

Standard Tooling For Haas Lathes



- Our printed catalogs and fliers are also available for download from the EWS website.

www.ews-tools.de

Motion, speed, precision – this is the world of EWS. We call it “Precision meets Motion”, because we are aware of the importance of precision for the future of our customers and target markets.

Our focus is on highest quality standards and utmost commitment to ensure an optimal design of our products in form and function. For this purpose, we systematically invest in state-of-the-art production lines and develop methods for quality assurance in cooperation with external institutions.

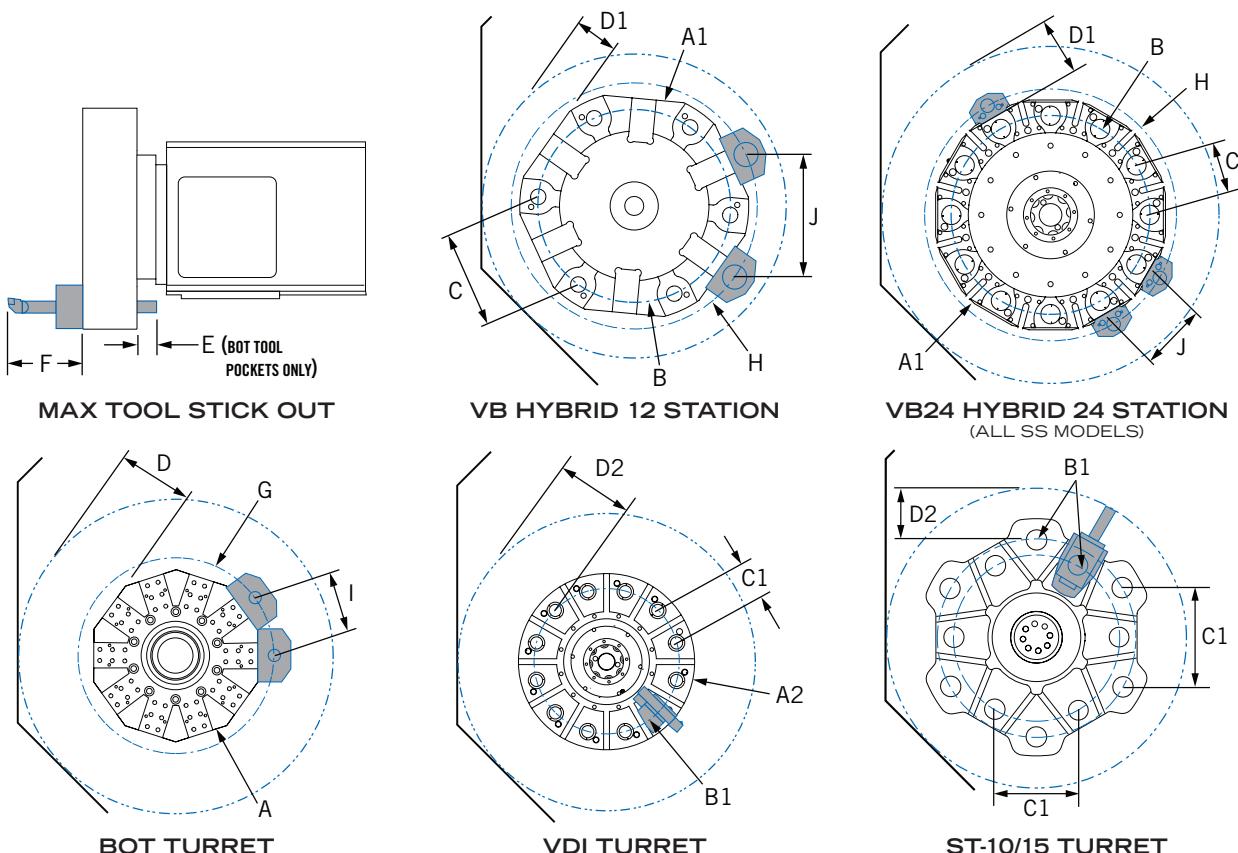
Our top performance in development and production is backed up by the high level of training of our staff members.

Competence and reliability in our advisory services, our daily communication and project management – these are the core elements convincing our customers of our performance and services over and over again.

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Haas Lathe Turret Specifications



Description		ST-20 ST-20Y	ST-30 ST-30Y	ST-20SS ST-20SSY	DS-30 DS-30Y	ST-30SS, ST-30SSY DS-30SS, DS-30SSY	SL-40 ST-40
A	BOT TURRET OD DIAMETER (FLATS)	410 mm	410 mm	—	—	—	566 mm
A1	VB12/24 TURRET OD DIAMETER (FLATS)	481 mm	481 mm	545 mm	481 mm	538 mm	566 mm
A2	VDI TURRET OD TURRET DIAMETER	483 mm	483 mm	—	—	—	603 mm
B	VB12/24 TURRET VDI40 POCKET CIRCLE	397 mm	397 mm	464 mm	397 mm	464 mm	508 mm
B1	VDI TURRET VDI40 POCKET CIRCLE	397 mm	397 mm	—	397 mm	—	508 mm
C	VB12/24 TURRET VDI40 POCKET SPACING	198 mm	198 mm	119 mm	198 mm	119 mm	254 mm
C1	VDI TURRET VDI40 POCKET SPACING	103 mm	103 mm	—	—	—	131 mm
D	BOT TURRET FROM FLATS TC CLEARANCE	175 mm	203 mm	—	—	—	229 mm
D1	VB12/24 TURRET FROM FLATS TC CLEARANCE	140 mm	174 mm	114 mm	174 mm	149 mm	229 mm
D1	VB12/24 TURRET FROM VDI40 CENTER TC CLEARANCE	178 mm	212 mm	152 mm	212 mm	187 mm	254 mm
D2	VDI TURRET FROM VDI40 CENTER TC CLEARANCE	178 mm	212 mm	—	—	—	254 mm
E	BOT TURRET BOLT-ON TOOL MAX REAR STICK-OUT	102 mm	102 mm	—	—	—	111 mm
E	VB12/24 TURRET BOLT-ON TOOL MAX REAR STICK-OUT	102 mm	102 mm	102 mm	102 mm	102 mm	111 mm
E	VDI TURRET VDI40 POCKET MAX TOOL REAR STICK-OUT	10.2 mm	10.2 mm	10.2 mm	10.2 mm	10.2 mm	10.2 mm
F	**REC. MAX TOOL STICK-OUT FROM FACE OF TURRET AT FULL Z TRAVEL	127 mm	127 mm	127 mm	127 mm	152 mm	***
G	BOT TURRET ID TOOL POCKET DIAMETER	474 mm	—	—	—	—	646 mm
H	VB12/24 TURRET ID TOOL POCKET DIAMETER	545 mm	545 mm	589 mm	545 mm	589 mm	646 mm
I	BOT TURRET ID TOOL POCKET SPACING	122 mm	—	—	—	—	168 mm
J	VB12/24 TURRET ID TOOL POCKET SPACING	272 mm	272 mm	152 mm	272 mm	152 mm	324 mm

**EXCEEDING THIS STICK-OUT MAY RESULT IN COLLISION WITH THE FRONT BULKHEAD
***A 25° (635 mm) DEEP POCKET IN THE ST-40 PROVIDES CLEARANCE FOR BORING BARS AND LONG TOOLS.

TURRET OPTIONS FOR HAAS LATHE MACHINES

TURRET TYPE AND MACHINE

BOT

BOT TURRET

12 Station bolt-on tool turret for turning tools and boring bars. The BOT turret accepts tools around the perimeter, with radial slots for mounting turning tools in the left or right hand direction.



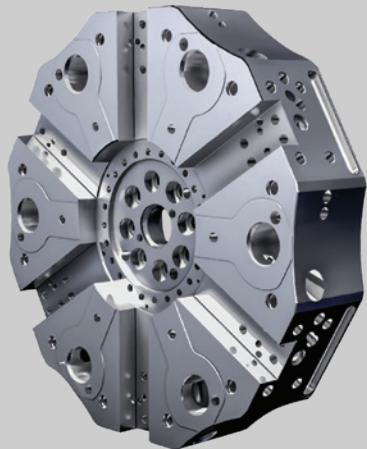
STANDARD TURRET ON

- + ST-30
- + ST-35
- + ST-40
- + ST-45
- + ST-50
- + ST-55

VB HYBRID

12 STATION HYBRID

12 Station hybrid turret for VDI40 tools, live tools and standard bolt-on tools. The VB Hybrid has 6 VDI stations and 6 bolt-on stations; radial slots for turning tools and perimeter stations for id tools.



OPTIONAL TURRET ON

- + ST-40
- + ST-45

FULL RANGE OF TOOLS FOR BOT, VB HYBRID, VB24, AND BMT65

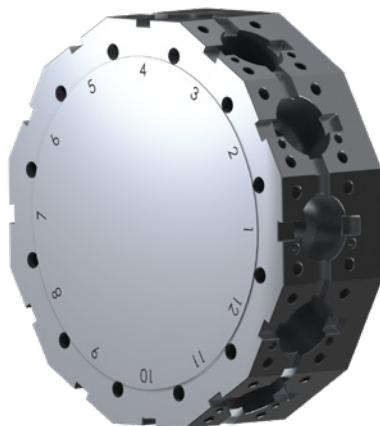
Haas ST/DS series turning center turrets are finish-machined as a complete unit. Keying off the turret's centerline, all critical features of each station are machined using single-axis moves, then the turret is indexed to the next station - ensuring the absolute concentricity of each station with the turret's true center. This reduces positioning variation from tool to tool by more than 90%. The results are easier job set up, higher accuracy, and better repeatability.



On-The-Fly Indexing - This standard feature allows tool changes on the fly as the axes retract from the part. Combined with high-speed rapid movements, this results in faster tool changes and shorter cycle times by reducing non-cutting time.



BMT65



12 STATION BMT65

The 12 Station base mount tooling turret accepts bolt-on tools and live tools.

