

Handling notes for replaceable milling heads with BFS connections

The new BFS connection for replaceable head milling systems makes it quicker and easier to change tools. The interchangeable head is simply inserted, rotated 90 degrees and immediately locked in place, which is significantly more straightforward compared to traditional thread-

based systems. The new BFS system (Bayonet Fitting System) offers very high levels of stability and symmetrical force distribution, which significantly increases tool life and machining quality.



Video clip:
BFS connection | Manual

Assembly of replaceable milling heads with BFS connections

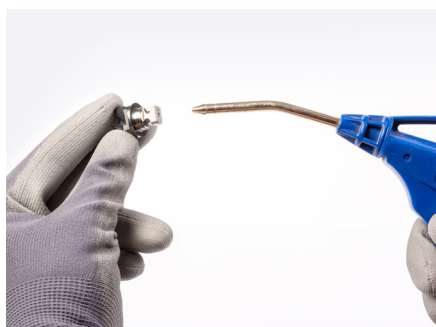
Note:



To minimise the risk of injuries, it is recommended to wear gloves and protective goggles when using compressed-air guns.

Comment:

For trained personnel only



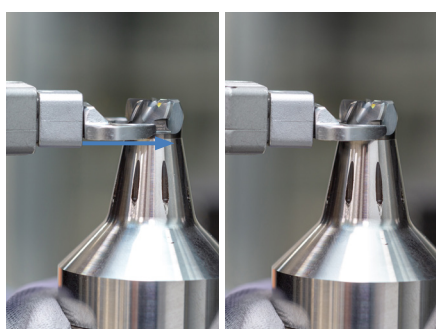
1. Clean the taper and contact surface on the replaceable milling head using compressed air and a cloth.



2. Clean the taper and contact surface on the replaceable head holder using compressed air and a cloth.



3. Hand tighten the replaceable milling head clockwise into the replaceable head holder. Then clamp the replaceable head holder with the tool in the setting fixture or an assembly system.



4. Place the torque wrench on the contact surface of the replaceable milling head so it is as horizontal as possible; do not tilt the faces on the wrench.



5. Tighten the replaceable milling head using the torque wrench and the corresponding combination wrench at the specified tightening torque (see table "Tightening torque of replaceable milling head").



Result:

The gap between the replaceable milling head and replaceable head holder is closed, producing a joint that is both force and form fit. The replaceable milling head is now ready for operation.

Note:

Place your free hand on the replaceable milling head to be able to make delicate adjustments. This allows the tightening torque to be set more precisely.

Tightening torques for replaceable milling heads

Diameter range [mm]	Connection size	Wrench size Open-ended spanner	Tightening torque [Nm]	Order no. Open-ended spanner	Order no. Torque wrench
11,8 - < 12,5	BFS01	SW 11	11	30673291	30641480
> 12,5 - ≤ 13,5	BFS02	SW 11	13	30673291	
> 13,5 - ≤ 15,0	BFS03	SW 12	16	30673292	
> 15,0 - ≤ 16,5	BFS04	SW 13	20	30673293	
> 16,5 - ≤ 18,5	BFS05	SW 15	25	30673294	
> 18,5 - ≤ 20,5	BFS06	SW 16	30	30673295	
> 20,5 - ≤ 22,5	BFS07	SW 18	37	30673296	