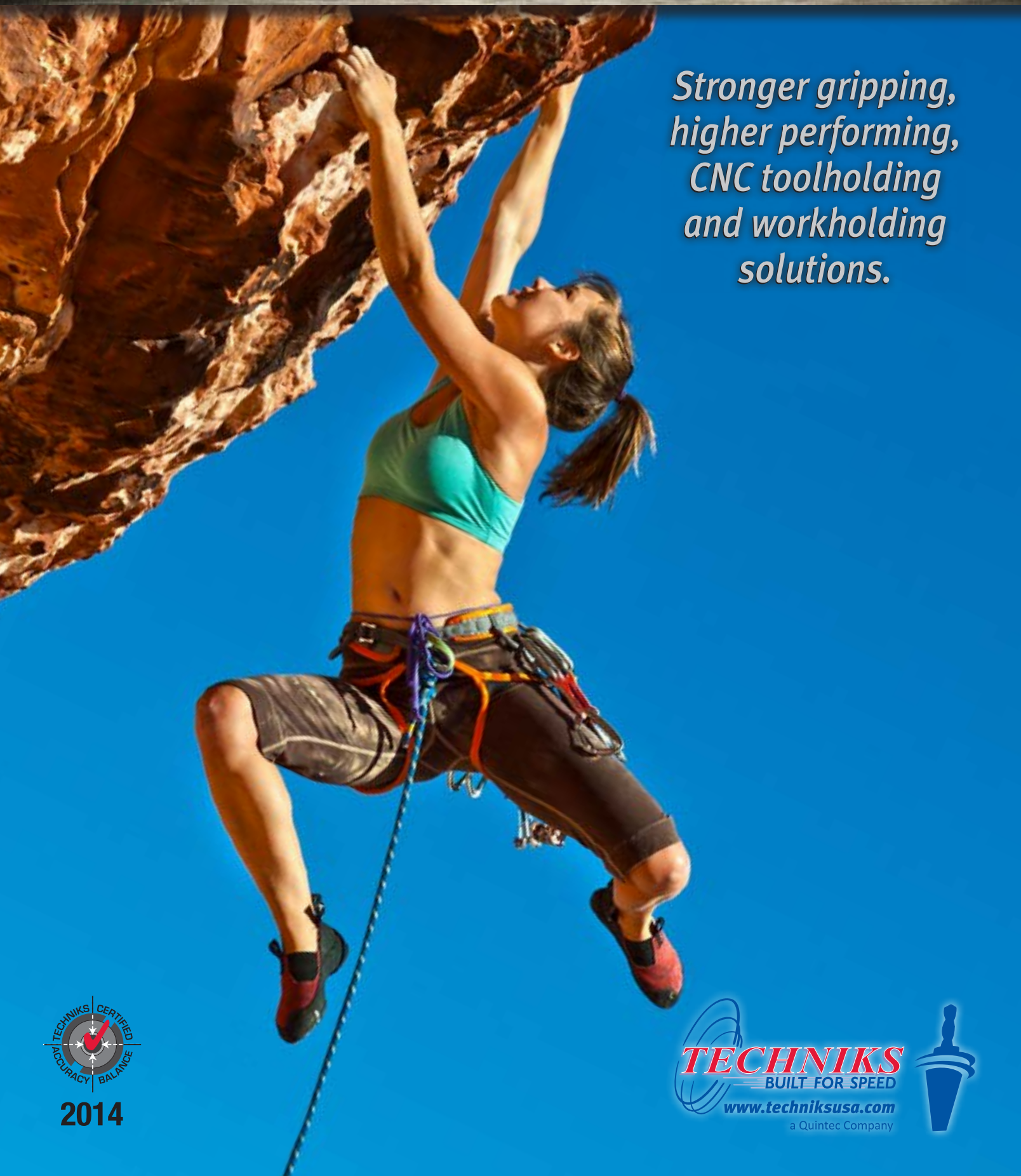
Techniks CNC Tooling Solutions



Stronger gripping, higher performing, CNC toolholding and workholding solutions.

TECHNIKS CERTIFIED ACCURACY BALANCE

2014

TECHNIKS
BUILT FOR SPEED
www.techniksusa.com
a Quintec Company

Techniks – Quality Toolholders & More!

