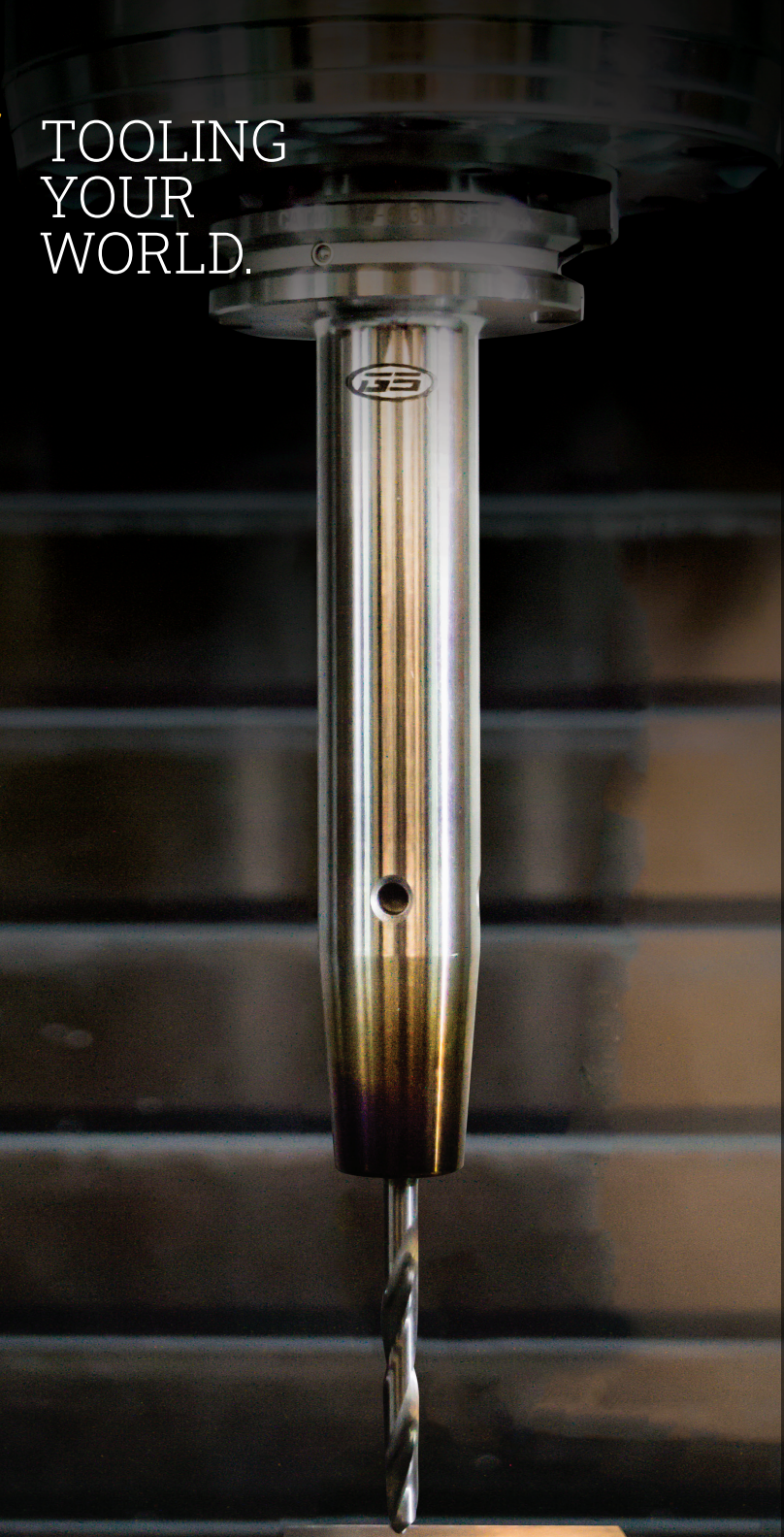




TOOLING
YOUR
WORLD.



Shrink Fit Solutions



ShrinkSMART

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ShrinkSMART

Modular shrink fit technology designed to be feature-rich, fast and flexible with an unrivaled entry price point.

