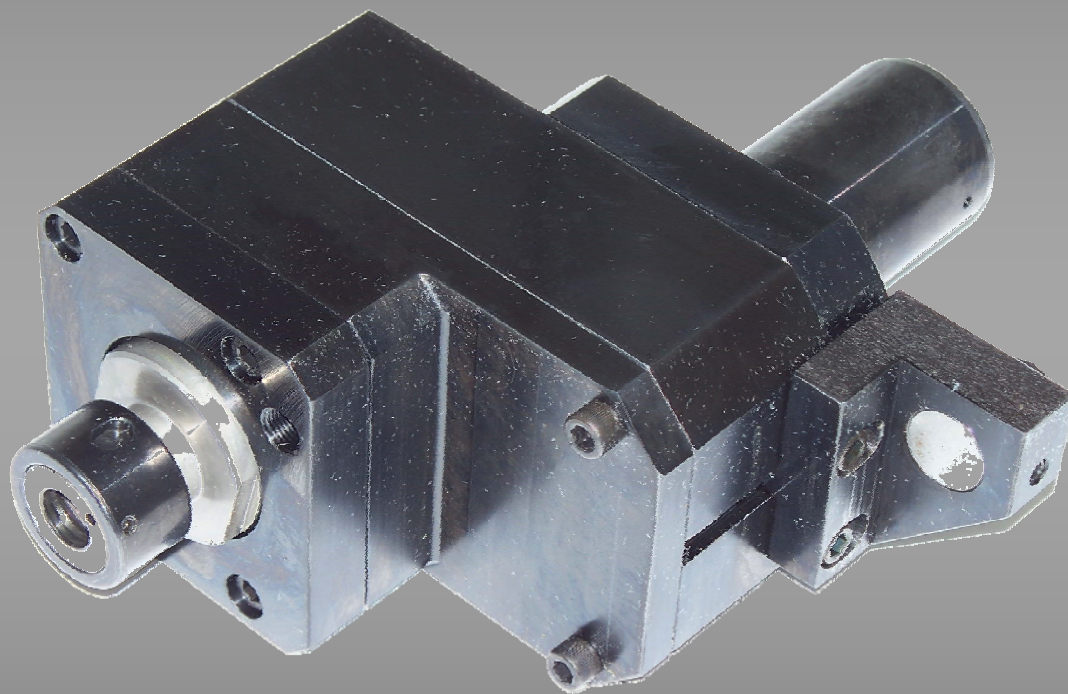
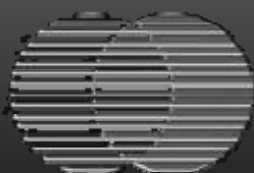


# PRECISION LIVE TOOLING & MACHINE TOOL ACCESSORIES

Master Catalog



***MADE IN THE USA***



**PLANET**  
*Products Corporation*

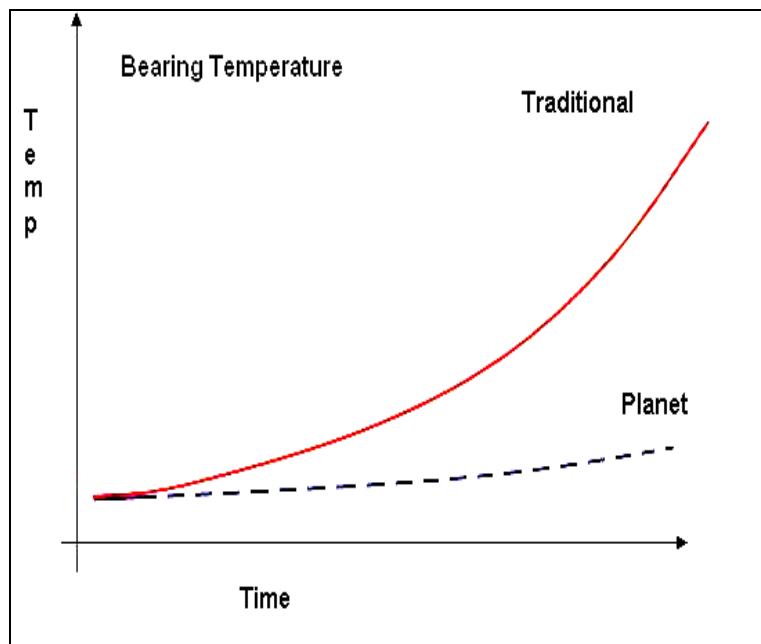
4200 Malsbary Road  
Cincinnati, OH 45242  
Phone (513) 984-5544  
Fax (513) 984-5580  
[www.planet-products.com](http://www.planet-products.com)

## Patent Pending Live Tooling

Planet Products Corporation has produced machine tool components & accessories since 1947. In 2008, we introduced a new technology to the live tooling industry that allows superior performance and reliability, while simplifying tool design.

The unique, patent pending design of the Planet tool allows tighter internal component tolerances, while allowing component heat to be removed from the tool. Our design uses filtered machine coolant to lubricate and cool the live tool components.

Planet Live Tools are unique because due to the continuous cooling process, they have no duty cycle limitations.



Since the tool is kept cool by the large volume of coolant flowing through the tool under operation, there are other advantages:

- Closer tolerance components
- Simpler design – elimination of complex labyrinth seals
- Longer life & Improved maintenance intervals
- Low-drag design

The bearings are usually the high wear components on live tooling. Failure modes are typically load related, heat related, or due to contamination. With constant bearing temperature, and filtered coolant washing out contaminants, bearing life is increased several times over the sealed units.

**We are convinced that our live tools are the finest and most robust available on the market and invite you to try our proof of performance program.**

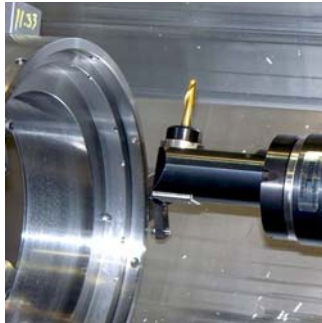
**NOTE: COOLANT IS REQUIRED FOR ALL PLANET LIVE TOOLS**

## Live Tooling Advantages & Applications

The addition of live tooling to turret lathes allows the following:

- Drilling operations on straight turning
- Milling operations on turret lathes
- ID drilling
- Reduce or eliminate secondary operations
- Speed up tooling on low speed turrets

*Examples of operations benefiting from live tooling:*



- ID slot milling on lathe operations.
- Serrations on the ID of a turned cup.
- Milling flats on the sides of turned components.
- Small diameter high speed drilling on turret lathe using speeder head.

Planet live tools can perform heavy milling, facing, boring, or cutting operations at loads or cycle times that would overheat or destroy other tools. While other tool manufacturers may claim improved sealing, longest lasting, or most reliable, we invite you to try a back to back test with our tools. You will find that our tools maintain tolerances and can outrun traditional sealed tools. We have achieved a quantum leap in performance by using a design much different than traditional tools.

INDEX	PART#
Mazak Live Tools - Quick Turn & Super Quick Turn	
Straight ER-32, VDI40	001993-3
Right Angle ER-32, VDI40	001996-5
Offset ER-16/32, 1:1, 2:1, 3.5:1,	002004-4
Okuma Live Tools - LB Series	
Straight, ER-32 Internal Nut, LU/LB 15 & 300	002007-5
Straight, ER-32 External Nut, LU/LB 15 & 300	002008-1
Straight, ER-32, VDI-40, Crown Drive Type II, LB300	002010-5
Right Angle, ER-32, LU/LB 15 & 300	002006-4
Right Angle, ER-32, Internal Nut, LU/LB 25 & 400	002011-3
Straight Drive, ER-32, External Nut, LU/LB 25 & 400	002011-4
Mori Seiki Live Tools	
Right Angle ER-32 Collet, NL Series Lathes	002015-5
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Right Angle ER-32 Collet, VDI40	002000-2
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BMT 55 Right Angle, ER-32, Puma Series Lathes	002015-9
Offset BMT65, ER-16/25/32 Collet, Puma, Invertturn	002011-7
Specialty Tools	
EI Tool Mill & Drill Heads	
Coolant Driven Angle Heads	
Accessories – Coolant Filters and Filter Systems	
Repair Services & Warranty	
<i>Special Applications – Contact Planet application engineering to discuss custom tools for your applications (513) 984-5544</i>	

## PROOF OF PERFORMANCE TRIAL PROGRAM

A tool purchased and not put in service may be returned within ten days of date of invoice freight prepaid with no restocking charge. "Not put in service" is defined as not being operated in a turret.

A tool purchased and operated with a fluid and properly cleaned per the instructions in the operation manual may be returned in undamaged condition within ten days of date of invoice freight prepaid with no restocking charge.

A tool purchased may be returned not put in service or put in service with a fluid and properly cleaned per the instructions in the operation manual within thirty days freight prepaid subject to a \$500.00 refurbishing charge.

An invoice for any tool kept beyond the thirty day "trial and approval" period will be due and payable in full **immediately** in accordance with our 30 days payment terms.

