



QUICK-CHANGE CHUCKS AND INSERTS FOR THREADS FROM M6 TO M42

Magnetic Drilling Machines in the ProfiPLUS class are ideal for thread cutting. They require clockwise/anti-clockwise operation, full-shaft control electronics, and high motor power.

Quick-Change Chuck Sizes MT 2, MT 3, and MT 4

The large stroke range of BDS Magnetic Drilling Machines, combined with the quick-change chuck, allows for fast and cost-effective operation without the need to realign or re-center when switching tools. The quick-change chuck is universally compatible with quick-change inserts, both with and without a safety slip clutch, ensuring versatile and efficient tool changes.



Order no.

GSW 222 Quick-change chuck

GSW 331 Quick-change chuck

GSW 332 Quick-change chuck

GSW 333 Quick-change chuck

GSW 442 Quick-change chuck

GSW 443 Quick-change chuck

GSW 444 Quick-change chuck

GSE 103 - GSE 114 per piece

GSE 205 - GSE 222 per piece

GSE 314 - GSE 330 per piece

GSS 205 - GSS 222 per piece

GSS 312 - GSS 330 per piece

GSS 420 - GSS 442 per piece

GSW quick-change chuck:
In the versions
MT 2, MT 3, MT 4.
For mounting
quick-change inserts
GSE or GSS

GSW 222 Size 2 MT 2

GSW 331 Size 1 MT 3

GSW 332 Size 2 MT 3

GSW 333 Size 3 MT 3

GSW 442 Size 2 MT 4

GSW 443 Size 3 MT 4

GSW 444 Size 4 MT 4



GSE quick-change insert, standard size 1, 2, 3

GSS quick-change insert with safety slip clutch size 2, 3, 4



VERSION 1: QUICK-CHANGE INSERTS WITH SAFETY SLIP CLUTCH

Ideal for blind-hole and through-hole threads from M6 to M42.

BDS inserts with safety slip clutch enable precise cutting of through-hole and blind-hole threads. The safety slip clutch prevents the tap from hitting the bottom of the hole and breaking off.



VERSION 2: STANDARD QUICK-CHANGE INSERTS

Ideal for through-hole threads from M6 to M30

BDS inserts for taps are suitable for holding taps for through-hole threads.



TAP ADAPTER WITH WELDON SHANK - AN INEXPENSIVE WAY TO GET STARTED.

The tap is inserted directly into the 19 or 32 mm Weldon system using an adapter. Only suitable for through-hole threads!



Order no.	Thread	Shank Ø (mm)	Square
ZGA 010	M10 DIN 376	7	5.5
ZGA 012	M12 DIN 376	9	7
ZGA 014	M14 DIN 376	11	9
ZGA 016	M16 DIN 376	12	9
ZGA 018	M18 DIN 376	14	11
ZGA 020	M20 DIN 376	16	12
ZGA 022	M22 DIN 376	18	14.5
ZGA 024	M24 DIN 376	18	14.5
ZGA 027	M27 DIN 376	20	16
ZGA 030	M30 DIN 376	22	18
ZGA 033	M33 DIN 376	25	20
ZGA 036	M36 DIN 376	28	22
ZGA 042	M42 DIN 376	32	24



up to ZGA 020 with 19 mm Weldon shank (3/4")

from ZGA 022 with 32 mm Weldon shank (1 1/2")



Scan the QR code or use the web link for our automated configuration for thread cutting systems:

<https://www.bds-machines.com/find-tapping-accessories/>

WHICH MACHINE, WHICH THREAD?

Assignment of tapping adapter sizes to the respective magnetic drilling machine models for correct application.



