

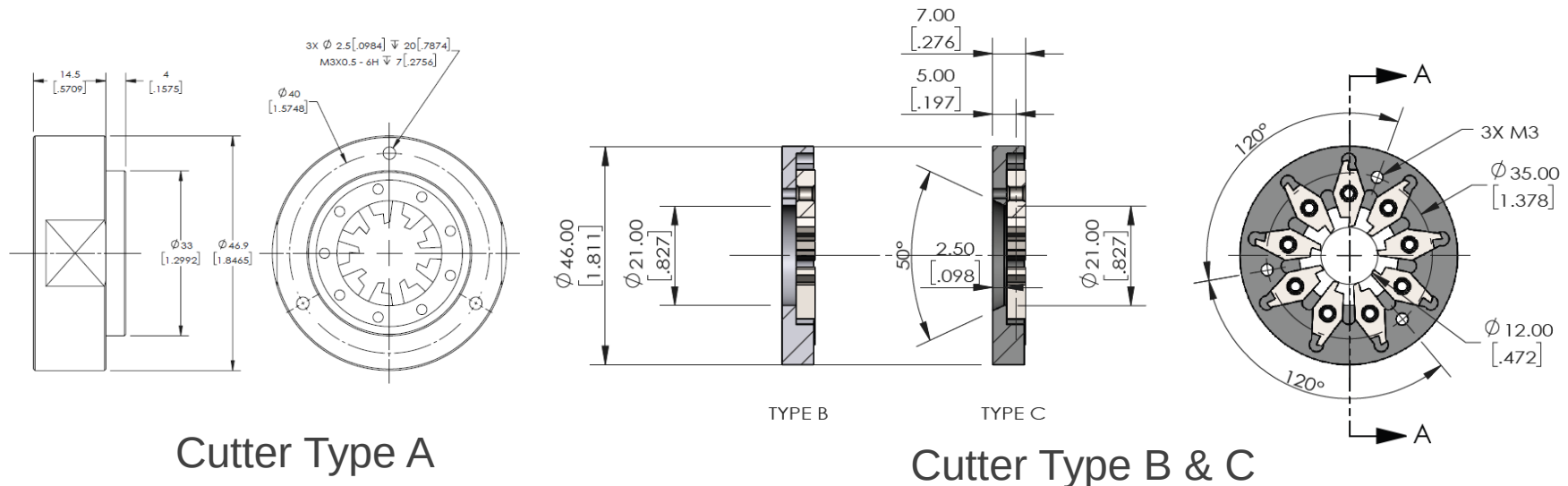
MCC Thread Whirling Brochure

Machine	Type							Brochure Page	Stock Code	Old Stock Code	Tool#	Tool Unit	Max No. of Cross spindle on Gang	Type of Cutter Ring	Setting angle	Tooling Gear Ratio	MAX Output RPM	Note
	3	5	7	8	9	10	12											
A220	-	-	X	-	-	-	-	1	BTW-2000-A220	-	T09(+T08)		2	A	25deg.	1.00	6000	BDF2005 needs to be removed. T08 is not available.
A32/A232	-	-	X	-	-	-	-	3	BTW-2000-A32	-	T10(+T09)		2	A	25deg.	1.00	6000	GDF9101 needs to be removed. T09 is not available.
A320	-	-	X	-	-	-	-	2	BTW-2000-02	BTW-2000-A320	T09(+T08)	A320N U33B	2	A	25deg.	1.00	6000	BDF2007 needs to be removed. T08 is not available.
	-	-	X	-	-	-	-	2	BTW-2000-02	BTW-2000-A320	T09(+T08)	A320N U34B	2	A	25deg.	1.00	6000	BDF2007 needs to be removed. T08 is not available.
	-	-	X	-	-	-	-	25	BTW-2000-07	-	T11(+T10)	A320N U35B	3	A	25deg.	1.00	6000	This unit for A320U35B Live tool unit. T10 is not available.
C220/32	-	-	-	X	-	-	-	-	BTW-1000-M32		T09 (+T08)		2	A	25deg.	1.00	6000	
D25	-	-	-	X	-	-	-	21	BTW-6000-01	BTW-6000-L32	B-axis	D25U32B	3	A	25deg.	1.00	6000	
K16E	-	-	X	-	-	-	-	-	GSW-101-000		T13 (+T12, T14)		1	-	15deg.	-		TW holder vendor is PCM (Gen Swiss)
L12	-	-	X	-	-	-	-	-	LSW-515-000		T10 (+T09)		2	-	15deg.	-		TW holder vendor is PCM (Gen Swiss)
L20E	-	-	-	-	X	X	-	7	BTW-3000-L20E		T13 (+T12)		5	B	15deg.	1.00	6000	
	-	-	-	-	X	X	-	6	BTW-1000-L720		T10 (+T09)		3	A	25deg.	1.00	6000	(GSE3110 or GSE3210) + GSD106 on T12
L220E	-	-	-	X	-	X	-	9	BTW-3100-01	BTW-3100-L220-L32	T13 (+T12)	L220E U30B/U35B/U36B	5	B	15deg.	1.00	6000	GSE3210 is required. Need to mount GSD107 or 109 on T12.
	-	-	-	X	-	X	-	8	BTW-2000-04	BTW-2000-L2032-T810	T11	L220E U30B/U35B/U36B	4	A	25deg.	1.00	6000	
	-	-	-	X	-	X	-	-	BTW-2000-L220-T12		T09(+T08, T10)	L220E U30B/U35B/U36B	5	A	15deg.	1.00	6000	Many possibilities of interference. Consult MCC.
	-	-	-	-	X	-	X	10	BTW-2000-L220-T12		T09(+T08)	L220E U33B/U34B	5	A	15deg.	1.00	6000	Many possibilities depends on B-axis angles. Consult MCC.
	-	-	-	-	X	-	X	11	BTW-3100-01	BTW-3100-L220-L32	T13 (+T12)	L220E U33B/U34B	4	B	15deg.	1.00	6000	BT-BH1000-01 + GSD107 or 109 on T12.
	-	-	-	-	X	-	X	12	BTW-5000-01	BTW-5000-L220	B-axis	L220E U33B/U34B	3	A	25deg.	0.74	5926	4-additional tapped holes (Red marked on the Fig.) on B-Axis mounting face is required. Tap added machine available from machine S/N: QF0218 (L220E/0224)
	-	-	-	-	X	-	X	27	BTW-5200-01 (Tandem)	-	B-axis	L220E U33B/U34B	3	A	25deg.	0.50	6000	
	-	-	-	-	X	-	X	31	BTW-5500-01	-	B-axis	L220E U33B/U34B	3	C (B)	35deg	0.50	6000	

Machine	Type							Brochure Page	Stock Code	Old Stock Code	Tool#	Tool Unit	Max No. of Cross spindle on Gang	Type of Cutter Ring	Setting angle	Tooling Gear Ratio	MAX Output RPM	Note
	3	5	7	8	9	10	12											
L320E	-	-	-	-	X	-	X	11	BTW-3100-01	BTW-3100-L220-L32	T13 (+T12)	L320EU32B	4	A	15deg.	1.00	6000	BT-BH1000-01 + GSD109 on T12.
	-	-	-	-	X	-	X	12	BTW-5000-01	BTW-5000-L220	B-axis	L320EU32B	3	A	25deg.	0.74	5926	BTW-5000 Rev1 (After S/N 22*-076A) needs to be used on L320E
	-	-	-	-	X	-	X	27	BTW-5200-01 (Tandem)	-	B-axis	L320EU32B	3	A	25deg.	0.50	6000	
	-	-	-	-	X	-	X	28	BTW-2000-07		T09(T08)	L320EU32B	5	A	15deg.	1.00	6000	B axis angle and T11 stroke will be restricted. Consult MCC.
	-	-	-	-	X	-	X	31	BTW-5500-01	-	B-axis	L320EU32B	3	C (B)	35deg	0.50	6000	
L32	-	-	-	X	-	X	-	14	BTW-3100-01	BTW-3100-L220-L32	T13 (+T12)	L32 U31B	5	B	15deg.	1.00	6000	GSE3210 + GSD107 or 109 on T12.
	-	-	-	X	-	X	-	13	BTW-2000-04	BTW-2000-L2032-T810	T11	L32 U31B	4	A	25deg.	1.00	6000	
	-	-	-	-	X	-	X	26	BTW-2000-07	-	T08 (+T07, T09)	L32 U32B/U33B	4	A	15Deg	1.00	6000	
	-	-	-	-	X	-	X	15	BTW-3100-02	BTW-3100-L32-B	T13 (+T12)	L32 U32B/U33B	4	B	15deg.	1.00	6000	BT-BH2000-01 + GSD107 or 109 on T12.
	-	-	-	-	X	-	X	16	BTW-6000-01	BTW-6000-L32	B-axis	L32 U32B/U33B	3	A	25deg.	1.00	6000	-
	-	-	-	-	X	-	X	29	BTW-6200-01 (Tandem)	-	B-axis	L32 U32B/U33B	3	A	25deg.	0.50	6000	
L720	-	-	-	X	-	-	-	6	BTW-1000-L720	-	T10 (+T09)		3	A	25deg.	1.00	6000	
M320/32	X	X	-	-	-	-	-	-	BTW-1000-M32	-	T09 (+T08)		3	A	25deg.	1.00	6000	
M416	-	-	-	X	-	-	-	17	BTW-5000-M416	-	B-axis		4	A	15deg.	0.74	5926	4-additional tapped holes (Red marked on the Fig.) on B-Axis mounting face is required. Tap added machine available from machine S/N: P20143 (M416/0152)
M420/32	X	X	X	-	-	-	-	19	BTW-2000-06	BTW-2000-M42032	T10 (+T09)		3	A	25deg.	1.00	6000	
	-	-	-	X	-	-	-	20	BTW-4000-M432		B-axis		4	B	15deg.	1.00	6000	Drive gear on B-axis unit needs to be changed.

Machine	Type							Brochure Page	Stock Code	Old Stock Code	Tool#	Tool Unit	Max No. of Cross spindle on Gang	Type of Cutter Ring	Setting angle	Tooling Gear Ratio	MAX Output RPM	Note
	3	5	7	8	9	10	12											
M532	-	X	X	X	-	-	-	24	BTW-2000-07	-	T08 (+T07, T09)	M532U33B/U34B	5	A	15(25)Deg	1.00	6000	Need to mount idoler unit on T09. In case of 25 deg helix, X1 need all the way UP when Y1 moving.
	-	X	X	-	-	-	-	23	BTW-2000-06	BTW-2000-M42032	T10 (+T09)	M532U34B	3	A	25deg.	1.00	6000	Need to mount idoler unit GSD109 on T09.
	-	-	-	X	-	-	-	22	BTW-6000-01	BTW-6000-L32	B-axis	M532U33B	4	A	25deg.	1.00	6000	BTW-6000 Rev1 (Jun. 2022 or later) needs to be used on M532
	-	-	-	X	-	-	-	30	BTW-6200-01 (Tandem)	-	B-axis	M532U33B	4	A	25deg.	0.5	6000	
Item	Title							Brochure Page	Supplier		Tel		Fax	Email		Note		
Cutter Ring and Insert	How to order Thread Whirling Cutter Ring and Insert							32	Genevieve Swiss Industries		(413) 562-4800		(413) 562-4802	sales@genswiss.com				
								33	NTK Cutting Tools		(866) 900-9800 (248) 668-0100 (from outside U.S.A.)		(248) 668-0200	ctinfo@ntktech.com				
								34	Schwanog LLC		(847) 289-1055		(847) 289-1056	info.usa@schwanog.com				

