Member IMC Group Tungaloy

ToolLine

For more information

Tooling system

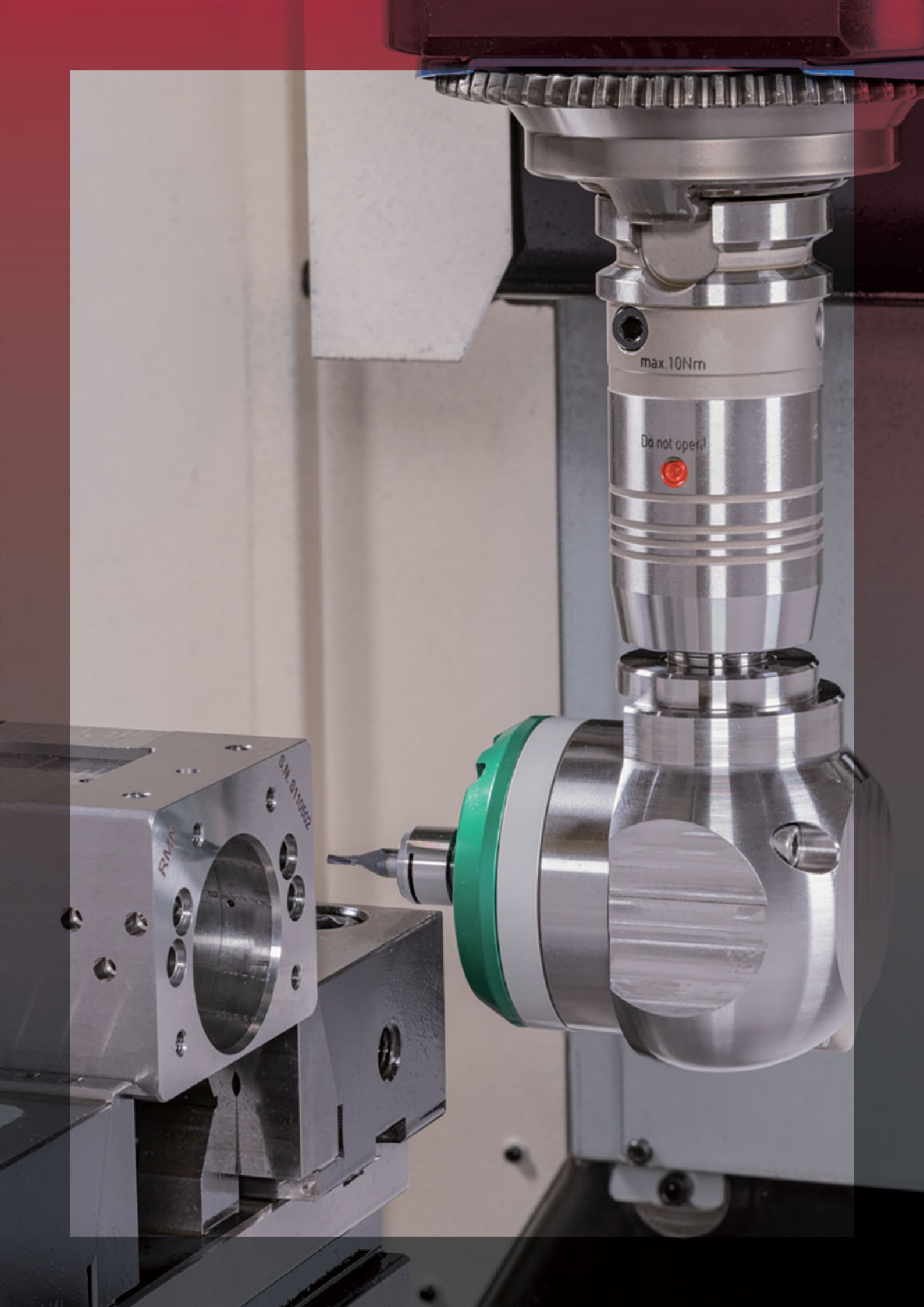
SPINJET

Tungaloy Report No. 428-G

Transform existing machine into a high-speed machine!



TUNGALOY ADDFORCE ACCELERATED LINES


max.10Nm

TUNGALOY ADDFORCE ACCELERATED LINES

SPINJET



Productivity quadruples due to spindles that rotate at high speed with coolant pressure!