Standard Turret On

- + ST-20Y
- + ST-25Y
- + ST-30Y
- + ST-35Y
- + DS-30Y

Optional Turret On

- + ST-20
- + ST-25
- + ST-30
- + ST-35

VDI



12 STATION VDI

12 Station VDI Turret accepts standard VDI40 tools, including axial and radial live tools.

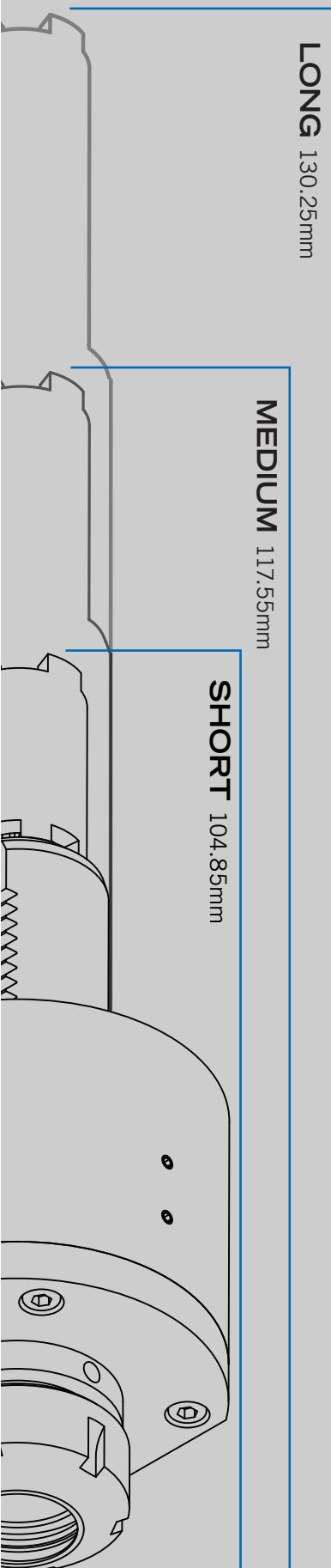
Standard Turret On

- + ST-20
- + ST-25

Optional Turret On

- + ST-30
- + ST-35

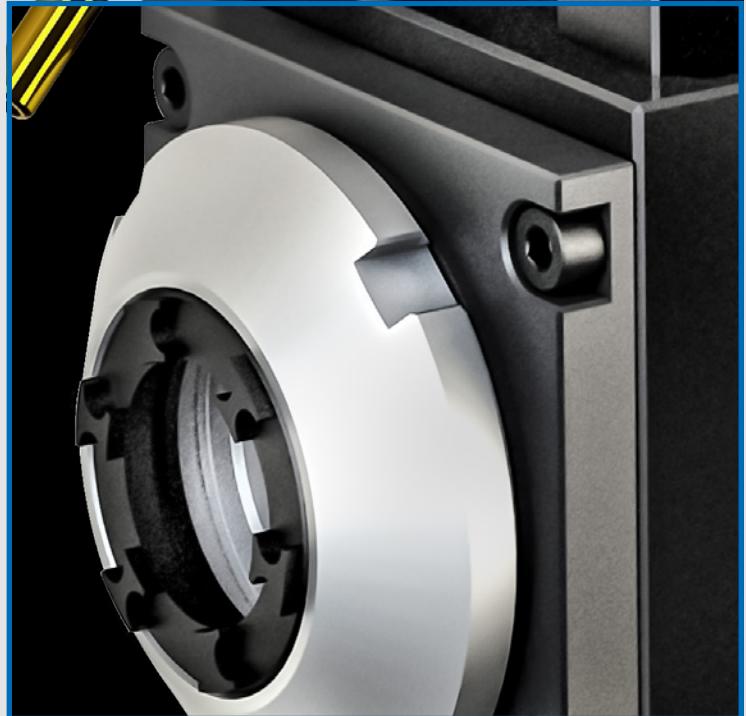
LIVE TOOL TURRET OPTIONS FOR HAAS LATHE MACHINES



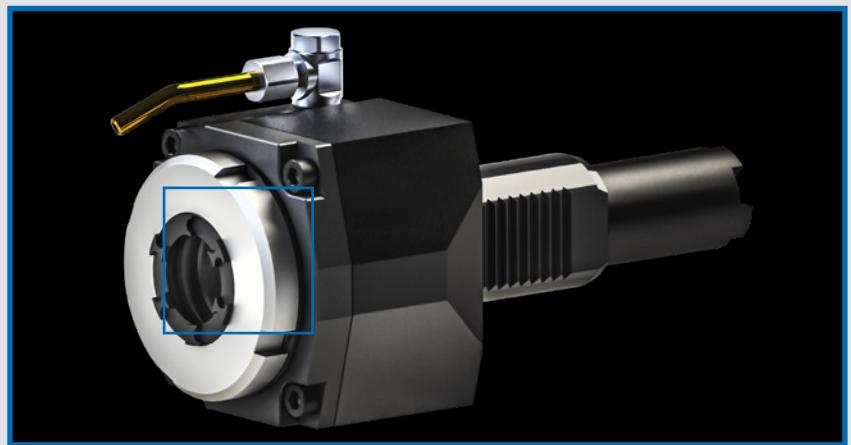
TURRET TYPE LIVE TOOL COUPLING LENGTH AND MACHINE

SHORT COUPLING LENGTH	105mm	+ SL-20 + SL-30
MEDIUM COUPLING LENGTH	118mm	+ ST-20 + ST-20Y + ST-25 + ST-25Y + ST-30 + ST-30Y + ST-35 + ST-35Y
MEDIUM COUPLING LENGTH	118mm	+ ST-20 + ST-20Y + ST-25 + ST-25Y + ST-30 + ST-30Y + ST-35 + ST-35Y + DS-30 + DS-30Y
LONG COUPLING LENGTH	130mm	+ ST-40 + ST-40L

AXIAL AND RADIAL LIVE TOOL FEATURES



Oversized flange is integral to the spindle, providing debris protection for the front seal and bearings.

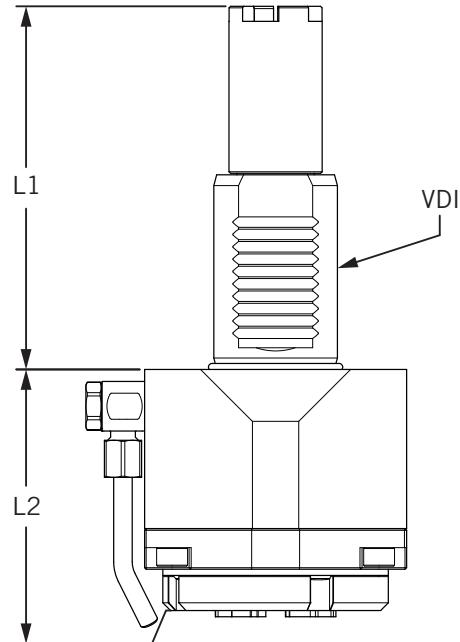
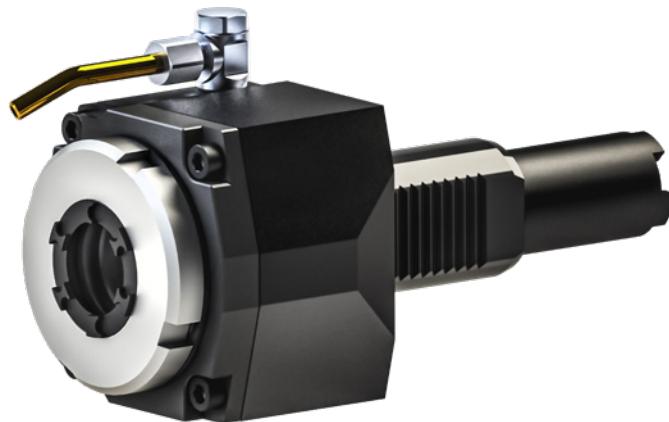


Collet pocket run-out is certified less than 0.005 mm—industry leading precision.

Axial Live Tool

Axial

- Axial live tools for VDI & VB Hybrid Turrets. Short, medium and long coupling lengths available.



ER32 Axial - MM	Part No.	Coupling Length	L1	L2	VDI	Collet Nut Type
	40.4032HAASSL20IM	SHORT	104.85mm	78 mm	40	Internal
	40.4032HAASSL20	SHORT	104.85mm	112 mm	40	External
	40.4032HAASSL40IM	MEDIUM	117.55mm	78 mm	40	Internal
	40.4032HAASSL40	MEDIUM	117.55mm	112 mm	40	External
	40.4032HAASSL40HIM	LONG	130.25mm	78 mm	40	Internal
	40.4032HAASSL40H	LONG	130.25mm	112 mm	40	External

- + Coolant Option: External Coolant
- + Uses standard ER32 collets
- + 1:1 drive ratio
- + 8,000 max RPM
- + Run-out ≤ 0.005 mm

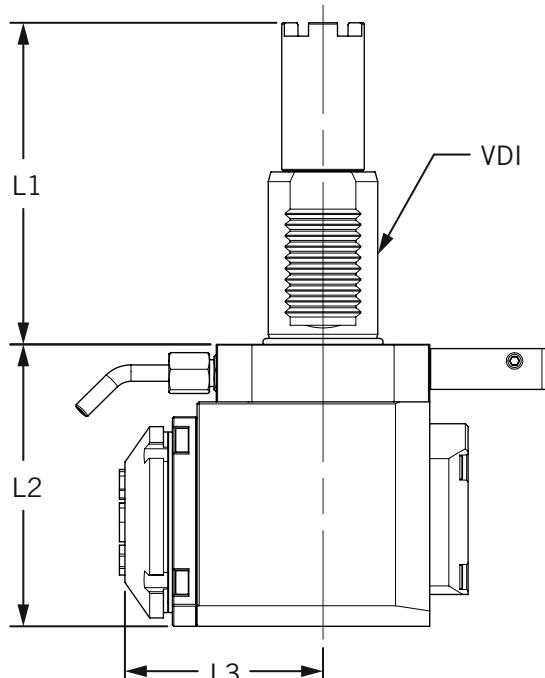
ACCESSORIES

COLLETS & ACCESSORIES 8	COOLANT KIT 8	COOLANT PIPE 8

Radial Live Tool

Radial

- Radial live tools for VDI & VB Hybrid Turrets. Short, medium and long coupling lengths available.



ER32 Radial - MM	Part No.	Coupling Length	L1	L2	L3	VDI	Collet Nut Type
	60.4032HAASSL20LIM	SHORT	104.85 mm	103 mm	72 mm	40	Internal
	60.4032HAASSL20L	SHORT	104.85 mm	103 mm	84 mm	40	External
	60.4032HAASSL40LIM	MEDIUM	117.55 mm	103 mm	72 mm	40	Internal
	60.4032HAASSL40L	MEDIUM	117.55 mm	103 mm	84 mm	40	External
	60.4032HAASSL40LGL	MEDIUM	117.55 mm	103 mm	84 mm	40	External
	60.4032HAASSL40HLIM	LONG	130.25 mm	103 mm	72 mm	40	Internal
	60.4032HAASSL40HL	LONG	130.25 mm	103 mm	84 mm	40	External

- + Coolant Option: External Coolant
- + Uses standard ER32 collets
- + 1:1 drive ratio
- + 8,000 max RPM
- + Run-out ≤ 0.005 mm

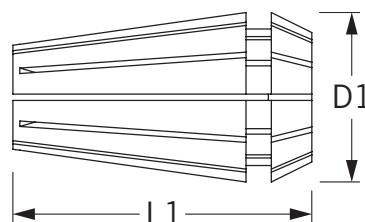
ACCESSORIES

COLLETS & ACCESSORIES	COOLANT KIT	COOLANT PIPE
8	8	8

Live Tool Accessories

Accessories

- Collet nut wrenches come with a drive square to adapt to torque wrench.