Sowa Tool's premium brand, GS Tooling, delivers top-tier quality and performance that rivals or exceeds the best in the world.

GS Tooling products offer exceptional features and dependability, at shockingly affordable prices, making them an ideal choice for applications where accuracy and speed matter most.

SMART Control Panel & Software

The easy to use SMART Control Panel has three optimized pre-programmed cycles that save energy and prevent over-heating which can damage your holder. The software allows you to connect to a web interface through WiFi or an Ethernet connection for special programming needs and gives you a system status overview on demand.



Cooling options to suit all needs – for now and the future.

Start your shrink fit journey with a powerful solution that gives you the flexibility to add solutions as your business needs evolve.

INCLUDED

- 1 Tube for Adapter Rings & Protecting Coil

UPGRADE OPTION

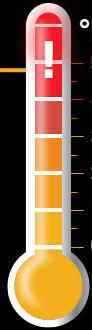
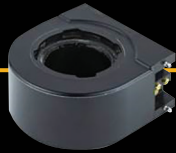
- 2 Air-Powered Cooling Unit
Holders that can be cooled: 1
Average cooling time: from 50 seconds*



ShrinkSMART

SMART Coil

Because toolholders can become hardened / tempered from excessive heating from some shrink machines, the SMART Coil measures the unique resistance for *each* toolholder and ensures *only* the proper and appropriate amount of heat is utilized. This also supports a super fast 2-7 second shrinking cycle.



°F
500° Machines without SMART Coil
400°
300° ShrinkSMART
200° Temperatures
100°
0°

Compatible with all popular tooling combinations

Tool types: HSS, Carbide, MST, Magnetic and Non-Magnetic

Diameters from: 0.118" to 1.259" (3mm to 32mm)
1.574" (40mm) possible with the same coil using optional stop disk.

Tapers: CAT/BT/SK40 & 50, HSK63A & 100A, C6 & C10 (with additional adapters available for CAT/BT/SK30, SK25 & 35 & 45, HSK32 & 50 & 80, C3 & C5 & C8 CAPTO)



ALTERNATE BASE UNIT

Rotary Table with Shrink Depth Settings

The Rotary Table stops the user from having any contact with hot holders, and allows them to safely switch from the heating position to a cooling position. The stop rods allow the user to set the depth of the cutting tool with a wheel that moves the stop rod and your tool into position. Stop rod also assists in removing broken tool.



UPGRADE OPTION

3 Air-Cooling Box & Storage

Holders that can be cooled: **5**
Extra storage for holder with air-cooling function.

UPGRADE OPTION

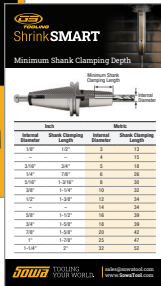
4 Water-Cooling Refrigeration Unit

Holders that can be cooled: **2**
Average cooling time: **from 45 seconds***

*depending on the tool holder shape

ShrinkSMART SHRINK FIT MACHINE

Operating Manual

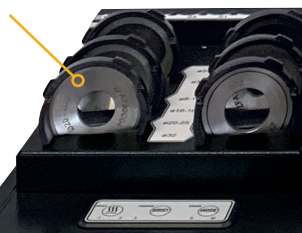


Quick Reference Card

Power	Up to 16kW allows the shrinking and unshrinking of tools Ø0.118" to Ø1.259" (Ø3mm to Ø32mm)
Voltage	AC 3 x 400V-480V (±10%) + PE/23.8 A/50-60Hz 2.5 meter cable is supplied Air 3-6 bars/duct Ø0.4" (Ø3mm) required
Max Tool Length	16" to 19.25" (406.4mm to 488.95mm)
Largest Possible Taper	HSK125A
Weight	102lbs (46.2kg) Approximate
Dimensions	12.5"W x 38"D x 36"H (317mm x 955mm x 920mm) Approximate

Heat Focusing Stop Disks (5)

Magnetic insulator allows the magnetic field to be concentrated on the front part of the tool holder to achieve optimized heating. Enables the shrinking and unshrinking of carbide or HSS tools.