GSW quick-change chuck



Quick-change inserts
Standard GSE



Quick-change inserts with safety
slip clutch GSS



MAB1300	MAB 825/845	MAB 525	MAB 485	Order no.	Quick-change chuck	Thread	Order no.	Ø x square	Order no.	Ø x square
			✓	GSW 222	Size 2 MT 2	M5 / M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
			✓			M6			GSS 206	4.5 / 3.4
			✓			M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
			✓			M8			GSS 205	6 / 4.9
			✓			M10	GSE 210.1	10 / 8		
			✓			M10	GSE 210	7 / 5.5	GSS 210	7 / 5.5
			✓			M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
			✓			M14	GSE 214	11 / 9.0	GSS 214	11 / 9.0
			✓			M16	GSE 216	12 / 9.0	GSS 216	12 / 9.0
	✓	✓		GSW 331	Size 1 MT 3	M4	GSE 104	4.5 / 3.4		
	✓	✓				M5 / M6	GSE 105	6 / 4.9		
	✓	✓				M8	GSE 108	8 / 6.2		
	✓	✓				M10	GSE 110	10 / 8.0		
	✓	✓				M12	GSE 112	9 / 7.0		
	✓	✓				M14	GSE 114	11 / 9.0		
	✓	✓		GSW 332	Size 2 MT 3	M5 / M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
	✓	✓				M6			GSS 206	4.5 / 3.4
	✓	✓				M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
	✓	✓				M8			GSS 205	6 / 4.9
	✓	✓				M10	GSE 210.1	10 / 8		
	✓	✓				M10	GSE 210	7 / 5.5	GSS 210	7 / 5.5
	✓	✓				M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
	✓	✓				M14	GSE 214	11 / 9	GSS 214	11 / 9
	✓	✓				M16	GSE 216	12 / 9	GSS 216	12 / 9
	✓	✓				M18	GSE 218	14 / 11	GSS 218	14 / 11
	✓	✓				M20	GSE 220	16 / 12	GSS 220	16 / 12
	✓	✓				M22 / 24	GSE 222	18 / 14.5	GSS 222	18 / 14.5
	✓	✓		GSW 333	Size 3 MT 3	M12			GSS 312	9 / 7.0
	✓	✓				M14	GSE 314	11 / 9	GSS 314	11 / 9
	✓	✓				M16	GSE 316	12 / 9	GSS 316	12 / 9
	✓	✓				M18	GSE 318	14 / 11	GSS 318	14 / 11
	✓	✓				M20	GSE 320	16 / 12	GSS 320	16 / 12
	✓	✓				M22 / M24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
	✓	✓				M27	GSE 327	20 / 16	GSS 327	20 / 16
	✓	✓				M30	GSE 330	22 / 18	GSS 330	22 / 18
✓				GSW 442	Size 2 MT 4	M5 / M6	GSE 205	6 / 4.9	GSS 205	6 / 4.9
✓						M6			GSS 206	4.5 / 3.4
✓						M8	GSE 208	8 / 6.2	GSS 208	8 / 6.2
✓						M8			GSS 205	6 / 4.9
✓						M10	GSE 210.1	10 / 8.0		
✓						M10	GSE 210	7 / 5.5	GSS 210	7 / 5.5
✓						M12	GSE 212	9 / 7.0	GSS 212	9 / 7.0
✓						M14	GSE 214	11 / 9	GSS 214	11 / 9
✓						M16	GSE 216	12 / 9	GSS 216	12 / 9
✓						M18	GSE 218	14 / 11	GSS 218	14 / 11
✓						M20	GSE 220	16 / 12	GSS 220	16 / 12
✓						M22 / M24	GSE 222	18 / 14.5	GSS 222	18 / 14.5
✓				GSW 443	Size 3 MT4	M12			GSS 312	9 / 7.0
✓						M14	GSE 314	11 / 9	GSS 314	11 / 9
✓						M16	GSE 316	12 / 9	GSS 316	12 / 9
✓						M18	GSE 318	14 / 11	GSS 318	14 / 11
✓						M20	GSE 320	16 / 12	GSS 320	16 / 12
✓						M22 / 24	GSE 322	18 / 14.5	GSS 322	18 / 14.5
✓						M27	GSE 327	20 / 16	GSS 327	20 / 16
✓						M30	GSE 330	22 / 18	GSS 330	22 / 18
✓				GSW 444	Size 4 MT4	M20			GSS 420	16 / 12
✓						M22 / 24			GSS 422	18 / 14.5
✓						M27			GSS 427	20 / 16
✓						M30			GSS 430	22 / 18
✓						M33			GSS 433	25 / 20
✓						M36			GSS 436	28 / 22
✓						M39 / 42			GSS 442	32 / 24