Techniks is a partner you can depend on.

You know we make toolholders, but did you know we are here to support your needs and make sure you are 100% satisfied with our products? Becoming a Techniks customer means you have a partner who will work hard to provide top quality products, excellent customer service, and the engineering support necessary to expand your business.

With Techniks you get:

- *inspected, tested and lab-certified products that provide outstanding value and extend perishable cutting tool life to save you money.*
- *full factory support before, during, and after the sale*
- *guaranteed turn-key CNC tooling and workholding solutions*
- *live phone support (toll-free) 8:00 am – 6:00 pm E.S.T.*
- *orders ship the same day they are received! (ground orders received by 2:00 pm, or expedited orders received by 5:00 pm)*
- *each order is checked 4 times before shipping. 99.9% average shipping accuracy (we track this each month)*
- *all products are backed by our 100% satisfaction guarantee*
- *training on how to use our products if needed*
- *24/7 access to request a quote, look up product information, request catalogs, on the web (www.techniksusa.com)*
- *receive promotions and product information by opt-in email*

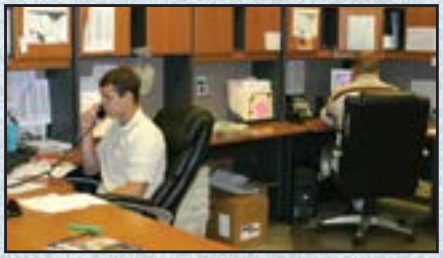
The whole team at Techniks is commited to excellent customer service and fast, accurate, fullfilment of orders.

Thank You for considering Techniks for your CNC tooling needs.

TECHNIKS BUILT FOR SPEED www.techniksusa.com a Quintec Company



Headquarters is located in Indianapolis, Indiana



Live phone support means your calls are given immediate attention.



Orders ship the same day they are received. (ground orders received by 2:00 pm, or expedited orders received by 5:00 pm – all ship same day). Distribution centers in east and west coasts and Toronto, Canada.

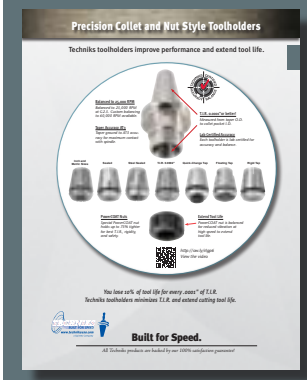


Complimentary product demonstrations live at your facility. Schedule your Roadshow visit today (pg. 9)

For more information call Toll Free: (800) 597-3921 or (317) 803-8000 • Fax: (877) 776-9994 or (317) 803-8001
Contact us by email: *info@techniksusa.com* • **Website:** *www.techniksusa.com*
Office Hours: M-F, 8:00 am - 6:00 pm E.S.T. • **Techniks Inc., 9930 E. 56th St., Indianapolis, IN 46236**

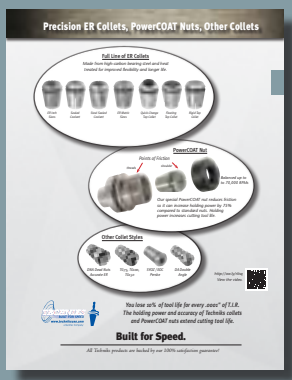
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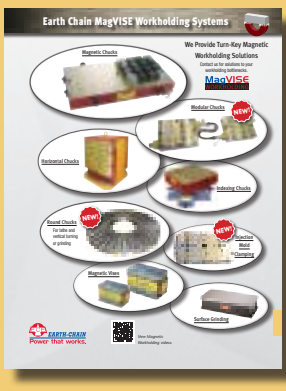
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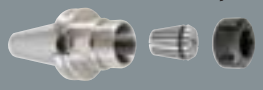


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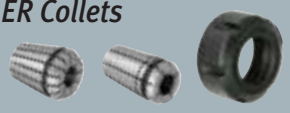
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Face Mill Arbors