Part Number	L1	D1
320 470E-Ø 03	40	33
320 470E-Ø 04	40	33
320 470E-Ø 05	40	33
320 470E-Ø 06	40	33
320 470E-Ø 07	40	33
320 470E-Ø 08	40	33
320 470E-Ø 09	40	33
320 470E-Ø 10	40	33
320 470E-Ø 11	40	33
320 470E-Ø 12	40	33
320 470E-Ø 13	40	33
320 470E-Ø 14	40	33
320 470E-Ø 15	40	33
320 470E-Ø 16	40	33
320 470E-Ø 17	40	33
320 470E-Ø 18	40	33
320 470E-Ø 19	40	33
320 470E-Ø 20	40	33

► Live Tool Wrench/Collet Nut

WRENCH FOR INTERNAL NUT
(AXIAL & RADIAL)



Part No:
DIN1810 A-68X75

INTERNAL
COLLET NUT



Part No:
E 32 A K

WRENCH FOR EXTERNAL NUT
(AXIAL & RADIAL)



Part No:
DIN1810 B-58X62

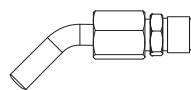
EXTERNAL
COLLET NUT



Part No:
XCCW-D032

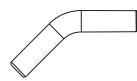
Part No:
XGSN-0032

► Coolant Nozzle Kits

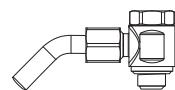


Kit Part No. **EWS-10315**

Included Coolant Pipe:

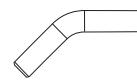


Pipe Part No. **EWS-10224**

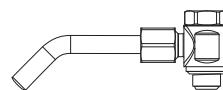


Kit Part No. **EWS-10223**

Included Coolant Pipe:

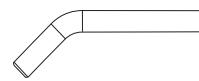


Pipe Part No. **EWS-10224**

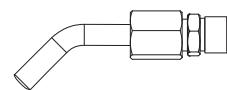


Kit Part No. **EWS-10316**

Included Coolant Pipe:

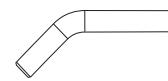


Pipe Part No. **EWS-10314**



Kit Part No. **EWS-10108**

Included Coolant Pipe:



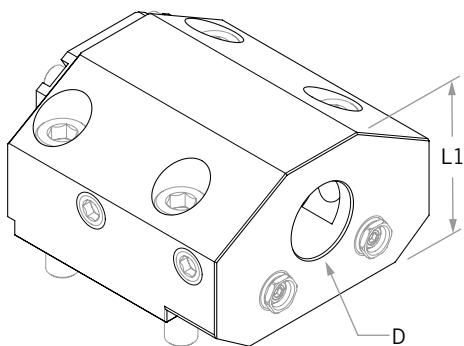
Pipe Part No. **EWS-10107**

All Coolant Pipes are 6mm in diameter and may be ordered separately from the coolant kit

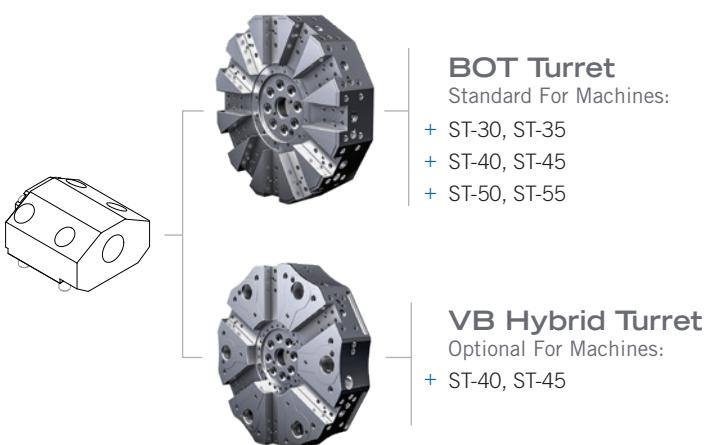
BOT or VB Hybrid Turret

Boring Bar Holder

- ▶ Bolt-On Boring Bar Holder for **BOT** or **VB Hybrid** 12 Station Turrets. See tool/turret diagram below for compatible machines.



Boring Bar - MM	Part No.	D	L1	Mfr. Part No. Equivalent
	19.BMT25HAASV12	25 mm	65 mm	BOT20MID-25
	19.BMT32HAASV12	32 mm	65 mm	BOT20MID-32
	19.BMT40HAASV12	40 mm	65 mm	BOT20MID-40
	19.BMT50HAASV12	50 mm	65 mm	BOT20MID-50

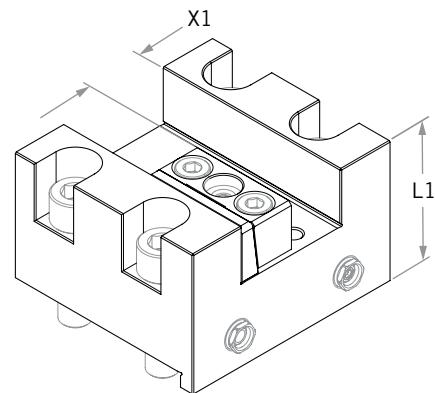
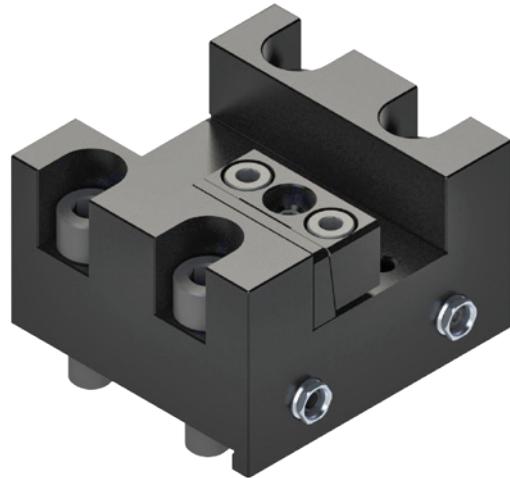


- + Coolant Option: Internal Coolant

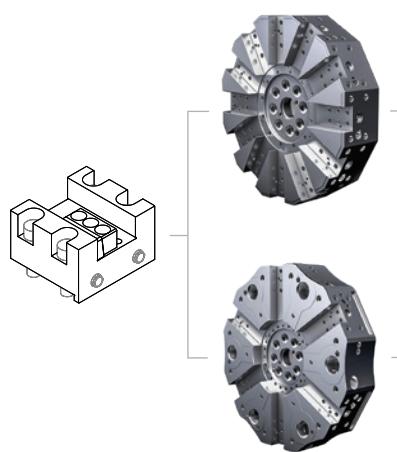
BOT or VB Hybrid Turret

Face Grooving

- ▶ Bolt-On Face Grooving Holder for **BOT** or **VB Hybrid** 12 Station Turrets. See tool/turret diagram below for compatible machines.



Face Grooving - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	5.BMT25HAASV12	25 mm	56 mm	BOT20MFG-25



BOT Turret

Standard For Machines:

- + ST-30, ST-35
- + ST-40, ST-45
- + ST-50, ST-55

VB Hybrid Turret

Optional For Machines:

- + ST-40, ST-45

ACCESSORIES

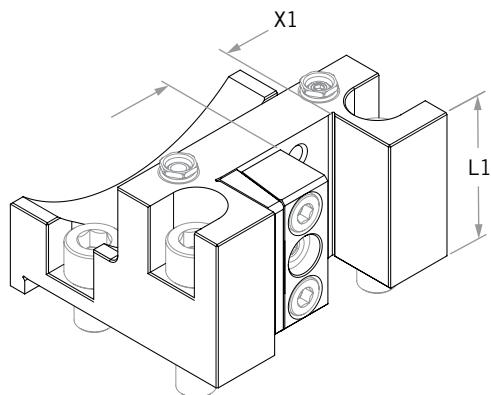
WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

- + Coolant Option: Internal Coolant

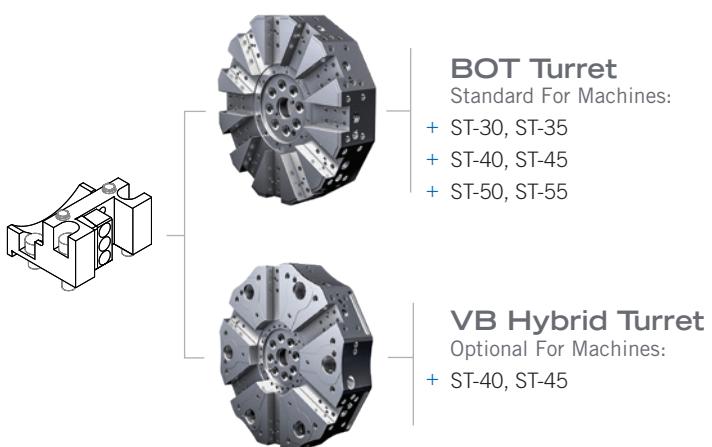
BOT or VB Hybrid Turret

Parting Tool

- ▶ Bolt-On Parting Toolholder for **BOT** or **VB Hybrid** 12 Station Turrets. See tool/turret diagram below for compatible machines.



Parting Tool - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	4.BMT25HAASV12X54.6	25 mm	55 mm	BOT20MOD-25



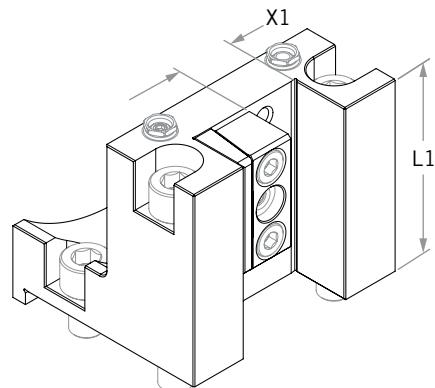
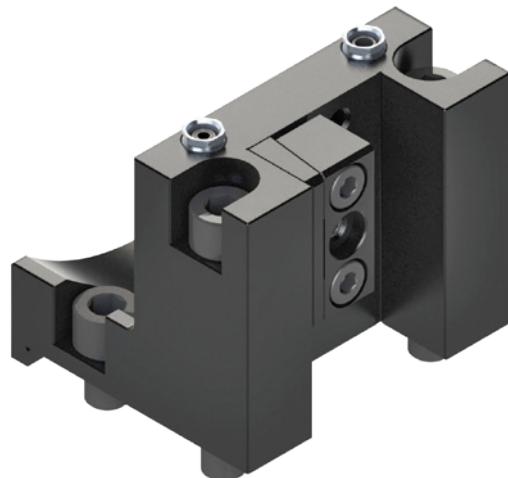
ACCESSORIES		
WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

- + Coolant Option: Internal Coolant

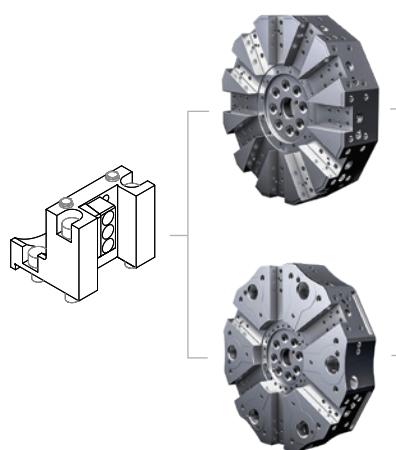
BOT or VB Hybrid Turret

Extended Parting Tool

- ▶ Bolt-On Extended Parting Toolholder for **BOT** or **VB Hybrid** 12 Station See tool/turret diagram below for compatible machines.