SPINJET

Coolant-driven HSM spindle for high productivity with small diameter tools on limited RPM machines

- SpinJet utilizes the machine tool's existing coolant supply, driven by a high pressure pump as an energy source to rotate a turbine at high speeds.
- Strong coolant jet flow provides extended tool life and machining stability.

ATC-Compatible Design

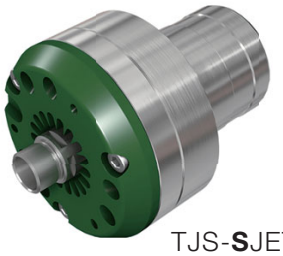
The light-weight and compact design allows a perfect fit into the ATC or tool magazine, ideal for un-manned, mass production lines.

Adoption of a cartridge system (modularization of the drive unit)

By adopting a cartridge system, the drive unit can be replaced individually if it fails, allowing the system to continue operating. Furthermore, this design enables the use of a single spare spindle across multiple different interfaces.



TJS-**P**JET-TR

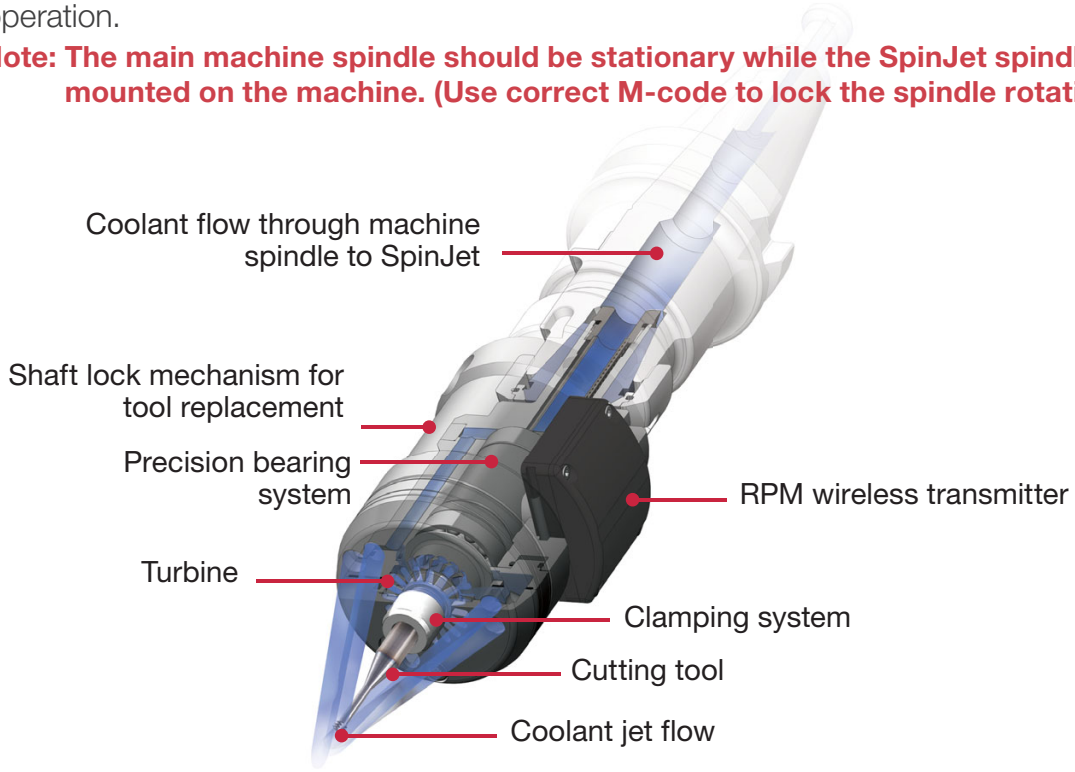


TJS-**S**JET-TR

Energy saving

Tools rotate only with coolant pressure, and the machine spindle is idle while SpinJet is in operation.

Note: The main machine spindle should be stationary while the SpinJet spindle is mounted on the machine. (Use correct M-code to lock the spindle rotation).



New Wireless RPM Monitoring

The built-in transmitter sends the RPM data wirelessly, allowing you to monitor the actual RPM using a dedicated mobile app available for free download.
(RPM monitoring range: up to 5 m)
*A dedicated display is no longer required.



*A dedicated display is not required.
*The mobile app is not compatible with older transmitters. SpinJet units equipped with older transmitters can monitor RPM via the mobile app by replacing the transmitter with the new model (TJSSPEEDTAGBLE).