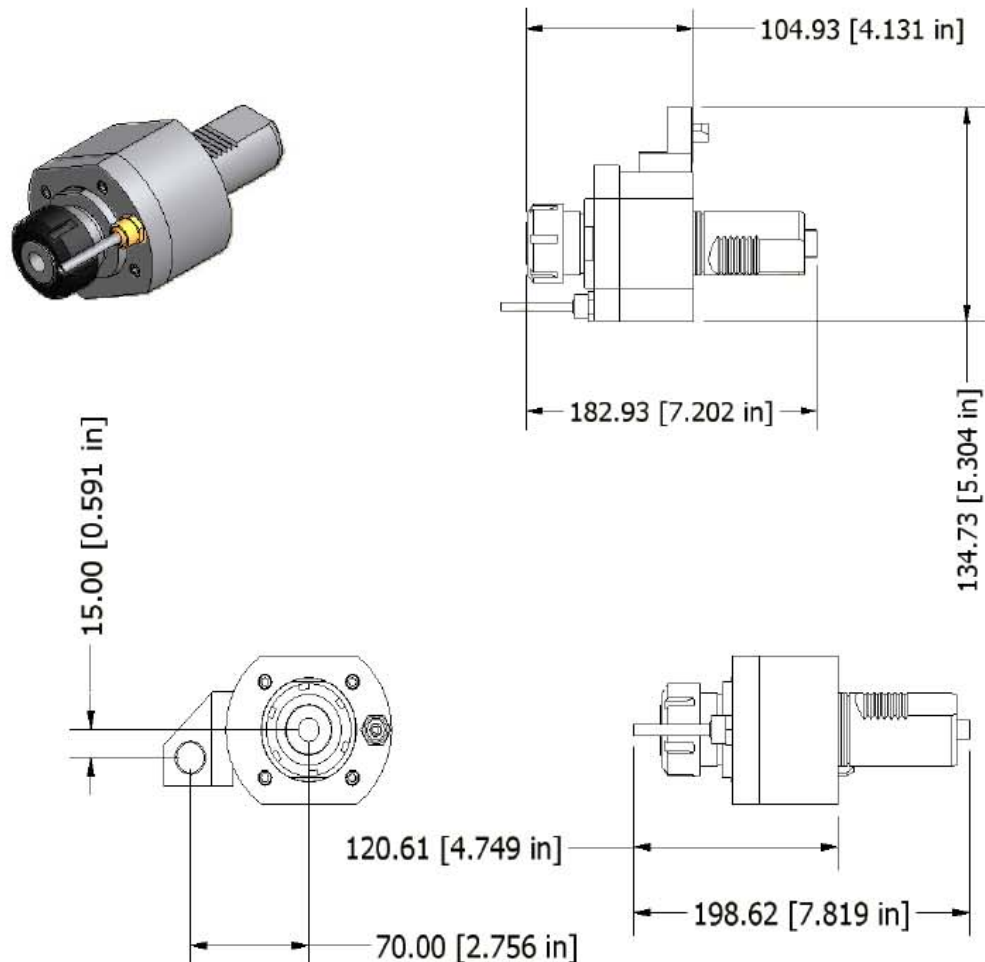
Non-trial tools have priority for the purpose of expediting deliveries. All trial tools are shipped freight collect.



## Live Tooling for Mazak QT/SQT

Super Quick Turn 15, 15M, 15MS, 15MSY, 18MY, 18, MS, 18MSY, 200MY, 200MS, 200MSY, 250M, 250MY, 250MSY, Quick Turn 250M, 250MS, 200M, 200MS

Part Number: 001993-3	Specifications:
Inline ER-32 Collet Drive Assembly	Weight: 4kg [8.8 lbs]
40mm VDI Shank with Straight Drive Tang	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 48 NM, [35 ft-lbs]
Coolant Required	

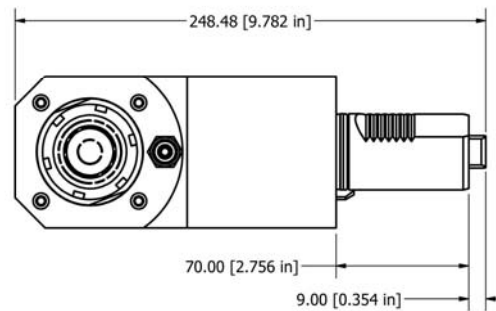
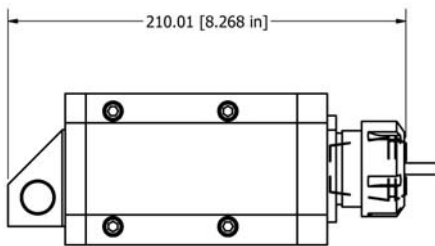
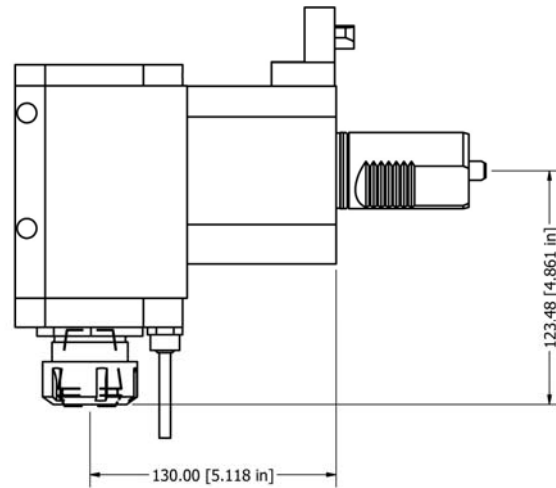




# Live Tooling for Mazak QT/SQT Right Angle Drive

Super Quick Turn 15, 15M, 15MS, 15MSY, 18MY, 18MS  
18MSY, 200MY, 200MS, 200MSY, 250M, 250MY, 250MSY  
Quick Turn 250M, 250MS, 200M, 200MS

Part Number: 001996-5	Specifications:
Right Angle ER-32 Collet Drive Assembly	Weight: 10.3kg [22.6 lbs]
40mm VDI Shank w/ Crown Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 48 NM, [35 ft-lbs]
Coolant Required	ER-32 Collet Chuck

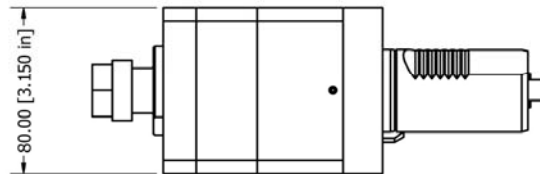
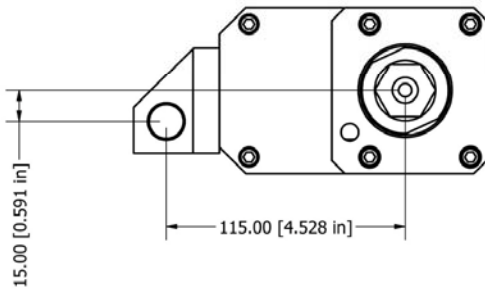
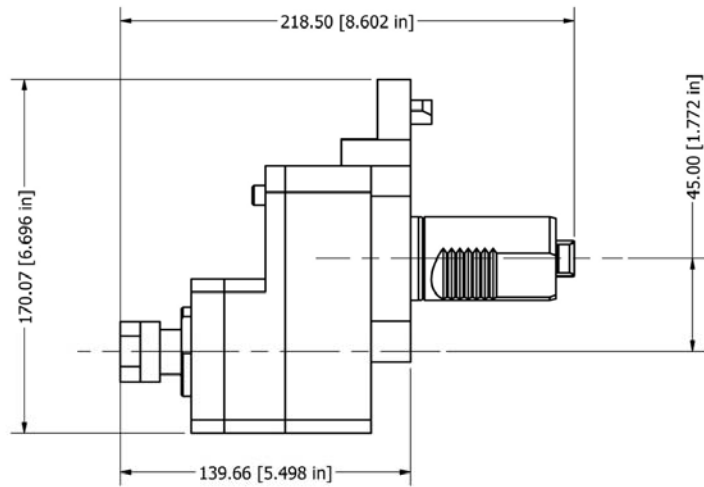
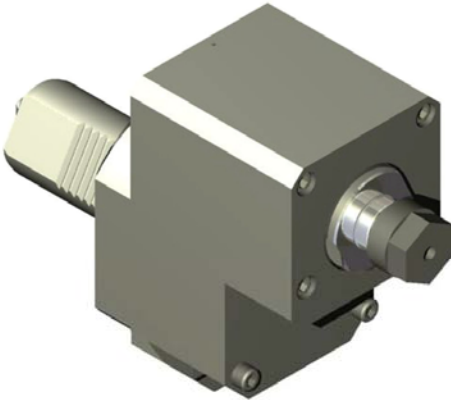




# Live Tooling for Mazak QT/SQT Offset Speedup Drive

Super Quick Turn 15, 15M, 15MS, 15MSY, 18MY, 18MS  
18MSY, 200MY, 200MS, 200MSY, 250M, 250MY, 250MSY  
Quick Turn 250M. 250MS. 200M. 200MS

Part Number: 002004-4	Specifications:
Offset ER-16/32 Collet Drive Assembly	Weight: 4kg [8.8 lbs]
40mm VDI Shank w/ Crown Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1, 2:1, or 3.5:1 Transmission	Max Speed: 20,000 RPM
Rated for Continuous Duty	ER-16 or ER-32 Collet Chuck
Coolant Required	

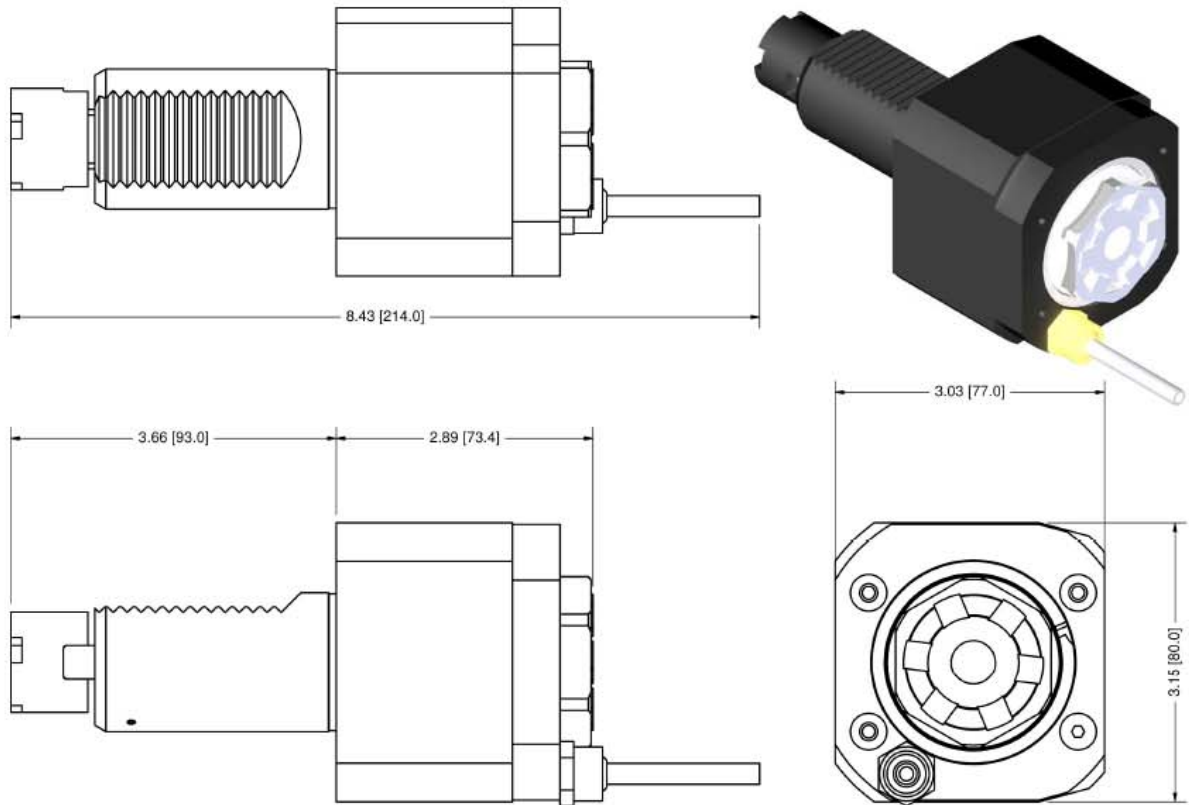




# Live Tooling for Okuma LB Straight Drive

Fits Okuma LB300 and others

Part Number: 002007-5	Specifications:
Inline ER-32 Collet Drive Assembly	Weight: 4kg [8.8 lbs]
40mm VDI Shank w/ Crown Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 68 NM, [50 ft-lbs]
Coolant Required	