Pi Interface (Internal)



GS Tooling ShrinkSMART Shrink Fit Machine

Included	Code No.
1 SMART Coil	541650
Heat Focusing Stop Disks: 0.118"-0.236" (3mm-6mm), 0.314"-0.551" (8mm-14mm), 0.629"-0.708" (16mm-18mm), 0.787"-0.984" (20mm-25mm), 1.259" (32mm)	
Adapter Rings: 2 CAT40/BT40/SK40/HSK63A/C6 CAPTO CAT50/BT50/SK50/HSK100A/C10 CAPTO	
1 Tube for Adapter Rings	
1 Protecting Cone	
1 Pair of Gloves	
Quick Reference Card: 1 Clamping Depth & MODE Selection	
1 Operating Manual	
1 Pi-Interface	



Adapter Rings (2)
Provides the correct positioning of the tool holder into the tube.

Protecting Cone
Directs the air stream against the front end of the holder for fast cooling, and protects from contact of tooling when it is hot.

Two Fans
Built-in for improved cooling cycle times.

ShrinkSMART

UPGRADE OPTIONS & PARTS

Air-Powered Cooling Unit

Cooling time: from 50 seconds (*Depending on the tool holder shape*)

Weight: 11.5lbs (5.24kg)

Height: 18.38" (467mm)

Connection: L1, N+PE

Voltage: 1 x 100Vac-277Vac

Frequency: 50/60Hz

Air Required: 3-6 Bars



Description	Code No.
Air-Powered Cooling Unit	541654

Air-Cooling Box & Extra Storage for 5 Holders

Cooling time: from 4-5 minutes
(*Depending on the tool holder shape*)

Weight: 23.15lbs (10.5kg)

Height x Width x Depth:
12.48" x 19.68" x 35.8"
(317mm x 500mm x 910mm)

Connection: L1, N+PE

Voltage: 1 x 100Vac-277Vac

Frequency: 50/60Hz



INCLUDED:
2 fans, 5 adapter rings for CAT40/BT40/HSK63A/C6,
5 adapter rings for CAT50/BT50/HSK100A/C10,
2 protecting cones

Description	Code No.
Air-Cooling Box for 5 Holders	541656

Water-Cooling Refrigeration Unit

Cooling time: from 45 seconds
(*Depending on the tool holder shape*)

Extension table: Allow storage of
5 contact bushings and 1 cooling bell

Weight: 88lbs (39.8kg)

**Height x Width x Depth
(Table Extension):**
14.25" x 5.69" x 35.8"
(362mm x 150mm x 910mm)

**Height x Width x Depth
(Refrigeration Unit):**
18.5" x 11.42" x 22.83"
(470mm x 290mm x 580mm)

INCLUDED:
Refrigeration unit, tube support,
2 cooling bells, extension table



Description	Code No.
Water-cooling refrigeration unit, tube support, 2 cooling bells & extension table	541688

Rotary Table with Shrink Depth Settings

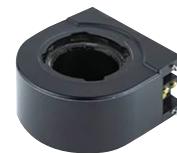
The Rotary Table stops the user from having any contact with hot holders, and allows them to safely switch from the heating position to a cooling position. The stop rods allow the user to set the depth of the cutting tool with a wheel that moves the stop rod and your tool into position. Stop Rods also assists in removing broken tools.



Description	Code No.
Rotary Table Attachment with Stop Rods	541652

SMART Coil

Measures the holder thickness and optimizes power consumption by automatically adjusting kW and heating time for each holder. This increases the life of your tool holders.



