



Semi-Universal Dividing Head



ORDER NO.	WEIGHT	CODE NO.
BS-0	20kgs	1001-050
BS-1	33kgs	1001-051

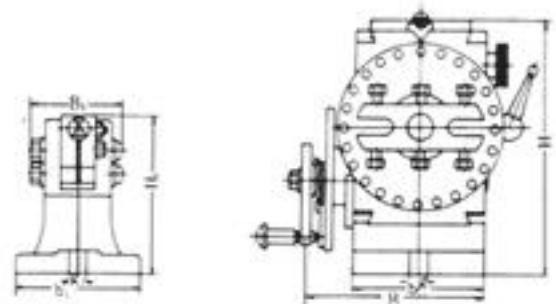
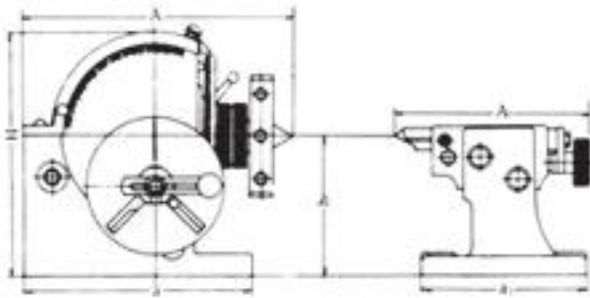
Standard Accessories



THREAD SPINDLE:BS-0. 1½ -8TPI
BS-0. 1½ -8TPI

Dividing Plate A,B,C

Numbers of hole	Plate A	15	16	17	18	19	20
	Plate B	21	23	27	29	31	33
	Plate C	37	39	41	43	47	49



Semi-Universal Index B & S Type No.0 No.1(Head-stock):

Unit:mm/inches.

ORDER NO.	A	B	H	h	a	b	g	TAPER OF CENTER	Diameter of spindle hole
BS-0	189 7 7/16	140 5 23/64	173 6 13/16	100 3 15/16	160 6 13/64	91 3 37/64	13 33/64	MT-2	18
BS-1	293 11 7/32	156 6 9/64	220 8 21/32	128 5 3/64	207 8 5/32	114 4 31/64	16 5/8	MT-3	20

Semi-Universal Index B & S Type No.0 No.1 (Tail-Stock):

Unit:mm/inches

ORDER NO.	A1	B1	H1	h	a1	b1	g1
BS-0	167 6 37/34	80 3 5/32	107.5 4 19/64	100 3 19/16	130 5 1/8	92 3 2/8	13 33/64
BS-1	191 7 33/64	88 3 15/32	137 5 25/64	128 5 3/64	150 5 29/32	108 4 1/4	16 5/8

- 1.Dividing Head can divide in any angle by the direct, indirect, or different methods. The ratio between the worm and the worm gear is 40:1.
- 2.Hardened and ground spindle is rigidly held in a taper roller bearing. Worm is hardened and ground also.
- 3.The swivel head can be locked of any angle from 10° below horizontal to 90° vertical-precision fitting to base assures smooth rotation.
- 4.All models have threaded spindle nose and 24 hole dividing plate with easy conversion to fast direct indexing on numbers 2, 3, 4, 6, 8, 12, and 24.
- 5.Easy indexing of all numbers from 2 to 50 and many numbers from 52 to 380. Model BS-2 is also equipped for different indexing of all numbers from 2 to 380, and for spiral cutting.
- 6.Accurate precision, little backlash, fine appearance and strong structure so can assure smooth rotation.