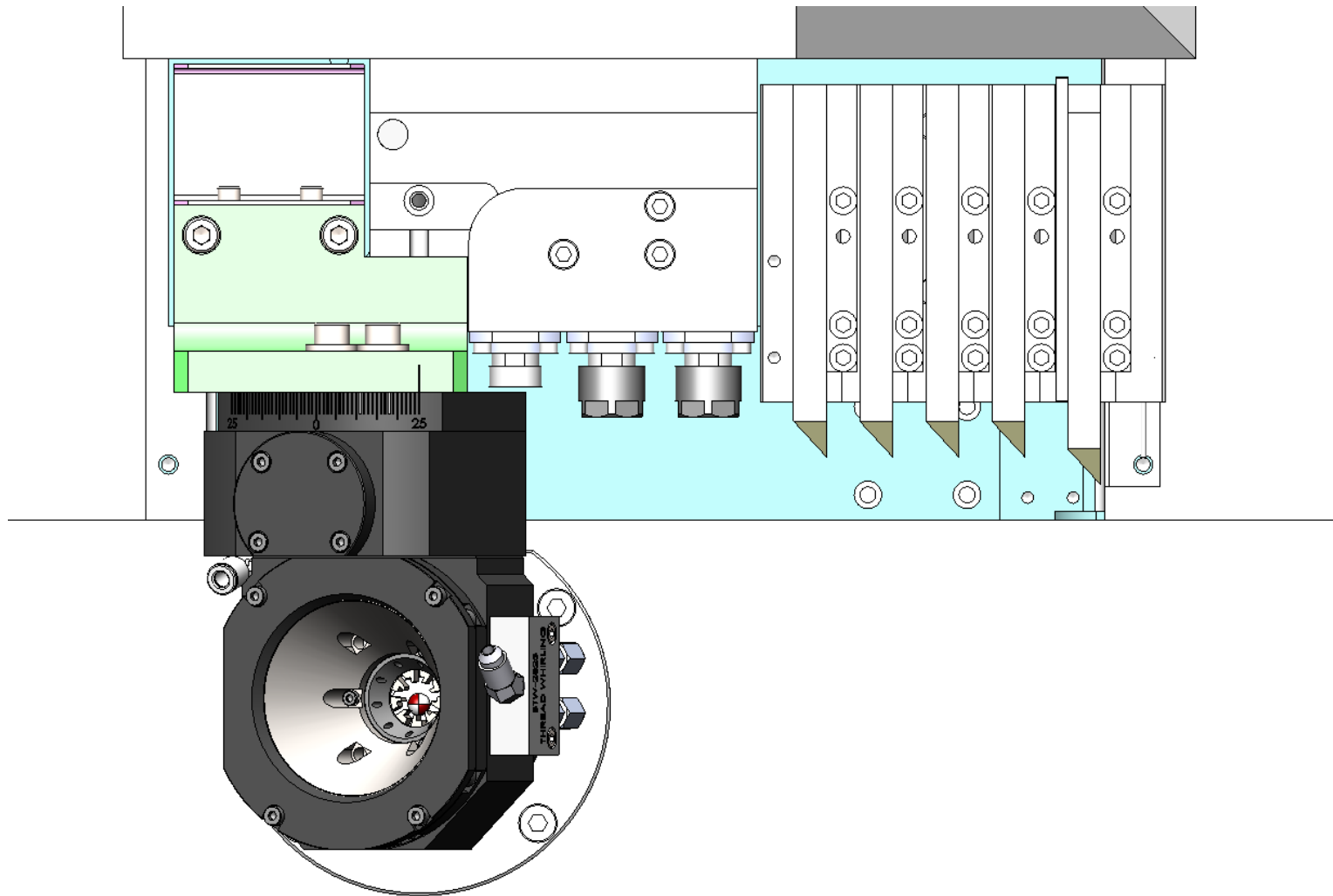
Thread Whirling Cutter Ring Information



1

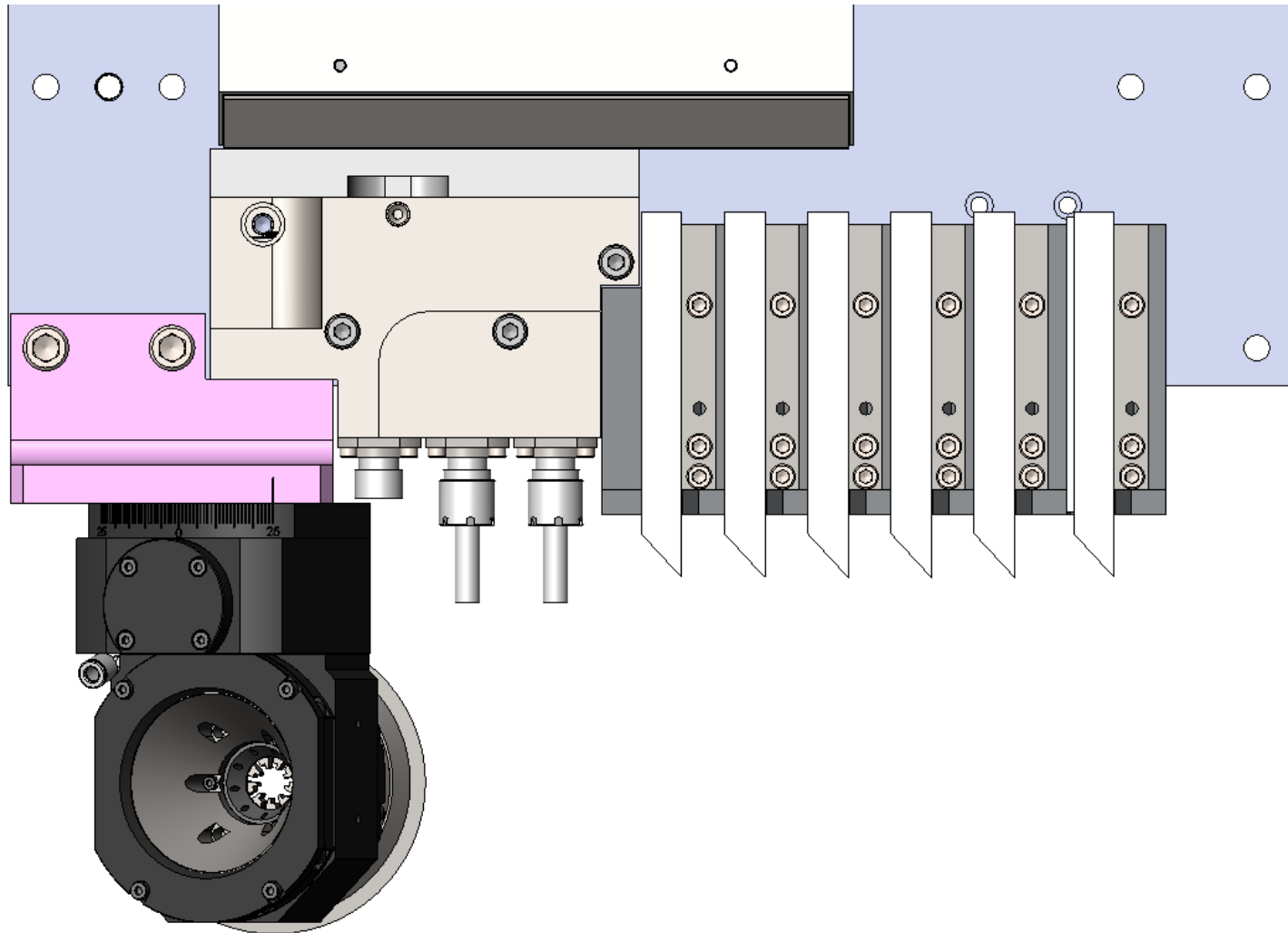
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BTW-2000 on A220, A320



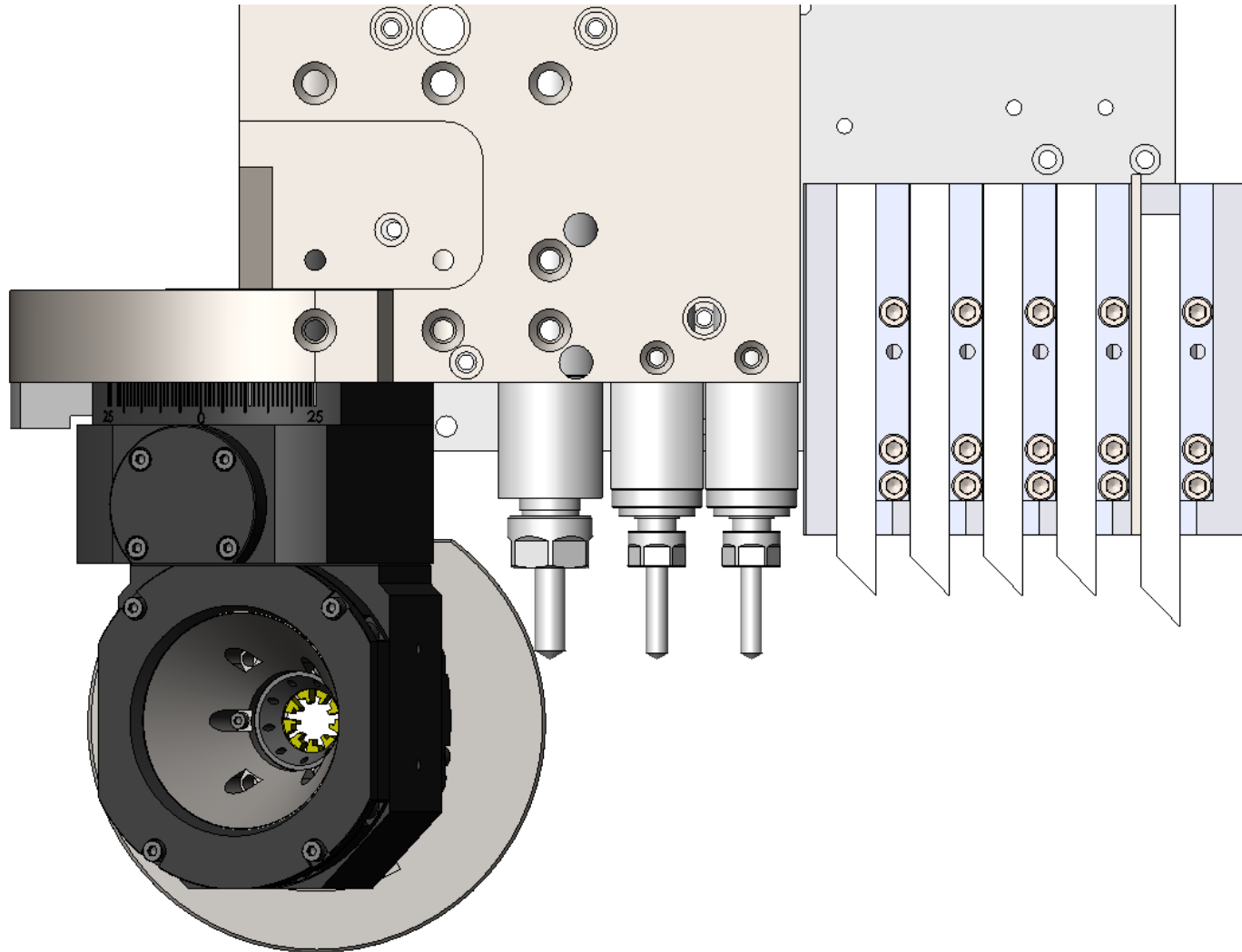
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BTW-2000 on A32, A232