Description	Code No.
SMART Coil	541686

Parts



Heat Focusing Stop Disk



Split Heat Focusing Stop Disk



Adapter Rings



Protecting Cone



Pair of Gloves



Stop Rods
(Set of 4 pc)



Finned Support Cooling Adapter



Cooling/Contact Bushing



Tube for Adapter Rings



Tube for Adapter Rings with Stop Rod Depth Setter

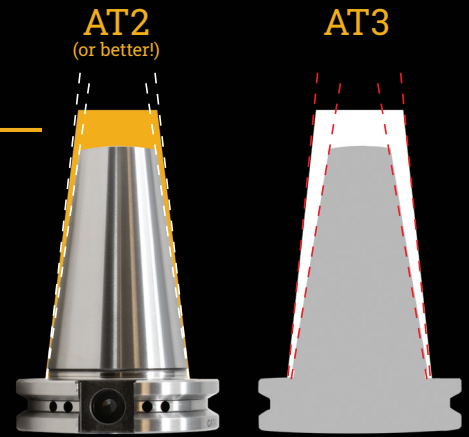
Description	Code No.	
Protecting Cone	541658	
Tube for Adapter Rings	541660	
Tube for Adapter Rings with Stop Rod Depth Setter	541661	
Stop Rods	4 pc 4.2mm diameter	541714
	4 pc 2.5mm diameter	541715
Pair of Heat Resistant Gloves (<i>May not look exactly as shown</i>)	541712	
Adapter Rings	CAT40/BT40/SK40/HSK63A/C6 CAPTO	541662
	CAT50/BT50/SK50/HSK100A/C10 CAPTO	541664
	BT30/SK30/HSK40A/C4 CAPTO	541666
	SK25/HSK32A/C3 CAPTO	541668
	SK35/HSK50A/C5 CAPTO	541670
Heat Focusing Stop Disks	SK45/HSK80A/C8 CAPTO	541672
	0.118"-0.236" (3mm-6mm)	541674
	0.314"-0.551" (8mm-14mm)	541676
	0.629"-0.708" (16mm-18mm)	541678
	0.787"-0.984" (20mm-25mm)	541680
Split Heat Focusing Stop Disks	1.259" (32mm)	541682
	0.118"-0.236" (3mm-6mm)	541675
	0.314"-0.551" (8mm-14mm)	541677
	0.629"-0.708" (16mm-18mm)	541679
	0.787"-0.984" (20mm-25mm)	541681
Finned Support Cooling Adapters (<i>Additional sizes can be quoted on request</i>)	1.259" (32mm)	541683
	CAT40/BT40	541690
	CAT50/BT50	541692
	BT30	541694
	HSK63A	541696
Cooling/Contact Bushings DIN4.5°	C6 CAPTO	541698
	1/8" & 3/16" (3/4/5mm)	541700
	1/4" & 5/16" (6/8mm)	541702
	3/8" & 7/16" & 1/2" (10/12mm)	541704
	9/16" & 5/8" (14/16mm)	541706
Stop Rods	3/4" (18/20mm)	541708
	1" & 1-1/4" (25/32mm)	541710

Shrink Fit Tool Holders

Only the best material is used

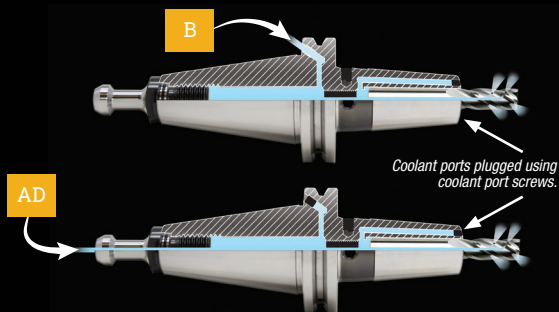
GS Tooling Shrink Fit Holders are made from **H13 Tool Steel**. This is a chromium-molybdenum steel with an exceptional combination of high toughness and resistance to thermal fatigue cracking (heat checking) as a result of cyclic heating and cooling cycles. It has better wear resistance than common alloy steels, and with proper use the life of our Shrink Fit Holders will exceed that of standard Shrink Fit Holders.

Our taper accuracy is **AT2 or better**, for the life of the holder – **guaranteed**.