Extended Parting Tool - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	4.BMT25HAASV12X83.2	25 mm	84 mm	BOT20EXTMOD-25



BOT Turret

Standard For Machines:

- + ST-30, ST-35
- + ST-40, ST-45
- + ST-50, ST-55

VB Hybrid Turret

Optional For Machines:

- + ST-40, ST-45

ACCESSORIES

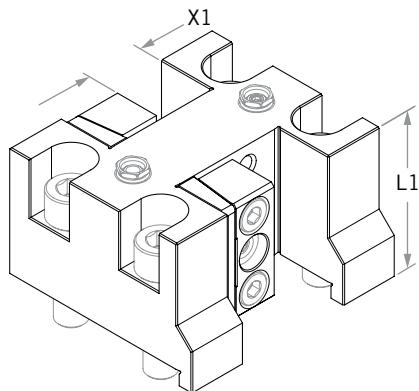
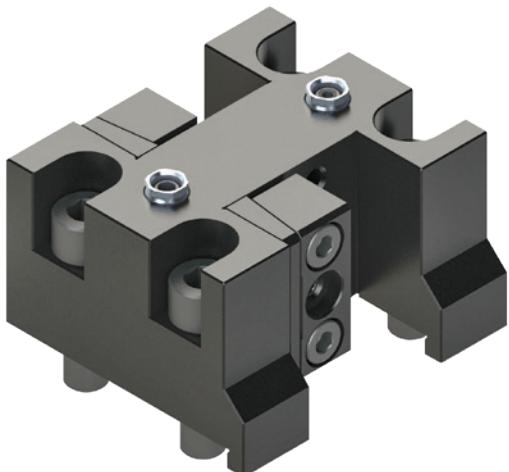
WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

- + Coolant Option: Internal Coolant

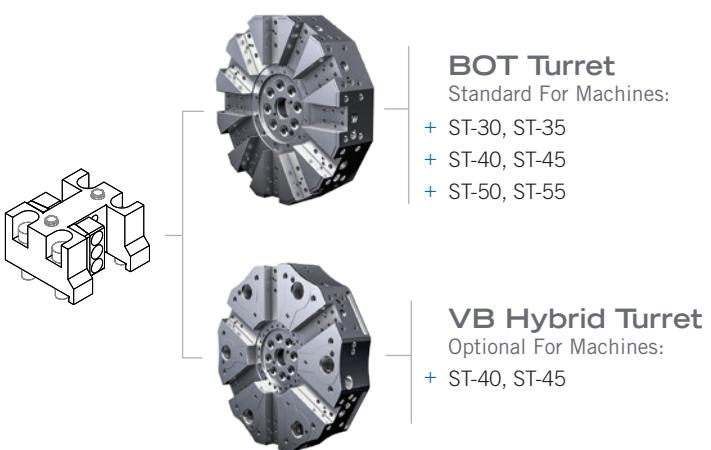
BOT or VB Hybrid Turret

Twin Turn

- ▶ Bolt-On Twin Turn Holder for **BOT** or **VB Hybrid** 12 Station Turrets. See tool/turret diagram below for compatible machines.



Twin Turn - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	15.BMT25HAASV12X54.6	25 mm	55 mm	BOT20MOD-25T



BOT Turret

Standard For Machines:

- + ST-30, ST-35
- + ST-40, ST-45
- + ST-50, ST-55

VB Hybrid Turret

Optional For Machines:

- + ST-40, ST-45

ACCESSORIES

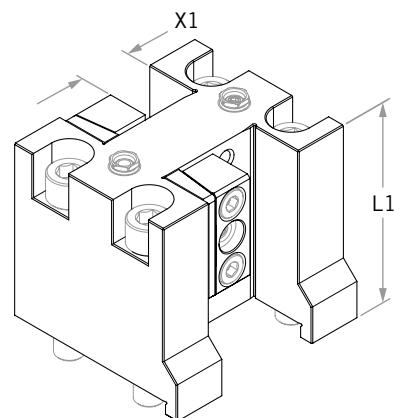
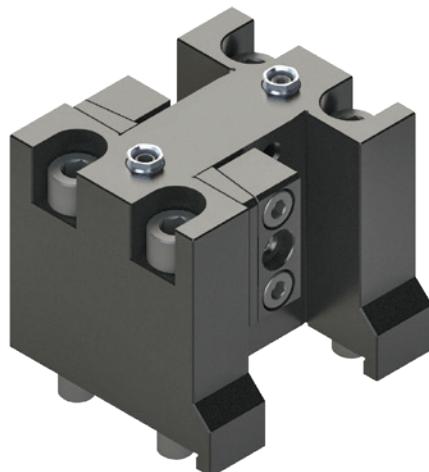
WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

- + Coolant Option: Internal Coolant

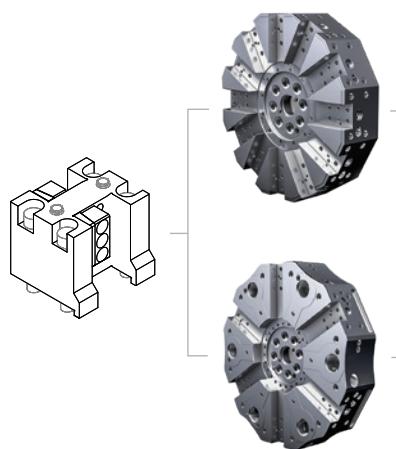
BOT or VB Hybrid Turret

Extended Twin Turn

- ▶ Bolt-On Extended Twin Turn Holder for **BOT** or **VB Hybrid** 12 Station Turrets. See tool/turret diagram below for compatible machines.



Extended Twin Turn - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	15.BMT25HAASV12X83.2	25 mm	84 mm	BOT20EXTMOD-25T



BOT Turret

Standard For Machines:

- + ST-30, ST-35
- + ST-40, ST-45
- + ST-50, ST-55

VB Hybrid Turret

Optional For Machines:

- + ST-40, ST-45

ACCESSORIES

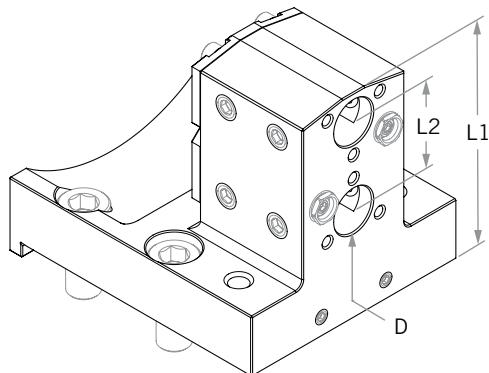
WEDGE CLAMPS	COOLANT NOZZLE	COOLANT PIPE
19	19	19

- + Coolant Option: Internal Coolant

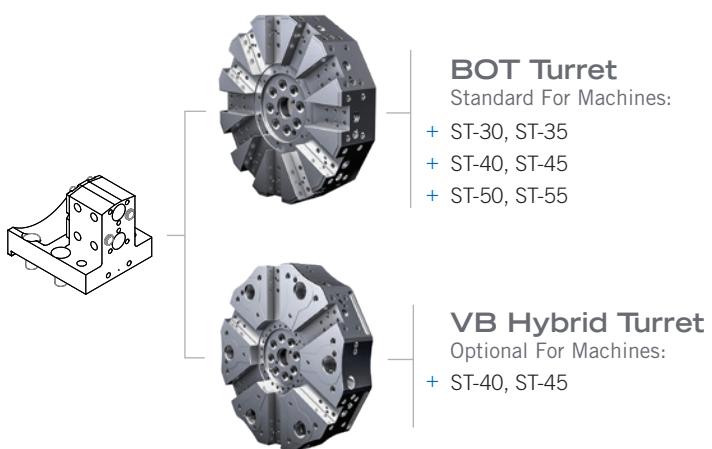
BOT or VB Hybrid Turret

Twin Bore

- Bolt-On Twin Bore Holder for **BOT** or **VB Hybrid** 12 Station Turrets. See tool/turret diagram below for compatible machines.



Twin Bore - MM	Part No.	D	L1	L2	Mfr. Part No. Equivalent
	19.BMT20HAASV12X45.72X83.82	20 mm	96.50 mm	38.10 mm	BOT20MID-20T



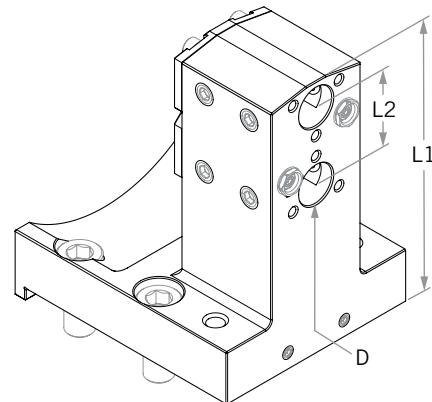
ACCESSORIES		
REDUCTION SLEEVES 18	COOLANT NOZZLE 19	COOLANT PIPE 19

- + Coolant Option: Internal Coolant

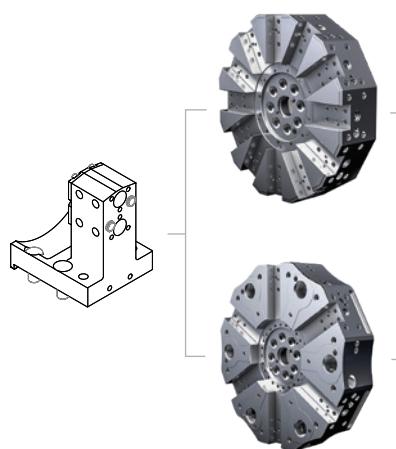
BOT or VB Hybrid Turret

Extended Twin Bore

- ▶ Bolt-On Extended Twin Bore Holder for **BOT** or **VB Hybrid** 12 Station Turrets. See tool/turret diagram below for compatible machines.



Extended Twin Bore - MM	Part No.	D	L1	L2	Mfr. Part No. Equivalent
	19.BMT20HAASV12X82.55X120.65	20 mm	133.40 mm	38.10 mm	BOT20EXTMID-20T



BOT Turret

Standard For Machines:

- + ST-30, ST-35
- + ST-40, ST-45
- + ST-50, ST-55

VB Hybrid Turret

Optional For Machines:

- + ST-40, ST-45

ACCESSORIES

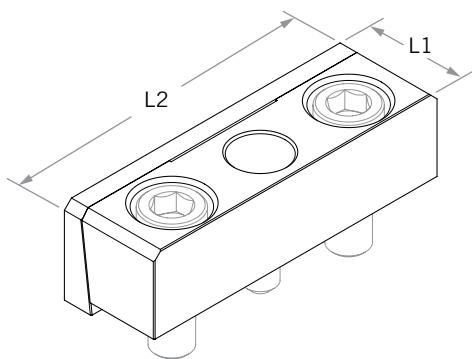
REDUCTION SLEEVES 28	COOLANT NOZZLE 29	COOLANT PIPE 29
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- + Coolant Option: Internal Coolant

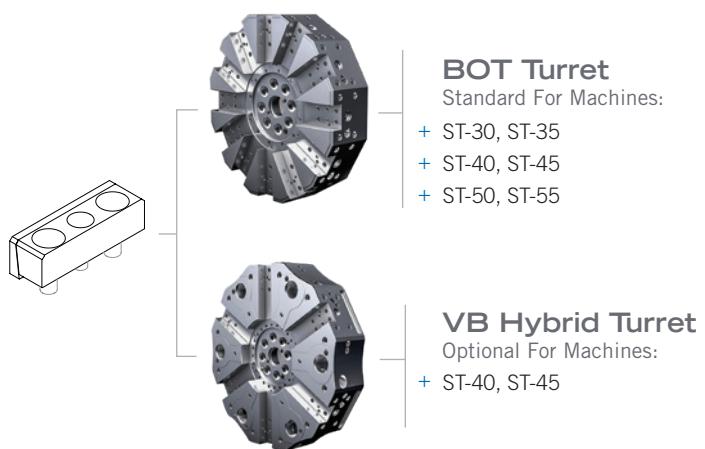
BOT or VB Hybrid Turret

Turret Wedge Clamp

- Wedge Clamp for **BOT** or **VB Hybrid** 12 Station Turret. See Page 29 for Bolt-On **Tool** Wedge Clamp. Also available to order separately.



Turret Wedge Clamp - MM	Part No.	L1 (min)	L2	Mfr. Part No. Equivalent
	EWS-10492	25 mm	80 mm	



BOT Turret

Standard For Machines:
+ ST-30, ST-35
+ ST-40, ST-45
+ ST-50, ST-55

VB Hybrid Turret

Optional For Machines:
+ ST-40, ST-45

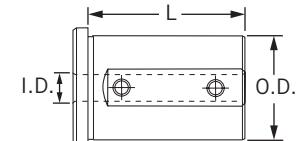
BOT / VB Hybrid/ BMT65 Accessories

Reduction Sleeves

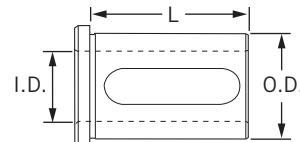
- ▶ Reduction Sleeves for BOT, VB Hybrid 12 Station, or BMT65 Turret Tools. 2 styles are available: Set Screw for smaller bores and Slotted for larger bores.

