NOGA MT
MACHINE TOOLS

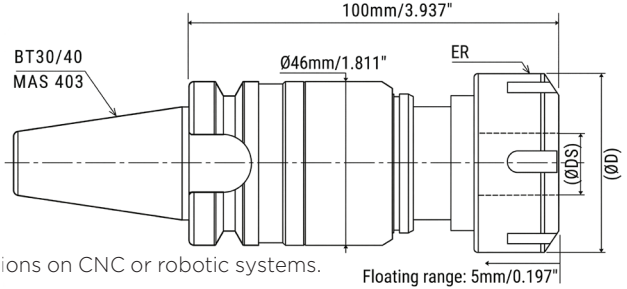
The NOGAMT FLOATING DAMPER SERIES UF-FD.....BT...

PRODUCT DESCRIPTION

The Floating Damper is designed to compensate for surface irregularities and bristle wear during operation. Its internal spring mechanism applies a controlled and consistent force, ensuring stable contact between the tool and workpiece for reliable, consistent deburring and polishing results.

KEY ADVANTAGES

- Minimizes the need for precise depth adjustments.
- Improves consistency of edge finishing.
- Reduces tool wear and extends service life.
- Eliminates programming adjustments to compensate for bristle wear.



TYPICAL APPLICATIONS

- Surface finishing using **UFIBER** brushes.
- Automated deburring and polishing operations on CNC or robotic systems.

SPECIFICATIONS

PARAMETER	VALUE
Interface	MAS 403-BT30 / BT40
Max Speed	6,000 rpm
Tool Shank Capacity ØDS	Ø6/Ø10/Ø12/Ø16 mm (0.236"/0.394"/0.472"/0.630")
ER Collet ØD Ultra Precision, ≤ 5 μm runout	ER25UM for BT30 / ØD=42mm (1.653") ER32UM for BT40 / ØD=50mm (1.968")
Floating Range	5 mm (0.197")
Spring Pressure	Approx. 50 N
BT30 Spare Part	M12 x 1.75
BT40 Spare Part	M16 x 2

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Note: Design and specifications may be changed without prior notice for product improvement.

PRECAUTIONS FOR USE

- Ensure the collet and holder are securely tightened before operation.
- Confirm that the tool shank is properly clamped in the machine chuck.
- Always wear appropriate protective equipment (safety glasses, gloves, etc.).
- If the tool is not fully inserted into the base, vibration during machining may cause loosening. This may result in tool detachment, breakage or injury.
- Use a chuck that matches the shank diameter correctly.
- Operate only with equipment capable of controlling rotational speed.
- Do not use through-spindle coolant. Coolant entering the holder may prevent proper floating operation.
- After extended use, the floating function may be affected due to reduced spring force. Check functionality before use.
- During machining, particles and dust may scatter. Use appropriate collection or extraction systems.
- Processing dust may be harmful to health (lungs, skin, allergies).
- Perform a short test run before use to ensure proper operation.
- If vibration or abnormal behaviour occurs, stop operation immediately. Continued use may lead to tool failure or injury.
- Do not exceed the maximum rotational speed, depth of cut, or brush projection. This increases the risk of failure and injury.

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OPERATING INSTRUCTIONS

OPERATION MODES	1. POSITION	2. PRELOAD	3. FEED	4. STOP	5. RETRACT
STANDARD FIGURE A	Approach the tool without rotation.	**Compress spring and set depth	Feed with rotation	Stop rotation & feed	Retract upward vertically
*RAMPING FIGURE B	Arc entry with rotation	**Compress spring & set depth (before feed)	Feed with rotation	———	Arc exit with rotation

*Ramping provides smoother engagement, reducing tool marks and improving surface finish quality.
**Max depth for compressing is 5 mm (0.197").



FIGURE A

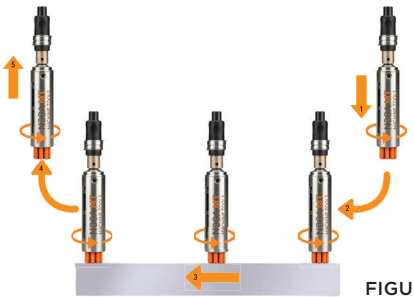


FIGURE B

USAGE GUIDELINES

- Approach the brush vertically and engage it with the workpiece. Avoid side contact, as it can damage the bristles. Figure C.
- Do not let the tool drop into pockets or contact protruding features. Figure D.
- Ensure the floating mechanism can move freely at all times.
- Prevent lateral (side) loading on the brush or tool.

PRACTICAL RECOMMENDATIONS

- Apply preload before starting the cutting process.
- Maintain consistent spring engagement throughout machining.
- Proper setup improves both entry and exit surface quality.
- Stable operating conditions help achieve longer tool life and repeatable results.



Side approach with proper alignment
FIGURE C



Do not allow the tool to drop onto pockets
FIGURE D



Avoid contact with protruding features
FIGURE D

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