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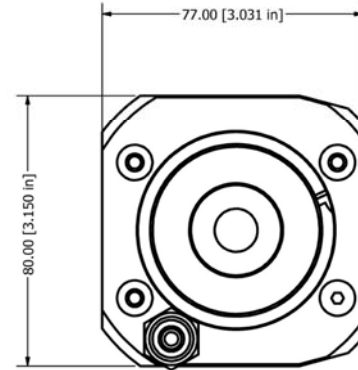
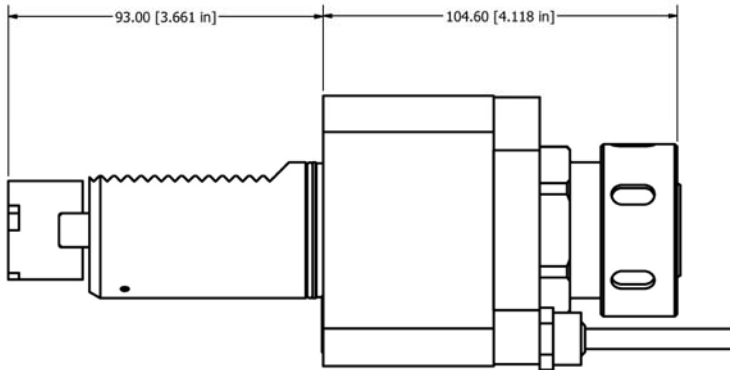
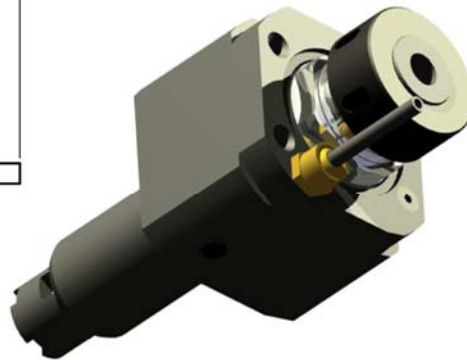
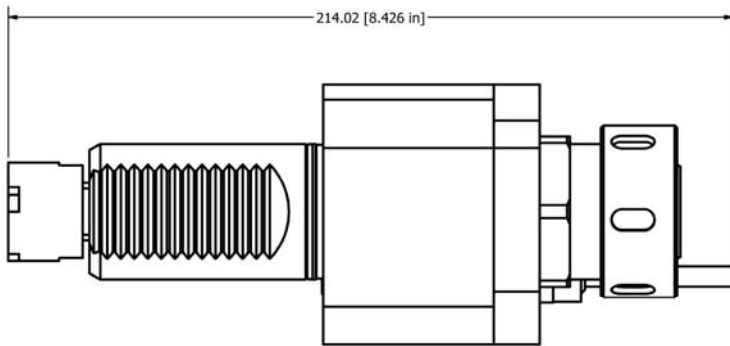


# Live Tooling for Okuma LB

## Straight Collet Drive

Fits Okuma LB300 and others

Part Number: 002008-1	Specifications:
Straight External ER-32 Collet Drive Assembly	Weight: 4.2 kg [9.3 lbs]
40mm VDI Shank w/ Crown Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 50 NM [37 ft-lbs]
Coolant Required	



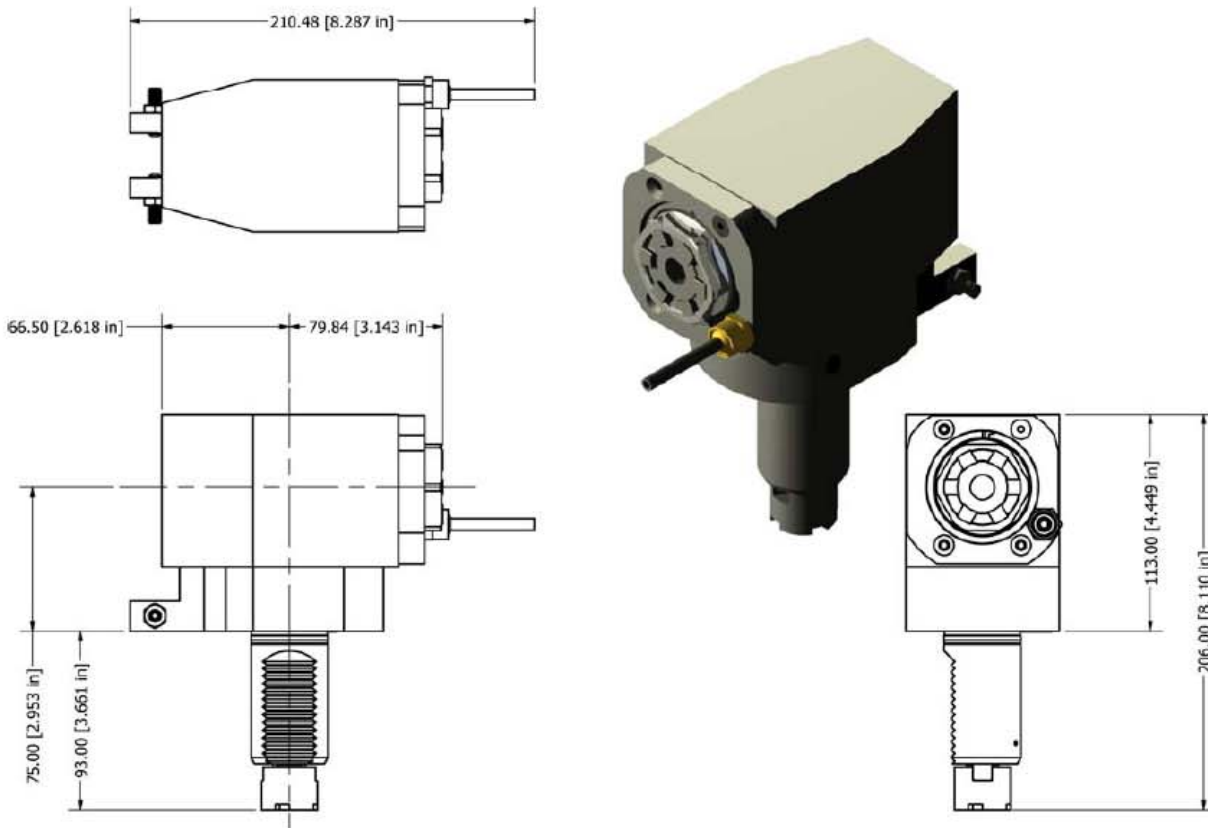


# Live Tooling for Okuma LB

## Right Angle Drive

Fits Okuma LB300 and others

Part Number: 002006-4	Specifications:
Right Angle ER-32 Collet Drive Assembly	Weight: 7.7kg [17 lbs]
40mm VDI Shank w/ Crown Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 50 NM [37 ft-lbs]
Coolant Required	



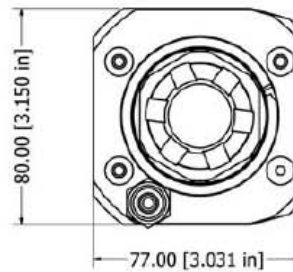
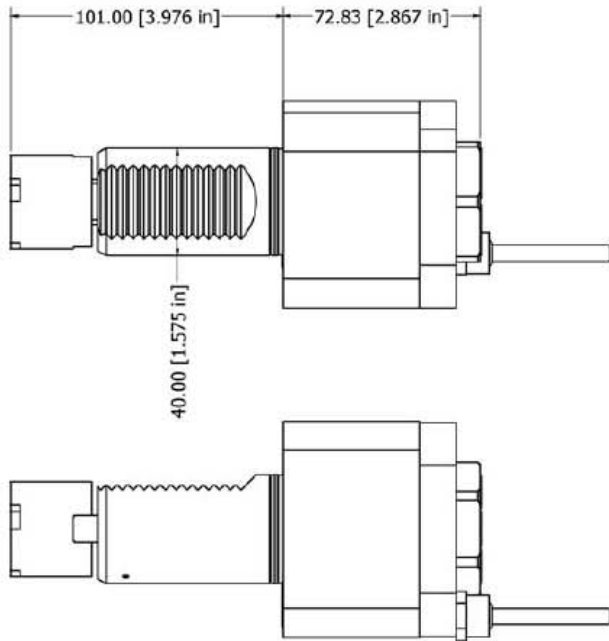
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# Live Tooling for Okuma LB, LU Straight Drive

Fits Okuma LB25, LU25, LB400, LU400 and others

Part Number: 002010-5	Specifications:
Inline ER-32 Collet Drive Assembly	Weight: 4kg [8.8 lbs]
40mm VDI Shank w/ Crown Drive Type 2	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 68 NM, [50 ft-lbs]
Coolant Required	