Part Number	O.D.	I.D.	L	Slotted	Set Screw
28.19.0506.35S	19.05 mm	06.35 mm	31.75 mm		*
28.19.0507.94S	19.05 mm	07.94 mm	31.75 mm		*
28.19.0506.35SL	19.05 mm	06.35 mm	50.80 mm		*
28.19.0507.94SL	19.05 mm	07.94 mm	50.80 mm		*
28.25.4006.35S	25.40 mm	06.35 mm	44.45 mm		*
28.25.4007.94S	25.40 mm	07.94 mm	44.45 mm		*
28.25.4009.53S	25.40 mm	09.53 mm	44.45 mm		*
28.25.4012.70S	25.40 mm	12.70 mm	44.45 mm		*
28.25.4015.88S	25.40 mm	15.88 mm	44.45 mm	*	
28.25.4019.05S	25.40 mm	19.05 mm	44.45 mm	*	
28.25.4006.35SL	25.40 mm	06.35 mm	69.85 mm		*
28.25.4007.94SL	25.40 mm	07.94 mm	69.85 mm		*
28.25.4009.53SL	25.40 mm	09.53 mm	69.85 mm		*
28.25.4012.70SL	25.40 mm	12.70 mm	69.85 mm		*
28.25.4015.88SL	25.40 mm	15.88 mm	69.85 mm	*	
28.25.4019.05SL	25.40 mm	19.05 mm	69.85 mm	*	
28.31.7507.94S	31.75 mm	07.94 mm	53.98 mm		*
28.31.7509.53S	31.75 mm	09.53 mm	53.98 mm		*
28.31.7512.70S	31.75 mm	12.70 mm	53.98 mm		*
28.31.7515.88S	31.75 mm	15.88 mm	53.98 mm	*	
28.31.7519.05S	31.75 mm	19.05 mm	53.98 mm	*	
28.31.7525.40S	31.75 mm	25.40 mm	53.98 mm	*	
28.31.7507.94SL	31.75 mm	07.94 mm	82.55 mm		*
28.31.7509.53SL	31.75 mm	09.53 mm	82.55 mm		*
28.31.7512.70SL	31.75 mm	12.70 mm	82.55 mm		*
28.31.7515.88SL	31.75 mm	15.88 mm	82.55 mm	*	
28.31.7519.05SL	31.75 mm	19.05 mm	82.55 mm	*	
28.31.7525.40SL	31.75 mm	25.40 mm	82.55 mm	*	
28.38.1007.94S	38.10 mm	07.94 mm	63.50 mm		*
28.38.1009.53S	38.10 mm	09.53 mm	63.50 mm		*
28.38.1012.70S	38.10 mm	12.70 mm	63.50 mm		*
28.38.1015.88S	38.10 mm	15.88 mm	63.50 mm	*	
28.38.1019.05S	38.10 mm	19.05 mm	63.50 mm	*	
28.38.1025.40S	38.10 mm	25.40 mm	63.50 mm	*	
28.38.1031.75S	38.10 mm	31.75 mm	63.50 mm	*	
28.50.8009.53S	50.80 mm	09.53 mm	76.20 mm		*
28.50.8012.70S	50.80 mm	12.70 mm	76.20 mm		*
28.50.8015.88S	50.80 mm	15.88 mm	76.20 mm	*	
28.50.8019.05S	50.80 mm	19.05 mm	76.20 mm	*	
28.50.8025.40S	50.80 mm	25.40 mm	76.20 mm	*	
28.50.8031.75S	50.80 mm	31.75 mm	76.20 mm	*	
28.50.8038.10S	50.80 mm	38.10 mm	76.20 mm	*	
28.50.8044.45S	50.80 mm	44.45 mm	76.20 mm	*	

SET SCREW REDUCTION SLEEVE



SLOTTED REDUCTION SLEEVE

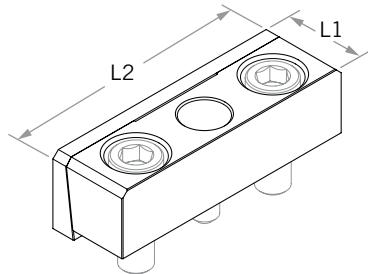


- + Inside of flange face is ground to ensure full contact to tool block
- + Made from 8620 steel
- + All bushings are case hardened
- + I.D. and O.D. are precision ground to H6 tolerance
- + Laser marked for easy identification

BOT / VB Hybrid/ BMT65 Accessories

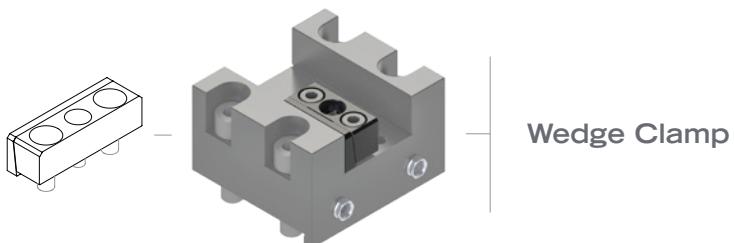
Bolt-On Tool Wedge Clamp

- Wedge Clamp for **BOT** or **VB Hybrid** 12 Station Turret Bolt-On Tools. Included with all bolt-on tools requiring tool wedge clamp. Also available to order separately.



Wedge Clamp - MM	Part No.	L1 (min)	L2	Mfr. Part No. Equivalent
	EWS-10491	25 mm	50 mm	

SEE PG 17 FOR TURRET WEDGE CLAMP



- Wedge Clamp for **BMT65** 12 Station Turret Bolt-On Tools. Included with all bolt-on tools requiring tool wedge clamp. Also available to order separately.

Wedge Clamp - MM	Part No.	L1 (min)	L2	Mfr. Part No. Equivalent
	EWS-11288	25 mm	60 mm	

► Coolant Nozzle

Part No. **EWS-10384**

 Coolant Nozzle for Bolt-On Tools. Threaded coolant ball to accommodate copper coolant pipes. Available to order separately.

► Coolant Pipe

Part No. **KV6 50X1XM6**

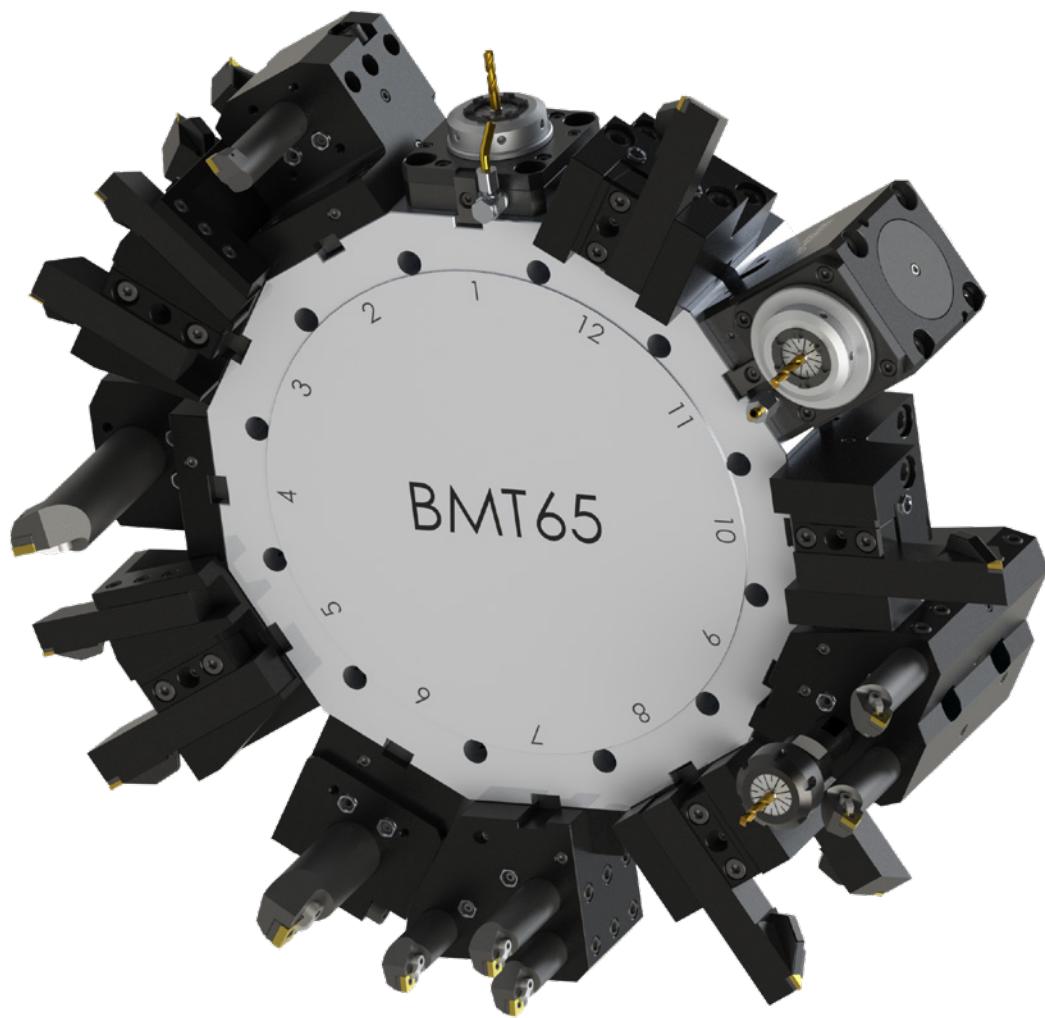


Copper Coolant Pipe for Bolt-On Tool Coolant Nozzles. Available to order separately.