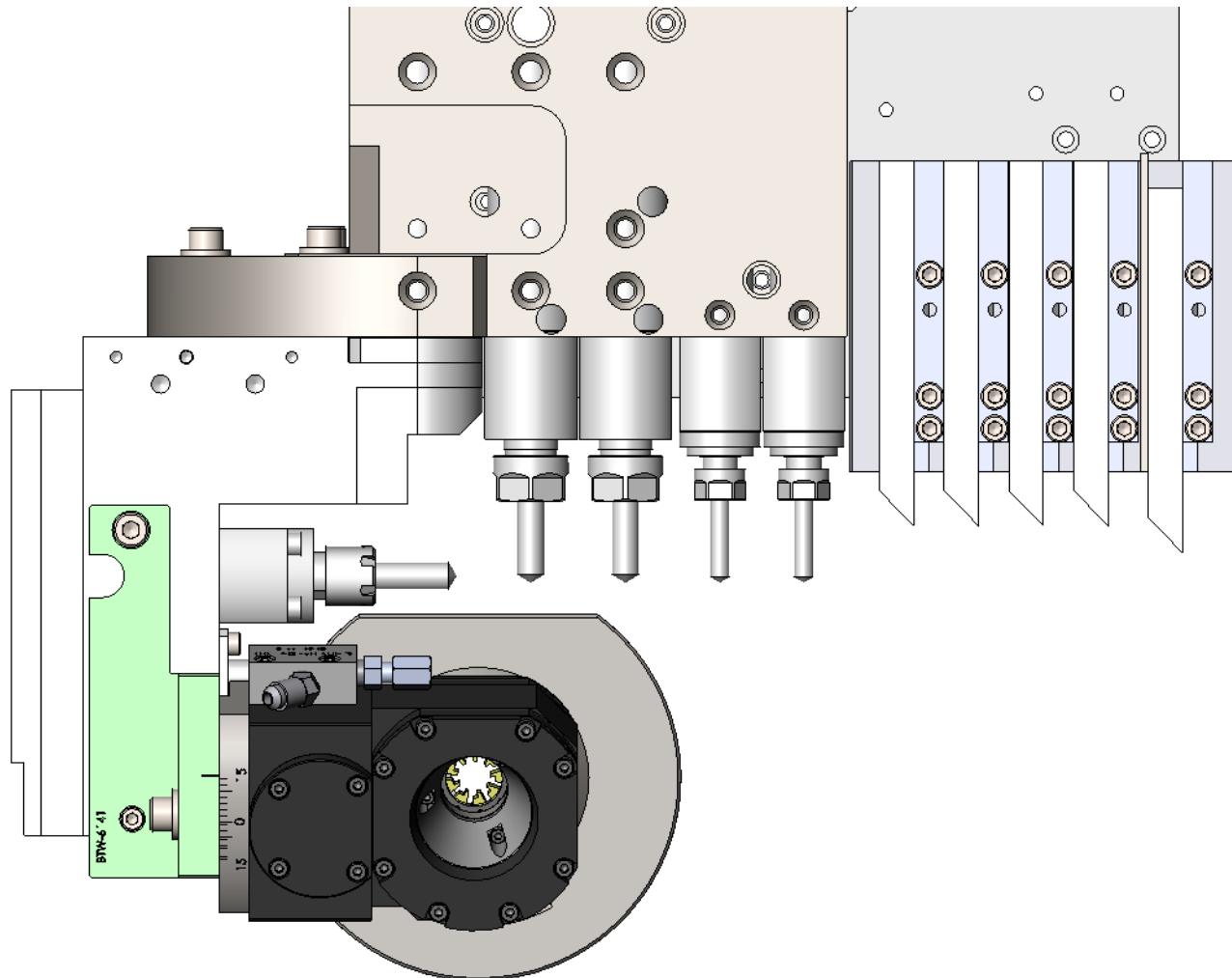


6

BTW-1000-L720

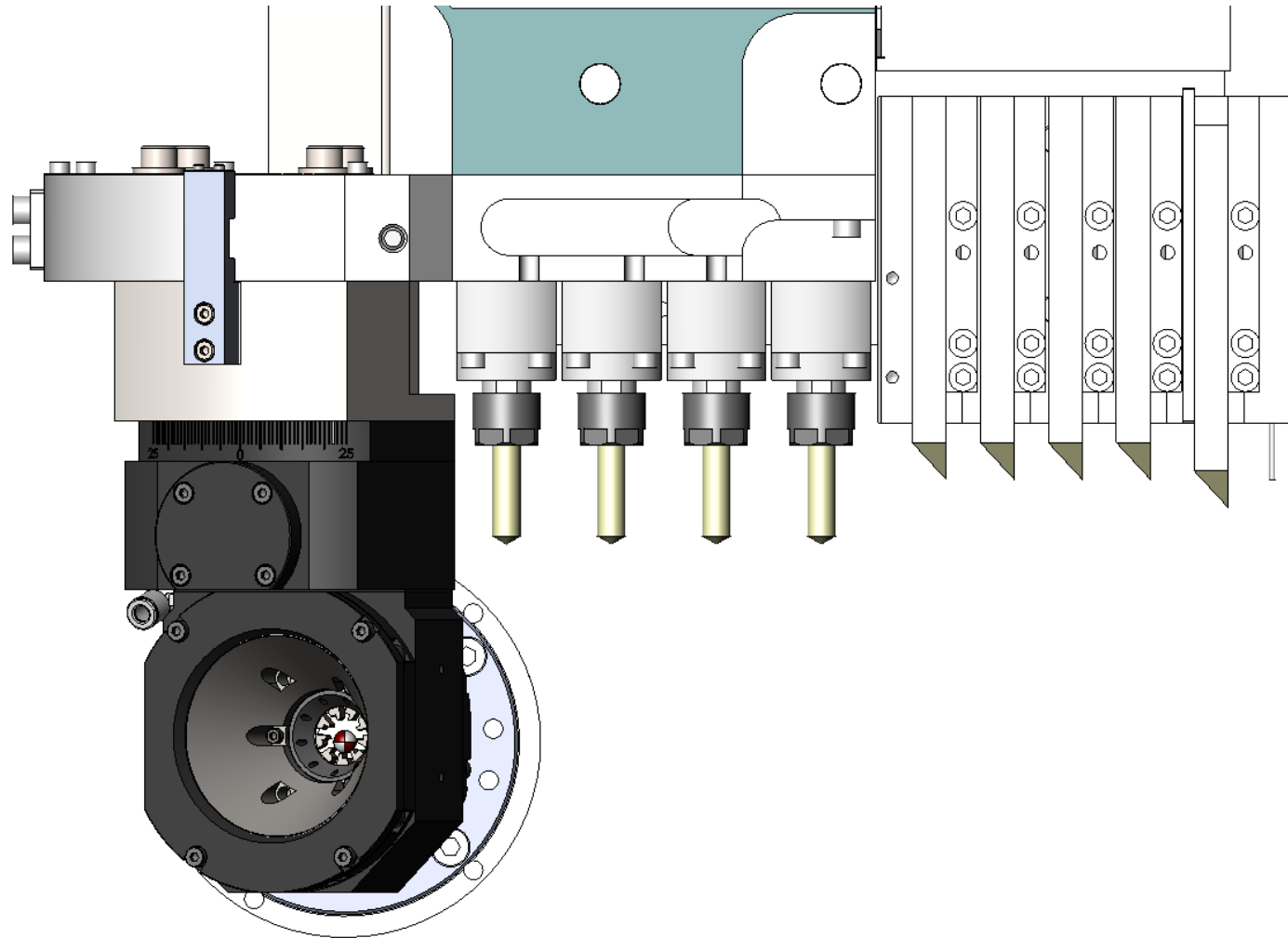


BTW-3000-L20E/L20X



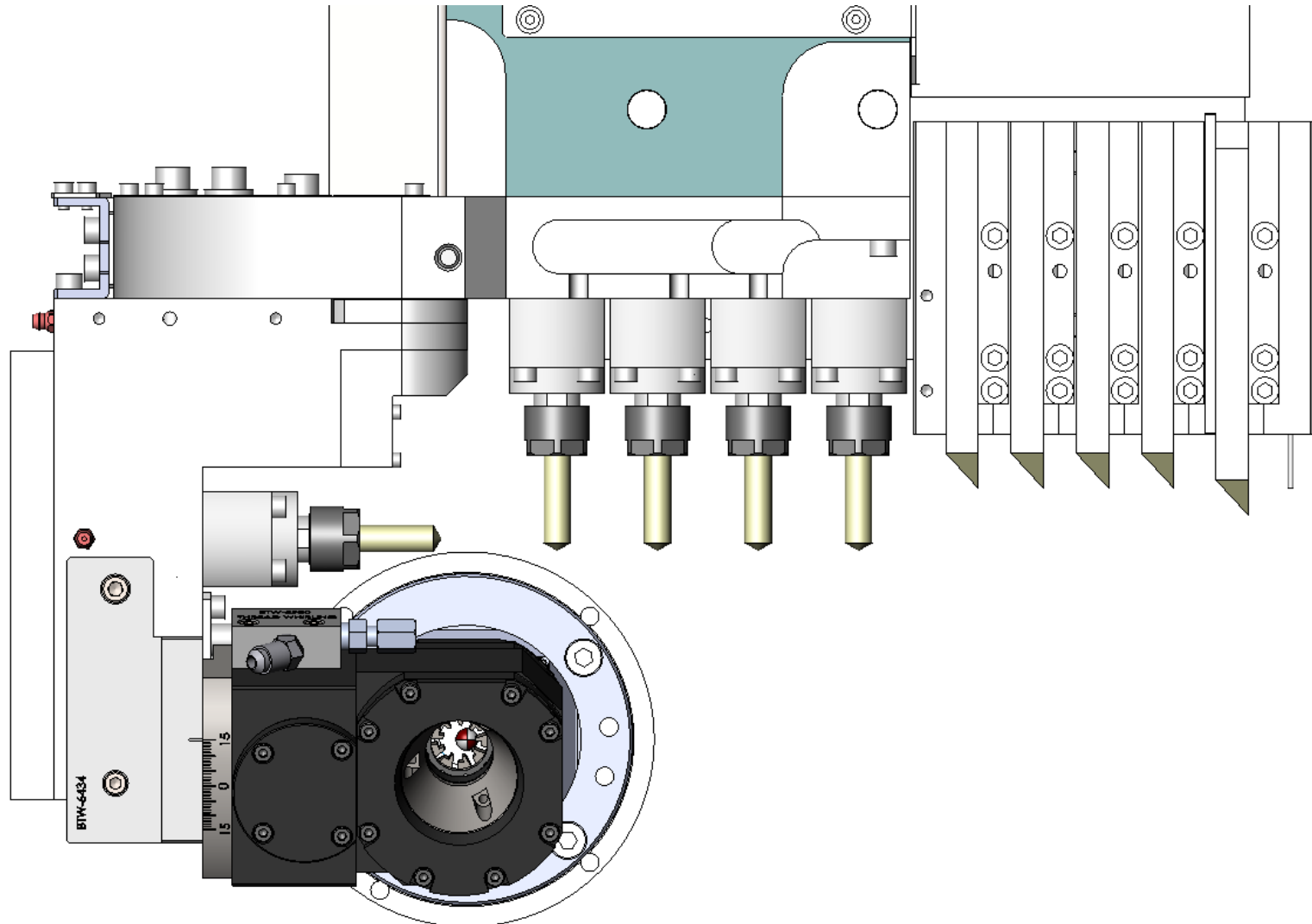
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BTW-2000 on L220E-VIII, X



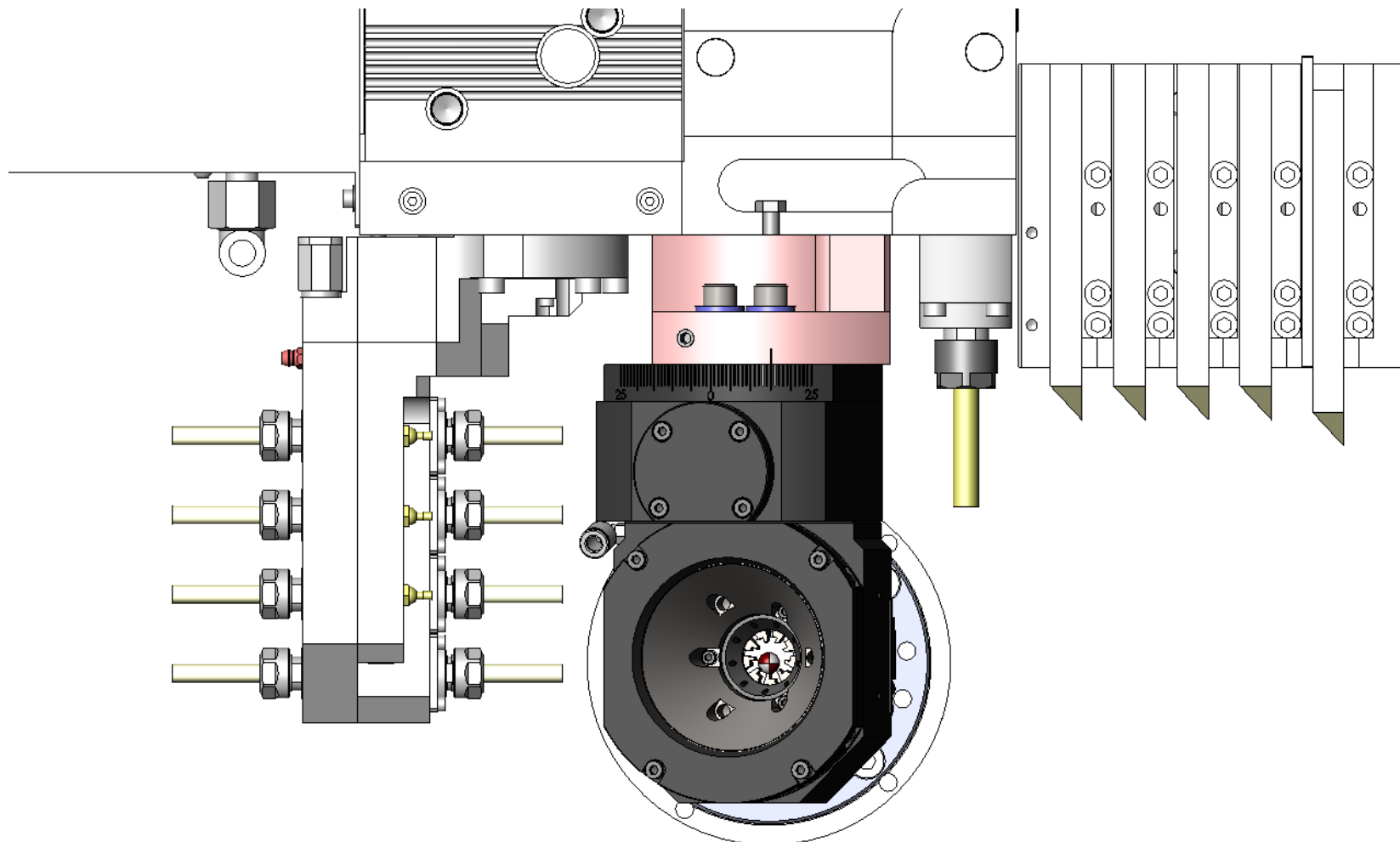
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BTW-3100 on L220E-VIII, X



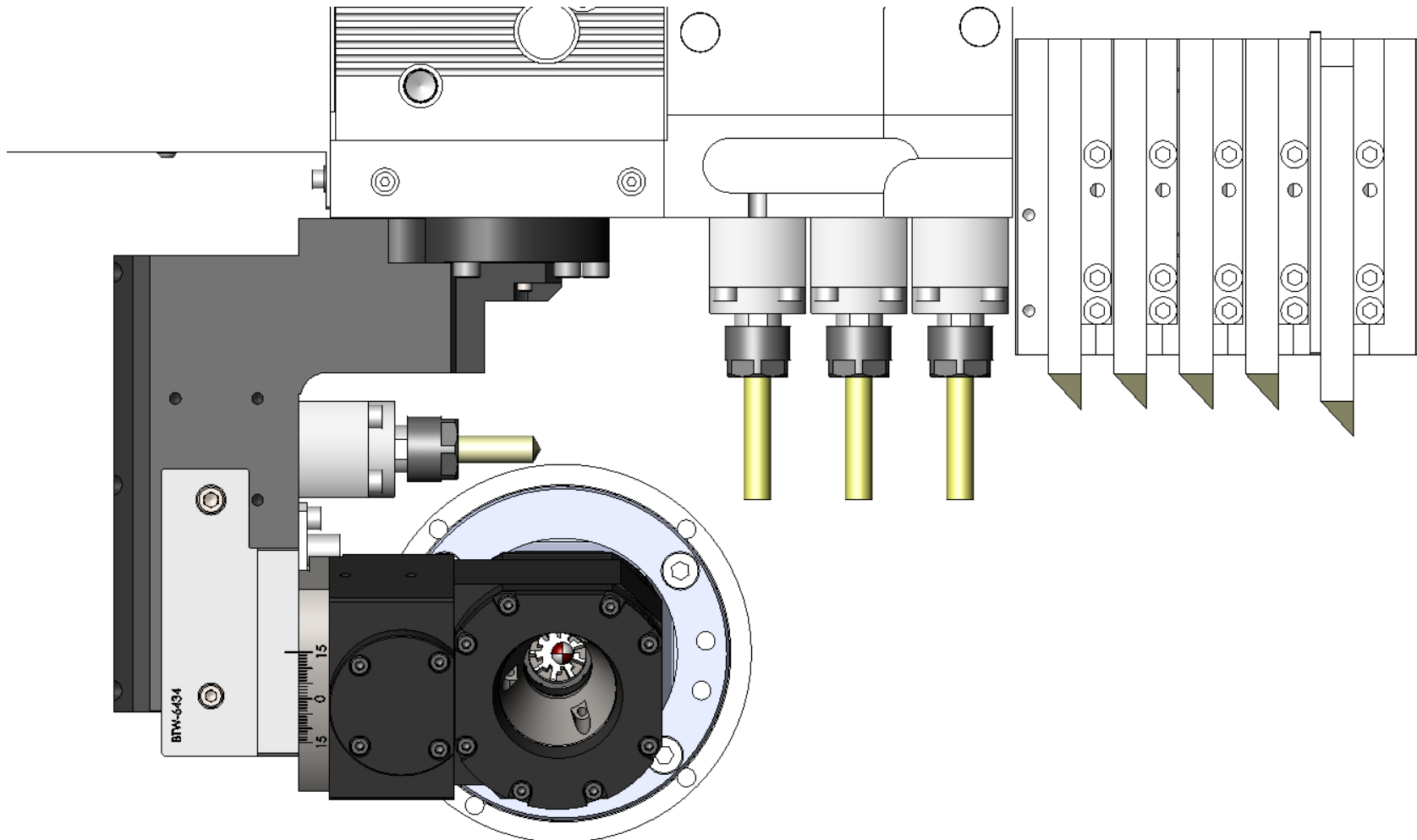
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BTW-2000 on L220E-IX, XII
L320E-IX, XII



11

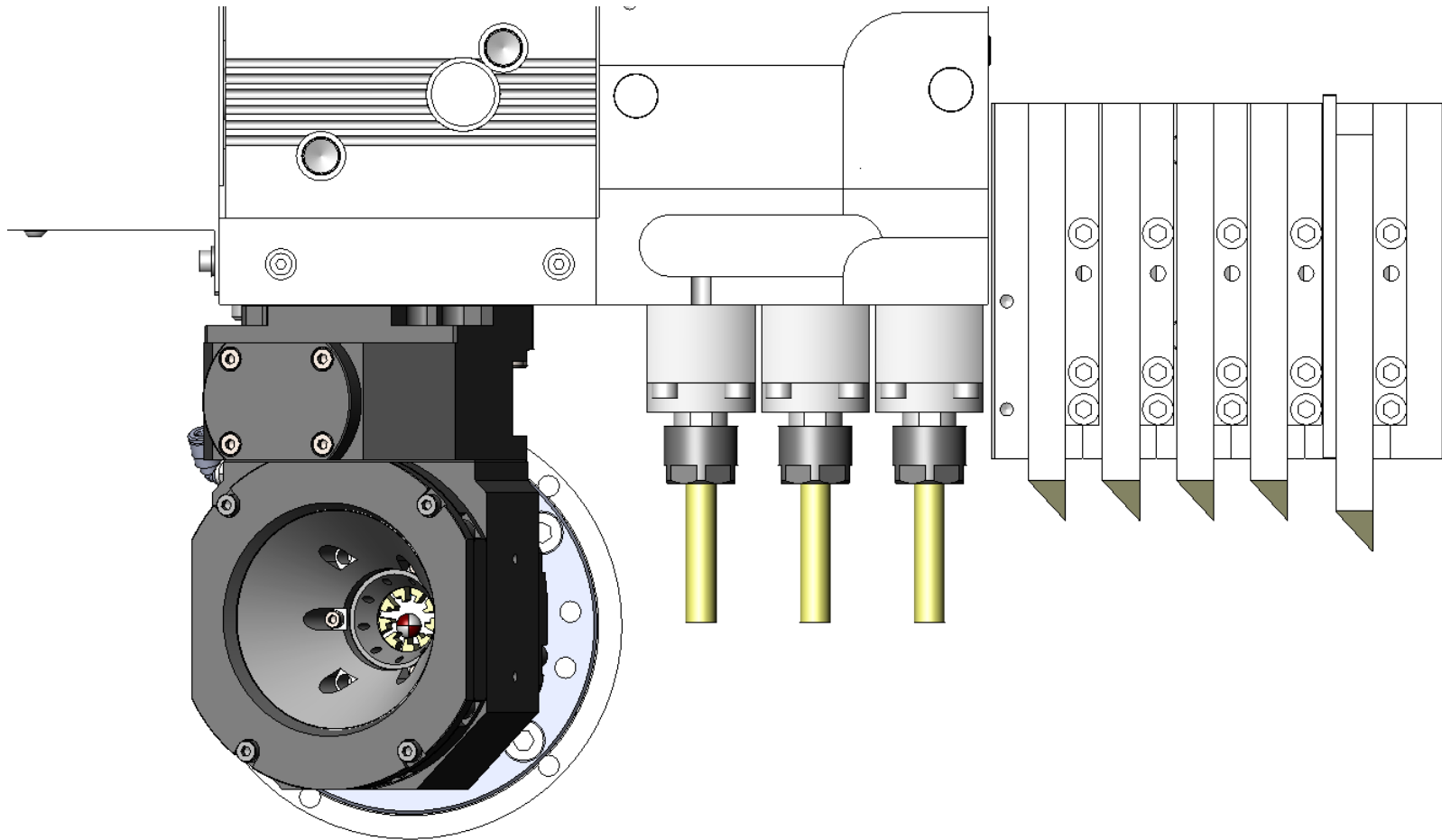
BTW-3100 on L220E-XII L320E-XII



12

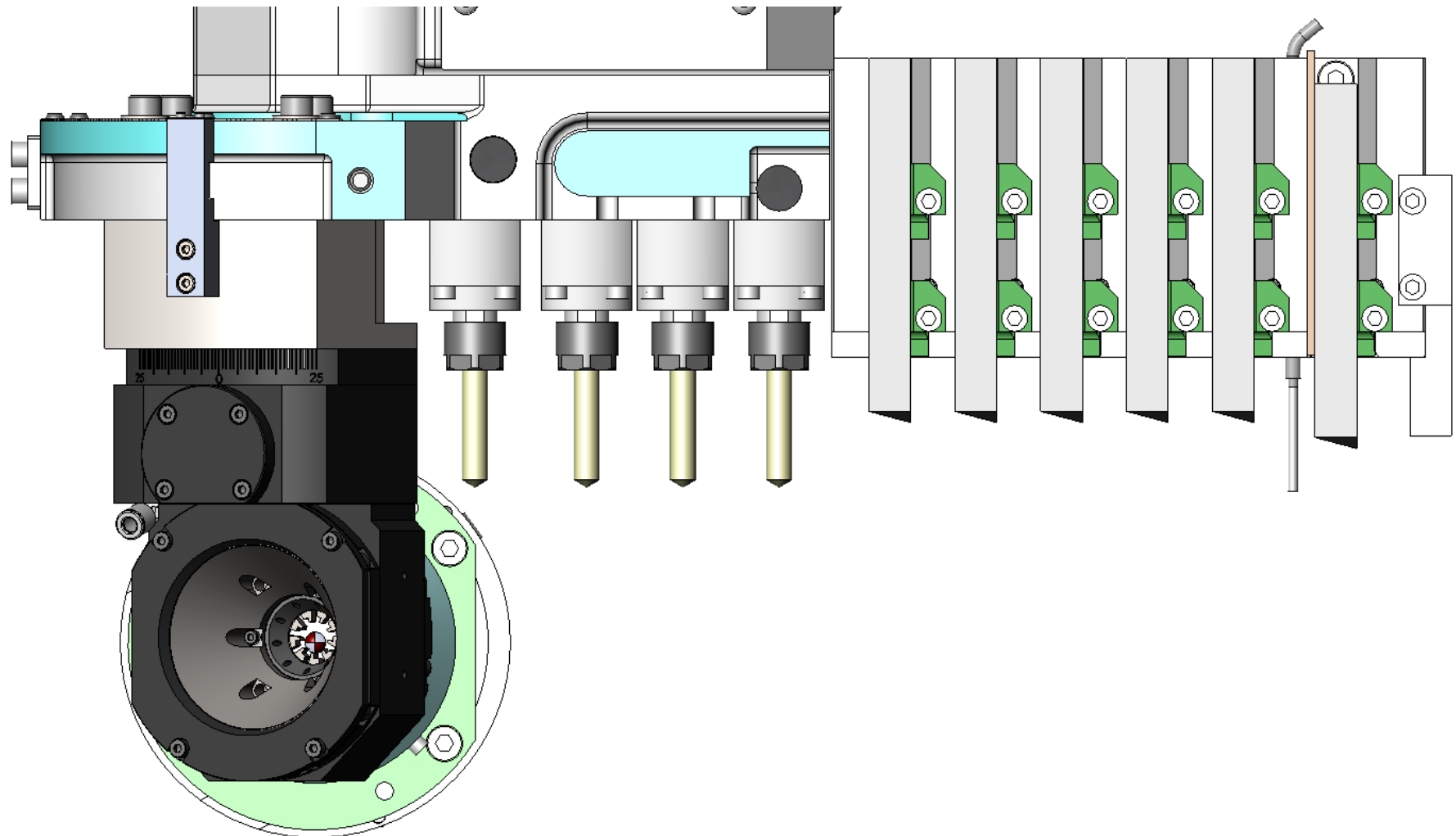
BTW-5000 on L220E-XII (B Axis) L320E-XII (B Axis)

<Note ONLY for L320E> B axis oil lubrication valve needs to be closed.