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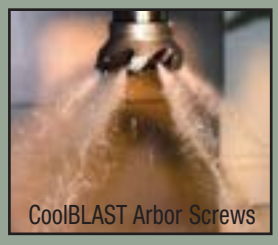
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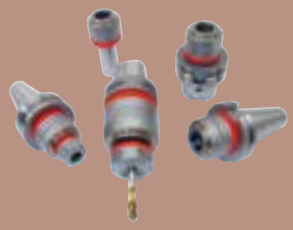
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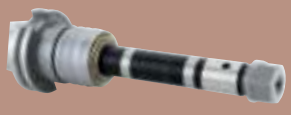
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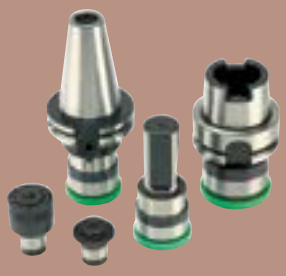


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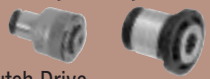
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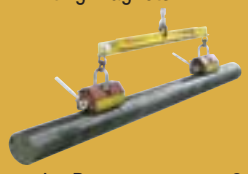
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SYIC

What Does Techniks Certified Mean?

Techniks Certified = Manufactured to The Highest Standards

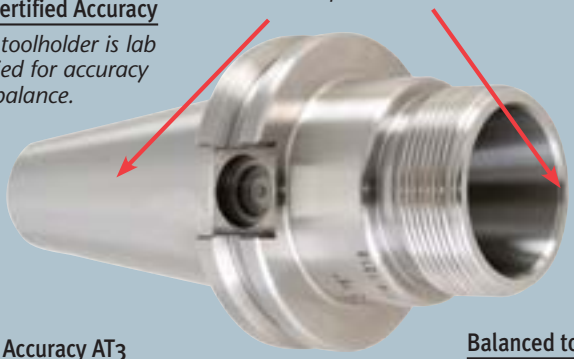
Techniks Certified Tooling means the critical features of each holder has been individually lab tested, measured and inspected for quality. Depending on the holder this can include: balance, dimensional accuracy, collet pocket runout (T.I.R.), bore I.D. and taper accuracy. Techniks Certified guarantees your holder will meet or beat our published specifications.

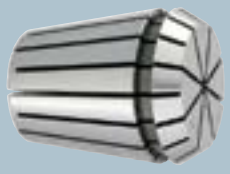
Taper-to-Pocket T.I.R. 0.0001"
Measured from taper O.D. to collet pocket I.D.

Lab Certified Accuracy
Each toolholder is lab certified for accuracy and balance.

Ultra Precision Collet
Each collet hand inspected. T.I.R. only 0.0002"

PowerCOAT Nuts
Our PowerCOAT nut holds 70% tighter than standard nuts for best T.I.R. and rigidity.







Taper Accuracy AT3
Taper ground to AT3 accuracy for maximum contact with spindle.

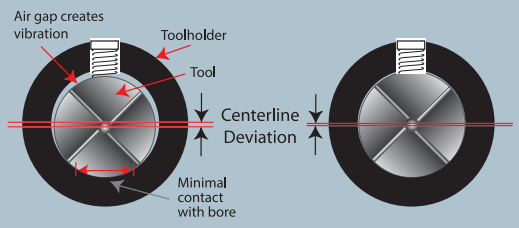
Balanced to 25,000 RPM
Factory balanced to 25,000 RPM at G2.5 Custom balancing to 60,000 RPM available.

Balanced Nut
Balanced nut reduces vibration to extend cutting tool life.

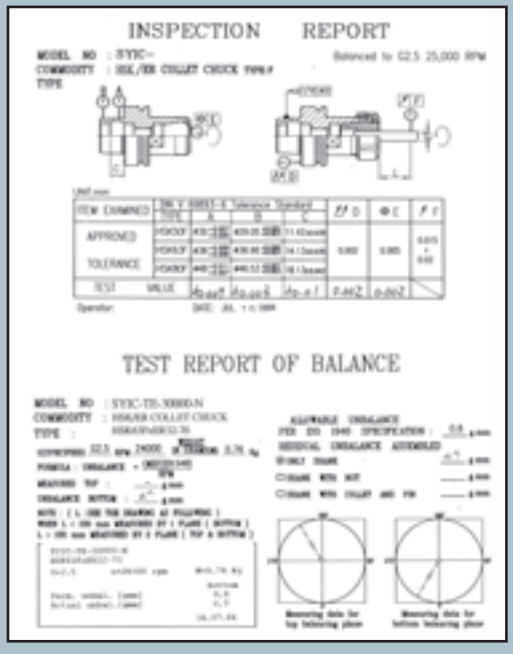
Endmill Holder Bore Tolerance is H5 – Best in The Industry – Improves Accuracy and Tool Life



Others T.I.R. .0008" *Techniks .0002"*



A full report comes with each holder



Use Techniks Certified holders to reduce T.I.R. and extended cutting tool life.