Specifications

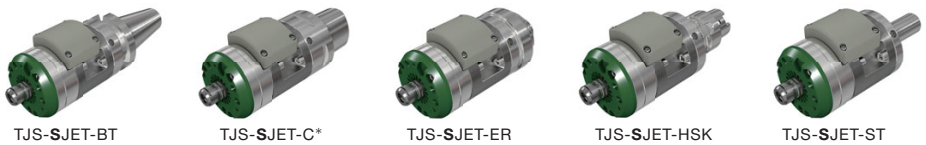
Features	SPINJET (S JET)	SPINJET (P JET)
Coolant pressure: P (MPa)	2 - 4	1.5 - 7
Min. flow rate: Q (l/min)	12 - 20	10 - 20
No. of revolution: *n* (RPM)	35,000 - 55,000	21,000 - 45,000
Tool dia: ø*Dc*(mm)	Drill: 0.5 - 2	Drill: 0.3 - 2
	Milling: 1.5 - 3.5	Milling: 0.3 - 3.5
Max. shank dia: ø*Ds* (mm)	7	7

These are approximate RPM values depending on coolant pressure, flow rate, and type.

Applicable on a wide variety of machines

SpinJet is available in several adaptation types.

Types of adaptations

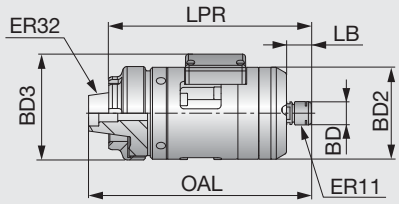

TJS-**S**JET-BT TJS-**S**JET-C* TJS-**S**JET-ER TJS-**S**JET-HSK TJS-**S**JET-ST


TJS-**P**JET-BT TJS-**P**JET-C* TJS-**P**JET-ER TJS-**P**JET-HSK TJS-**P**JET-ST

New

TJS-SJET-ER

Coolant driven high speed compact spindles with ER32 shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSSJETER32	16	63	81	17	138.8	152.6	6	33,000	55,000	2.2

- Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
- Min. flow rate: 12 l/min

(1) Max. tool shank diameter: ø7 mm

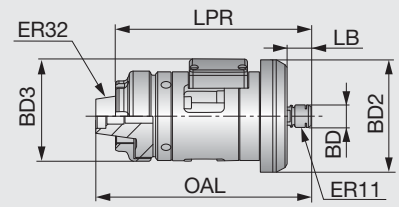
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSGJETER32	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEY	P-2

New

TJS-PJET-ER

High-pressure coolant driven high speed compact spindles with ER32 shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSPJETER32	16	80	81	17	138.9	152.7	6	20,000	45,000	2.25

- Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
- Min. flow rate: 10 l/min

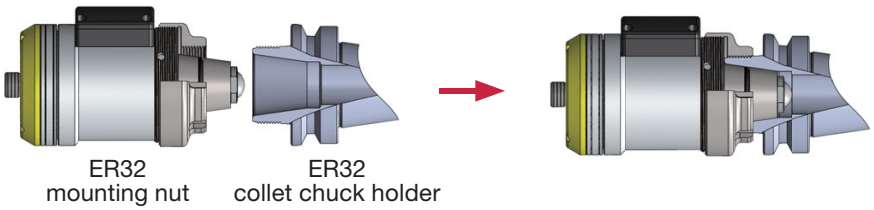
(1) Max. tool shank diameter: ø7 mm

SPARE PARTS

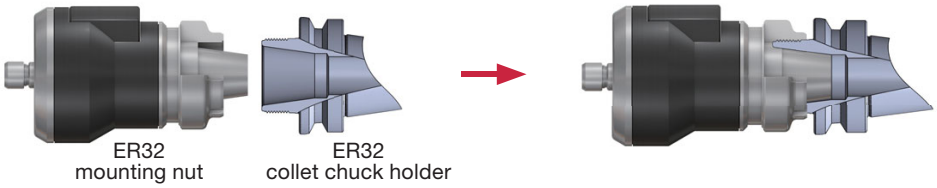
Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSPJETER32	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCK KEY	P-2