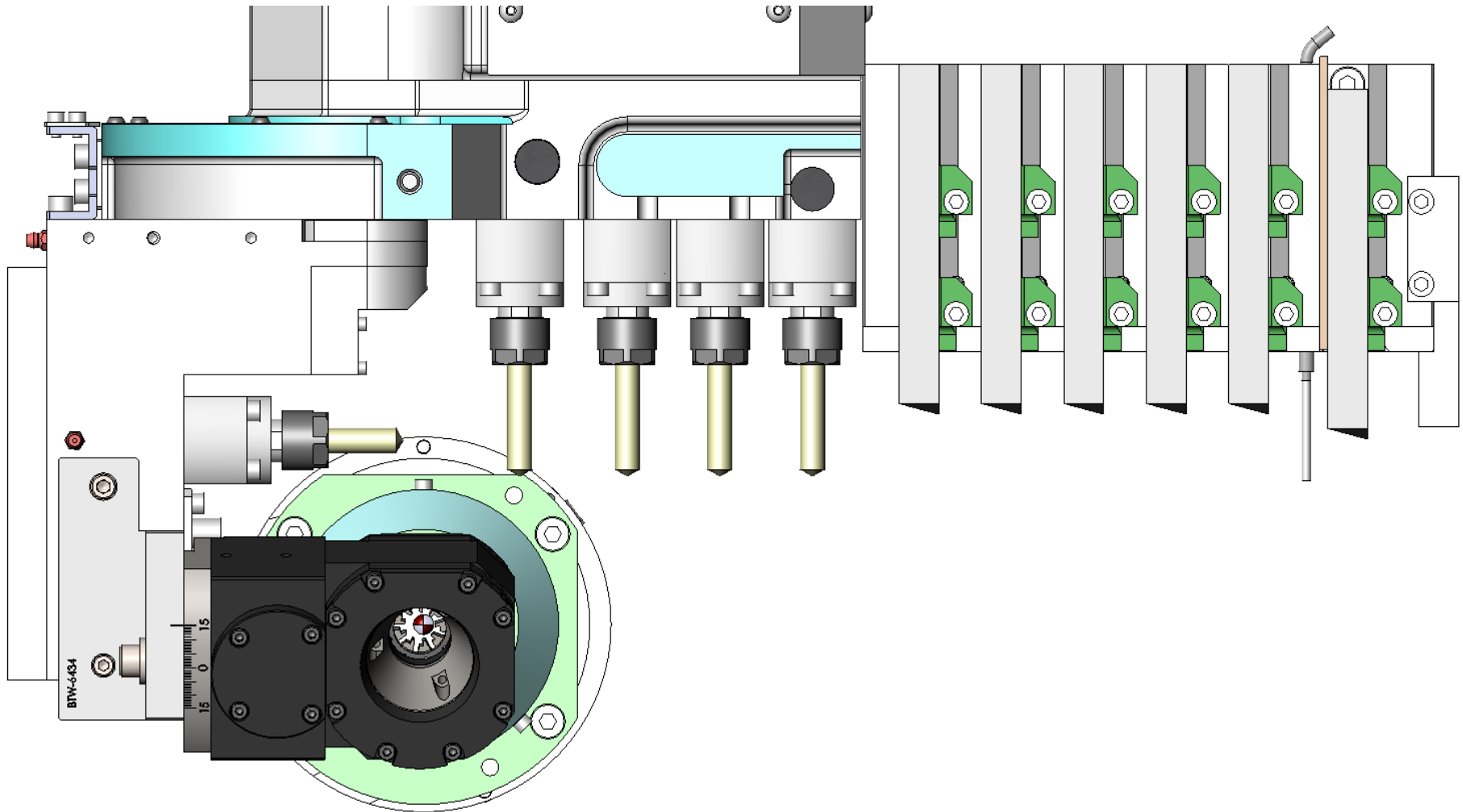
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BTW-2000 on L32-VIII, X



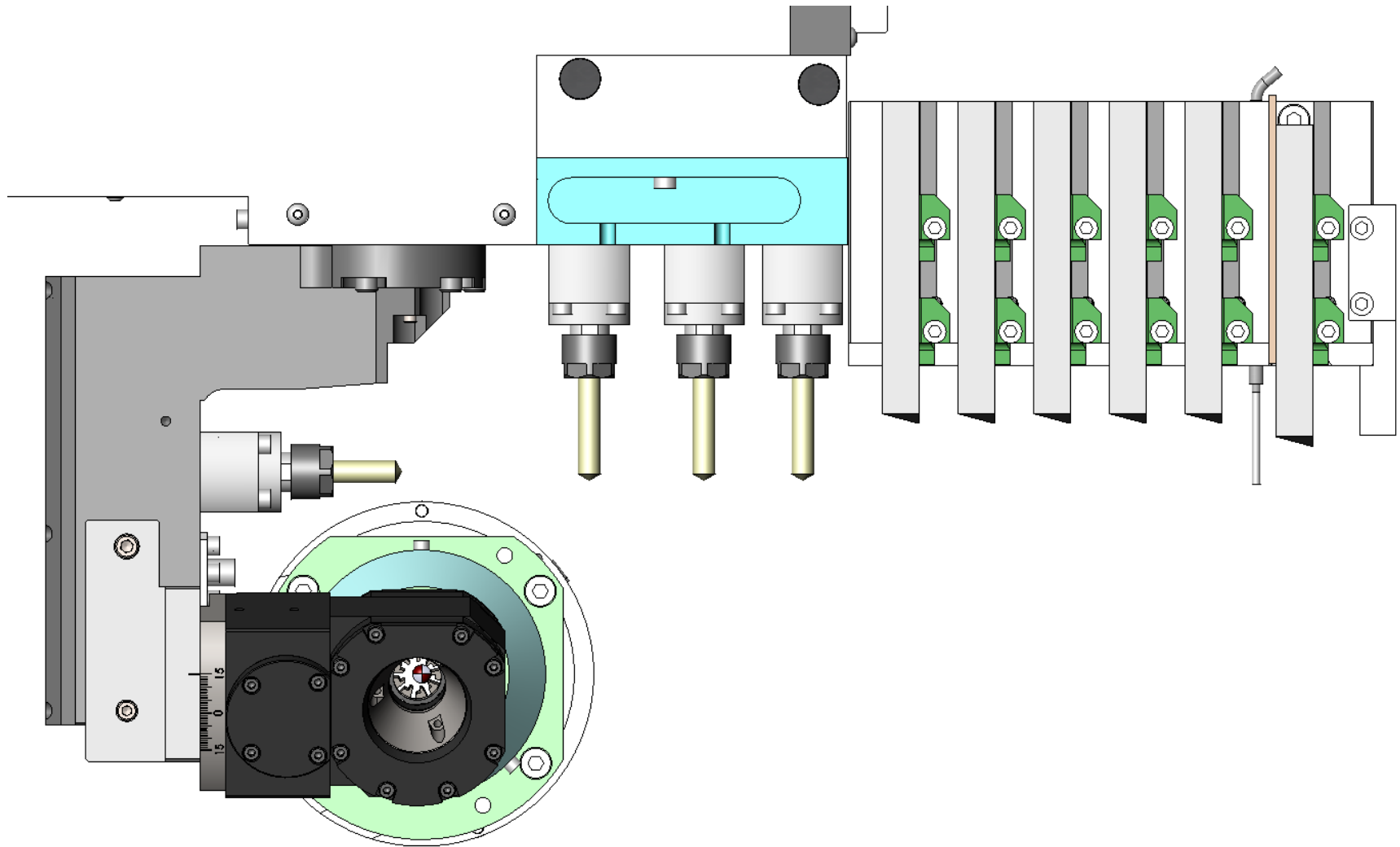
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BTW-3100 on L32-VIII, X



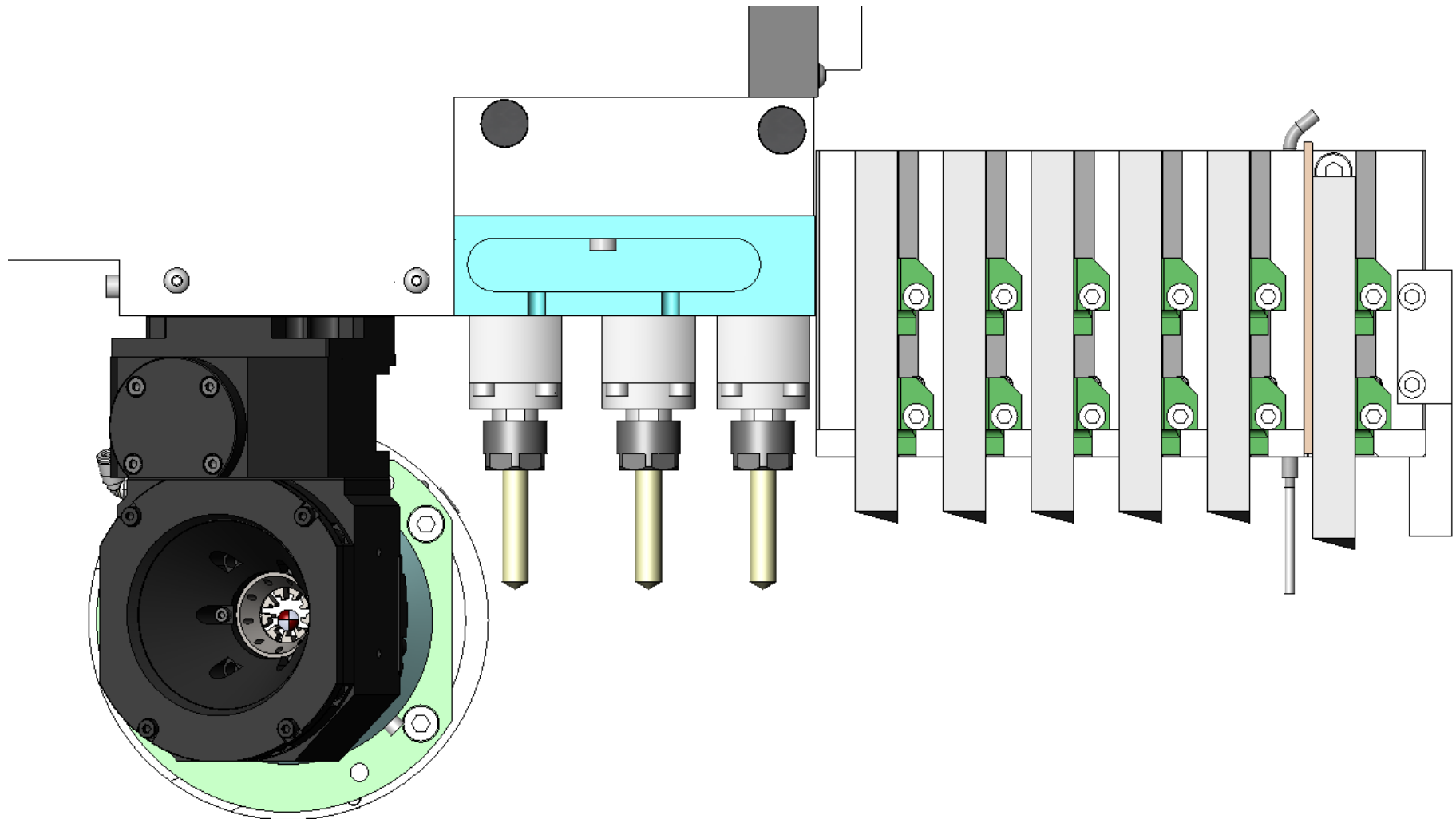
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BTW-3100 on L32-XII



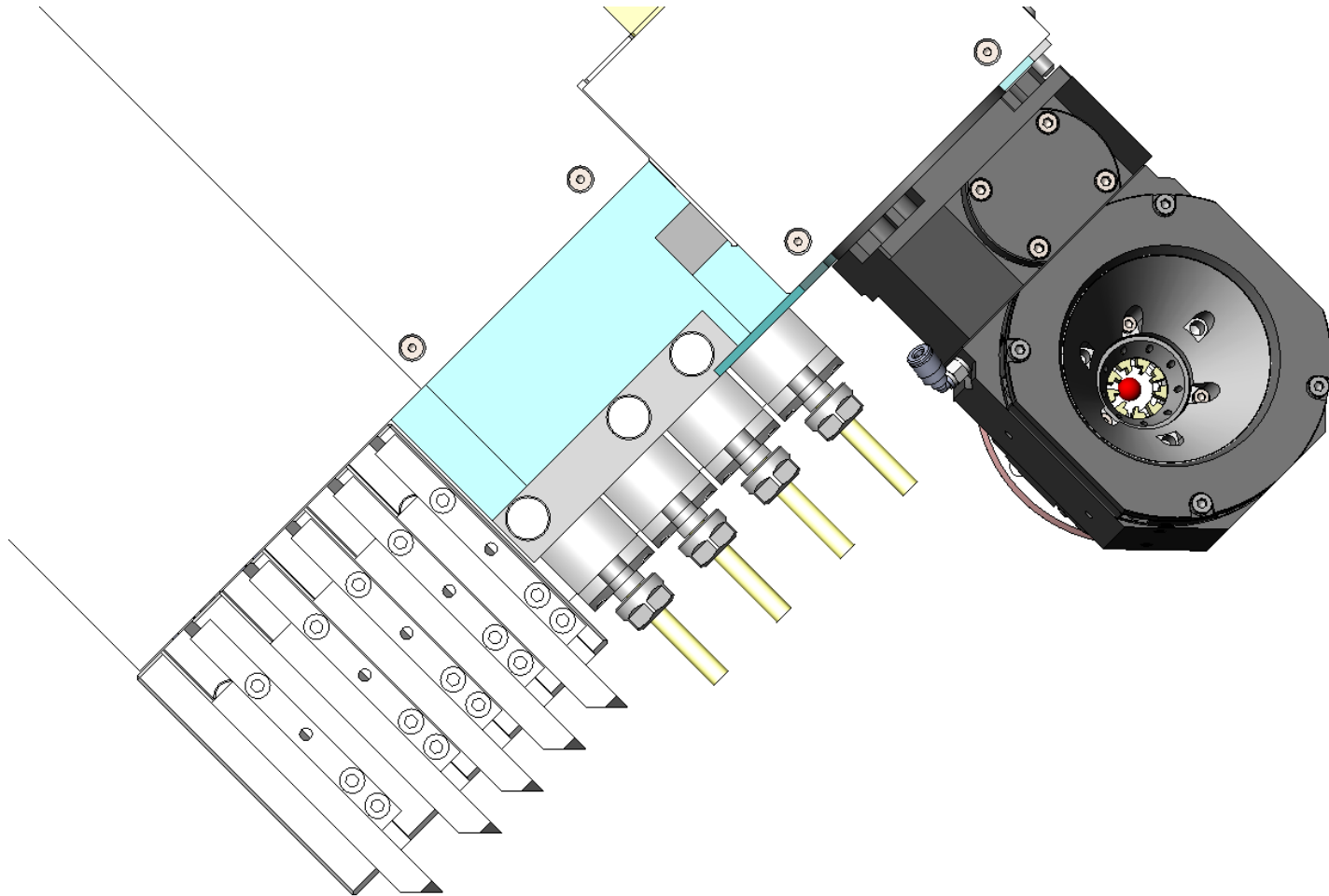
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BTW-6000 on L32-XII (B-Axis)