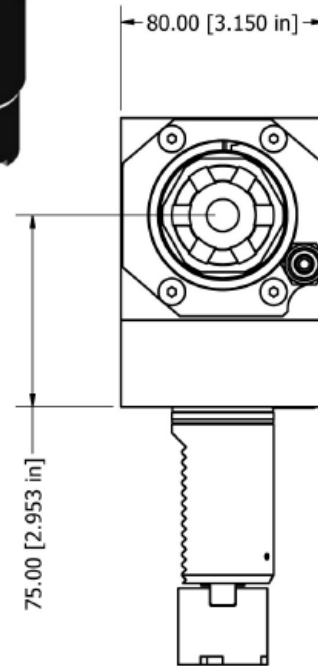
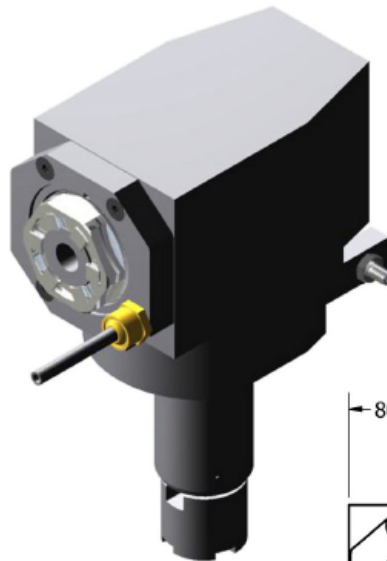
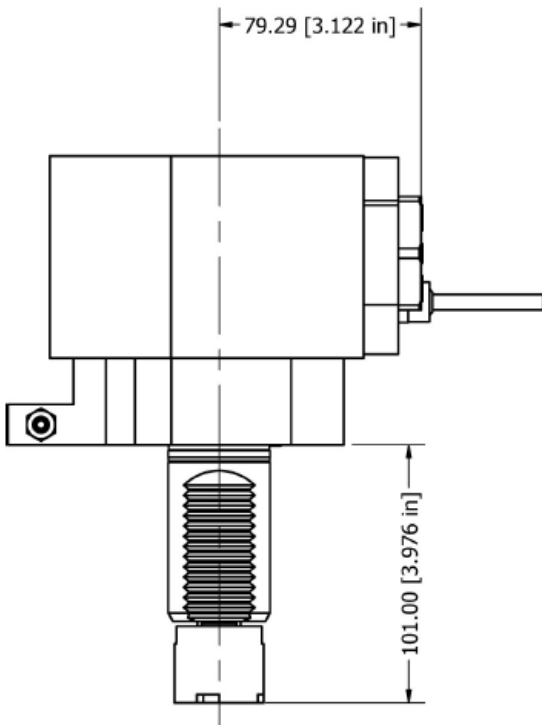
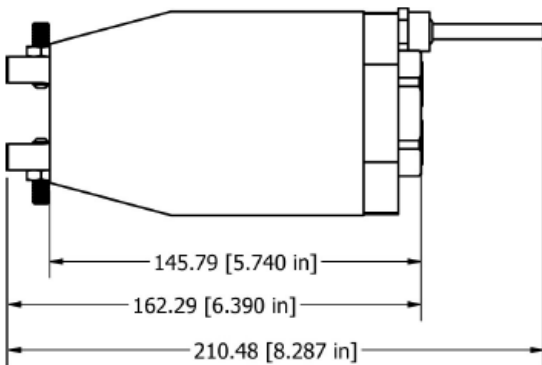
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# Live Tooling for Okuma Right Angle Drive

Fits Okuma LU/LB25, LU/LB400 and others

Part Number: 002011-3	Specifications:
Right Angle ER-32 Collet Drive Assembly	Weight: 7.7kg [17 lbs]
40mm VDI Shank w/ Type 2 Crown Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 50 NM [37 ft-lbs]
Coolant Required	



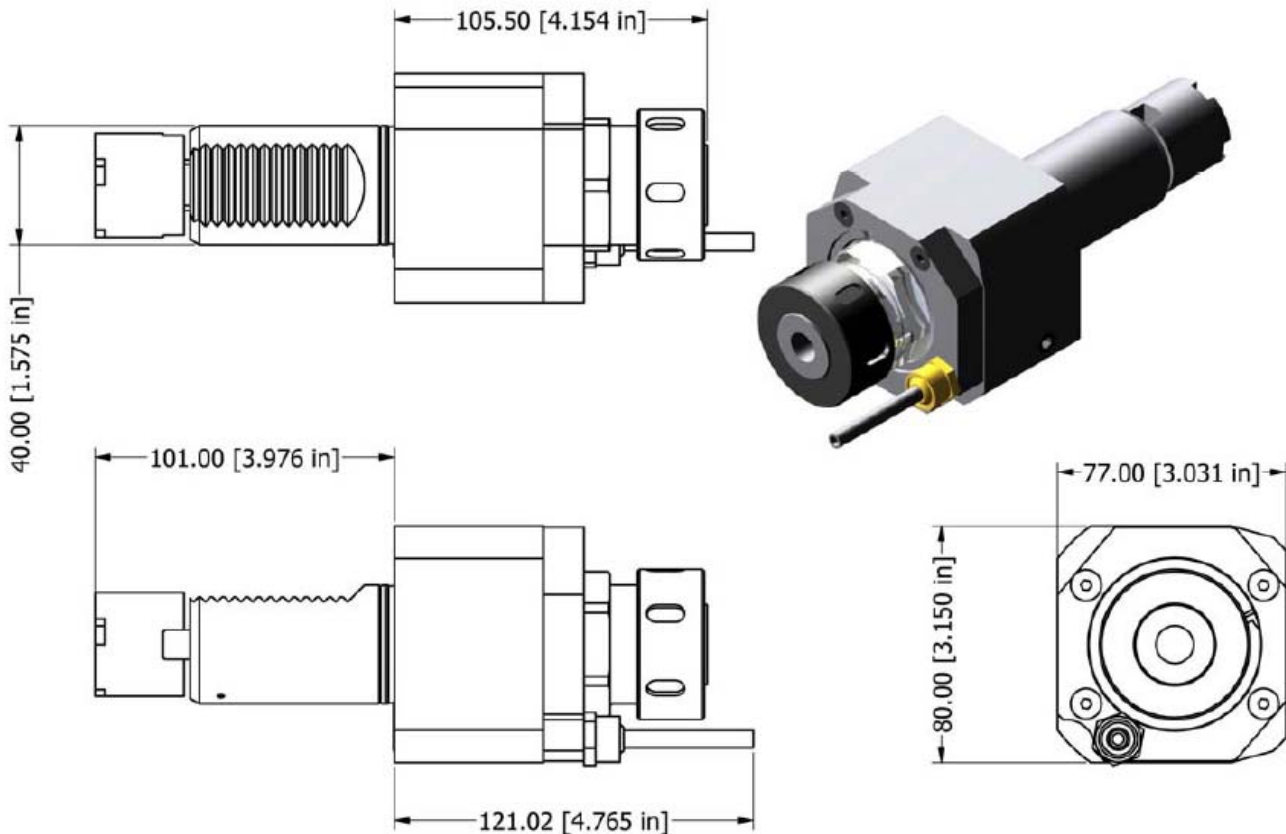
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# Live Tooling for Okuma Straight Drive

Fits Okuma UL/LB25, UL/LB400 and others

Part Number: 002011-4	Specifications:
Inline ER-32 Collet Drive Assembly	Weight: 4kg [8.8 lbs]
40mm VDI Shank w/ Type 2 Crown Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 68 NM, [50 ft-lbs]
Coolant Required	



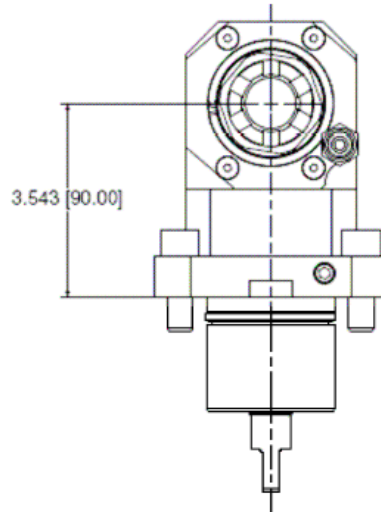
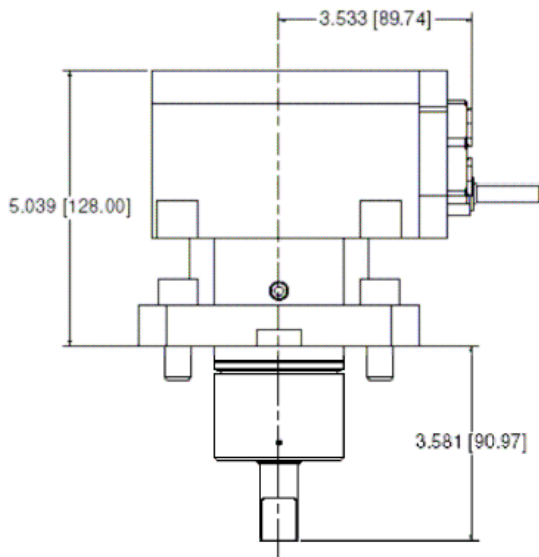
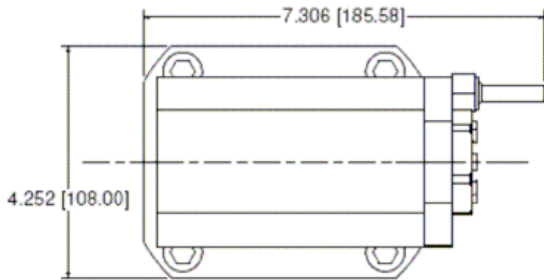
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# Live Tooling for Mori Seiki Right Angle Drive

Fits Mori Seiki NL1500, NL2000, NL2500, NL3000

Part Number: 002015-5	Specifications:
Right Angle ER-32 Collet Drive Assembly	Weight: 7.7kg [17 lbs]
D60 Shank w/ Tang Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 50 NM [37 ft-lbs]
Coolant Required	