BMT65 Turret

BMT65 Turret Tools

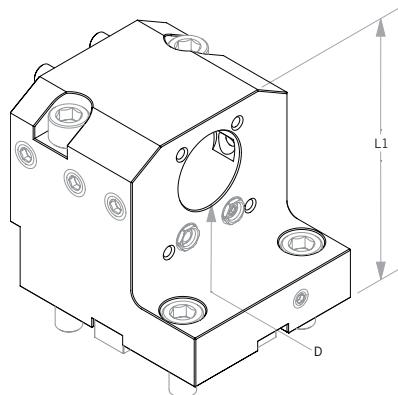
- ▶ Introducing Command's new line of BMT65 Static and Live Tools
- ▶ Our 15° half-index tools can increase your turret tooling capacity



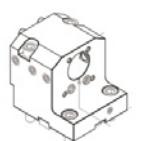
BMT65 Turret

Boring Bar Holder

- ▶ Bolt-On Boring Bar Holder for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



Boring Bar - MM	Part No.	D	L1	Mfr. Part No. Equivalent
	19.BMT25HAAS65Z15	25 mm	100 mm	BMT65MID-25
	19.BMT40HAAS65Z15	40 mm	100 mm	BMT65MID-40



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

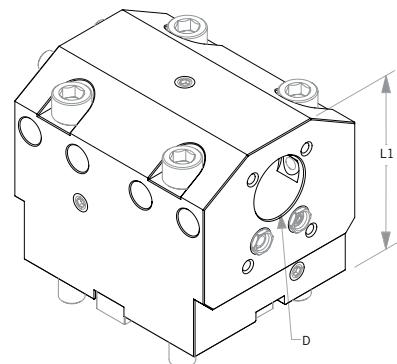
ACCESSORIES

REDUCTION SLEEVES	COOLANT NOZZLE	COOLANT PIPE
18	19	19

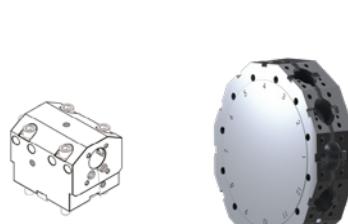
BMT65 Turret

Twin Boring Bar Holder

- ▶ Bolt-On Twin Boring Bar Holder for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



Twin Boring Bar - MM	Part No.	D	L1	Mfr. Part No. Equivalent
	17.BMT32HAAS65	32 mm	100 mm	BMT65MID-32T



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

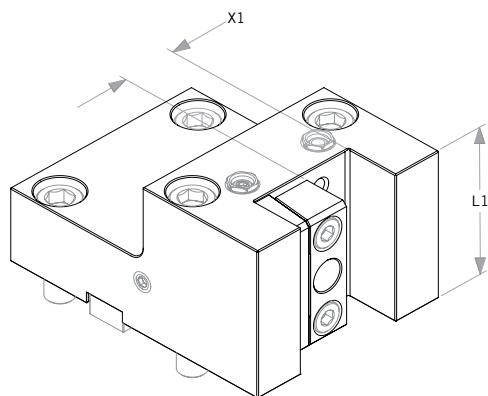
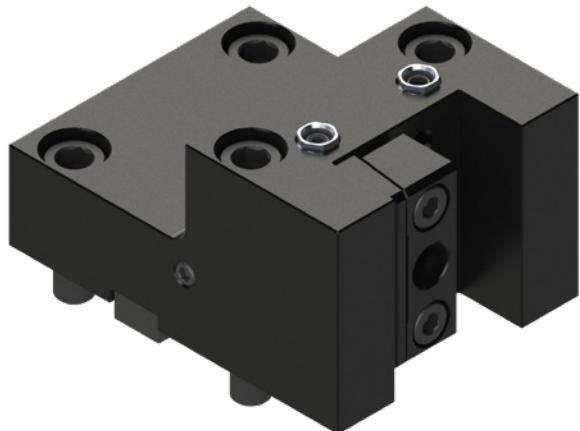
ACCESSORIES

REDUCTION SLEEVES	COOLANT NOZZLE	COOLANT PIPE
18	19	19

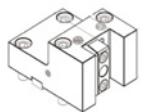
BMT65 Turret

Turning Tool

- ▶ Bolt-On Turning Tool for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



Turning Tool - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	4.BMT25HAAS65	25 mm	70 mm	BMT65MOD-25



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

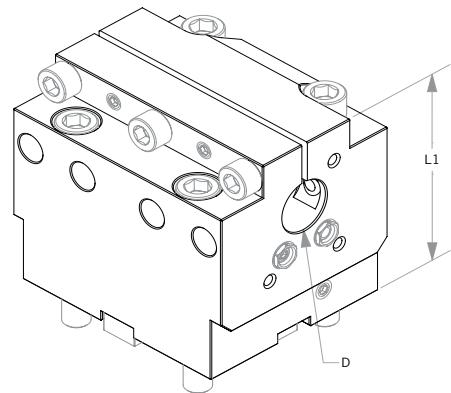
ACCESSORIES

WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

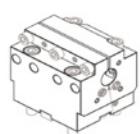
BMT65 Turret

Split Block Boring Bar Holder

- ▶ Bolt-On Split Block Boring Bar Holder for [BMT65](#) 12 Station Turret. See tool/turret diagram below for compatible machines.



Split Block Boring Bar - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	20.BMT25HAAS65	25 mm	105.5 mm	BMT65MID-25S
	20.BMT40HAAS65	40 mm	112 mm	BMT65MID-40S
	20.BMT50HAAS65	50 mm	118.5 mm	BMT65MID-50S



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

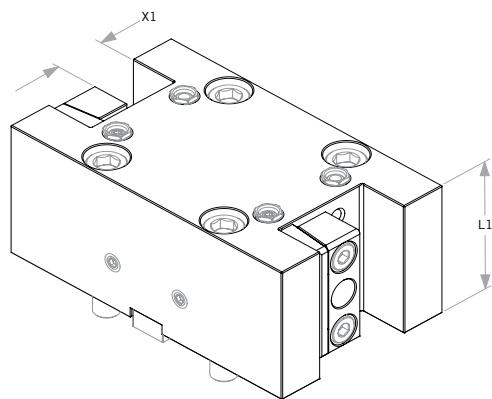
ACCESSORIES

REDUCTION SLEEVES	COOLANT NOZZLE	COOLANT PIPE
18	19	19

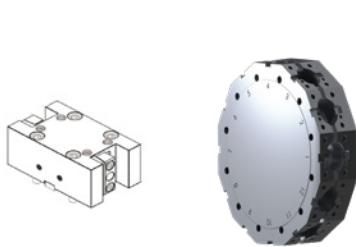
BMT65 Turret

Twin Turning Tool

- ▶ Bolt-On Twin Turning Tool for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



Twin Turn - MM	Part No.	X1	L1	Mfr. Part No. Equivalent
	15.BMT25HAAS65	25 mm	70 mm	BMT65MOD-25T



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

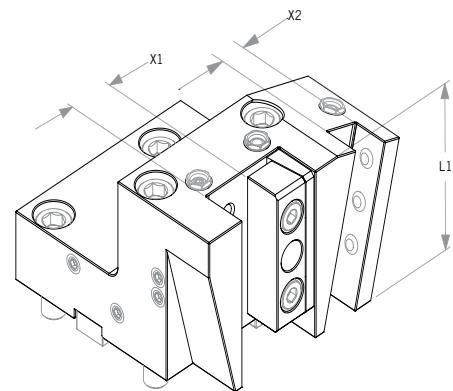
ACCESSORIES

WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

BMT65 Turret

Half-Index Turning Tool

- ▶ Bolt-On Half-Index Turning Tool for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



Half-Index Turning Tool - MM	Part No.	X1	X2	L1	Mfr. Part No. Equivalent
	4.BMT25/20HAAS65-15°	25 mm	20 mm	85 mm	BMT65MOD24-25



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional
For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

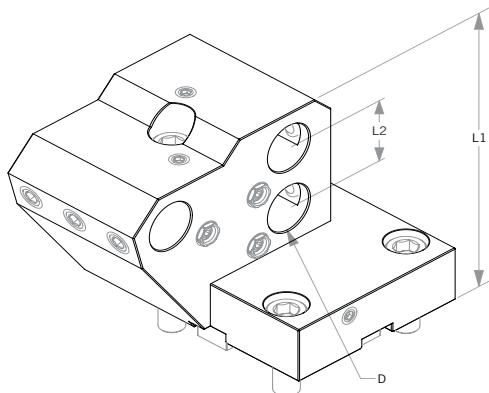
ACCESSORIES

WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

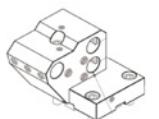
BMT65 Turret

Half-Index Boring Bar Holder

- ▶ Bolt-On Half-Index Boring Bar Holder for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



Half-Index Twin Boring Bar - MM	Part No.	D	L1	L2	Mfr. Part No. Equivalent
	19.BMT25HAAS65X50X85-15°	25 mm	105 mm	35 mm	BMT65MID24-25



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

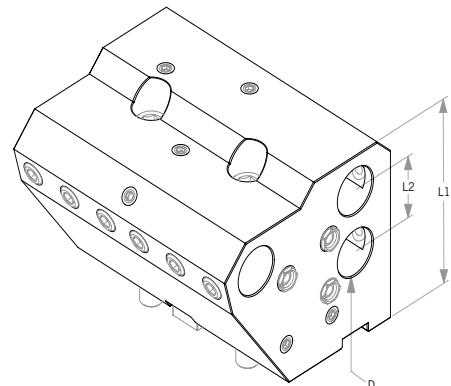
ACCESSORIES

REDUCTION SLEEVES	COOLANT NOZZLE	COOLANT PIPE
18	19	19

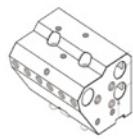
BMT65 Turret

Extended Half-Index Twin Boring Bar Holder

- ▶ Bolt-On Extended Half-Index Twin Boring Bar Holder for [BMT65](#) 12 Station See tool/turret diagram below for compatible machines.



Extended Half-Index Twin BBH - MM	Part No.	D	L1	L2	Mfr. Part No. Equivalent
	19.BMT25HAAS65X50X85-15°	25 mm	56 mm	35 mm	BMT65MID24-25T



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional
For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

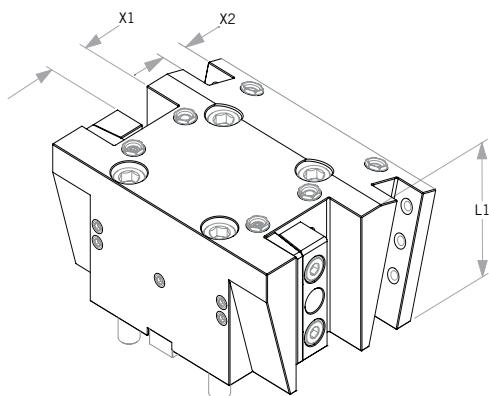
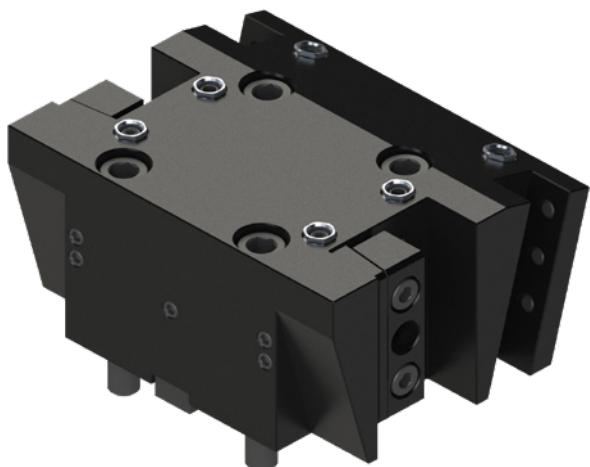
ACCESSORIES

REDUCTION SLEEVES 18	COOLANT NOZZLE 19	COOLANT PIPE 19

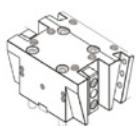
BMT65 Turret

Half-Index Twin Turning Tool

- ▶ Bolt-On Half-Index Twin Turning Tool for [BMT65](#) 12 Station Turret. See tool/turret diagram below for compatible machines.



Half-Index Twin Turn - MM	Part No.	X1	X2	L1	Mfr. Part No. Equivalent
	15.BMT25/20HAAS65-15°	25 mm	20 mm	85 mm	BMT65MOD24-25T



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional
For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

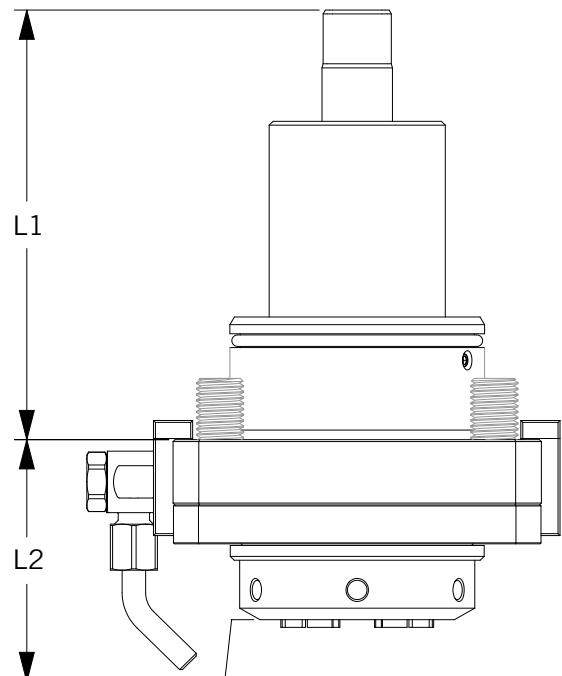
ACCESSORIES

WEDGE CLAMPS 19	COOLANT NOZZLE 19	COOLANT PIPE 19

BMT65 Axial Live Tool

Axial

- Axial live tools for **BMT65** 12 Station Turret.