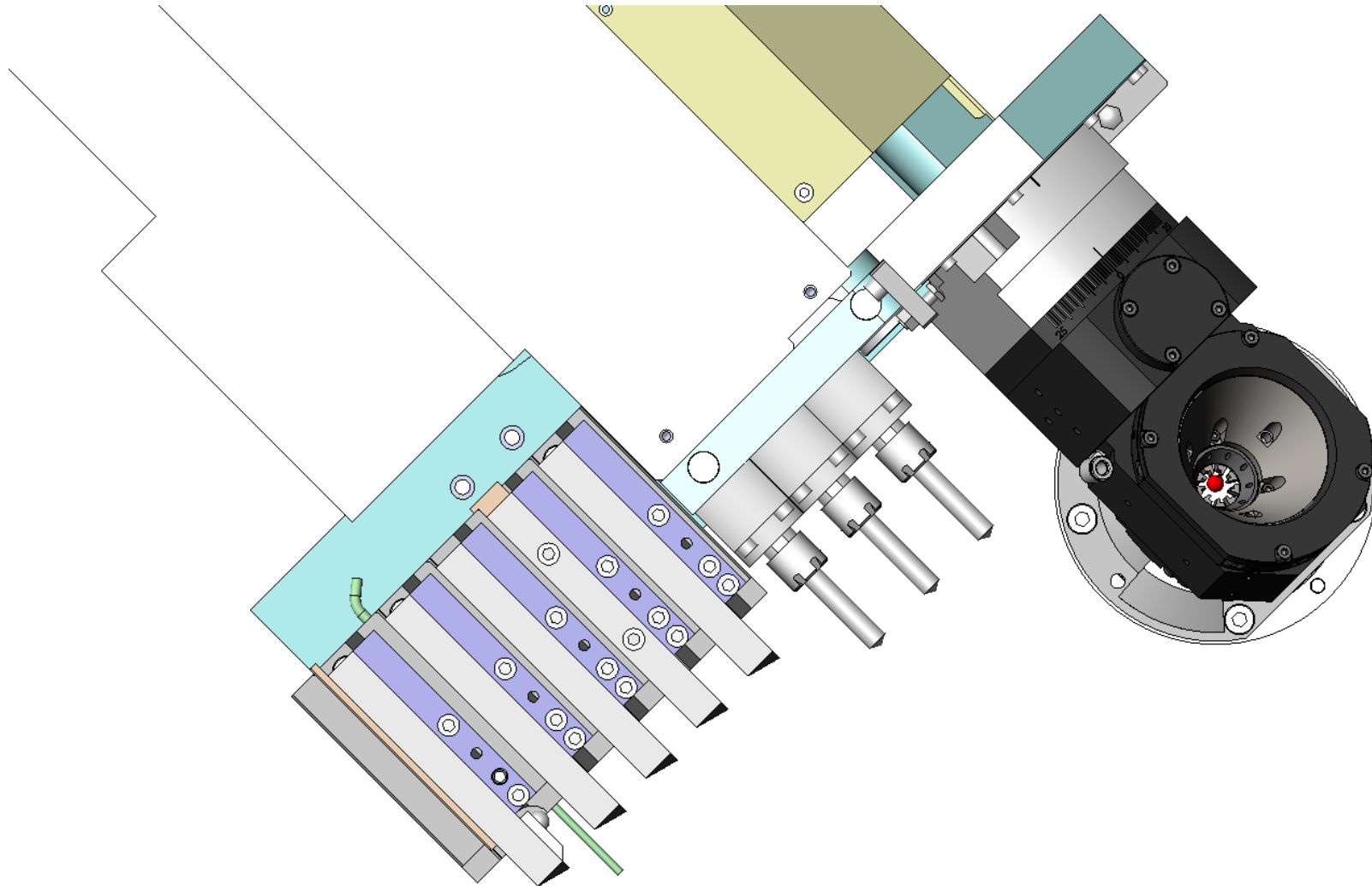
17

BTW-5000 on M416 VIII (B Axis)



20

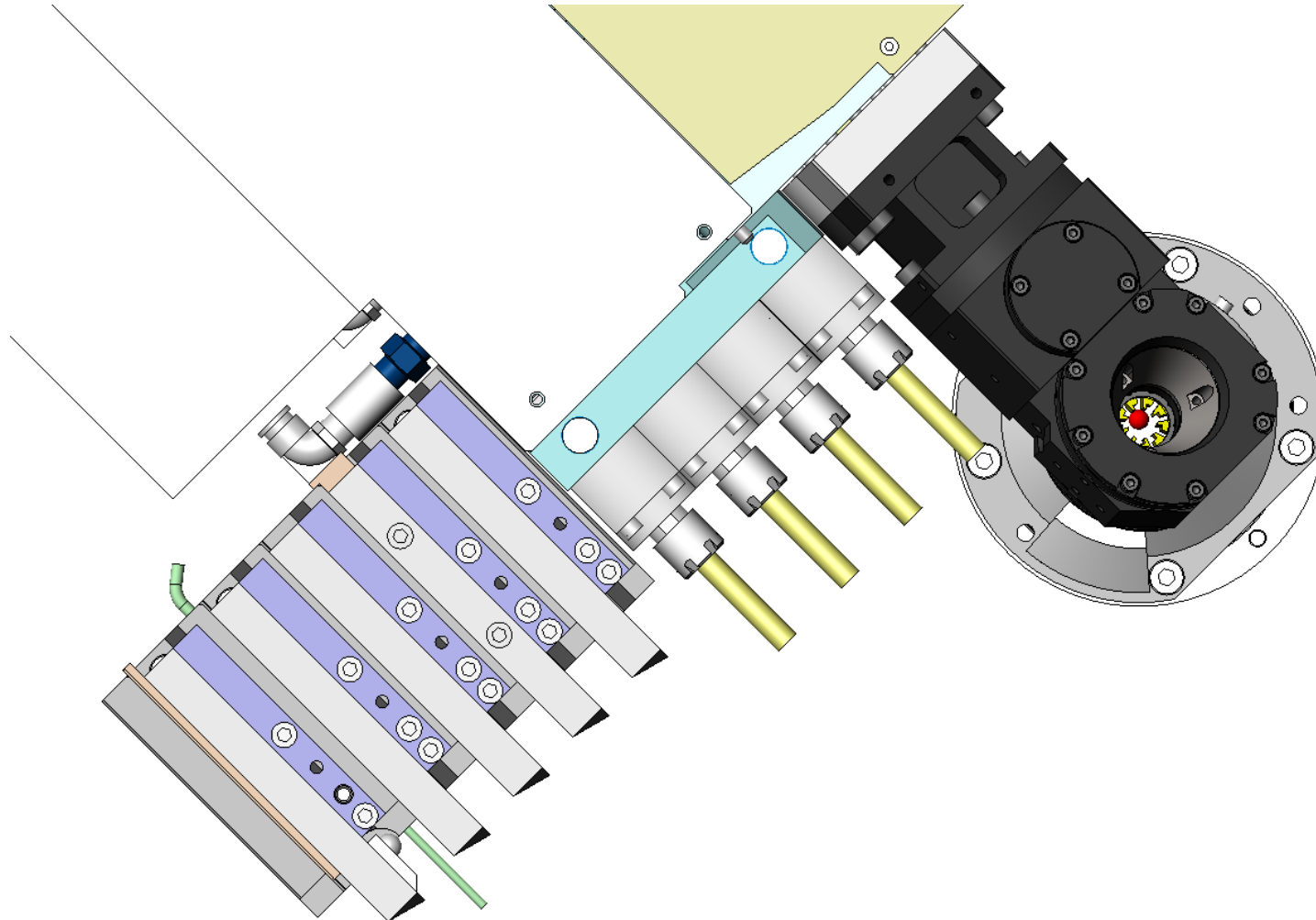
BTW-2000 on M432III, V, VII



20

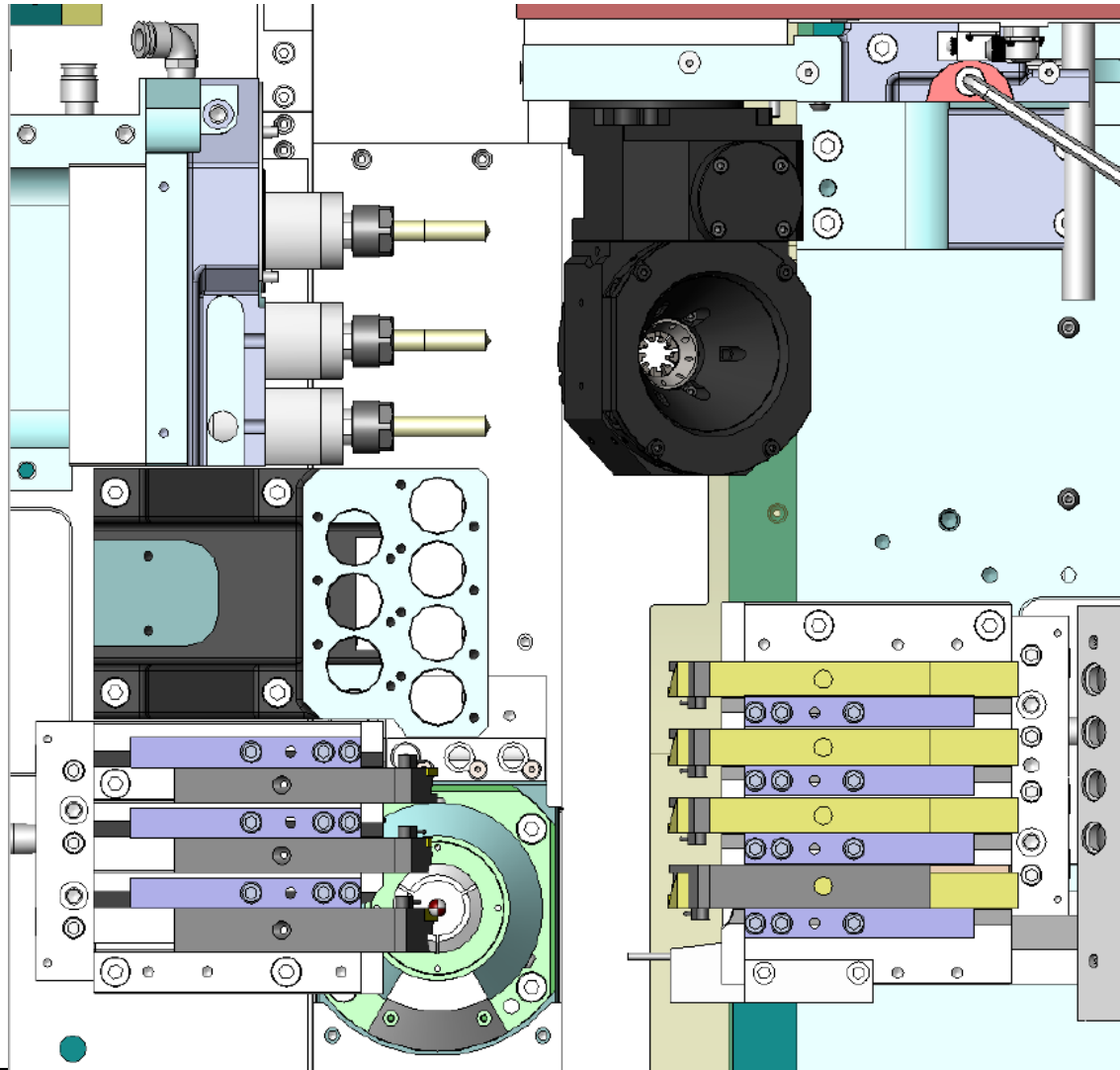
BTW-4000 on M432 VIII (B Axis)

<Note> Drive gear on B-axis unit needs to be changed.



21

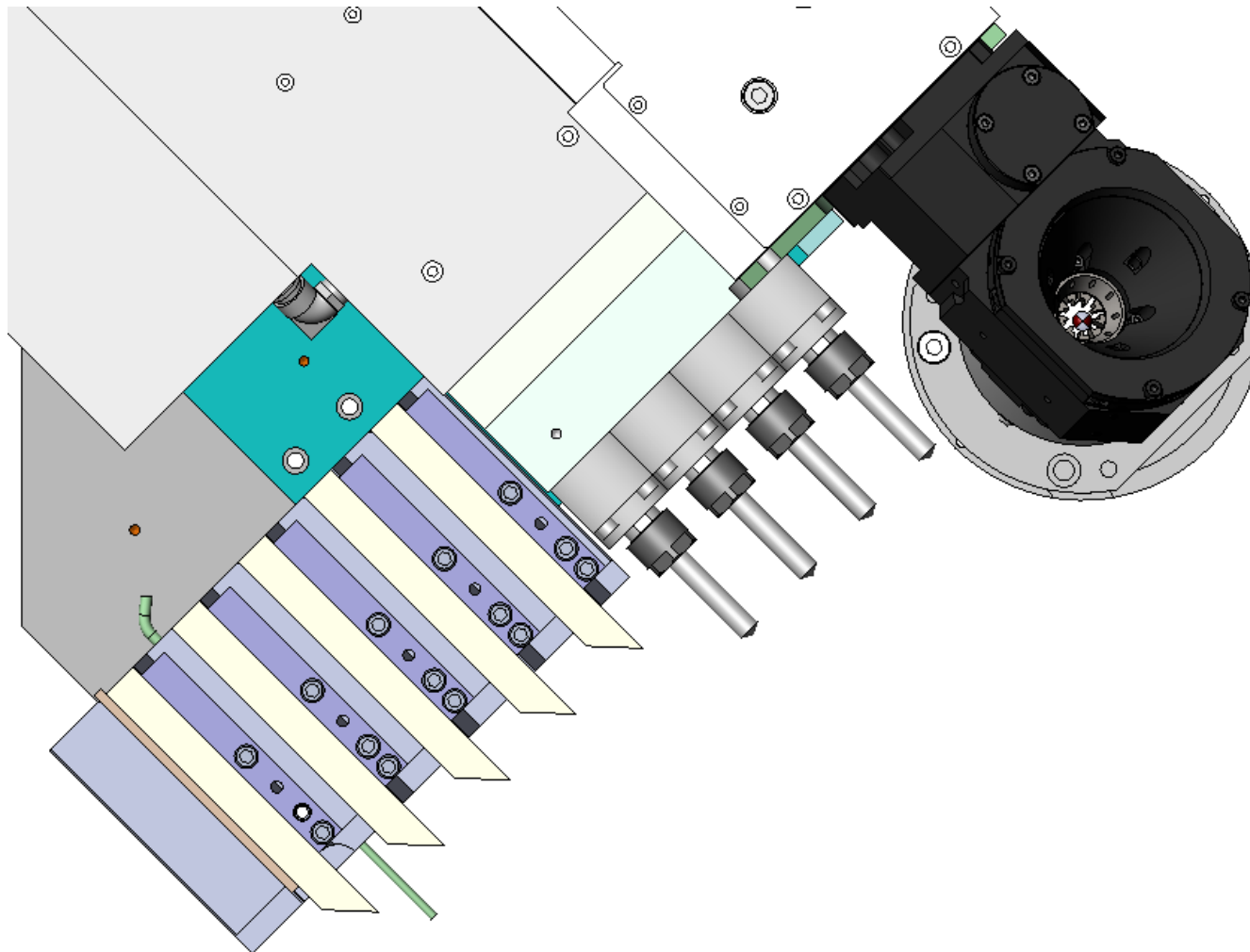
BTW-6000 on D25 VIII (B Axis)