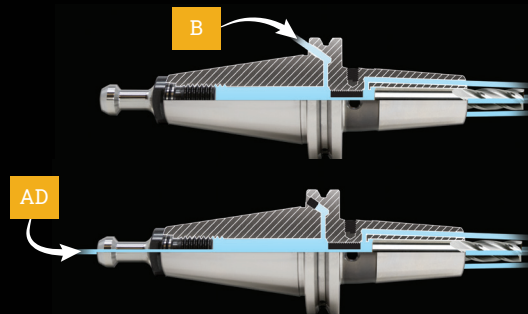


Multiple coolant options are standard

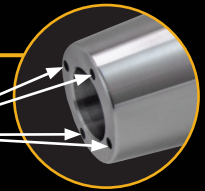
Coolant through tool:



Coolant through coolant ports:



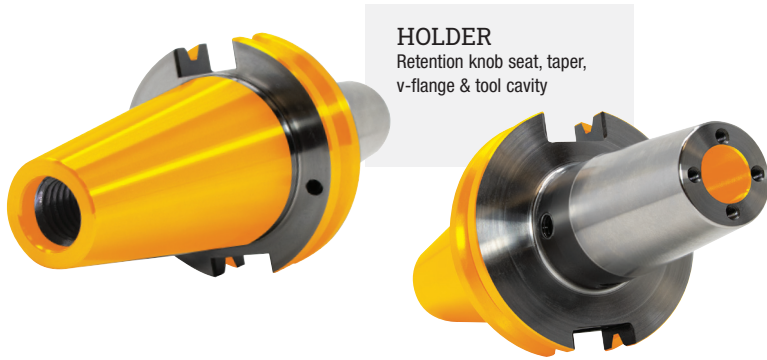
Four Coolant Ports in the Nose



GS Tooling coolant-through Shrink Fit Holders require no special backup screws or seals. The fit between the I.D. of the holder and cutting tool shank forms the seal, preventing the coolant from flowing anywhere else except through the coolant ports. Coolant ports can be closed with a 3mm set screw.

GS Tooling shrink fit holders and components are ground to perfection

For an extra level of precision, we start with prebalanced holders and components. We then invest the time to grind all surfaces that will be in contact with the machine to a fine finish, giving our holder a **runout accuracy of 0.0001"** and our **taper and collet cavities an accuracy of AT2 or better** (Compare this with the runout accuracy of 0.0002" and taper accuracy AT3 of other brands). This offers a tighter connectivity and grip in all mated areas, increasing tolerances throughout.



PREMIUM BALANCE
G2.5 at 30,000rpm
CERTIFICATE INCLUDED
 CAT/BT 30, 40, HSK63A

PREMIUM BALANCE
G2.5 at 25,000rpm
CERTIFICATE INCLUDED
 CAT50, HSK100A


Artist rendering uses a gold color on the holder and components to clearly show all surfaces that are ground.




 Coolant Port Screws
 4 screws included with
 holders over 6mm I/D.

Quality QC

All GS Tooling holders are inspected, one piece at a time. An individualized balance certificate of inspection is included with each holder.

		BALANCE CERTIFICATION	
Machine:	_____		
Rotor Name:	_____	Correction Diameter:	_____
Date:	_____	Correction Mode:	_____
Rotor No.:	_____	Result:	_____
Measuring Speed:	_____	_____	
This Holder is Balanced To		/ RPM	
Signature:	_____		
<small>For Customer Service Inquiries please call Sowa Tool & Machine Co. Ltd. at 1-800-265-8221</small>			

Explore all of our rotary tooling systems.

Sowa Tool offers a large SKU offering of a wide range of quality rotary tooling: End Mill Holders, Collet Chucks & Collets, Shell Mill & Face Mill Holders, Shrink Fit Holders, Tap Holders, Driven Tooling and Angle Heads.



CAT40/CAT50 Shrink Fit Holders With Coolant Ports

Simple and fast. The total time elapsed to remove one cutting tool and insert another is **less than 10 seconds**.

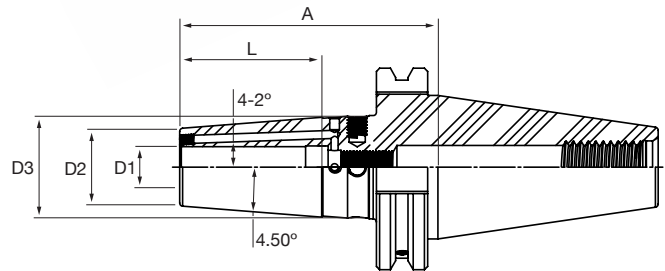
Four coolant ports come standard for through-spindle coolant capability, allowing for even faster cutting speeds!