Built-in ER32 collet chuck

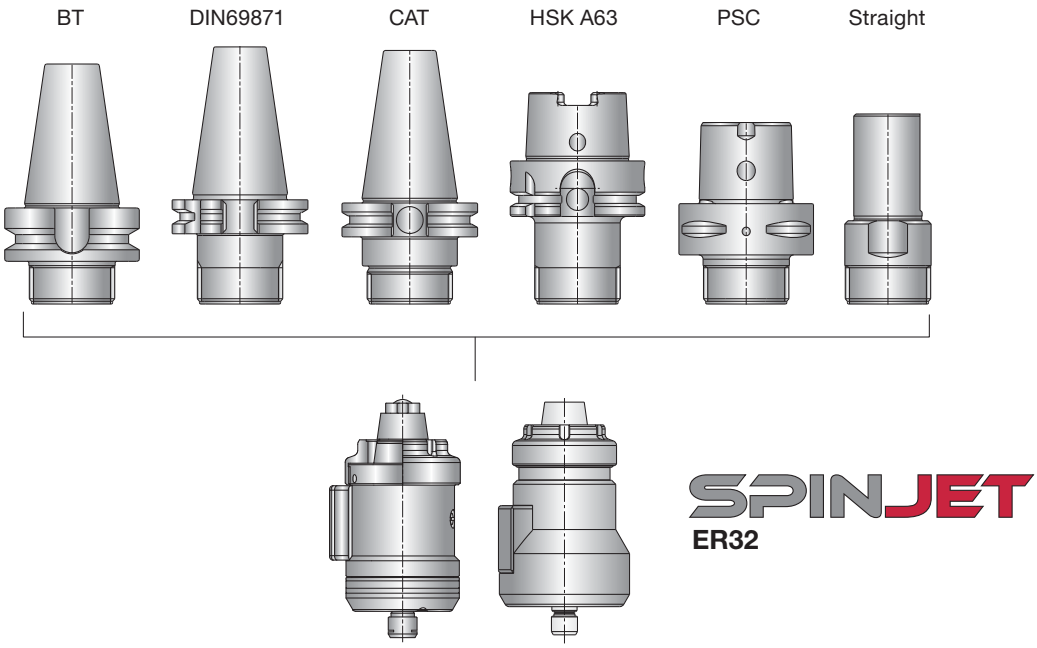
TJSSJETER32



TJSPJETER32



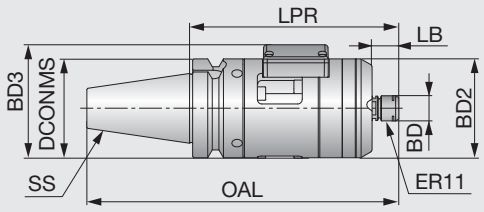
Options of SpinJet adaptation with ER32



New

TJS-SJET-BT

Coolant driven high speed compact spindles with BT shanks



Designation	BD	BD2	BD3	LB	SS	LPR	OAL	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSSJETBT30	16	63	81	17	30	139.3	187.7	6	33,000	55,000	2
TJSSJETBT40	16	63	81	17	40	133.3	198.7	6	33,000	55,000	2.5

• Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
• Min. flow rate: 12 l/min
(1) Max. tool shank diameter: ø7 mm

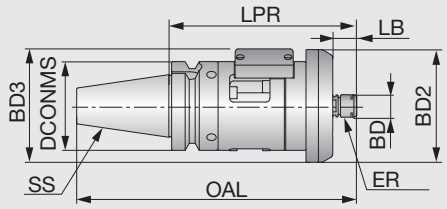
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSSJETBT...	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-PJET-BT

High-pressure coolant driven high speed compact spindles with BT shanks



Designation	BD	BD2	BD3	LB	SS	LPR	OAL	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSPJETBT30	16	80	81	17	30	139.4	187.8	6	20,000	45,000	2.1
TJSPJETBT40	16	80	81	17	40	133.4	198.8	6	20,000	45,000	2.6

• Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
• Min. flow rate: 10 l/min
(1) Max. tool shank diameter: ø7 mm

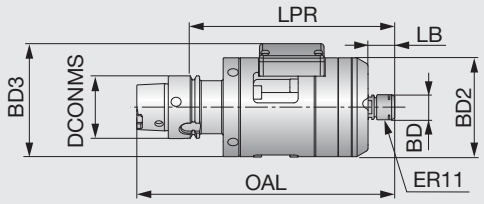
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSPJETBT...	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-SJET-HSK

Coolant driven high speed compact spindles with HSK shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	DCONMS	DCONXWS(1)	WT(kg)
TJSSJETHSKA40	16	63	81	17	144.3	164.3	40	6	1.9
TJSSJETHSKA63	16	63	81	17	149.3	181.3	63	6	2.4

- Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
- Min. flow rate: 12 l/min