New CNC Solutions from Techniks

Capto-Compatible*

- *C4, C5, C6 tooling*
  (see page 133)

NEW!



Dual-Contact DualDRIVE

- *Collet chucks, end mill holders, shrink fit, and face mill arbors for dual-contact spindles*

NEW! 1-Piece Design



ShrinkPRO

NEW!



- *High-performance small footprint*
- *touch-screen controls*

(see page 106)

High-Performance Milling Chucks

- *Standard & Heavy-Duty*
- *3/4" and 1 1/4"*

(see page 119)

NEW!



MacroBOHR

NEW!

- *ranges up to 40.157"*

(see page 194)



MicroFLOAT for Rigid Tapping

- *Improves rigid tap performance*
- *greatly extends tap life!*

(see page 143)

NEW!



Modular Workholding

NEW!

- *save 50% time on setups*
- *for large & small parts*



(see page 220)

UltraFINE Finish Heads

- *for fine surface finish*

(see page 172)

NEW!



**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

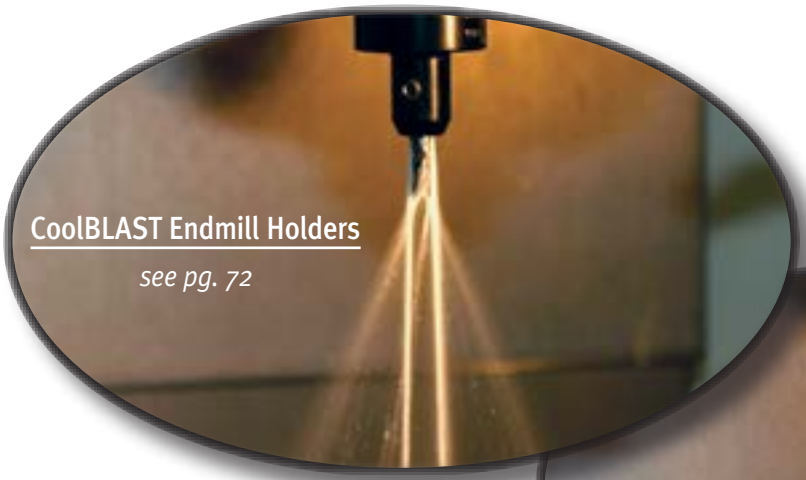
All Techniks products are backed by our 100% satisfaction guarantee!

SYIC

Coolant Options – CoolBLAST and CoolFLEX DIN B

CoolBLAST puts coolant right on toolpath

- *Use CoolBLAST instead of coolant-thru tools*
- *Our CoolFLEX option provides DIN B coolant-thru flange on many of our holders*



CoolBLAST Endmill Holders
see pg. 72



CoolBLAST ShrinkFIT
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CoolBLAST Collet Chucks
see pg. 61



CoolBLAST Face Mill Arbors
see pg. 117



CoolBLAST Milling Chucks
see pg. 120



MicroFLOAT Coolant-Thru Tap Holders
see pg. 143

Need Tooling for a New Machine?

With Techniks Tooling Certificates you'll have the tooling you need, when you need it.



Wouldn't it be great if you could purchase your tooling at the same time you buy your machine, but defer the selection until you are more certain of your needs?

Now you can do that. Here is how it works.

Purchase a Techniks Tooling Certificate

- ✓ Either from your machine tool dealer or your cutting tool distributor.

Redeem your Certificate as needs arise

- ✓ You work directly with Techniks experts to specify the tooling you need from our full-line CNC Tooling Solutions catalog.
- ✓ You are assured you are getting top quality Techniks Certified Tooling, plus our Factory Direct Support when you need it.
- ✓ You can redeem all or any portion of your Certificate value at any time, but the Certificate does expire after 1 year.

Avoid additional out-of-pocket expenses as you bring your new machine on-line.