The state of
BS-0 fitted with 5" 3-Jaw Chuck



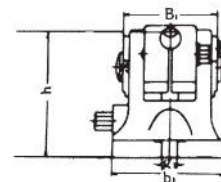
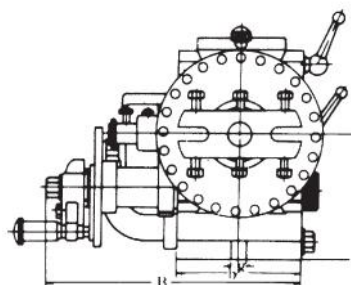
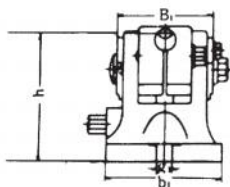
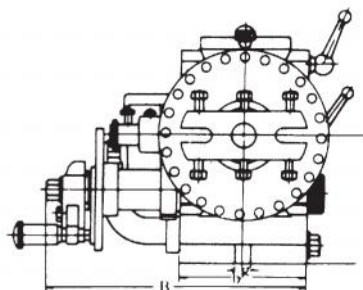
Universal Dividing Head



THREAD SPINDLE: 2 1/4"-8TPI

ORDER NO.	WEIGHT	CODE.NO.
BS-2	65kgs	1001-052

Standard Accessories



Universal Index B & S Type No.2 (Head-stock)

Unit:mm/inches.

ORDER NO.	A	B	H	h	a	b	g	Taper of center	Spindle hole
BS-2	365 14 13/32	272 10 45/64	236 9 15/64	132.7 5 15/64	213 5 25/64	134 5 9/32	16 5/8	MT-4	25.4 1

BS-2(Tail-stock)

Unit:mm/inches.

ORDER NO.	A1	B1	H1	h1	a1	b1	g1
BS-2	205~255 8 5/64 ~ 10 5/64	86 3 15/32	139 5 15/32	132.7 5 15/64	175 6 57/64	124 4 7/8	16 5/8

ORDER NO.	Gross Weight kg	Meas. CFT	Applicable Chuck
BS-0	(C)20	0.8	4" OR 5"
BS-1	(C)33	1.3	5" OR 6"
BS-2	(C)65	3.4	6" ,7" OR 8"

TEST REPORT

ITEM NO.	TESTING OBJECTIVE	VARIATION (INCHES)(MM) MAXIMUM TESTED	
1	TRUE RUNNING OF CENTER	0.0006(0.015)	
2	TRUE RUNNING OF INSIDE TAPER OF DIVIDING SPINDLE (1)MEASURED AT SPINDLE NOSE (2)MEASURED AT ARBOR 8-IN.LONG	(1)0.0004(0.01) (2)0.0012(0.03)	(1) (2)
3	AXIAL MOVEMENT OF DIVIDING SPINDLE	0.0004(0.01)	
4	DIVIDING ACCURACY OF WORM DRIVE MAXIMUM CUMULATIVE SPACING ERROR	1'30"	



Super Indexing Spacer



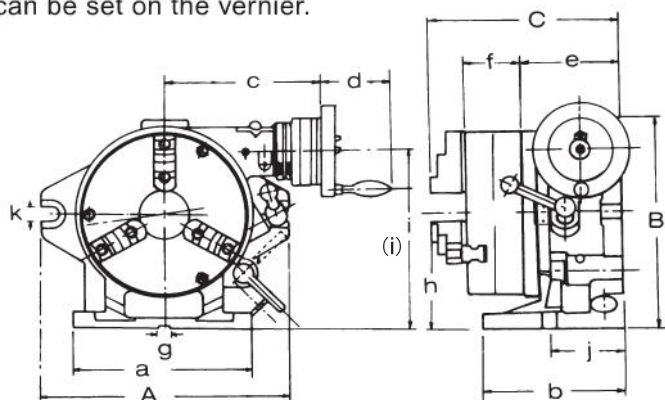
Special Accessories

The same as Rotay table
Please see page A2



CS-8 with VSK-8 3-JAW MASKING PLATE & FACE PLATE

This index combines the advantages of the Super Index with those of a worm-gear index. When mounted on a milling, boring or other machine tool it can carry out single-purpose indexing and indirect indexing using the worm-drive mechanism. Disengaging the worm drive the 24-notch master plate permits 2,3, 4,6,8,12 and 24 dividing in the same manner as the Simple Index. When the chuck is removed the unit can be used as a horizontal and vertical type rotary table. The operating handle to rotary table worm gear reduction ratio is 1:90. The operating handle collar is graduated 'in one minute, and readings down to ten seconds can be set on the vernier.