(1) Max. tool shank diameter: ø7 mm

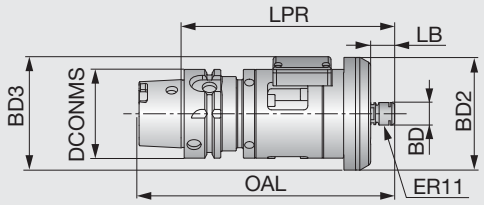
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Coolant tube (Optional)	Tube wrench (Optional)	Wrench
TJSSJETHSKA40	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	(COOLINGTUBEHSKA40)	(WRENCH COOL TUBE HSK40)	P-2
TJSSJETHSKA63	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	(COOLINGTUBEHSKA63)	(WRENCH COOL TUBE HSK63)	P-2

New

TJS-PJET-HSK

High-pressure coolant driven high speed compact spindles with HSK shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	DCONMS	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSPJETHSKA40	16	80	81	17	144.4	164.4	40	6	20,000	45,000	2
TJSPJETHSKA63	16	80	81	17	149.4	181.4	63	6	20,000	45,000	2.5

- Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
- Min. flow rate: 10 l/min

(1) Max. tool shank diameter: ø7 mm

SPARE PARTS

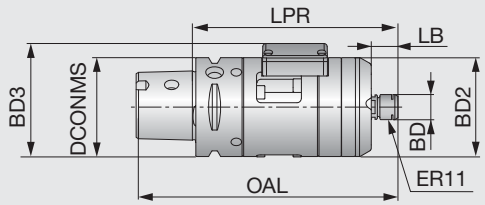
Designation	Nut	Wrench for nut	Shaft lock key	Coolant tube (Optional)	Tube wrench (Optional)	Wrench
TJSPJETHSKA40	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	(COOLINGTUBEHSKA40)	(WRENCH COOL TUBE HSK40)	P-2
TJSPJETHSKA63	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	(COOLINGTUBEHSKA63)	(WRENCH COOL TUBE HSK63)	P-2

SPINJET

New

TJS-SJET-C*

Coolant driven high speed compact spindles with TungCap PSC shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	DCONMS	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSSJETC5	16	63	81	17	127.3	157.3	50	6	33,000	55,000	2
TJSSJETC6	16	63	81	17	128.8	166.8	63	6	33,000	55,000	2.3

• Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
• Min. flow rate: 12 l/min
(1) Max. tool shank diameter: ø7 mm

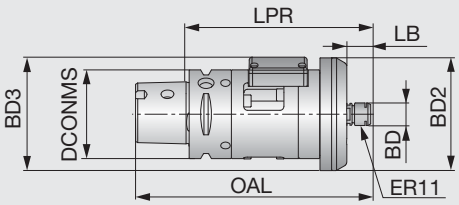
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSSJETC*	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-PJET-C*

High-pressure coolant driven high speed compact spindles with TungCap PSC shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	DCONMS	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSPJETC5	16	80	81	17	127.4	157.4	50	6	20,000	45,000	2.1
TJSPJETC6	16	80	81	17	128.9	166.9	63	6	20,000	45,000	2.4

• Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
• Min. flow rate: 10 l/min
(1) Max. tool shank diameter: ø7 mm

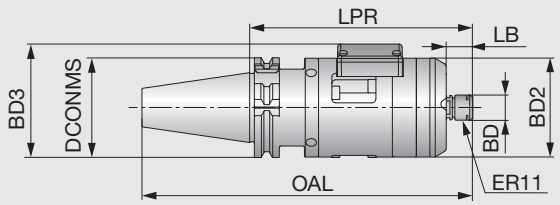
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSPJETC*	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-SJET-SK

Coolant driven high speed compact spindles with SK (DIN69871) shanks



Designation	BD	BD2	BD3	LB	SS	LPR	OAL	DCONMS	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSSJETDIN6987140	16	63	81	17	40	142.4	210.8	63.55	6	33,000	55,000	2.6

- Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
- Min. flow rate: 12 l/min

(1) Max. tool shank diameter: ø7 mm

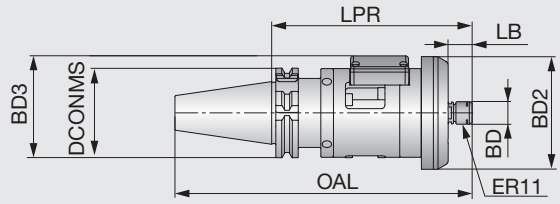
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSSJETDIN6987140	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-PJET-SK