Techniks Tooling Certificate

Redeem this certificate for tooling valued at:

$ _____ Date: _____

Customer Name: _____ Company: _____

Distributor: _____ Signature: _____

This certificate entitles the above mentioned customer to select products from the Techniks CNC Tooling catalog, at the value stated above. Expiration is one year from the date above.

Techniks "Roadshow" Event – At Your Facility!

Live Factory Demonstrations

Contact us to Schedule a Visit!



What we will bring:

- *Techniks Certified CNC toolholders*
- *ShrinkFIT Machines*
- *MagVISE Magnetic Workholding*
- *sPINner small parts deburring*

What we will do:

- *Our factory reps will come to your facility, prepared to demonstrate the product capabilities and answer your questions*
- *Just let us know ahead of time if you have specific products in mind and we will be sure to bring them. No risk, no obligation.*



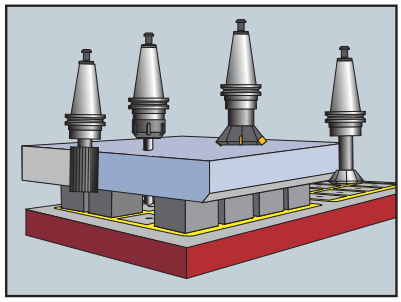




Featured: MagVISE Magnetic Workholding

Use magnetic workholding for machining on all 5 sides of the workpiece PLUS save 50% on setup and part change-over times. Use for all types of drilling, milling, and boring operations on thick or thin workpieces.

MagVISE WORKHOLDING



Machine 5 sides freely and thru-hole drill



Milling warped stock with induction blocks



Featured: sPINner Small Parts Deburring



the sPINner

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To Schedule Your Roadshow Visit:

Contact Techniks: e-mail: *info@techniksusa.com*
Toll Free: (800) 597-3921 or Local: (317) 803-8000

Featured: Techniks Certified Tooling



Toolholders & accessories



ShrinkFIT & ShrinkFIT machines



MicroFLOAT rigid tap holders



Full-line Mill/Turn tooling

TECHNIKS BUILT FOR SPEED www.techniksusa.com a Quintec Company

Need it FAST? We offer Same Day Shipping until 6:00 pm E.S.T.

CAT40 or CAT50 12-Pack Tooling Special!



Score Big Savings on a 12-Pack

Your choice – of either CAT40 or CAT50 holders!

1. **Select 6 collet chucks & 6 end mill holders (sale priced!)**
2. **and choose a complimentary collet set (value up to $486.00)**

(sorry, you cannot mix CAT40 with CAT50)

CAT 40 (12PACK-C40)

Sale Price: $1,490 - Save up to $616.00

CAT 40 Collet Chucks (choose 6)

Part No.	Description	Each
22225	CAT 40 x ER 16-2.76"	$143.00
22227	CAT 40 x ER 16-4"	$143.00
22235	CAT 40 x ER 20-2.76"	$143.00
22237	CAT 40 x ER 20-4"	$143.00
22243	CAT 40 x ER 25-2.76"	$143.00
22245	CAT 40 x ER 25-4"	$155.00
22253	CAT 40 x ER 32-2.76"	$153.00
22255	CAT 40 x ER 32-4"	$153.00
22261	CAT 40 x ER 40-3.15"	$160.00

CAT 40 End Mill Holders (choose 6)

Part No.	Description – d1	Each
22907	CAT 40 x SLN - 1/8"	$85.00
22909	CAT 40 x SLN - 3/16"	$85.00
22911	CAT 40 x SLN - 1/4"	$85.00
22911-1.75	CAT 40 x SLN - 1/4"	$85.00
22915	CAT 40 x SLN - 3/8"	$85.00
22915-1.75	CAT 40 x SLN - 3/8"	$85.00
22917	CAT 40 x SLN - 1/2"	$85.00
22917-1.75	CAT 40 x SLN - 1/2"	$85.00
22919	CAT 40 x SLN - 5/8"	$85.00
22919-1.75	CAT 40 x SLN - 5/8"	$85.00
22921	CAT 40 x SLN - 3/4"	$85.00
22921-1.75	CAT 40 x SLN - 3/4"	$95.00
22925	CAT 40 x SLN - 1"	$95.00
22925-1.75	CAT 40 x SLN - 1"	$95.00