Balanced & Certified – the best out there!
G2.5 at 30,000rpm (CAT/BT 30, 40, HSK63A)
G2.5 at 25,000rpm (CAT50, HSK100A)

Tool is **gripped 360° along the entire length of the bore**. This results in maximum clamping force, greater rigidity, and an exceptional concentricity (0.0001"/0.003mm). You can run your machine at faster speeds and feeds with no danger of the tool slipping or bending.

Short projections are possible because no mechanical clamping devices are used. No moving parts and low centrifugal forces due to low holder mass allow for a **long holder life with tighter tolerances**.

Chip load is distributed evenly along the cutting edge of the tool which results in longer tool life.

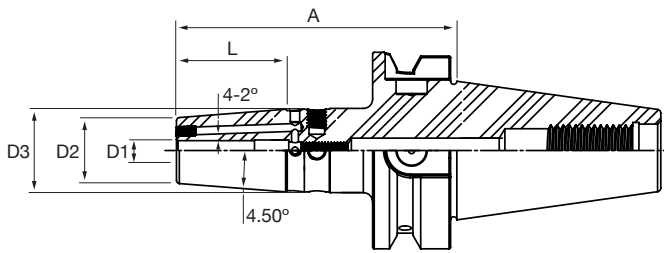


Taper	Hole Diameter (D1)	Gage Length (A)	D2	D3	L	Code No.
Inch						
CAT40	1/8"	3.15"	0.59"	0.787"	0.35"	541838*
	3/16"	3.15"	0.59"	0.787"	0.47"	541840*
	1/4"	3.15"	0.83"	1.06"	1.42"	541842
	1/4"	6.30"	0.83"	1.06"	1.42"	541844
	5/16"	3.15"	0.83"	1.06"	1.42"	541846
	5/16"	6.30"	0.83"	1.06"	1.42"	541848
	3/8"	3.15"	0.94"	1.26"	1.65"	541850
	3/8"	6.30"	0.94"	1.26"	1.65"	541852
	1/2"	3.15"	0.94"	1.26"	1.65"	541854
	1/2"	6.30"	0.94"	1.26"	1.65"	541856
	5/8"	3.15"	1.06"	1.34"	1.97"	541858
	3/4"	3.15"	1.30"	1.65"	2.05"	541862
	3/4"	6.30"	1.30"	1.65"	2.05"	541864
	1"	3.94"	1.73"	2.09"	2.28"	541866
	1"	6.30"	1.73"	2.09"	2.28"	541868
	1-1/4"	3.94"	1.73"	2.09"	2.28"	541870
	1-1/4"	6.30"	1.73"	2.09"	2.28"	541872
	CAT50	1/4"	3.15"	0.83"	1.06"	1.42"
1/4"		6.30"	0.83"	1.06"	1.42"	541934
5/16"		3.15"	0.83"	1.06"	1.42"	541936
3/8"		3.15"	0.94"	1.26"	1.65"	541940
3/8"		6.30"	0.94"	1.26"	1.65"	541942
1/2"		3.15"	1.06"	1.34"	1.65"	541944
1/2"		6.30"	0.94"	1.26"	1.65"	541946
5/8"		3.15"	1.06"	1.34"	1.97"	541948
5/8"		6.30"	1.06"	1.34"	1.97"	541950
3/4"		3.15"	1.30"	1.65"	2.05"	541952
3/4"		6.30"	1.30"	1.65"	2.05"	541954
1"		3.94"	1.73"	2.09"	2.28"	541956
1"		6.30"	1.73"	2.09"	2.28"	541958
1-1/4"		3.94"	1.73"	2.09"	2.28"	541960
1-1/4"		6.30"	1.73"	2.09"	2.28"	541962