High-pressure coolant driven high speed compact spindles with SK (DIN69871) shanks



Designation	BD	BD2	BD3	LB	SS	LPR	OAL	DCONMS	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSPJETDIN6987140	16	80	81	17	40	142.5	210.9	63.55	6	20,000	45,000	2.7

- Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
- Min. flow rate: 10 l/min

(1) Max. tool shank diameter: ø7 mm

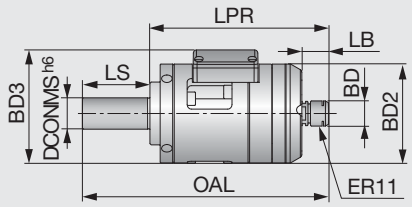
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSPJETDIN6987140	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-SJET-ST

Coolant driven high speed compact spindles with straight shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	DCONMS	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSSJETST20	16	63	81	17	113.8	156.8	20	6	33,000	55,000	1.7

- Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
- Min. flow rate: 12 l/min

(1) Max. tool shank diameter: ø7 mm

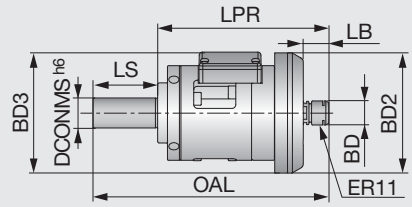
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSSJETST20	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-PJET-ST

High-pressure coolant driven high speed compact spindles with straight shanks



Designation	BD	BD2	BD3	LB	LPR	OAL	LS	DCONMS	DCONXWS(1)	RPMN	RPMX	WT(kg)
TJSPJETST20	16	80	81	17	113.9	156.9	43	20	6	20,000	45,000	1.8

- Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
- Min. flow rate: 10 l/min

(1) Max. tool shank diameter: ø7 mm

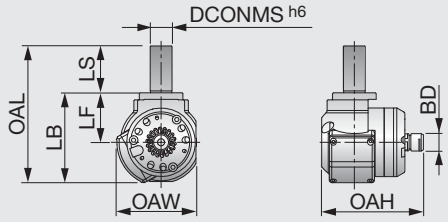
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSPJETST20	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-SJET-ST-90D

Coolant driven high speed compact spindles with 90˚ shanks



Designation	BD	OAH	OAW	LS	LB	LF	OAL	DCONMS	RPMN	RPMX	WT(kg)
TJSSJETST2090D	16	93.5	81.9	43	45.5	45.5	125.58	20	35,000	55,000	2.3

• Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
• Min. flow rate: 12 l/min
(1) Max. tool shank diameter: ø7 mm

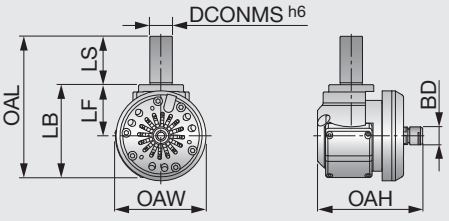
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSSJETST2090D	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-PJET-ST-90D

High-pressure coolant driven high speed compact spindles with 90˚ shanks



Designation	BD	OAH	OAW	LS	LB	LF	OAL	DCONMS	RPMN	RPMX	WT(kg)
TJSPJETST2090D	16	93.4	73.59	43	45.5	45.5	125.58	20	18,000	45,000	2.3

• Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
• Min. flow rate: 10 l/min
(1) Max. tool shank diameter: ø7 mm

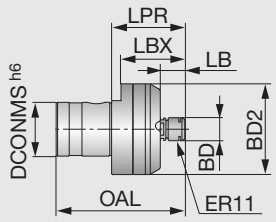
SPARE PARTS

Designation	Nut	Wrench for nut	Shaft lock key	Wrench
TJSPJETST2090D	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET	P-2

New

TJS-SJET-TR

Coolant driven high speed spindles with replaceable TR cartridge



Designation	BD	BD2	LB	LBX	LPR	OAL	DCONMS	RPMN	RPMX	WT(kg)
TJSSJETTR	16	63	17	39.7	50.8	89.3	37.4	33,000	55,000	1

- Coolant pressure through machine spindle: Min. 2 MPa / Max. 4 MPa
- Min. flow rate: 12 l/min

SPARE PARTS

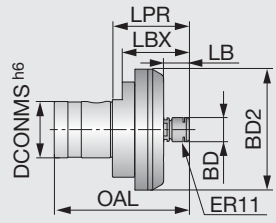
Designation	Nut	Wrench for nut (Optional)	Shaft lock key (Optional)
TJSSJETTR	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET

How to Replace the Cartridge

New

TJS-PJET-TR

High-pressure coolant driven high speed spindles with replaceable TR cartridge



Designation	BD	BD2	LB	LBX	LPR	OAL	DCONMS	RPMN	RPMX	WT(kg)
TJSPJETTR	16	80	17	39.7	50.9	89.4	63	20,000	45,000	1

- Coolant pressure through machine spindle: Min. 1.5 MPa / Max. 7 MPa
- Min. flow rate: 10 l/min

SPARE PARTS

Designation	Nut	Wrench for nut (Optional)	Shaft lock key (Optional)
TJSPJETTR	NUTER11GHS	WRENCHER11SMS	TJSSHAFTLOCKKEYGJET

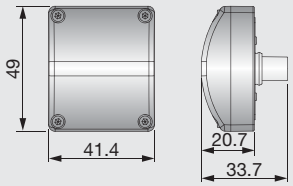
How to Replace the Cartridge

New Transmitter (for Mobile Apps)

BLE SPEED SENSOR

Bluetooth RPM transmitter for high-speed spindles





Designation

TJSSPEEDTAGBLE

SPARE PARTS










Designation	Silicone gasket	Ring	O-ring	Cover	BLE speed sensor	Hex. socket head screw 1	Hex. socket head screw 2	Hex wrench
TJSSPEEDTAGBLE	TJGS-011	OR-9.25x1.78-N70	OR-45.0x1.0-N70	TJEH-030	-	M2.5x8	M3x6	TK-004

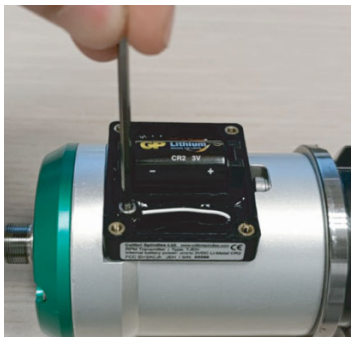
How to Replace the Transmitter

Before proceeding with the replacement, please make sure to have a 2.5 mm hex wrench (P-2.5) and a utility knife on hand, in addition to the transmitter (TJSSPEEDTAGBLE).

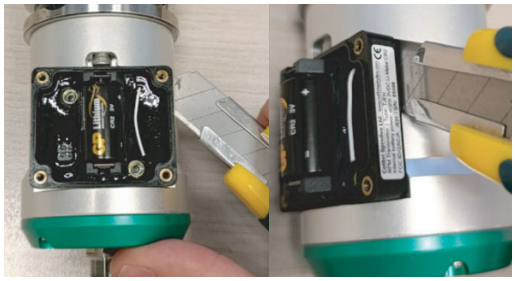
1 Unscrew the M2.5x8 screws from the cover using the TK-004 wrench, then remove the cover.



2 Unscrew the M3x6 screws using a 2.5 mm hex wrench.



3 Cut the adhesive attaching the sensor to the unit with a utility knife.



4 After removing the sensor, clean off any adhesive residue. It's crucial that none of this residue enters the hole (marked with a red circle in the image) that leads to the bearing housing.



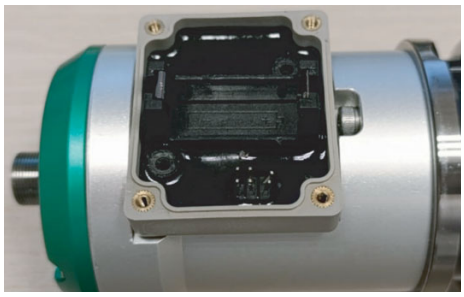
5 Place the silicone gasket on the unit as shown in the picture.



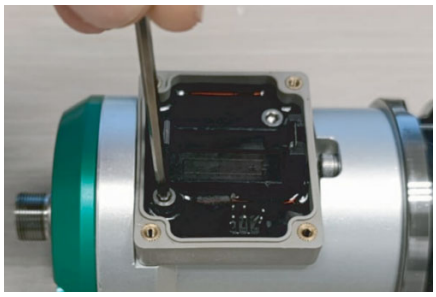
6 Put the OR-9.25x1.78-N70 on the sensor as shown in the picture.