22

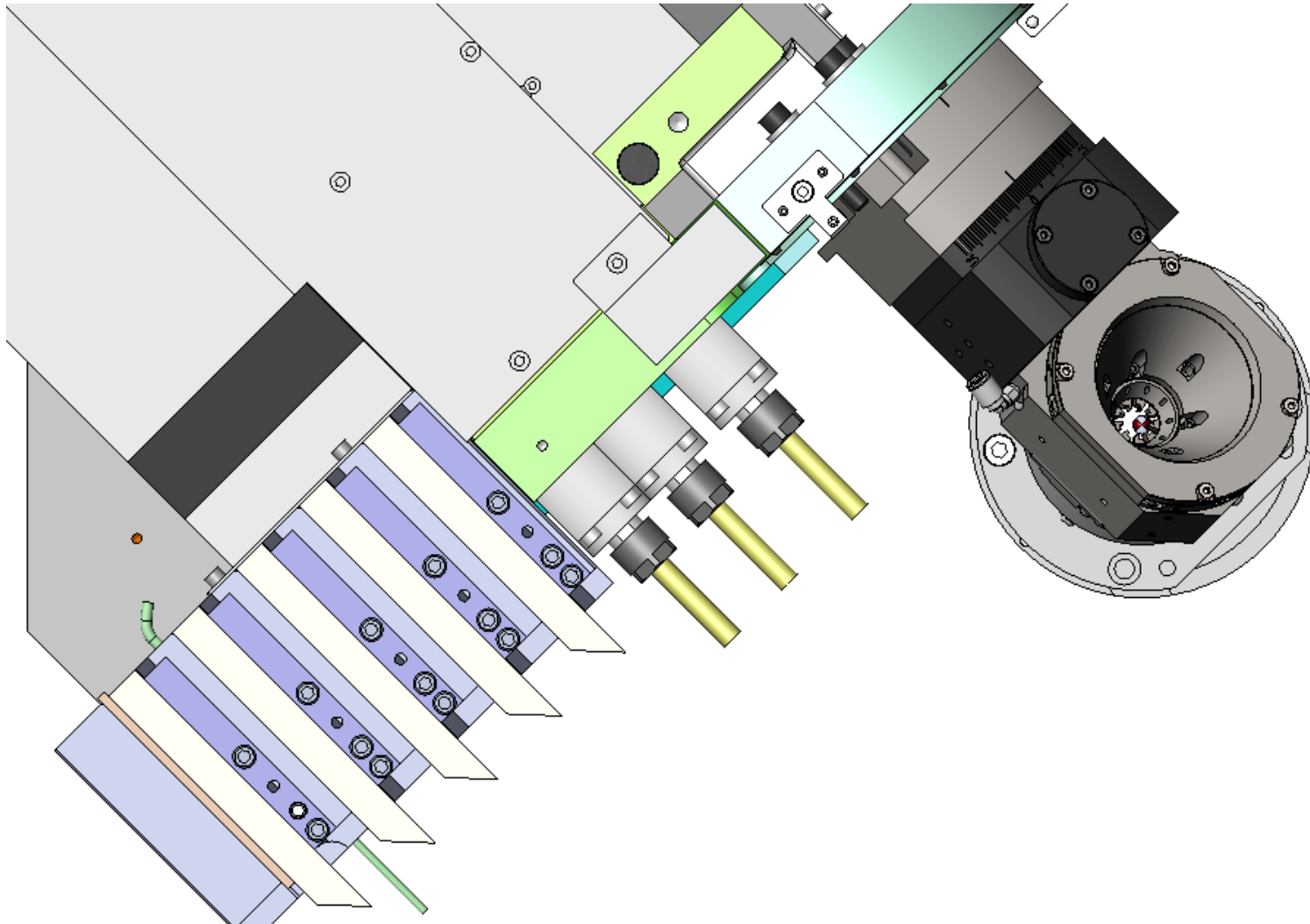
BTW-6000 on M532 VIII (B Axis)

<Note> BTW-6000 Rev1 needs be used on M532



23

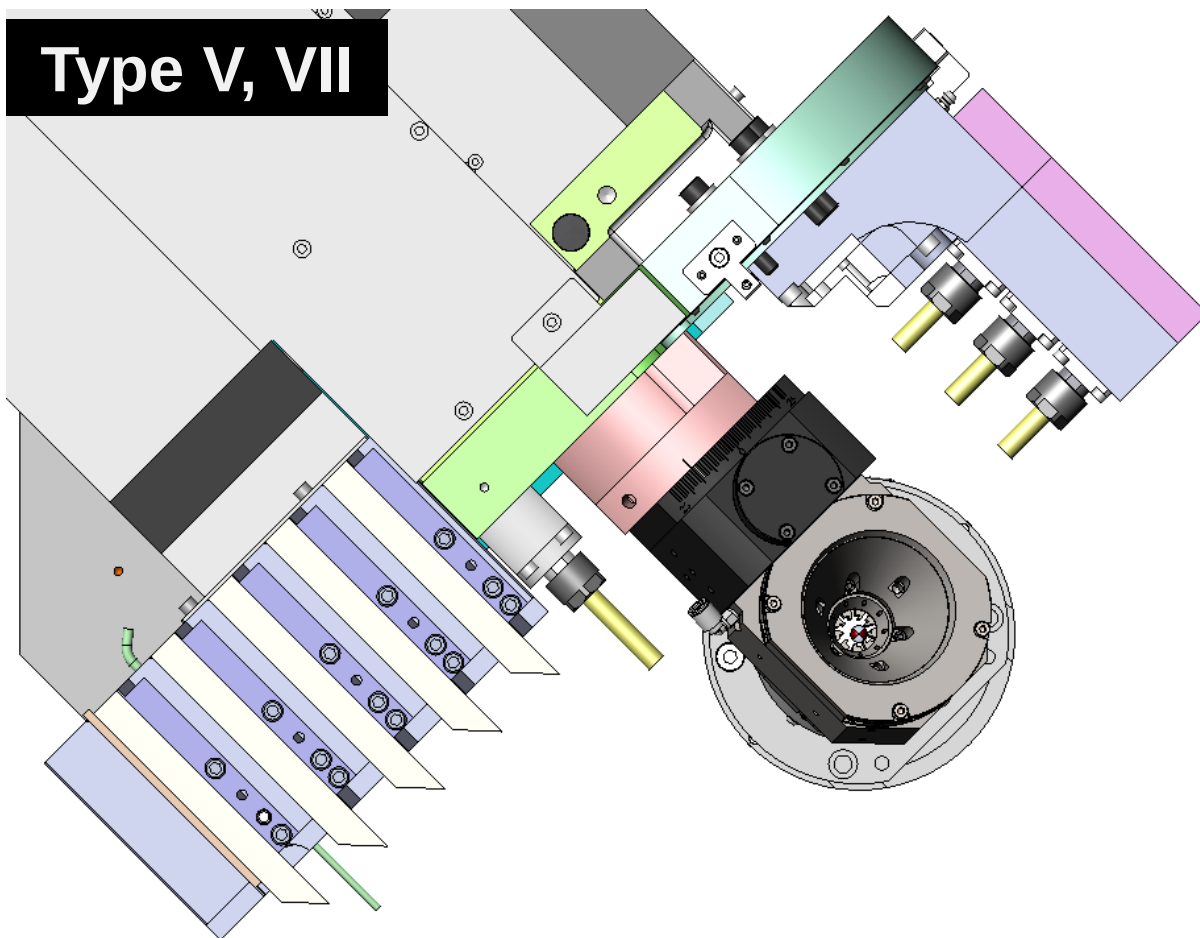
BTW-2000 on M532 V, VII (T10)



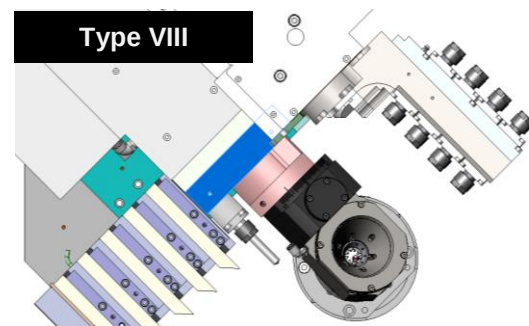
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BTW-2000 on M532 V, VII, VIII (T08)