CAT 50 (12PACK-C50)

Sale Price: $1,750 - Save up to $716.00

CAT 50 Collet Chucks (choose 6)

Part No.	Description	Each
22281	CAT 50 x ER 16-4	$175.00
22291	CAT 50 x ER 20-4	$180.00
22303	CAT 50 x ER 25-4	$170.00
22311	CAT 50 x ER 32-4	$170.00
22321	CAT 50 x ER 40-4	$180.00

CAT 50 End Mill Holders (choose 6)

Part No.	Description – d1	Each
22931	CAT 50 x SLN - 1/4"	$130.00
22935	CAT 50 x SLN - 3/8"	$130.00
22937	CAT 50 x SLN - 1/2"	$130.00
22939	CAT 50 x SLN - 5/8"	$130.00
22941	CAT 50 x SLN - 3/4"	$130.00
22945	CAT 50 x SLN - 1"	$130.00
22947	CAT 50 x SLN - 1 1/4"	$134.00
22937-6	CAT 50 x SLN - 1/2"	$150.00
22939-6	CAT 50 x SLN - 5/8"	$150.00
22941-6	CAT 50 x SLN - 3/4"	$150.00
22945-6	CAT 50 x SLN - 1"	$135.00

Choose any Inch or Metric Collet Set FREE!

(value up to $486.00)



ER Inch Collet Sets

Part No.	Desc.	Pcs.	Set Range	Each
04209IS	ER16	10	3/32 – 3/8" by 32nds	$233.50
04210IS	ER20	12	5/32 – 1/2" by 32nds	$306.00
04211IS	ER25	16	5/32 – 5/8" by 32nds	$432.00
04212IS	ER32	18	7/32 – 3/4" by 32nds	$486.00
04213IS	ER40	13	1/8 – 1.0" by 16ths	$390.00

ER Metric Collet Sets

Part No.	Desc.	Pcs.	Set Range	Each
04202MS	ER16	10	1 - 10 by 1mm	$235.00
04203MS	ER20	12	2 - 13 by 1mm	$321.00
04204MS	ER25	15	2 - 16 by 1mm	$410.00
04205MS	ER32	18	3 - 20 by 1mm	$486.00

See our product application videos at: www.techniksusa.com

CAT40, CAT50, BT40 Tooling – Package Savings

Don't See What You Need?

We have tooling packages available for practically every CNC machine made. Call (800) 597-3921 and ask about a package for your machine and spindle type.

CAT40 – Sale: $1,690 *(original price $2,409)*

No. TP-C40, 43 piece CAT40 Tooling Package



Order No. TP-C40, 43 piece CAT40 Tooling Package

Qty.	Part No.	Description	Each	Extended
4	22253	CAT40 x ER 32 - 2.76	$153.00	$612.00
2	22225	CAT40 x ER 16 - 2.76	$143.00	$286.00
1	04212 (set)	ER 32 x 18 piece collet set - Inch	$486.00	$486.00
1	04209 (set)	ER 16 x 10 piece collet set - Inch	$233.50	$233.50
1	22911	CAT40 x SLN 1/4" - 3"	$85.00	$85.00
1	22915	CAT40 x SLN 3/8" - 3"	$85.00	$85.00
1	22917	CAT40 x SLN 1/2" - 3"	$85.00	$85.00
1	22919	CAT40 x SLN 5/8" - 3"	$85.00	$85.00
1	22921	CAT40 x SLN 3/4" - 3.5"	$95.00	$95.00
1	22925	CAT40 x SLN 1" - 4"	$95.00	$95.00
1	22403	CAT40 x SPU 1/2" - 4"	$228.00	$228.00
1	04616	ER 32 - E WRENCH	$20.00	$20.00
1	04609	ER 16 - A WRENCH	$13.50	$13.50