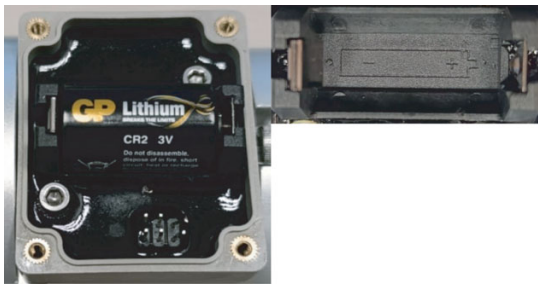
7 Put on the speed sensor as shown in the picture, make sure the OR-9.25x1.78-N70 does not fall.



8 Screw in the M3x6 screws using a 2.5 mm hex wrench, with a torque of 0.8-1.2 N·m.



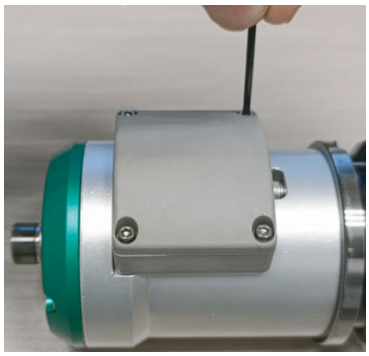
9 Insert the CR2 3V battery into the battery compartment in the correct direction as marked on the battery compartment.



10 Before closing the cover, check that the OR-45.0x1.0-N70 is seated properly.



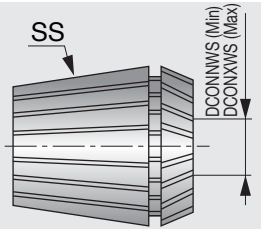
11 Put the cover on the sensor and screw the M2.5x8 screws using a 2 mm hex wrench. (TK-004), with a torque of 0.45-0.65 N·m.

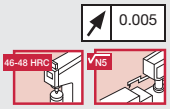


ER-SPR-AA

ER 11 AA collets





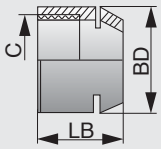


Designation	SS	DCONNWS (Min)	DCONXWS (Max)
ER11SPR0.5-1.0AA	ER11	0.5	1
ER11SPR1.0-1.5AA	ER11	1	1.5
ER11SPR1.5-2.0AA	ER11	1.5	2
ER11SPR2.0-2.5AA	ER11	2	2.5
ER11SPR2.5-3.0AA	ER11	2.5	3.
ER11SPR3.0-3.5AA	ER11	3	3.5
ER11SPR3.5-4.0AA	ER11	3.5	4
ER11SPR4.0-4.5AA	ER11	4	4.5
ER11SPR4.5-5.0AA	ER11	4.5	5
ER11SPR5.0-5.5AA	ER11	5	5.5
ER11SPR5.5-6.0AA	ER11	5.5	6
ER11SPR6.0-6.5AA	ER11	6	6.5
ER11SPR6.5-7.0AA	ER11	6.5	7

AA collets run-out: 0.005 mm

Nut and wrench for nut







Designation	BD	LB	C	Wrench
NUTER11GHS	16	11.5	M13X0.75	WRENCHER11SMS

Shaft lock key



Designation
TJSSHAFTLOCKKEYGJET

SPINJET Inquiry form for applicability

Company

***Required**

Check item		Answer	Note
Machine tool	Maker / Model*		
	Max. revolution		
	Type of main spindle chucking*		For BT50, please check if it has a programming pre-read function.
	Through coolant*	Possible / Not possible	
	Coolant		
	Coolant pressure* (MPa)		Need to be 2 - 4 MPa
	Coolant flow rate* (ℓ/min)		Min. flow rate 12 ℓ/min
	Coolant filtration* (μm)		Need to be ≤ 100 μm (Recommendation : ≤ 50 μm) *With grinding wheel : ≤ 10 μm
Work material	Work material		
Application	Application*		Ex. Endmilling, drilling, etc.
Cutting Tool	Tool diameter* (mm)		Endmill : ≤ ø3.5 Drill : ≤ ø2 (Need step drilling)
	Shank diameter* (mm)		Need to be ≤ ø6
Current cutting condition	Cutting speed *Vc* (m/min)		
	Number of revolutions *n* (min^{-1})		
	Feed *f* (mm/rev)		
	Feed per tooth *fz* (mm/t)		
	Feed speed *Vf* (mm/min)		
	Depth of cut *ap* (mm)		
	Width of cut *ae* (mm)		

Remarks (Desired cutting condition, request, etc.)

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