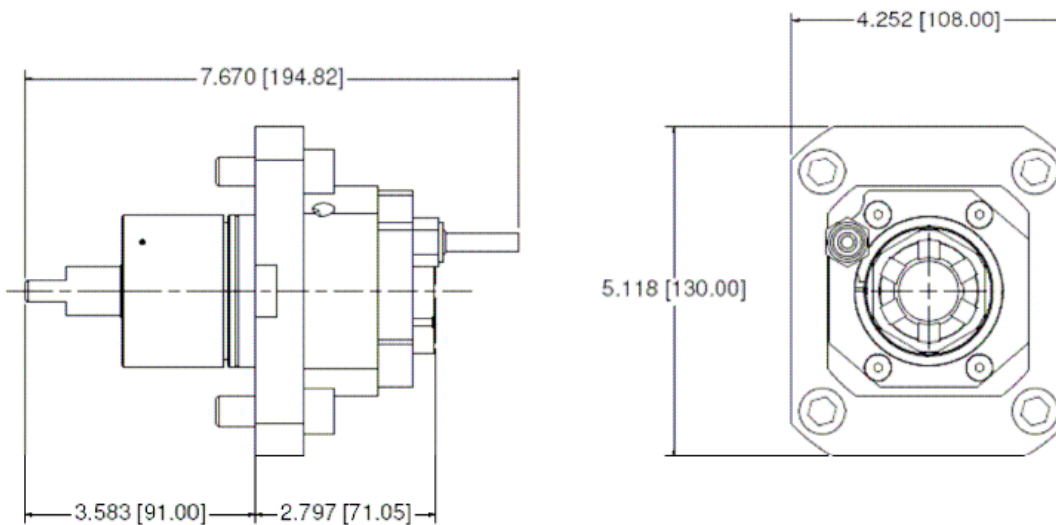
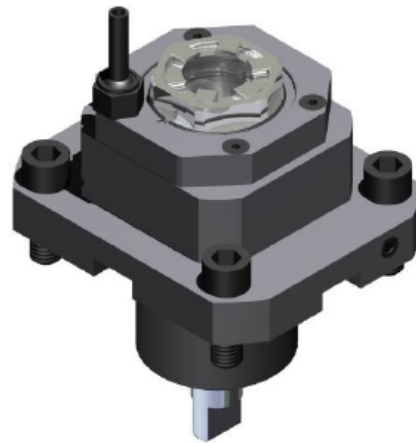




# Live Tooling for Mori Seiki Straight Collet Drive

Fits Mori Seiki NL1500, NL2000, NL2500, NL3000

Part Number: 002015-6	Specifications:
Straight ER-32 Collet Drive Assembly	Weight: 4.7kg [10.3 lbs]
D60 Shank w/ Tang Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 50 NM [37 ft-lbs]
Coolant Required	

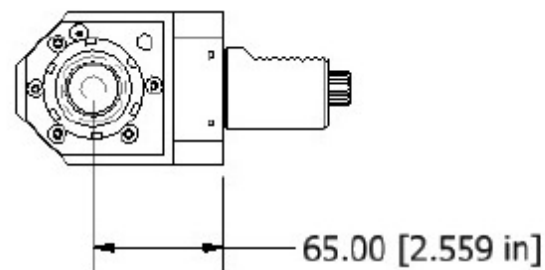
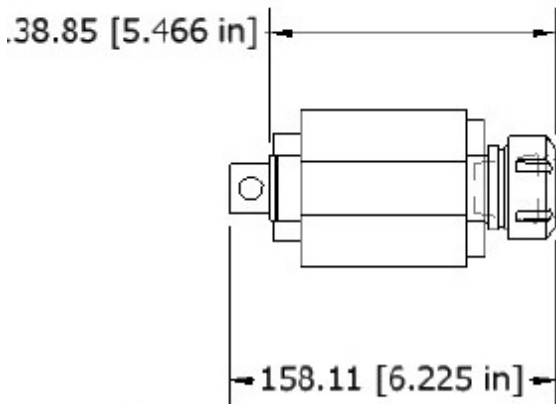
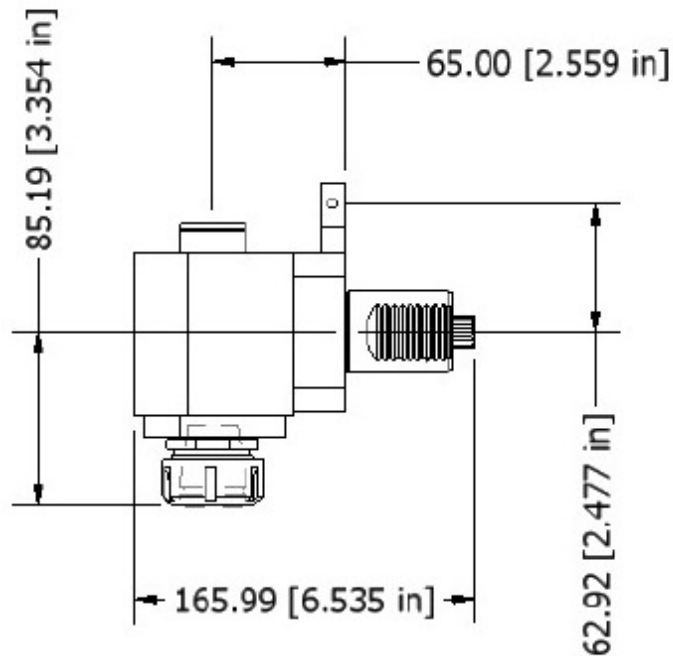
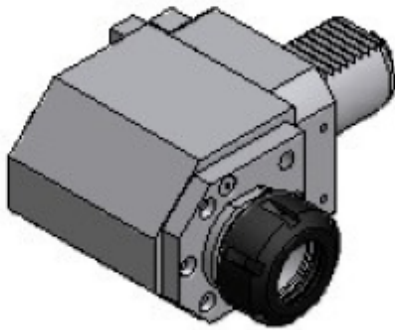


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# Live Tooling for Daewoo Right Angle Drive

Part Number: 002000-2	Specifications:
Right Angle ER-32 Collet Drive Assembly	Weight: 4kg [8.8 lbs]
40mm VDI Shank with Straight Drive Tang	Dynamic Load Capacity: 10.9 kN [2646 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 30 NM, [22 ft-lbs]
Coolant Required	



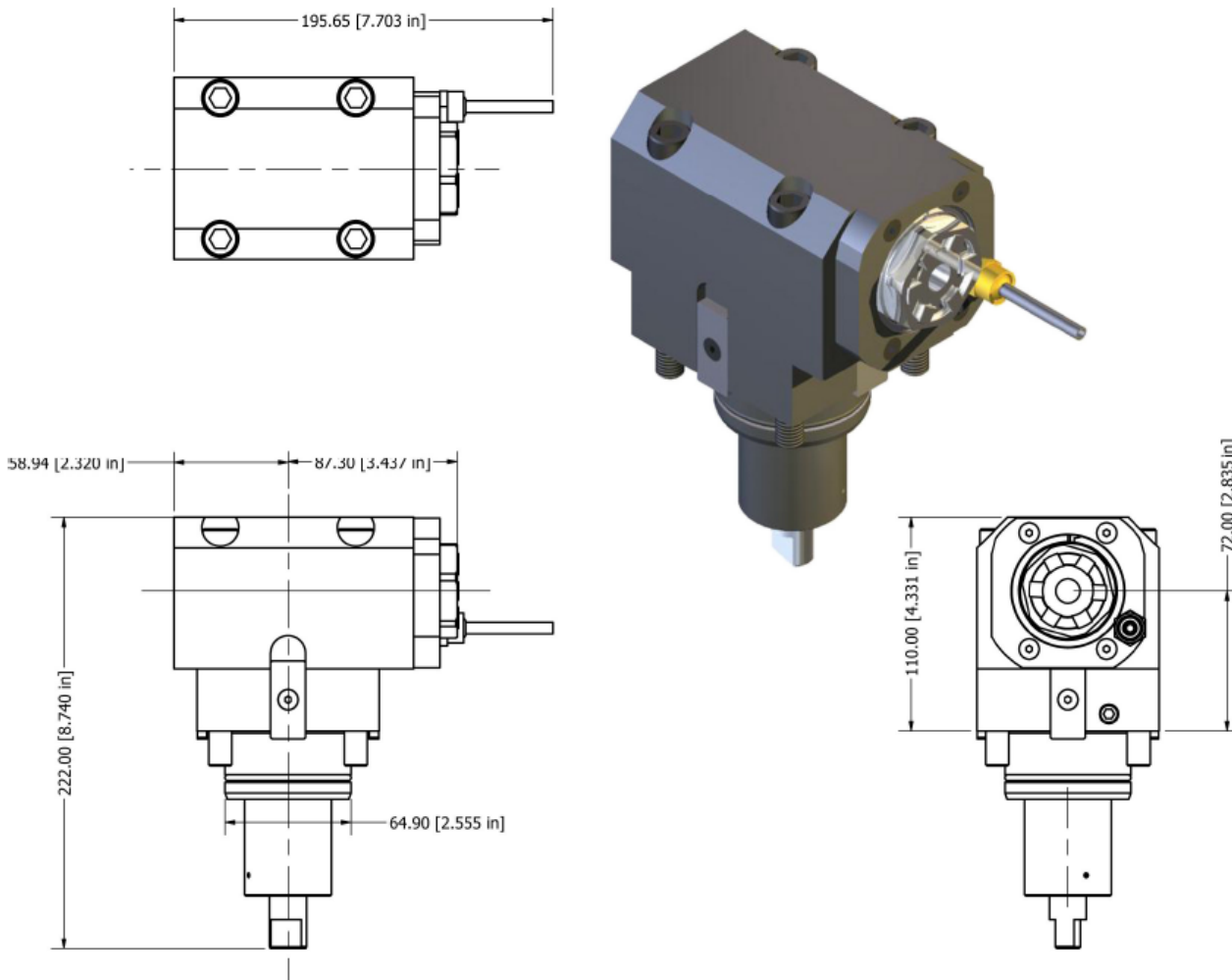


# Live Tooling for BMT 65 Turrets

## Right Angle Drive

Fits Doosan and others

Part Number: 002009-2	Specifications:
Right Angle ER-32 Collet Drive Assembly	Weight: 9.7kg [21.4 lbs]
BMT 65 Mounting	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 68 NM, [50 ft-lbs]
Coolant Required	Internal Collet Nut