Taper	Hole Diameter (D1)	Gage Length (A)	D2	D3	L	Code No.
Metric						
CAT40	4mm	80mm	15mm	20mm	12mm	541802*
	6mm	80mm	21mm	27mm	36mm	541806
	6mm	160mm	21mm	27mm	36mm	541808
	8mm	80mm	21mm	27mm	36mm	541810
	8mm	160mm	21mm	27mm	36mm	541812
	10mm	80mm	24mm	32mm	42mm	541814
	10mm	160mm	24mm	32mm	42mm	541816
	12mm	80mm	24mm	32mm	47mm	541818
	12mm	160mm	24mm	32mm	47mm	541820
	16mm	80mm	27mm	34mm	50mm	541822
	16mm	160mm	27mm	34mm	50mm	541824
	20mm	80mm	33mm	42mm	52mm	541826
	25mm	100mm	44mm	53mm	58mm	541830
	32mm	100mm	44mm	53mm	58mm	541834
	6mm	80mm	21mm	27mm	36mm	541900
	6mm	160mm	21mm	27mm	36mm	541902
	8mm	80mm	21mm	27mm	36mm	541904
	8mm	160mm	21mm	27mm	36mm	541906
10mm	80mm	24mm	32mm	42mm	541908	
10mm	160mm	24mm	32mm	42mm	541910	
12mm	80mm	24mm	32mm	47mm	541912	
12mm	160mm	24mm	32mm	47mm	541914	
16mm	80mm	27mm	34mm	50mm	541916	
16mm	160mm	27mm	34mm	50mm	541918	
20mm	80mm	33mm	42mm	52mm	541920	
25mm	100mm	44mm	53mm	58mm	541924	
32mm	100mm	44mm	53mm	58mm	541928	

*No coolant ports or threaded balance holes on holders under 6mm I.D.

BT30/BT40 Shrink Fit Holders With Coolant Ports



Taper	Hole Diameter (D1)	Gage Length (A)	D2	D3	L	Code No.
Inch						
BT30	1/8"	3.15"	0.39"	-	0.35"	542414*
	3/16"	3.15"	0.39"	-	0.47"	542416*
	1/4"	3.15"	0.83"	1.06"	1.42"	542418
	3/8"	3.15"	0.94"	1.26"	1.65"	542422
	1/2"	3.15"	0.94"	1.26"	1.65"	542424
BT40	3/16"	3.54"	0.39"	-	0.47"	542466*
	1/4"	3.54"	0.83"	1.06"	1.42"	542468
	1/4"	6.30"	0.83"	1.06"	1.42"	542470
	3/8"	3.54"	0.94"	1.26"	1.65"	542476
	1/2"	3.54"	1.06"	1.34"	1.65"	542480
	1/2"	6.30"	1.06"	1.34"	1.65"	542482
	3/4"	3.54"	1.30"	1.65"	2.05"	542488
	3/4"	6.30"	1.30"	1.65"	2.05"	542490
	1"	3.94"	1.73"	2.09"	2.28"	542492
	1-1/4"	3.94"	1.73"	2.09"	2.28"	542496
Metric						
BT30	4mm	80mm	10mm	-	12mm	542402*
BT40	6mm	90mm	21mm	27mm	36mm	542432
	8mm	90mm	21mm	27mm	36mm	542436

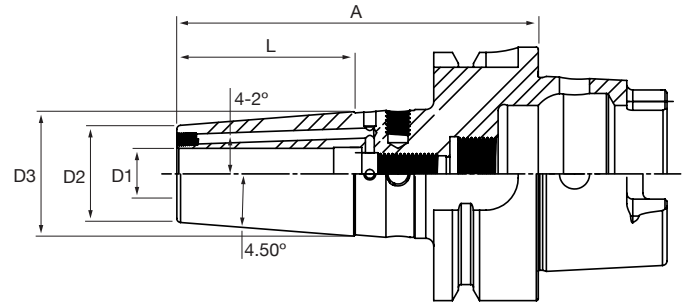
Coolant Port Screws

Set screws that allow you to close coolant ports.
4 screws per package.
No coolant ports on holders under 6mm I.D.