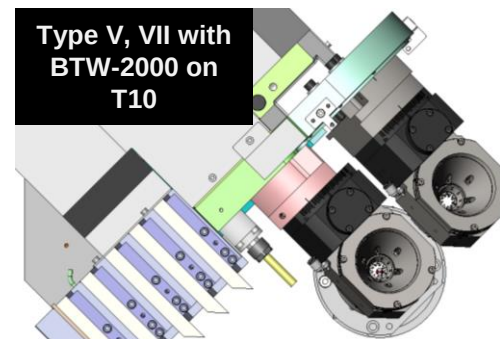
Type V, VII



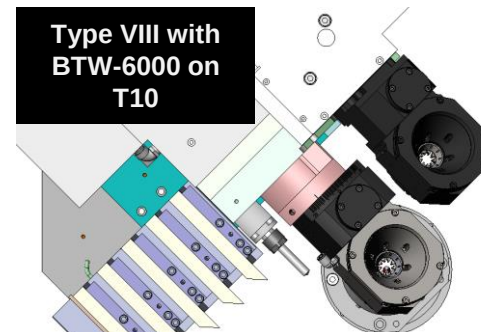
Type VIII



Type V, VII with
BTW-2000 on
T10

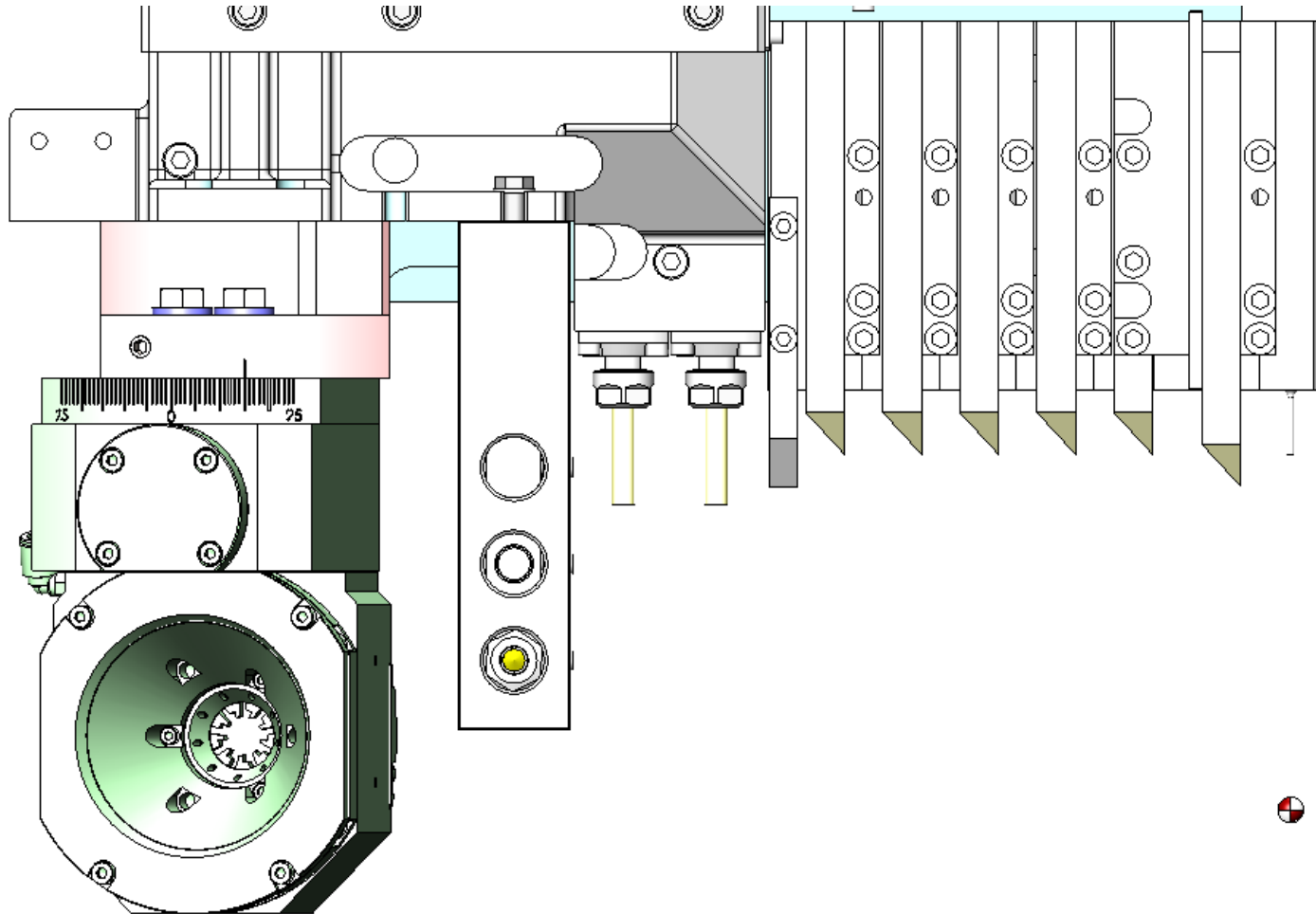


Type VIII with
BTW-6000 on
T10



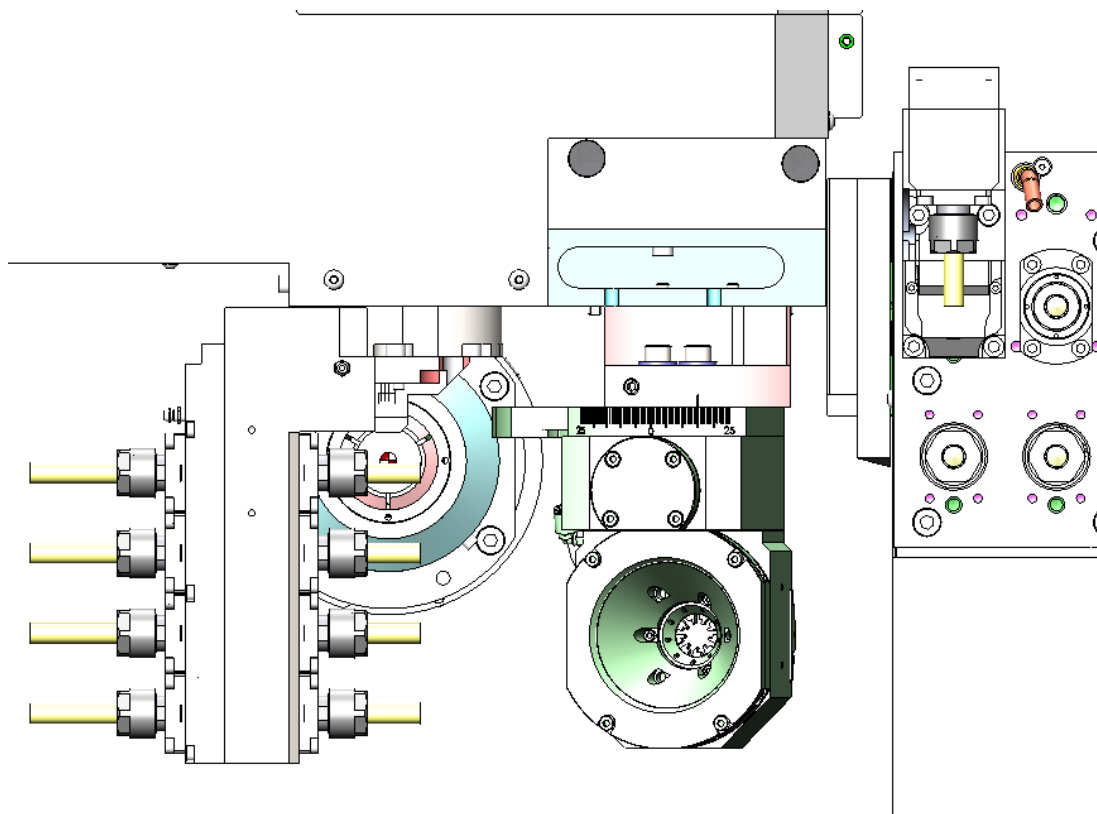
25

BTW-2000 on A320 U35B VII

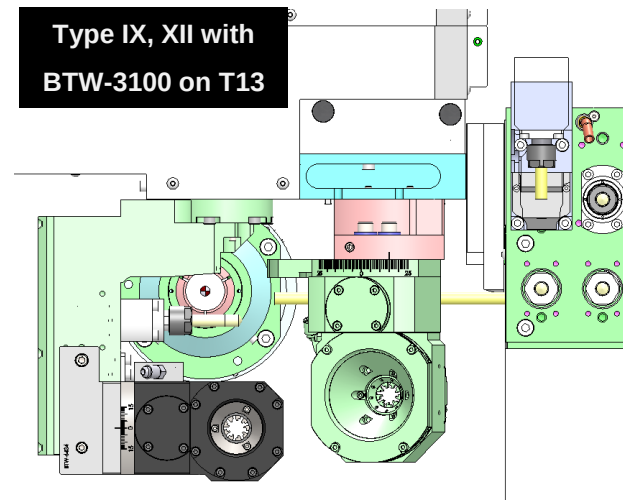


26 BTW-2000 on L32 IX, XII (T08)

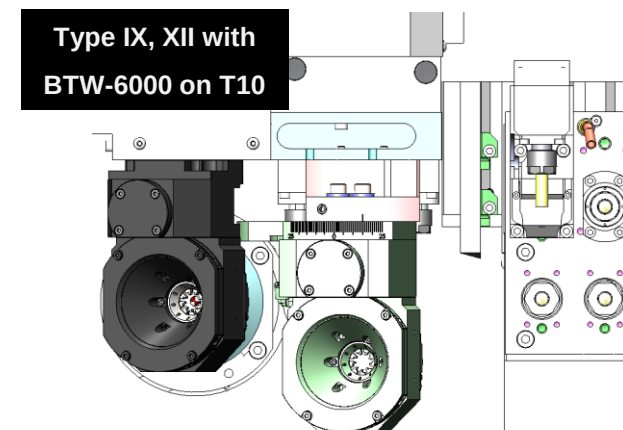
Type IX, XII



Type IX, XII with BTW-3100 on T13



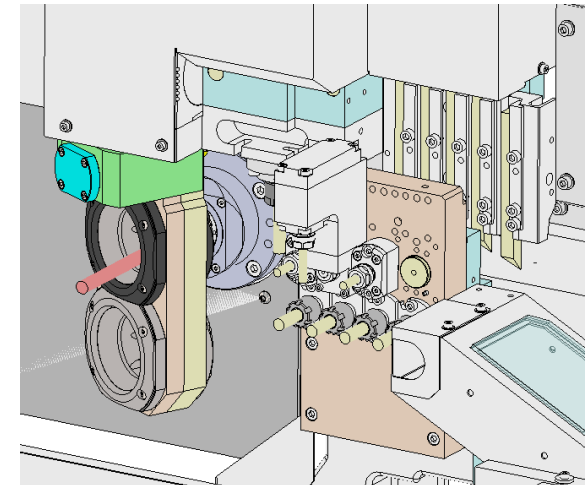
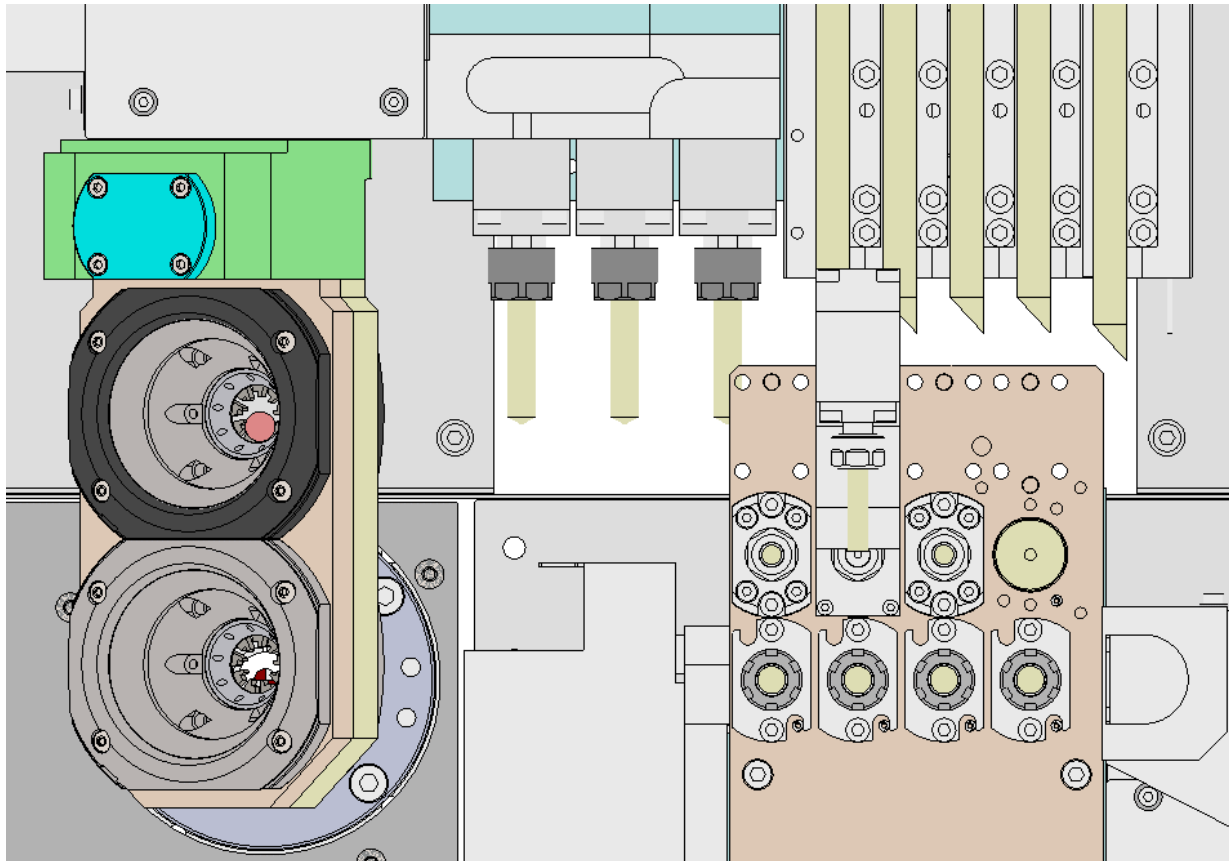
Type IX, XII with BTW-6000 on T10



27

BTW-5200 on L220E IX, XII (B Axis)
L320E IX, XII (B Axis)

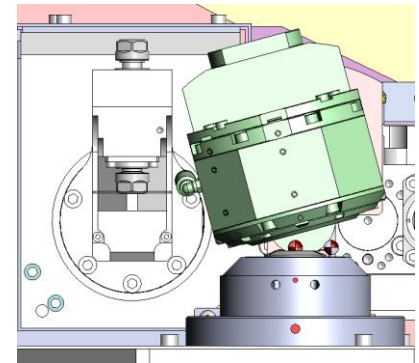
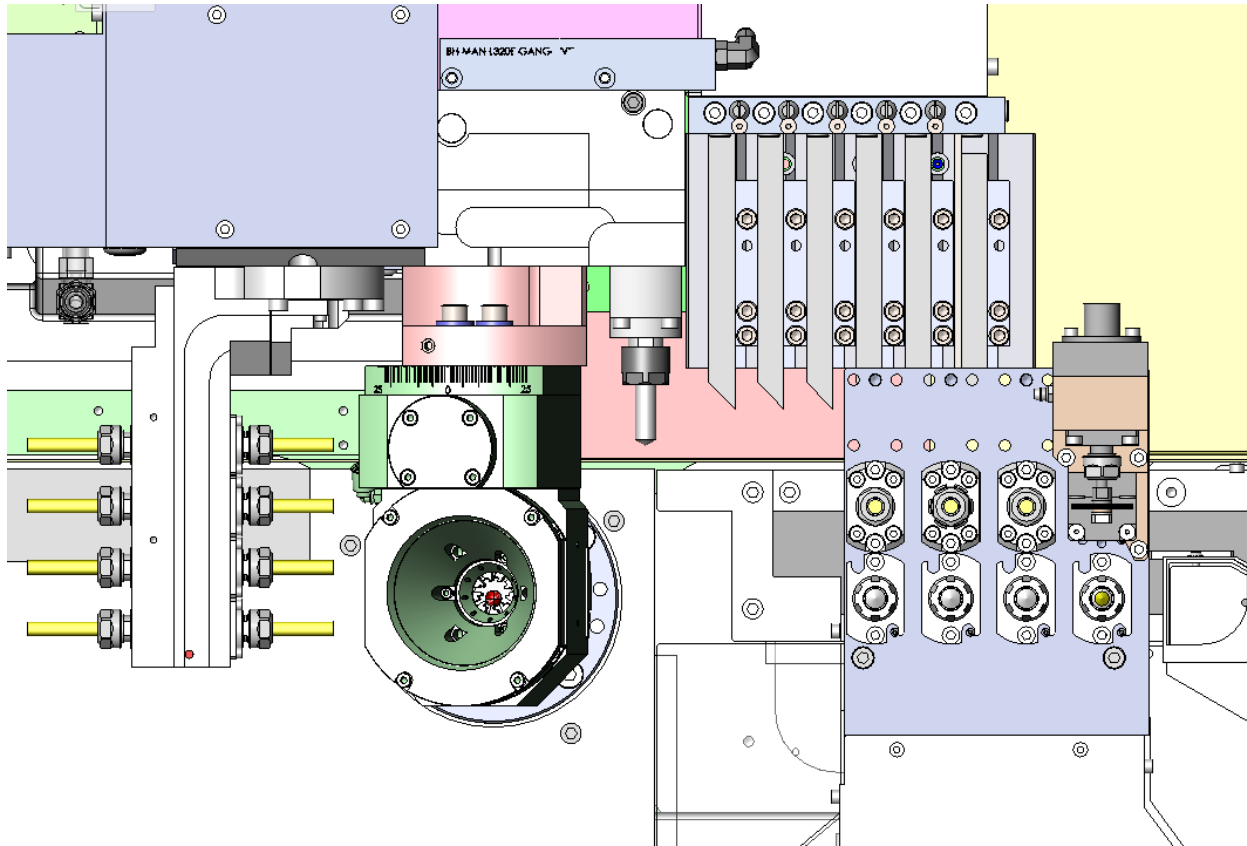
<Note ONLY for L320E> B axis oil lubrication valve needs to be closed.



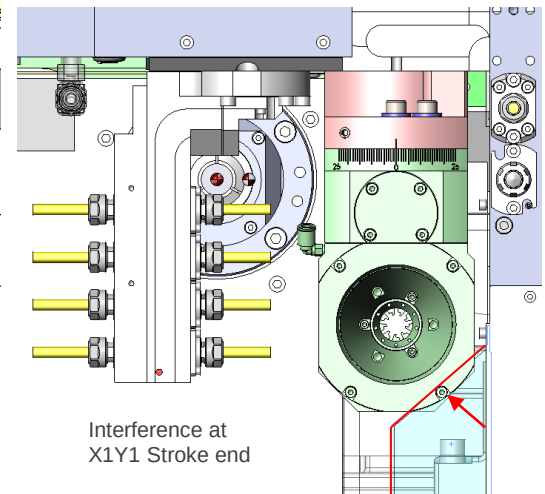
28

BTW-2000 on L320E-XIIB5 (T09)

<Note> B axis angle and T11 stroke will be restricted. Consult MCC.



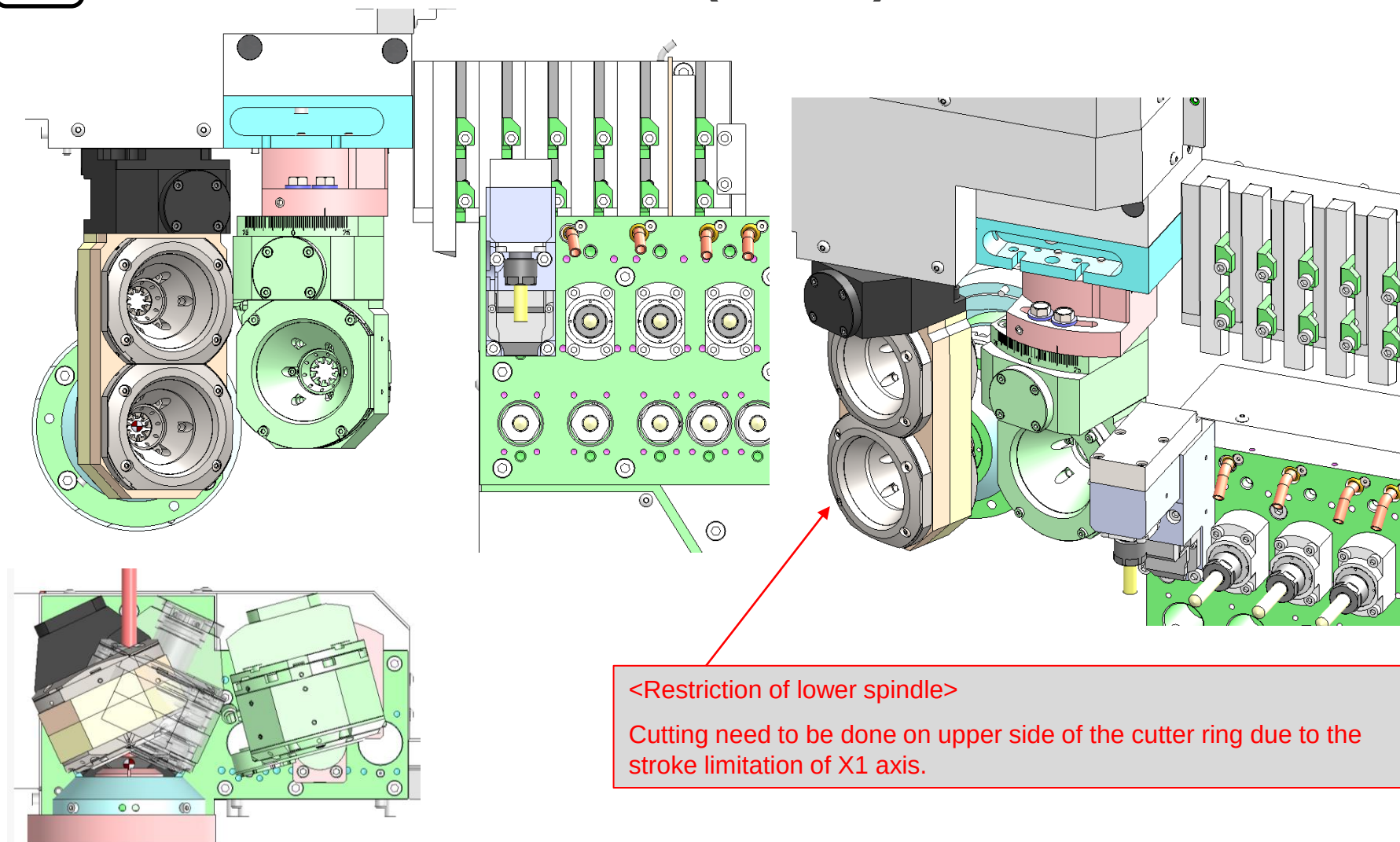
MEU507 (B axis) stroke
restricts until End face (0deg)