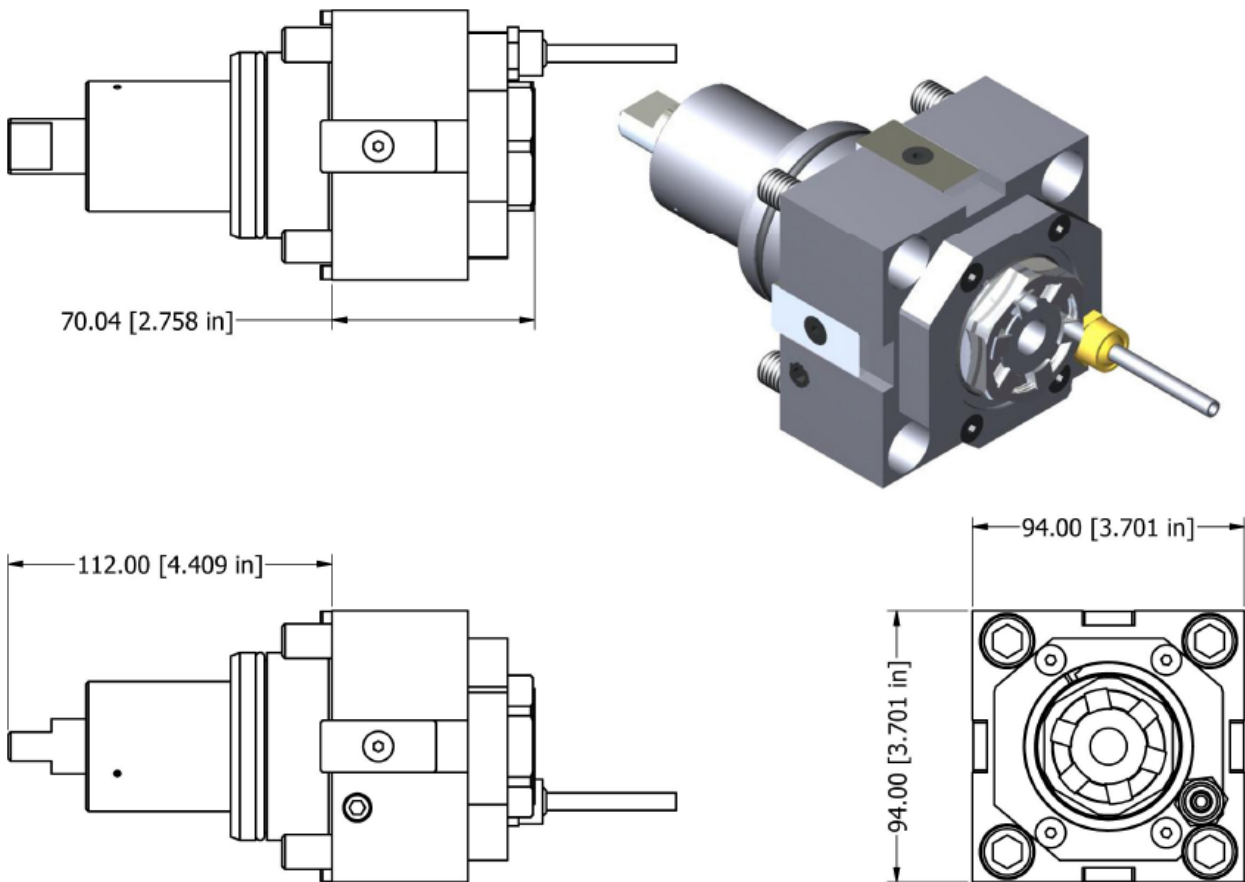


# Live Tooling for BMT 65 Turrets

## Straight Drive

Fits Doosan, Daewoo, and others

Part Number: 002010-9	Specifications:
Straight ER-32 Collet Drive Assembly	Weight: 4.7kg [10.3 lbs]
BMT 65 Mounting	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 68 NM, [50 ft-lbs]
Coolant Required	Internal Collet Nut

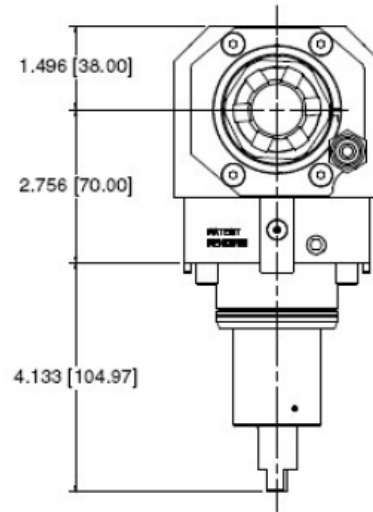
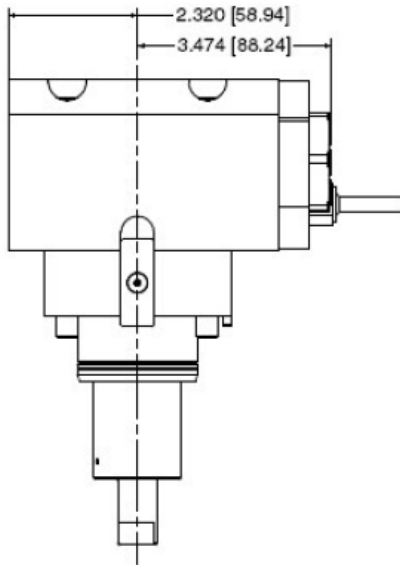
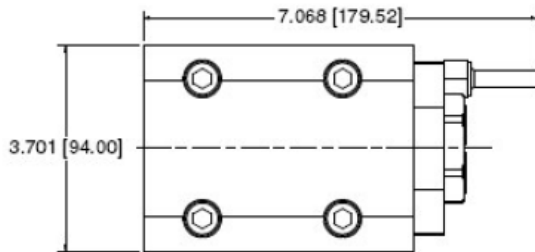




# Live Tooling for Doosan Right Angle Collet Drive

Fits Doosan PUMA 230-240-1500/2000/2500

Part Number: 002015-9	Specifications:
Right Angle ER-32 Collet Drive Assembly	Weight: 12.7kg [28 lbs]
BMT 55 Shank w/ Tang Drive	Dynamic Load Capacity: 13.3 kN [3214 lbs]
1:1 Transmission	Max Speed: 13,000 RPM
Rated for Continuous Duty	Continuous Torque Capacity: 50 NM [37 ft-lbs]
Coolant Required	



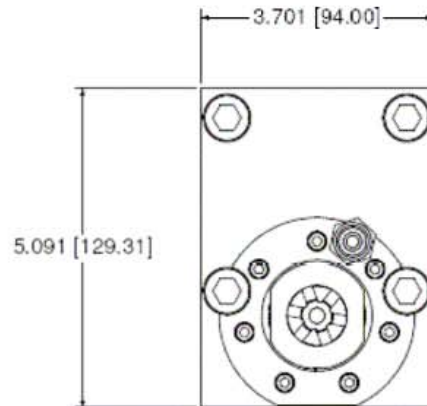
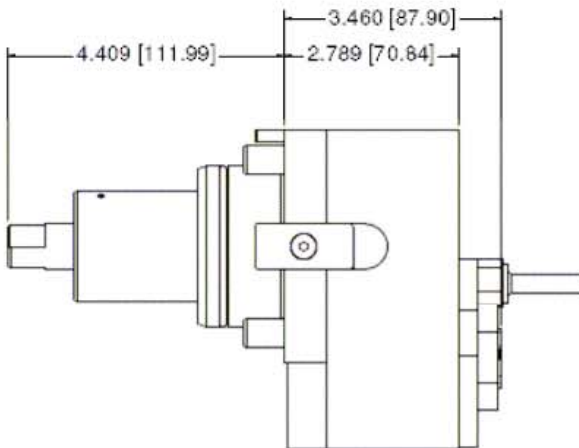
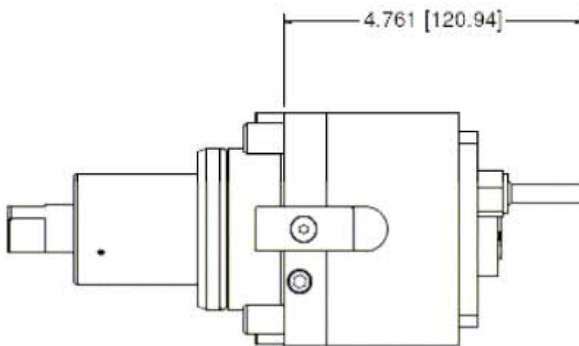


# Live Tooling for Doosan

## Offset Speedup Drive

TT2000/2500, MX2000/2500/3000  
 INVERTURN  
 PUMA 300

Part Number: 002011-7ABC16	Specifications:
Offset Speedup Collet Drive	Weight: 7kg [15.4 lbs]
BMT 65 Shank w/ Tang Drive	Dynamic Load Capacity: 13.3kN [3214 lbs]
2:1, 3.5:1, 1:1 Transmission (Select A, B, or C)	Max Speed: 21,000 RPM
Rated for Continuous Duty	ER-16 Internal Collet
Coolant Required	



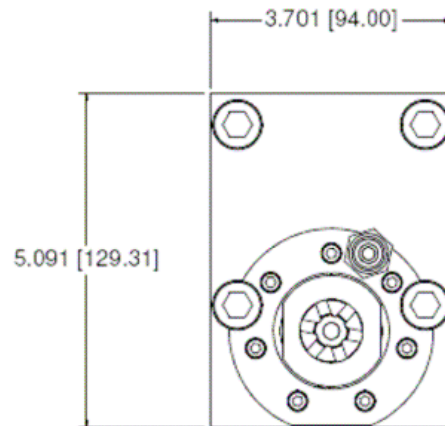
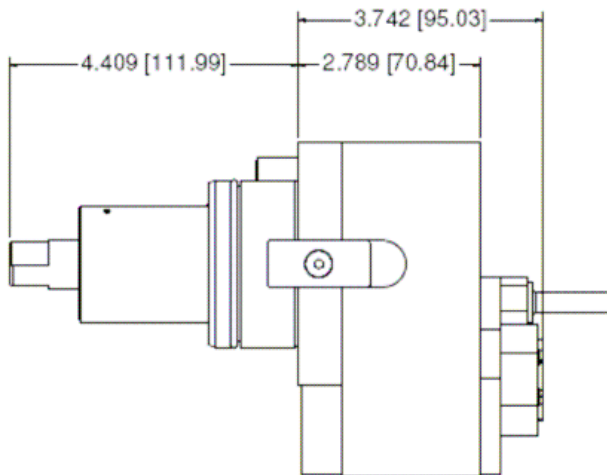
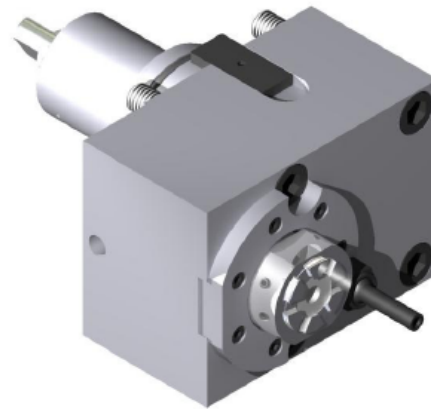
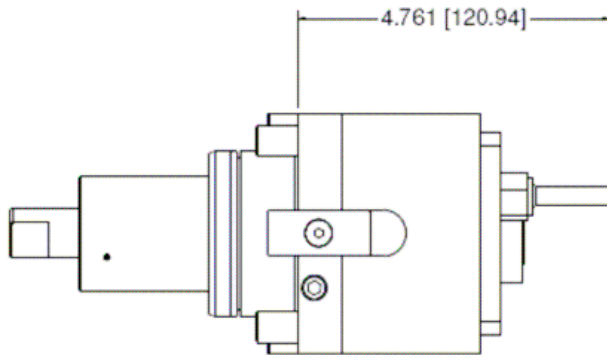