The state of CS-8 fitted with Face Plate & Dividing Plate

Order NO. & Dimensions

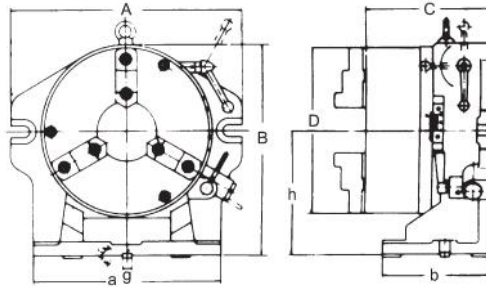
Unit:mm

ORDER NO.	Numbers of dividing	Chuck				Face plate			A	B	C	a	b	c	d	e	f	g	h	i	j	k	Gross Weight kg	Meas. CFT	CODE NO.
		Outer diameter	Inner jaw	Outer jaw	Inner dia	Outer dia	Thickness																		
CS-6	2,3,4,6	167 VSK-6	4~42	10~156	44	203	50	250	235	221	220	150	184	82	112	66	16	130	186	80	18	(W)50	1.2	1001-060	
CS-8	8,12,24	210 VSK-8	4~62	10~180	63	254	58	310	285	243	225	160	201	82	125	75	16	155	232	90	18	(W)79	3.1	1001-061	

(W)Wooden Case (C)Carton Case



Simple Indexing Spacer



Special Accessories



Order No. & Dimensions

Unit:mm

ORDER NO.	Dividual number	A	B	C	D	a	b	h	Inner jaw	Guide block g	Outer jaw	Diameter of hole(truuet)	Diameter of hole(truuet)	Gross weight kg	Meas. CFT	CODE NO.
CC-6	2, 3, 4, 6	260	218	156.2	167	220	130	130	4~42	16	10~156	44	36	(C)36	0.9	1001~062
CC-8	8, 12, 24	312	257	173.3	200	258	148	155	4~62	16	10~180	63	63	(C)51	1.3	1001~063

- 1.The center through hole is big to be suitable for the large and long workpiece.
- 2.Hardened and ground 24 position master plate, can index the special angle of 15 with excellent accuracy.
- 3.CS-Type can be used with 2 pcs type 3-Jaw Chuck. And to do similar work. as rotary table when it match with face plate.
- 4.Rapid indexing and easy operation. It's a sharp equipment for mass-production.
- 5.Super Spacer index include 3 jaw chuck, Face plate dia. 10",250mm Masking Plates 2,3,4,6,8,12.
- 6.Simple index include 3-jaw chuck, Masking Plates 2, 3, 4, 6, 8, 12
- 7.Used the key guide block, the center can be corrected both quickly and accurately.

STANDARDS OF ACCURACY for Simple Index for Super-Dex.

NO.	Testing Objective	Tolerances Unit: inches Permitted Max.
1	Parallelism of table surface to base per 12"	.0006
2	True running of axial movement of table surface	.0006
3	True running of center boss	.0004
4	Squareness of base to angle face per 12"	.0008
5	True running of chuck center	.0012
6	Dividing accuracy individual spacing error	45"



Precision 3-Jaw Scroll Chuck

•Detail specification shown on page E5.E6



- 1.Internal jaws and External Jaws may be used interchangeably.
- 2.This type of chuck is suitable for the operation of mass-production. It is durable and economical.

ORDER NO.

VSC-5 SUIT FOR BS-0 OR HV-6
 VSC-6 SUIT FOR BS-1 OR HV-8,10
 VSC-7,8 SUIT FOR BS-2 OR HV-10,12,14
 VSC-10 SUIT FOR HV-14,16

Reversible type



ORDER NO.

VSK-6 SUIT FOR CS-6 , CC-6
 VSK-8 SUIT FOR CS-8 , CC-8

For indexer, The fixing hole is from front.

- 1.This type of chuck have wide scope of applications. the hard jaws are suitable for heavy cutting. the soft jaws are suitable for light cutting they maybe used alternately.
- 2.Hard jaws may be used as both internal jaws and external jaws.