Interference at
X1Y1 Stroke end

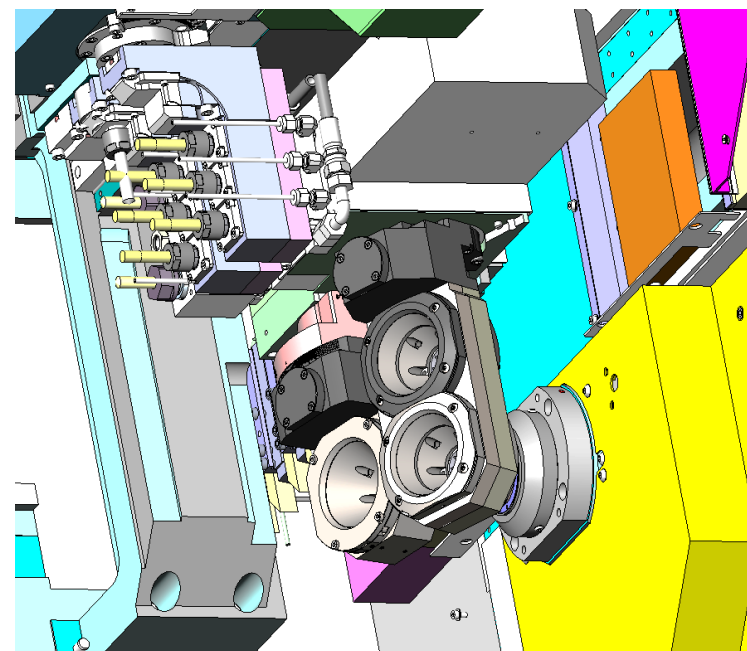
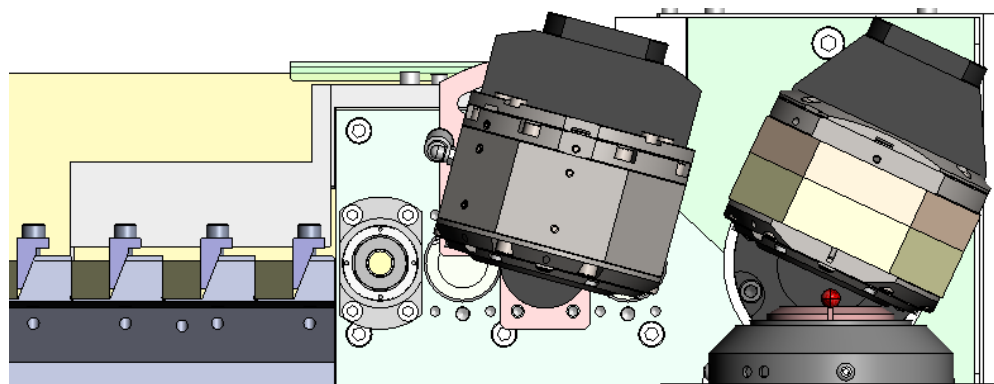
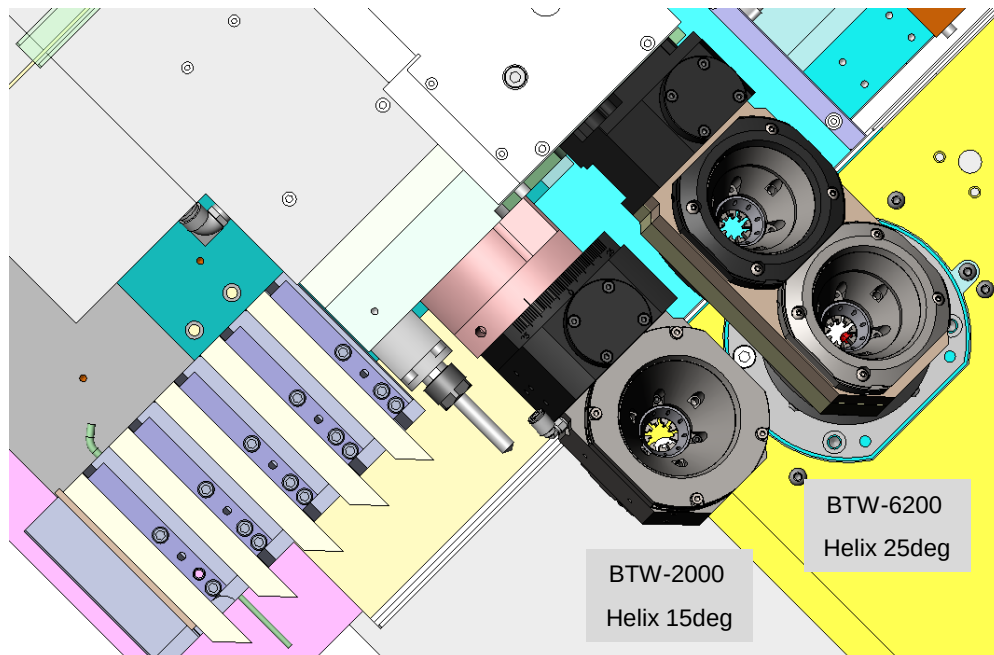
29

BTW-6200 on L32-IX, XII (B Axis)



30

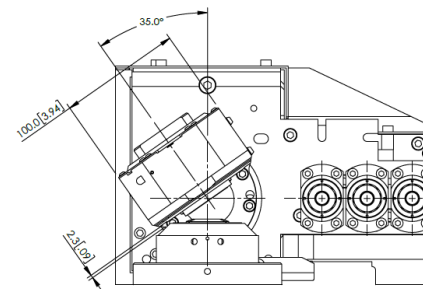
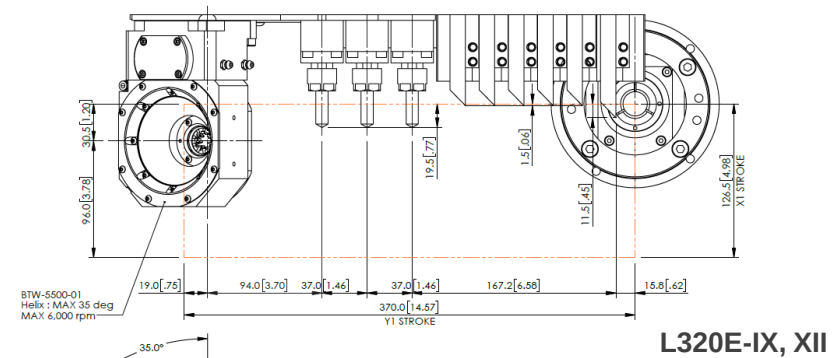
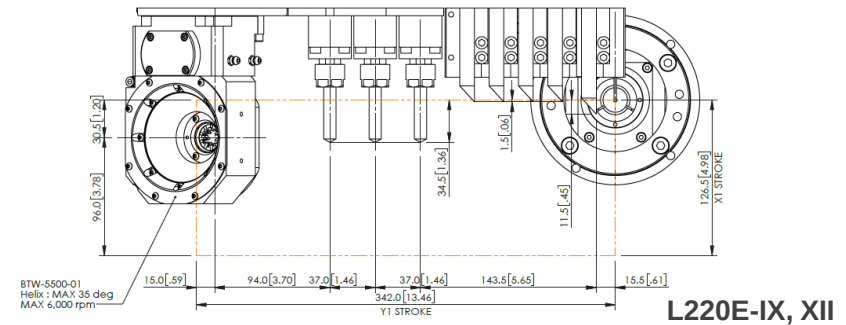
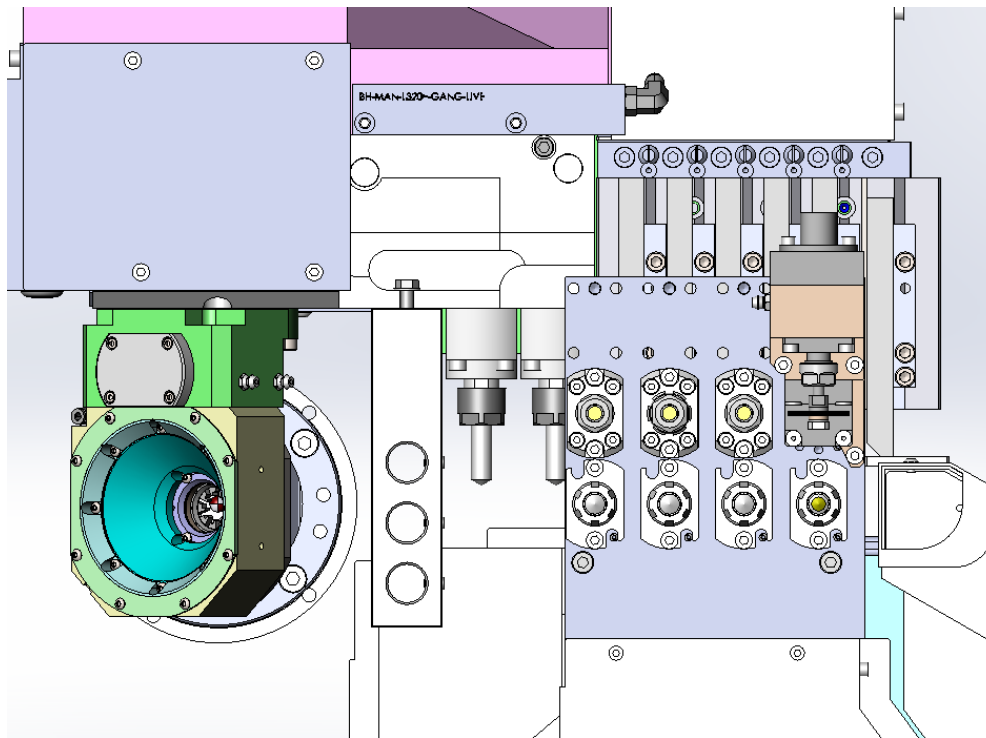
BTW-6200 on M532-VIII (B Axis)



31

BTW-5500 on L220E-IX, XII (B Axis) L320E-IX, XII (B Axis)

<Note ONLY for L320E> B axis oil lubrication valve needs to be closed.

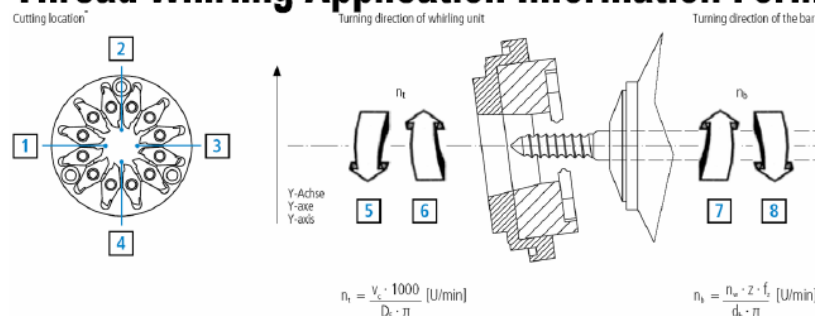


32 How to Order Thread Whirling Cutter Ring and Insert

Accessories that Advance Small Parts Manufacturing
Genevieve Swiss Industries, Inc.

Ph: (413) 562-4800
Fx: (413) 562-4802
www.genswiss.com

Thread Whirling Application Information Form



Customer:	Date:
Machine Specifications	
Machine Manufacturer	Citizen
Type Of Machine	
Manufacturer of Whirling Spindle	CMA
Model Number of Whirling Spindle	BTW1000 / BTW2000
Does Whirling Have Y-Axis Available?	
High Pressure Coolant Pressure?	
Rotational Direction of Whirling Unit? (5,6)	Circle One: 5 6
Cutting Location (1,2,3,4)	Circle One: 1 2 3 4
Material Information:	
Designation	
Stock Diameter	Ø
Direction of Stock Rotation	Circle One: 7 8
Part Information:	
Part No.	
Drawing No	
Tool Dwg Provided	

Contact: Jim Gosselin	Phone: 413-562-4800	Fax: 413-562-4802
Address: 6 Old Stage Road	City: Westfield	State: MA Zip 01085 Country USA
NOTES: Need Approval Drawing		

FILL OUT AND RETURN TO FAX: (413) 562-4802
OR EMAIL TO SALES@GENSWISS.COM

Thread Whirling Cutter Ring and Insert are supplied from :

Genevieve Swiss Industries

Address : 6 Old Stage Road
Westfield, MA 01085

Tel : (413) 562-4800

Fax : (413) 562-4802

Email : sales@genswiss.com

To purchase insert cutter rings use part number :

BTW-UT9-138611 (Type A)

After completing the “Thread Whirling Application Information Form” on the left format, fax to the above number.

33 How to Order Thread Whirling Cutter Ring and Insert



Features

- Excellent surface finish
- Unparalleled tool life
- Superior chip evacuation
- Max .157" depth of cut *

* Varies with helix angle and thread form.



How to order NTK thread whirling tools (cutter and inserts)

1. Fill out the NTK thread whirling tool quotation request form (see next page).
2. E-mail or fax the form together with a part drawing to NTK (see below for contact info).
3. You will receive a quote with official item numbers from your local NTK distributor.
4. Place an order with the official item numbers from your local NTK distributor.

Recommended Cutting Condition

Work Material	Thread Whirling Cutter		Main Spindle
316 Stainless	110 - 200 SFM	600 - 2500 RPM	8 - 16 RPM
Titanium Alloy	45 - 250* SFM		

* High pressure coolant is required to run at this speed.

Thread Whirling System (Cutter ring)

For BTW-L1000, BTW-L2000	TWC9C1040HP1
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Spare Parts

Insert Screw	FSH7-2.2*6.0
Screw Wrench	T-07

For any inquiries about NTK products, contact us
 E-mail: ctinfo@ntktech.com Fax: 248-668-0200
 Phone: **866-900-9800 (Toll Free)**
 248-668-0100 (from outside the U.S.)
 Web: www.ntkcuttingtools.com

Thread Whirling Cutter Ring and Insert are supplied from :

NTK Cutting Tools

Address : 46929 Magellan Drive

Wixom, MI 48393

Tel : (866) 900-9800

(248) 668-0100 (from outside U.S.A.)

Fax : (248) 668-0200

Email : ctinfo@ntktech.com

To purchase insert cutter rings use part number :

TWC9C1040HP1 (Type A)

TWC9C0746HP1 (Type B)

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After completing the “Thread Whirling Application Information Form” on the left format, fax to the above number.

34 How to Order Thread Whirling Cutter Ring and Insert



ORDER FORM

From: _____



222628..... Price upon request**
 Schwanog cutter ring with 6 WEP inserts,
 Insert carries 3 edges for Citizen whirling attachment
 BTW-1000 and BTW-2000.



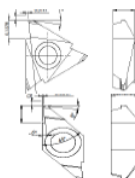
241031..... Price upon request**
 Schwanog cutter ring with 6 WEP inserts,
 Insert carries 3 edges for Citizen whirling attachment
 BTW-3000.



223831..... Price upon request**
 Schwanog cutter ring with 9 DCI inserts,
 Insert carries 2 cutting edges for Citizen whirling attachment
 BTW-1000 and BTW-2000.



223917..... Price upon request**
 Schwanog cutter ring with 12 DCI inserts,
 Insert carries 2 cutting edges for Citizen whirling attachment
 BTW-1000 and BTW-2000.



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 Phone (847) 289-1055 Fax (847) 289-1056 E-mail: info.usa@schwanog.com

Thread Whirling Cutter Ring and Insert are supplied from :

Schwanog LLC

Address : 1630 Todd Farm Dr.

Elgin, IL 60123

Tel : (847) 289-1055

Fax : (847) 289-1056

Email : info.usa@schwanog.com

To purchase insert cutter rings use part number :

222628 (Type A)

223831 (Type A)

223917 (Type A)

241031 (Type B)

After completing the “Thread Whirling Application Information Form” on the left format, fax to the above number.

END