# Live Tooling for Doosan

## Offset Speedup Drive

TT2000/2500, MX2000/2500/3000  
 INVERTURN  
 PUMA 300

Part Number: 002011-7ABC25	Specifications:
Offset Speedup Collet Drive	Weight: 7kg [15.4 lbs]
BMT 65 Shank w/ Tang Drive	Dynamic Load Capacity: 13.3kN [3214 lbs]
2:1, 3.5:1, 1:1 Transmission (Select A, B, or C)	Max Speed: 21,000 RPM
Rated for Continuous Duty	ER-25 Internal Collet
Coolant Required	



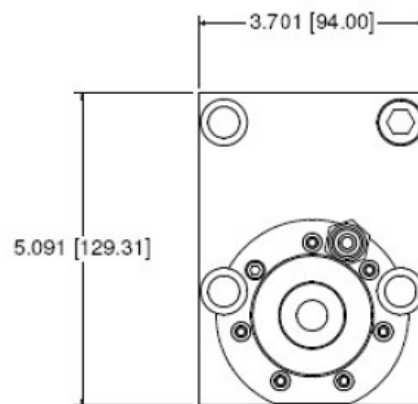
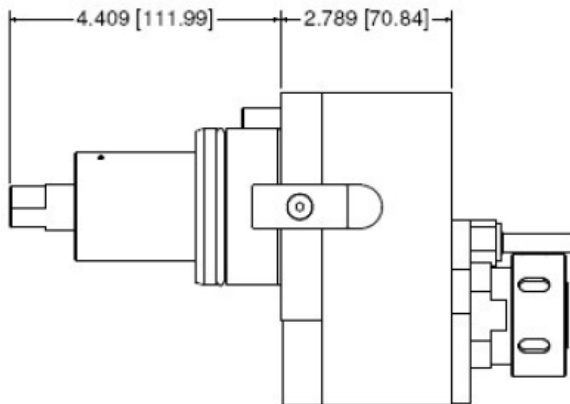
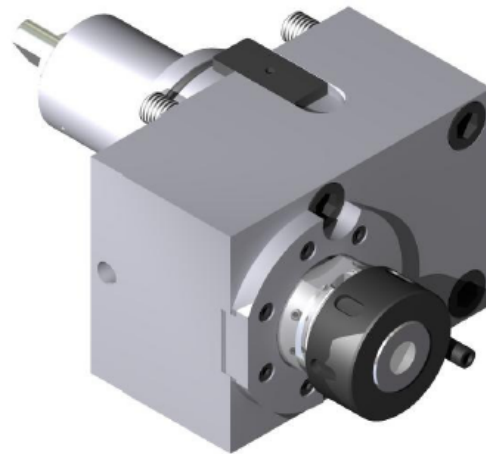
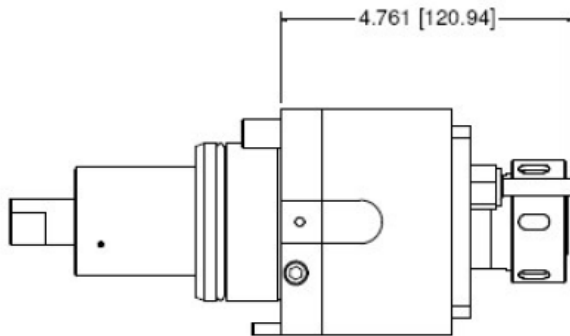


# Live Tooling for Doosan

## Offset Speedup Drive

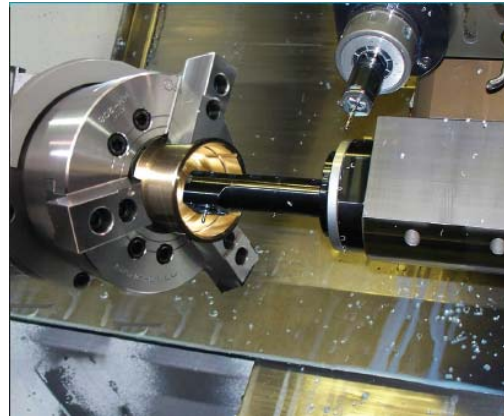
TT2000/2500, MX2000/2500/3000  
 INVERTURN  
 PUMA 300

Part Number: 002011-7ABC32	Specifications:
Offset Speedup Collet Drive	Weight: 7kg [15.4 lbs]
BMT 65 Shank w/ Tang Drive	Dynamic Load Capacity: 13.3kN [3214 lbs]
2:1, 3.5:1, 1:1 Transmission (Select A, B, or C)	Max Speed: 21,000 RPM
Rated for Continuous Duty	ER-32 External Collet
Coolant Required	



# ELTOOL ID MILL & DRILL HEADS

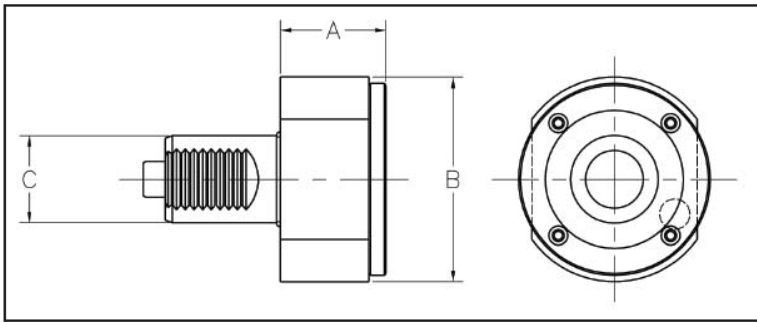
Internal mill & drill heads for ID holes, keyways, and detail milling. Mechanically driven ID heads that mount to Planet Live tool body. Filtered coolant required for tool cooling & lubrication.



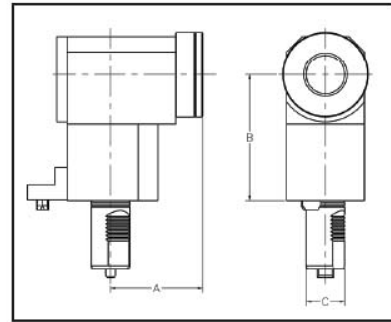
## Sizes and Dimensions

### Live Tool Modules

#### Face Mounted



#### O.D. Mounted



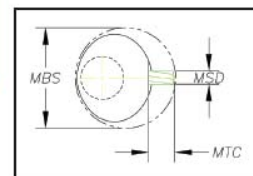
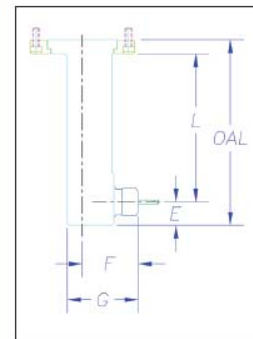
Part No.	MFG	Model	Mount	A	B	C
MZ40A	Mazak	QT, SQT	Face	1.938	3.700	1.575
MZ40B	Mazak	QT, SQT	O.D.	3.750	5.125	1.575
OK40A	Okuma	LT, LB, LU, 15 300,CAPT. L370	Face	1.650	3.860	1.575
HY40A	Hyundai-Kia	SKT	Face	1.650	3.700	1.575
HY40B	Hyundai-Kia	SKT	O.D.	2.250	2.550	1.575

### Angle Heads

Head Size	Part No.	Spindle	L	E	F	G	OAL	MBS	MSD	MTC
1D 1 Drilling	1DSTL	Taperlock	3.000	.500	.465	.813	3.875	1.000	.115	.125
	1DSTEL	Eltool	3.000	.500	.688	.985	3.875	1.125	.125	.094
	1DSTW	Weldan	3.000	.500	.500	.813	3.875	1.000	.125	.125
1M 1 Milling	1MSTL	Taperlock	3.000	.375	.625	.938	3.750	1.125	.115	.125
	1MSTEL	Eltool	3.000	.375	.670	.985	3.750	1.125	.125	.125
	1MSTB	ER-8	3.000	.375	1.000	1.312	3.750	1.438	.196	.125
2D 2 Drilling	2DSTL	Eltool	4.000	.625	.720	1.125	5.000	1.625	.156	.281
	2DST11	ER-11	4.000	.625	1.250	1.650	5.000	1.875	.275	.140
	2DSTW	Weldan	4.000	.625	.906	1.312	5.000	1.500	.312	.125
2M 2 Milling	2MSTEL	Eltool	4.000	.625	.975	1.375	5.000	1.750	.156	.281
	2MST11	ER-11	4.000	.625	1.538	1.938	5.000	2.250	.275	.140
	2MSTW	Weldan	4.000	.625	1.100	1.500	5.000	1.875	.375	.125
3D 3 Drilling	3DST11	ER-11	5.000	.688	1.595	2.355	6.470	2.875	.275	.390
	3MST16	ER-16	5.000	.688	1.812	2.625	6.470	3.000	.406	.250
	3MSTW	Weldan	5.000	.688	1.353	2.188	6.470	2.625	.500	.250