Description	Overall Length	Code No.
Coolant port screws	3mm	541801

HSK63A/HSK100A Shrink Fit Holders With Coolant Ports



Taper	Hole Diameter (D1)	Gage Length (A)	D2	D3	L	Code No.
Inch						
HSK63A	1/8"	3.15"	0.59"	0.787"	0.35"	546338*
	3/16"	3.15"	0.59"	0.787"	0.47"	546340*
	1/4"	3.15"	0.826"	1.06"	1.42"	546342
	1/4"	6.30"	0.83"	1.06"	1.42"	546344
	5/16"	3.15"	0.826"	1.06"	1.42"	546346
	3/8"	3.35"	0.94"	1.26"	1.65"	546350
	3/8"	6.30"	0.94"	1.26"	1.65"	546352
	1/2"	3.54"	1.06"	1.34"	1.65"	546354
	1/2"	6.30"	1.06"	1.34"	1.65"	546356
	5/8"	3.74"	1.06"	1.34"	1.97"	546358
	5/8"	6.30"	1.06"	1.34"	1.97"	546360
	3/4"	3.94"	1.30"	1.65"	2.05"	546362
	3/4"	6.30"	1.30"	1.65"	2.05"	546364
	1"	4.53"	1.73"	2.09"	2.28"	546366
	1"	6.30"	1.73"	2.09"	2.28"	546368
1-1/4"	4.72"	1.73"	2.09"	2.28"	546370	
1-1/4"	6.30"	1.73"	2.09"	2.28"	546372	
HSK100A	1/4"	3.35"	0.826"	1.06"	1.42"	546432
	5/16"	3.35"	0.826"	1.06"	1.42"	546436
	3/8"	3.54"	0.94"	1.26"	1.65"	546440
	3/8"	6.30"	0.94"	1.26"	1.65"	546442
	1/2"	3.74"	1.06"	1.34"	1.65"	546444
	1/2"	6.30"	1.06"	1.34"	1.65"	546446
	5/8"	3.94"	1.06"	1.34"	1.97"	546448
	5/8"	6.30"	1.06"	1.34"	1.97"	546450
	3/4"	4.13"	1.30"	1.65"	2.05"	546452
	3/4"	6.30"	1.30"	1.65"	2.05"	546454
	1"	4.53"	1.73"	2.09"	2.28"	546456
	1"	6.30"	1.73"	2.09"	2.28"	546458
	1-1/4"	4.72"	1.73"	2.09"	2.28"	546460
	1-1/4"	6.30"	1.73"	2.09"	2.28"	546462
	Metric					
HSK63A	3mm	80mm	15mm	20mm	-	546300*
	4mm	80mm	15mm	20mm	12mm	546302*
	5mm	80mm	15mm	20mm	15mm	546304*
	6mm	80mm	21mm	27mm	36mm	546306
	6mm	160mm	21mm	27mm	36mm	546308
	8mm	80mm	21mm	27mm	36mm	546310
	10mm	85mm	24mm	32mm	42mm	546314
	12mm	90mm	24mm	32mm	47mm	546318
	16mm	95mm	27mm	34mm	50mm	546322
	20mm	100mm	33mm	42mm	52mm	546326
	25mm	115mm	44mm	53mm	58mm	546330
	32mm	120mm	44mm	53mm	58mm	546334

*No coolant ports or threaded balance holes on holders under 6mm I.D.

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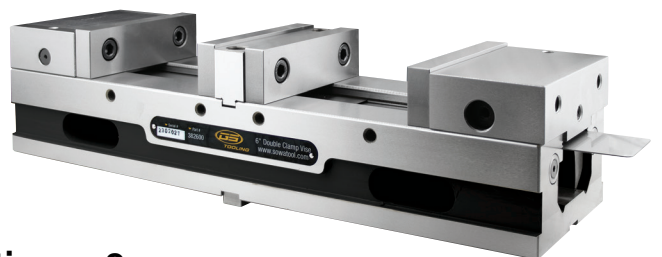


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