ER32 Axial - MM	Part No.	L1	L2	BMT	Collet Nut Type
	40.65321809HAASIM	112	47	65	Internal
	40.65321809HAASIKCIM	112	47	65	Internal

- + Coolant Option: External Coolant
- + Uses standard ER32 collets
- + 1:1 drive ratio
- + 6,000 max RPM
- + Run-out ≤ 0.005 mm

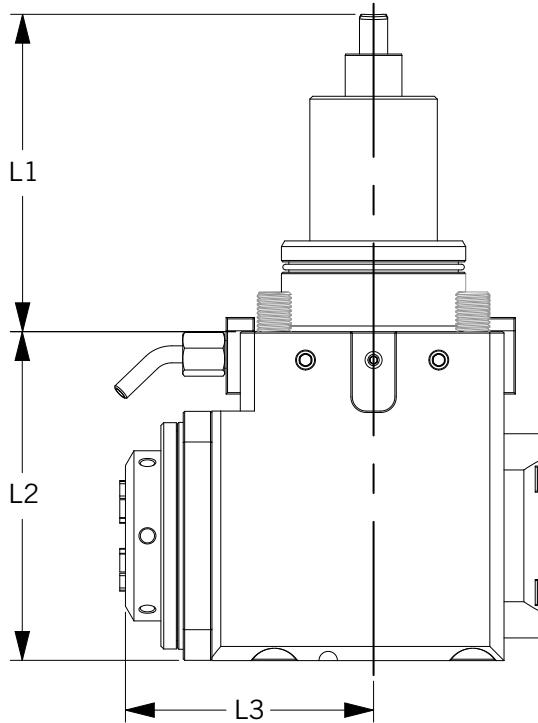
ACCESSORIES

COLLETS & ACCESSORIES 8	COOLANT KIT 8	COOLANT PIPE 8

BMT65 Radial Live Tool

Radial

- Radial live tools for **BMT65** 12 Station Turret.



ER32 Radial - MM	Part No.	L1	L2	L3	BMT	Collet Nut Type
	60.65321809HAASGLIM	112	116	87,5	65	Internal
	60.65321809HAASIKGLIM	112	116	87,5	65	Internal

- + Coolant Option: External Coolant
- + Uses standard ER32 collets
- + 1:1 drive ratio
- + 6,000 max RPM
- + Run-out ≤ 0.005 mm

ACCESSORIES

COLLETS & ACCESSORIES 8	COOLANT KIT 8	COOLANT PIPE 8

BMT65 Turret

BMT65 Modular Turret Tools

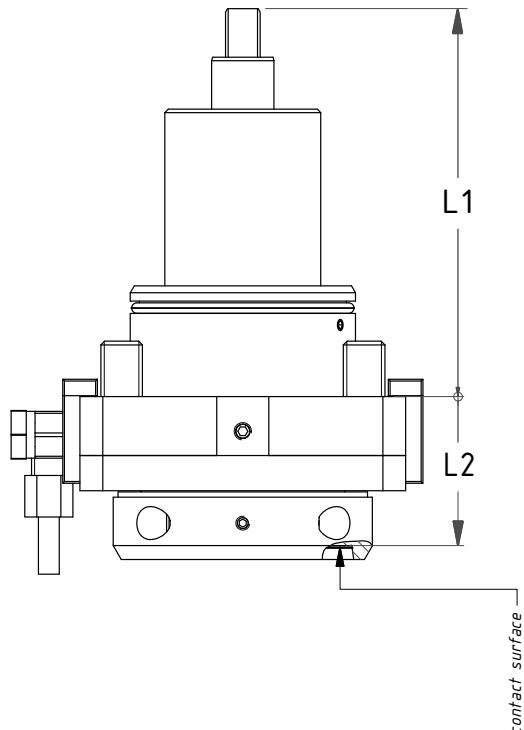
- ▶ Command has once again taken a step forward to make tooling more flexible for your BMT65 turret with the new product offerings of the Varia, KM, and PSC static and live tools.
- ▶ Reduce your tool set-up times by placing an order for these tools today!



BMT65 Axial Live Tool

Axial

- ▶ Varia axial live tool for [BMT65](#) 12 Station Turret.



Varia Axial	Part No.	L1	L2	BMT	Modular Type
	40.65VX41809HAAS#01	112	43	65	Varia
	40.65VX41809HAASIKC	112	43	65	Varia

- + Coolant Option: External Coolant
- + Uses standard Varia inserts
- + 1:1 drive ratio
- + 6,000 max RPM
- + Run-out ≤ 0.005 mm

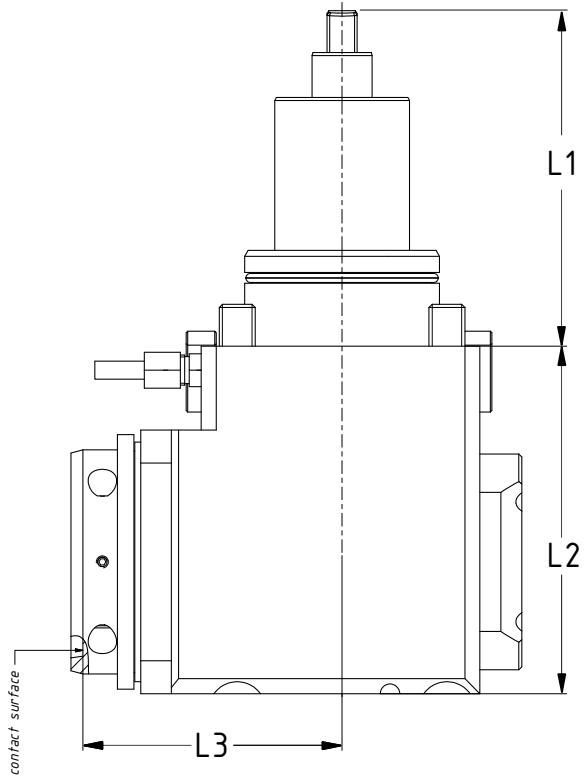
ACCESSORIES

ADAPTERS 35	COOLANT KIT 8	COOLANT PIPE 8

BMT65 Radial Live Tool

Radial

- ▶ Varia radial live tool for BMT65 12 Station Turret.



Varia Radial	Part No.	L1	L2	L3	BMT	Modular Type
	60.65VX41809HAASGL	112	116	86,5	65	Varia
	60.65VX41809HAASIKGL	112	116	86,5	65	Varia

- + Coolant Option: External Coolant
- + Uses standard Varia inserts
- + 1:1 drive ratio
- + 6,000 max RPM
- + Run-out ≤ 0.005 mm

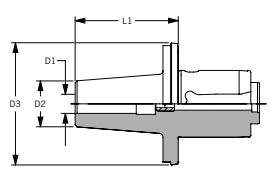
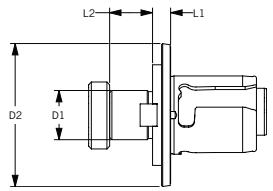
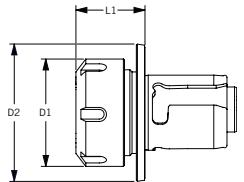
ACCESSORIES

ADAPTERS 45	COOLANT KIT 18	COOLANT PIPE 18

BMT65 Modular Adapters

Varia Adapters

- ▶ Varia inserts for **BMT65** 12 Station Turret Modular Tools. Additional sizes available.



Collet Chuck Insert

Part Number	Collet Size	L1	D1	D2
31.VX416L23.5	16	23.5mm	28mm	64mm
31.VX420L27	20	27mm	34mm	64mm
31.VX425L28	25	28mm	42mm	64mm
31.VX432L30	32	30mm	50mm	64mm
31.VX440L57	40	57mm	63mm	64mm

Shell Mill Insert

Part Number	L1	L2	D1	D2
42.VX416L08	8mm	25mm	16mm	64mm
42.VX422L08IK	8mm	27mm	22mm	64mm
42.VX427L08	8mm	21mm	27mm	64mm

Shrink Fit Insert

Part Number	L1	D1	D2	D3
27.VX408L54SHR	54mm	8mm	21mm	64mm
27.VX410L54SHR	54mm	10mm	24mm	64mm
27.VX412L54SHR	54mm	12mm	24mm	64mm
27.VX414L54SHR	54mm	14mm	27mm	64mm
27.VX416L54SHR	54mm	16mm	27mm	64mm

Varia Starter Kit - VSK-VX4

- ▶ Starter kit comes with the following:

1 QTY - ER32 Collet Insert 1 QTY - VX4 Fit Up Aid 1 QTY - Torque Wrench 5 QTY - Varia Tool Tag



Part No:
31.VX432L30*

Part No:
MB-VX4*

Part No:
DSV SW505.7NM*

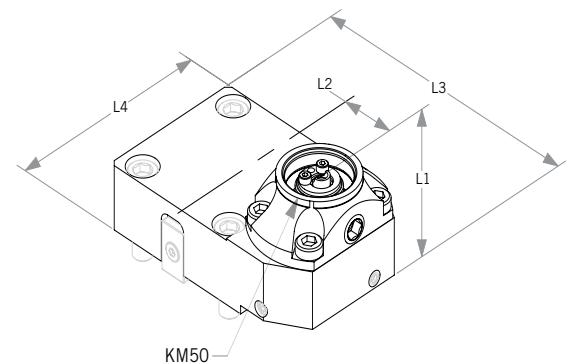
Part No:
PT-VX4*

* Also available to order separately.

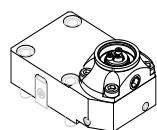
BMT65 Turret

KM50 Turning Tool

- ▶ Bolt-On KM50 Turning Tool Holder for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



KM50 Turning Tool	Part No.	L1	L2	L3	L4	Modular Type
	4.BMTKM50SKT250	70 mm	71 mm	148.5 mm	95 mm	KM50



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional For Machines:

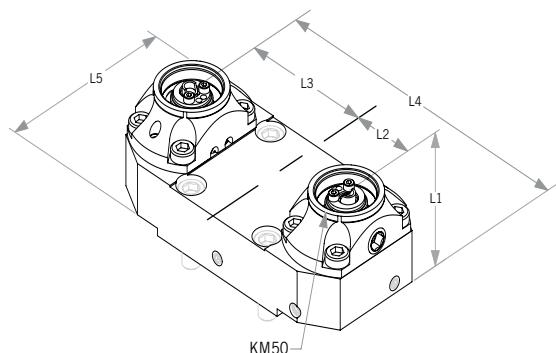
- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

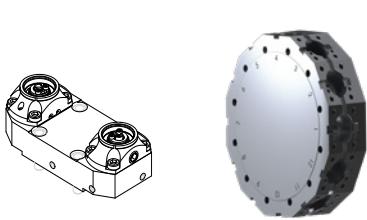
BMT65 Turret

KM50 Twin Turning Tool

- ▶ Bolt-On KM50 Twin Turning Tool Holder for [BMT65](#) 12 Station Turret. See tool/turret diagram below for compatible machines.