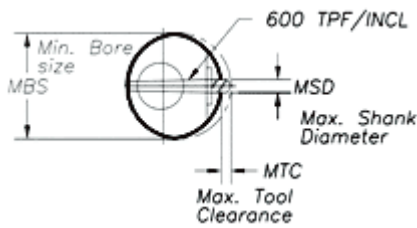
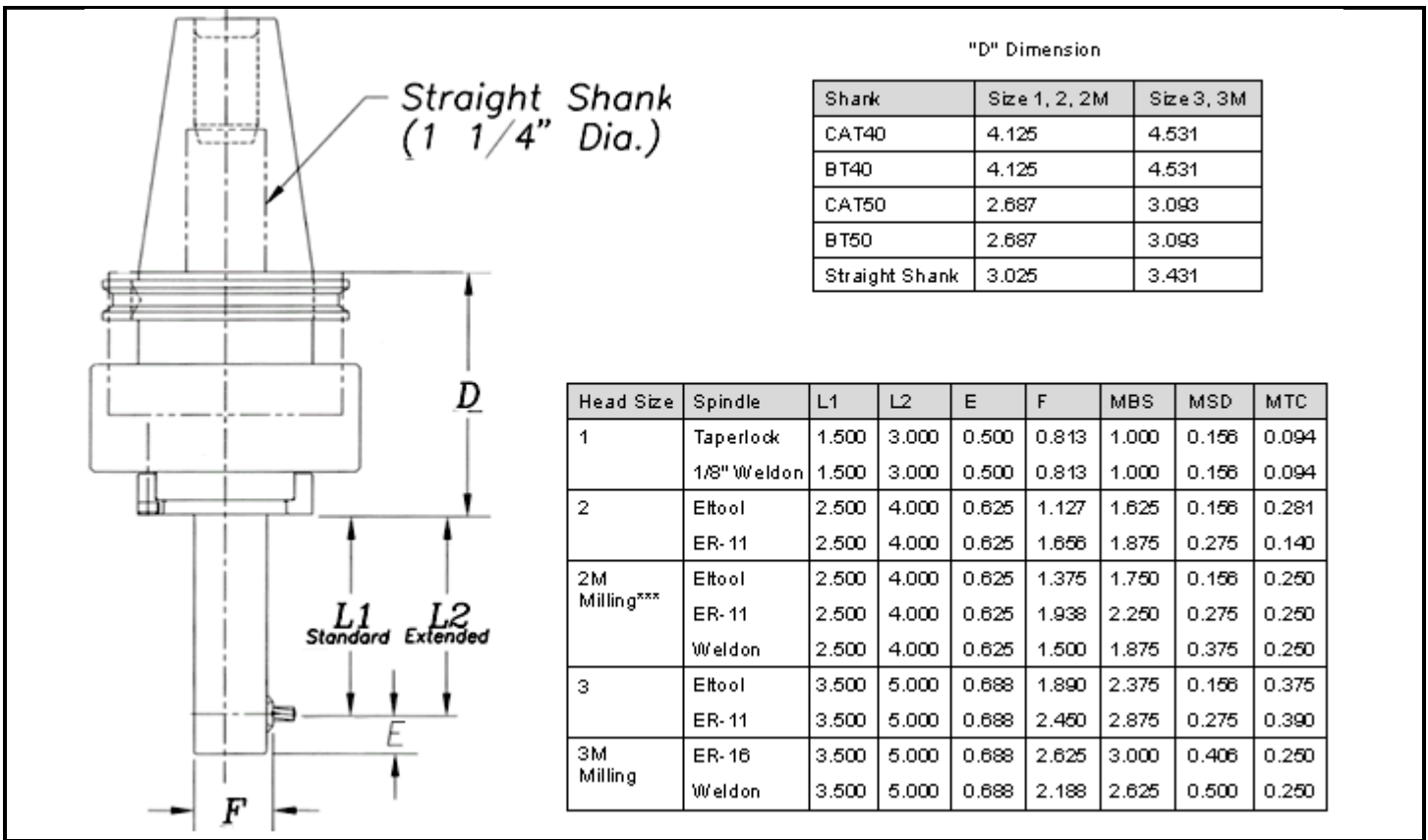
#### Notes:

1. Milling heads are recommended for heavier duty milling applications. They incorporate two preloaded angular contact bearings on the front for improved performance and durability in side load applications. Drilling heads are more compact.
2. "Taperlock" and "Eltool" Spindles are proprietary spindles designed to minimize the profile of the angle heads.
3. Please specify the size of Weldon spindle when ordering.

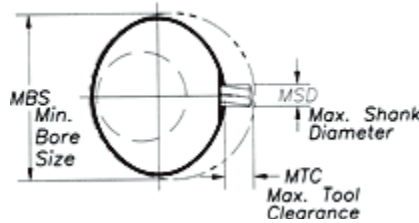


MBS—Minimum Bore Size  
MSD—Maximum Shank Diameter  
MTC—Maximum Tool Clearance

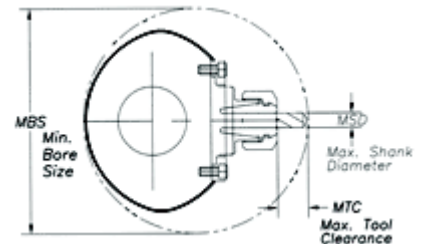
# Coolant Driven EI-Tool Tightspot Angle Heads



Size 1 Head with Taperlock\* or 1/8 Weldon Spindle



Size 2, 2M or 3 Head with Eltool\* Collet, and Size 2M and 3M Head with Weldon\*\* Spindle



Size 2, 2M and 3 Head with ER-11 Collet, and Size 3M Head with ER-16 Collet

## Notes:

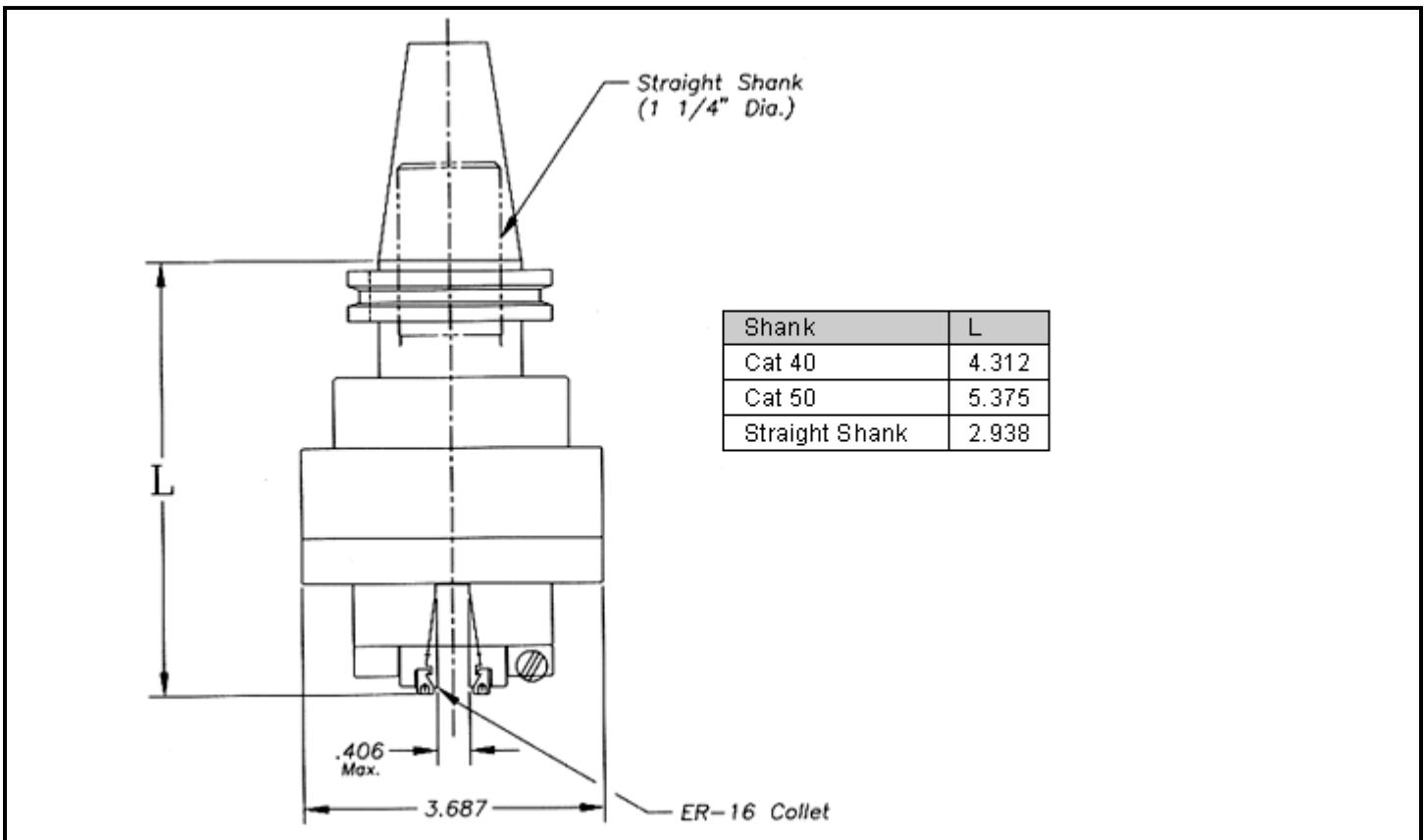
\* "Taperlock" and "Eltool" collets are proprietary collets designed to minimize the profile of the angle heads.

\*\* Please specify size of Weldon spindle when ordering.

\*\*\* Milling heads are recommended for heavier duty milling applications. They incorporate two preloaded angular contact bearings on the front for improved performance and durability in side load applications.

## In-Line Heads

The In-Line version of our coolant driven drill head provides a low cost way to *convert an ordinary lathe to live tooling*. Capable of speeds *up to 13,500 RPM* the In-Line head also functions as a *spindle speeder on machining centers*.



### Please Consult Factory For:

- Other shank styles, including HSK, Capto, ABS
- Din B or External coolant delivery

# Coolant Filtration

All Planet live tools require filtered coolant to lubricate the internal components.

## Part # 500191-4

10 Micron Filtration  
3/4" NPT Ports  
1/8" NPT Gauge Port  
150 PSI Max Pressure



# Tooling Repair Services



Planet repairs all makes of live tooling and right angle heads. We offer a knowledgeable, experienced staff, engineering assistance, and quick turnaround.

- 48 Hr quotation
- All Parts & Labor
- Refurbish with new components & re-machine if necessary
- Performance test to OEM specifications

# Warranty Service & Repair

Planet warranties it's live tooling for one year from date of purchase against defects in material & workmanship. For warranty service, please contact:

**Planet Products Corporation**  
4200 Malsbary Road  
Cincinnati, OH 45242  
(513) 984-5544  
(513) 984-5580  
[Sales@planet-products.com](mailto:Sales@planet-products.com)