	.157/.155								

Add suffix TiN to end of part # for TiN Coating

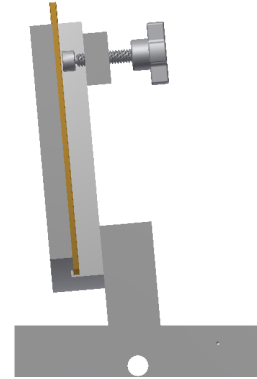
MADE IN USA

2017 Cut-Off Tooling

Blade Sharpening Fixture



Order # Sk-1614



Incorrect



MADE IN USA

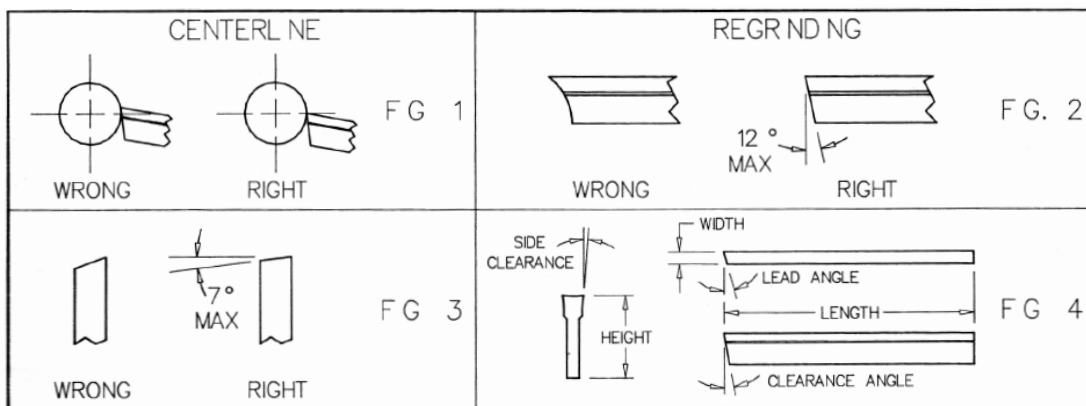
Advantages of a Blade Sharpening Fixture

- User Friendly, Easy to set-up and operate
- Consistent Lead / Clearance angles = Longer Tool Life
- Less Heat Damage = Longer Tool Life
- Compound Angles in one set-up
- All types of blades and sizes can be sharpened in house

2017 Cut-Off Tooling

Setup Troubleshooting

Setup / Cutoff Troubleshooting	
Problem	Cause
Rough Finish	Lack of Coolant, Misdirected Coolant
	Dull Tool
	Insufficient Side Clearance (fig 4)
	Worn Clamp or Tool Holder
	Tool Not on Center (fig 1)
	Excessive Feed Rate
	Spindle Speed (RPM) Low
Excessive Tool Wear	Lack of Coolant, Misdirected Coolant
	Insufficient Side Clearance (fig 4)
	Cut Off Blade Width to Narrow
	Spindle Speed (RPM) High
Tool Chipping	Tool Not on Center (fig 1)
	Front Lead Angle to Large (fig 3)
	Insufficient Cam Travel (rise)
	Worn Clamp or Tool Holder
Tool Breakage	Excessive Blade Extension
	Dull Tool
	Excessive Feed Rate
	Cut Off misaligned with Breakdown
	Worn Clamp or Tool Holder or Slide
	Insufficient Cam Travel (rise)
Chatter	Tool Not on Center - below (fig 1)
	Improper Front Clearance (fig 2)
	Excessive Blade Extension
	Worn Clamp or Tool Holder
	Machine Spindle Bearings Loose/Worn
Part Length Variation	Worn Clamp or Tool Holder or Slide
	Cut Off Blade Width to Narrow
	Machine Spindle Bearings Loose/Worn
	Dull Tool
	Excessive Feed Rate
Front Lead Angle to Large (fig 3)	



MADE IN USA