KM50 Twin Turning Tool	Part No.	L1	L2	L3	L4	L5	Modular Type
	15.BMTKM50SKT250	70 mm	71 mm	71 mm	197 mm	95 mm	KM50



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional For Machines:

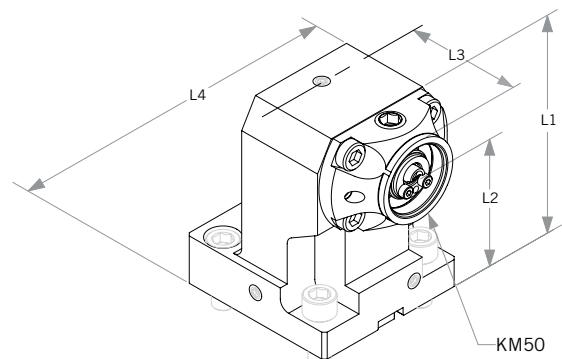
- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

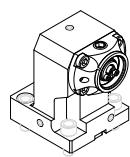
BMT65 Turret

KM50 Boring Bar Holder

- ▶ Bolt-On KM50 Boring Bar Holder for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



KM50 Boring Bar Holder	Part No.	L1	L2	L3	L4	Modular Type
	19.BMTKM50SKT250X100	128 mm	100 mm	70 mm	96 mm	KM50



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

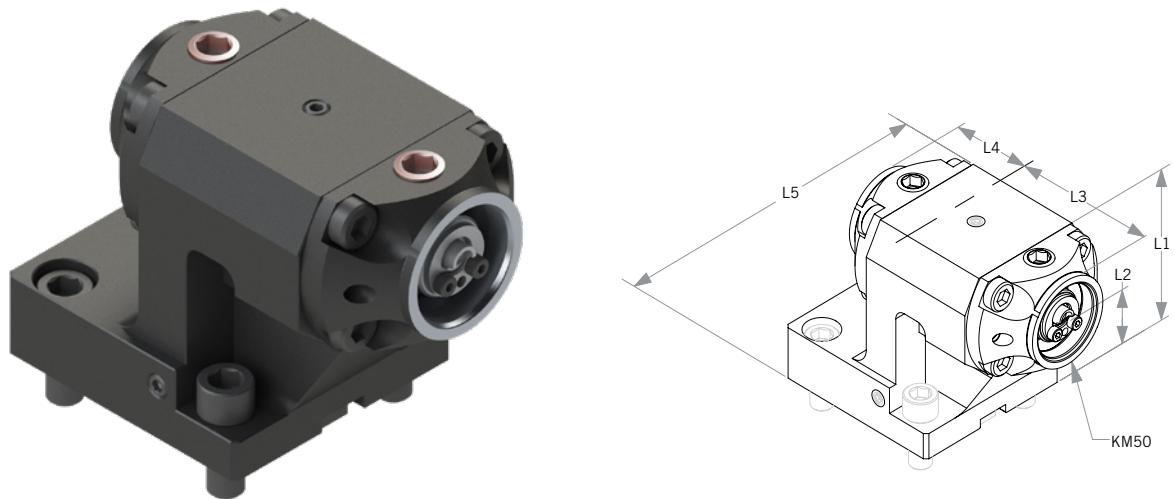
- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

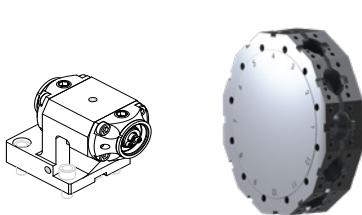
BMT65 Turret

KM50 Twin Boring Bar Holder

- ▶ Bolt-On KM50 Twin Boring Bar Holder for [BMT65](#) 12 Station Turret. See tool/turret diagram below for compatible machines.



KM50 Twin Boring Bar Holder	Part No.	L1	L2	L3	L4	L5	Modular Type
	17.BMTKM50SKT250X85	112.5mm	85 mm	103 mm	27 mm	95 mm	KM50



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

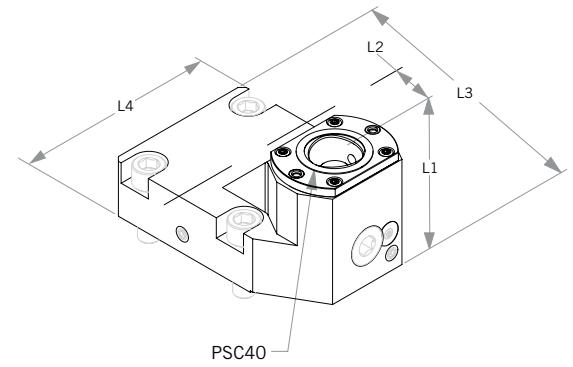
- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

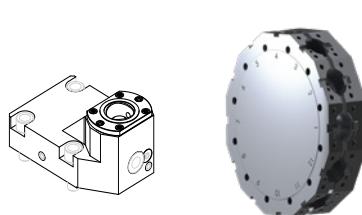
BMT65 Turret

PSC 40 Turning Tool

- ▶ Bolt-On PSC 40 Turning Tool Holder for **BMT65** 12 Station Turret. See tool/turret diagram below for compatible machines.



PSC 40 Turning Tool	Part No.	L1	L2	L3	L4	Modular Type
	4.BMTC4SKT250	74 mm	65 mm	139 mm	94 mm	PSC 40



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

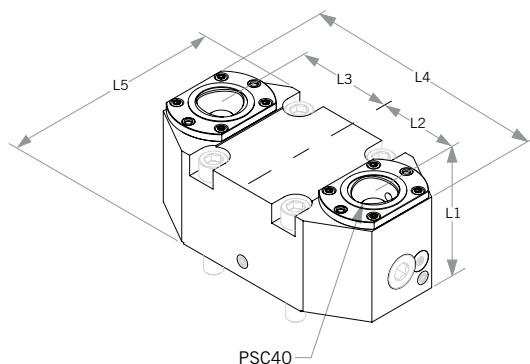
- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

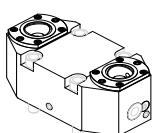
BMT65 Turret

PSC 40 Twin Turning Tool

- ▶ Bolt-On PSC 40 Twin Turning Tool Holder for [BMT65](#) 12 Station Turret. See tool/turret diagram below for compatible machines.



PSC 40 Twin Turning Tool	Part No.	L1	L2	L3	L4	L5	Modular Type
	15.BMTC4SKT250	74mm	65mm	65mm	178mm	95mm	PSC 40



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional

For Machines:

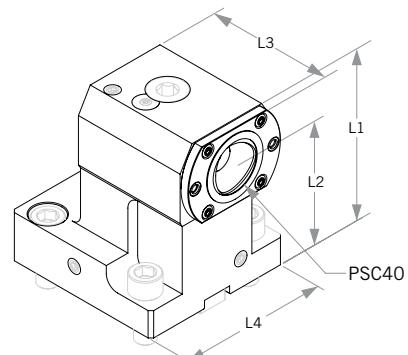
- + ST-20, ST-25
- + ST-30, ST-35

+ Coolant Option: Internal Coolant

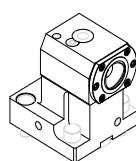
BMT65 Turret

PSC 40 Boring Bar Holder

- ▶ Bolt-On PSC 40 Boring Bar Holder for [BMT65](#) 12 Station Turret. See tool/turret diagram below for compatible machines.



PSC 40 Boring Bar Holder	Part No.	L1	L2	L3	L4	Modular Type
	19.BMTC4SKT250	114 mm	90 mm	113 mm	95 mm	PSC 40



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional For Machines:

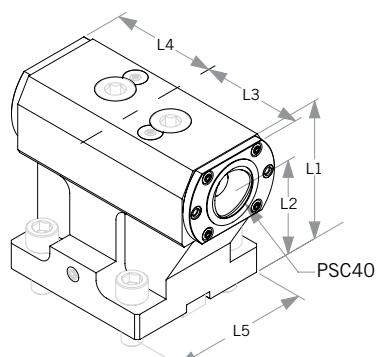
- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

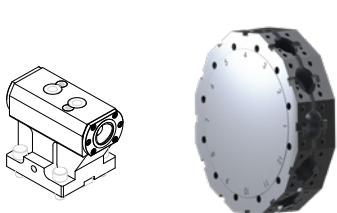
BMT65 Turret

PSC 40 Twin Boring Bar Holder

- ▶ Bolt-On PSC 40 Twin Boring Bar Holder for [BMT65](#) 12 Station Turret. See tool/turret diagram below for compatible machines.



PSC 40 Twin Boring Bar Holder	Part No.	L1	L2	L3	L4	L5	Modular Type
	17.BMTC4DSKT250	114mm	90 mm	77 mm	63 mm	95 mm	PSC 40



BMT65 Turret

Standard For Machines:

- + ST-20Y, ST-25Y
- + ST-30Y, ST-35Y
- + DS-30Y

BMT65 Turret Optional For Machines:

- + ST-20, ST-25
- + ST-30, ST-35

- + Coolant Option: Internal Coolant

Notes

A large grid of blue dots on a white background, intended for handwritten notes. The grid consists of approximately 20 columns and 30 rows of dots.



EWS Weigle GmbH & Co. KG
Maybachstraße 1 · D-73066 Uhingen
Telefon +49(0)7161-93040-100
Telefax +49(0)7161-93040-30
E-Mail: info@ews-tools.de
www.ews-tools.de



WSW Spannwerkzeuge-Vertriebs GmbH
Maybachstr. 1 · D-73066 Uhingen
Telefon +49(0)7161-93040-100
Telefax +49(0)7161-93040-30
E-Mail: info@wsw-collets.de
www.wsw-collets.de



Command Tooling Systems
13931 Sunfish Lake Blvd NW
Ramsey · MN 55303 USA
Telefon +1-763-576-6910
Telefax +1-763-576-6911
support@commandtool.com
www.commandtool.com



EWS Korea Co. Ltd.
60-11 · Woongnam-Dong
Changwon
Kyoung-Nam Korea
Telefon +82 55-267-8085
Telefax +82 55-262-3118
E-Mail: info@ewskorea.co.kr
www.ewskorea.co.kr



EWS Ltd.
Krassnaja str., 38
600015 Vladimir
Russland
Telefon +7-4922-541160
Telefax +7-4922-541160
E-Mail: info@ews-russland.ru
www.ews-russland.ru



JIANGSU EWS MACHINE CO.,LTD
37 hao xizhangzhenbeilu
fenghuangzhen zhangjiangang
China
Telefon +86-512-5842-9991
Telefax +86-512-5842-9990
yujo@ewskorea.co.kr



埃维斯刀座技术(太仓)

EWS Tool Holder Technologies (Taicang Co. Ltd)
Beijing East Road No. 88
215400 Taicang · Jiangsu
P. R. China
Telefon +86 512 3306 2600
Telefax +86 512 3306 2601
E-Mail: sales.cnews-tools.de
www.ews-tools.cn



Tool-Arena GmbH
Maybachstraße 1 · D-73066 Uhingen
Telefon +49(0)7161-93040-100
E-Mail info@tool-arena.com
www.tool-arena.com



EWS Tutucu Sistemleri ve Taretleri Anonim Şirket
Aydınlı mah.Melodi No.2/19 Sk. Bilmo
San.Sit. 18-19
34956 Tuzla / İstanbul
Turkey
Telefon +90-216-593-22-44
E-Mail: mehmet@ewstools.com
www.ews-tools.de