CAT50 – Sale: $2,370 *(original price $2,976)*

No. TP-C50, – 45 piece CAT50 Tooling Package



Order No. TP-C50, – 45 piece CAT50 Tooling Package

Qty.	Part No.	Description	Each	Extended
5	22291	CAT50 x ER 20 - 4	$180.00	$900.00
5	22311	CAT50 x ER 32 - 4	$170.00	$850.00
1	04212(set)	ER 32 x 18 piece collet set - in.	$486.00	$486.00
1	04210(set)	ER 20 x 12 piece collet set - in.	$306.00	$306.00
2	22945	CAT50 x SLN 1- 4	$130.00	$260.00
1	22947	CAT50 x SLN 1-1/4 - 4.6	$134.00	$134.00
1	04610	ER 20 - A wrench	$20.00	$20.00
1	04616	ER 32 - E wrench	$20.00	$20.00

BT40 – Sale: $1,598 *(original price $2,128)*

No. TP-B40, – 41 piece BT40 Tooling Package



Order No. TP-B40, – 41 piece BT40 Tooling Package

Qty.	Part No.	Description	Each	Extended
2	16151	BT40 X ER 16-70	$140.00	$280.00
1	04209(set)	ER16 X 10 pc. collet set - inch	$233.50	$233.50
4	16177	BT40 X ER 32-70	$150.00	$600.00
1	04212(set)	ER 32 x 18 piece collet set - inch	$486.00	$486.00
1	17140-3/8	BT40 x SLN 3/8" - 2-1/2"	$99.00	$89.00
1	17140-1/2	BT40 x SLN 1/2" - 2-1/2"	$99.00	$89.00
1	17140-5/8	BT40 x SLN 5/8" - 2-1/2"	$99.00	$89.00
1	17140-3/4	BT40 x SLN 3/4" - 2-1/2"	$99.00	$89.00
1	17140-1	BT40 x SLN 1" - 3-9/16"	$99.00	$89.00
1	04609	ER 16 - A wrench	$13.50	$13.50
1	04616	ER 32 - E wrench	$20.00	$20.00

ISO 20 and BT30 Tooling Packages

10 Piece ISO 20 Tooling Package – Great for Haas* OM1-OM2

Includes: toolholder, PowerCOAT mini-nut, and pull stud





No. TP-ISO20 **Only: $1,990.00**

Qty.	Part No.	Description	Each	Extended
10	16000-2016MC	ISO20 x ER 16 - 52mm Power Coat Mini Nut and Pull Stud	$199.00	$1,990.00

33 Piece BT30 Tooling Package for Haas DT-1





Free Tap Collets



And choose 5 free, ER 20 rigid tap collets!

$200.00 Value

No. TP-DT1 Sale: $1,250 (original price $1,536) **Save: $286.00**

Qty.	Part No.	Description	Each	Extended
1	17130-1/8	BT30-SLN-1/8"	$80.00	$80.00
1	17130-1/4	BT30-SLN-1/4"	$80.00	$80.00
1	17130-3/8	BT30-SLN-3/8"	$80.00	$80.00
1	17130-1/2	BT30-SLN-1/2"	$80.00	$80.00
6	16106	BT30-ER20-70mm	$125.00	$750.00
1	04210IS	ER20-12 piece collet set	$306.00	$306.00
10	07801	BT30-45° Retention Knobs	$14.00	$140.00
1	04610	ER20 - A wrench	$20.00	$20.00

* HAAS is trademark of HAAS Inc. and used here only for identification.

Properly torque down the nut for safety and best tool life. See the Torque Chart on page 41.

SYIC

Precision Collet and Nut Style Toolholders

Techniks toolholders improve performance and extend tool life.



Balanced to 25,000 RPM

Balanced to 25,000 RPM at G2.5. Custom balancing to 60,000 RPM available.

Taper Accuracy AT3

Taper ground to AT3 accuracy for maximum contact with spindle.

T.I.R. 0.0001"or better!

Measured from taper O.D. to collet pocket I.D.

Lab Certified Accuracy

Each toolholder is lab certified for accuracy and balance.



PowerCOAT Nuts

Special PowerCOAT nut holds up to 75% tighter for best T.I.R., rigidity, and safety.



Extend Tool Life

PowerCOAT nut is balanced for reduced vibration at high speed to extend tool life.

http://ow.ly/rlgp6

View the video

You lose 10% of tool life for every .0001" of T.I.R.
Techniks toolholders minimizes T.I.R. and extend cutting tool life.

TECHNIKS
BUILT FOR SPEED
www.techniksusa.com
a Quintec Company

Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!

CAT40 Precision ER Toolholders



Techniks Certified for accuracy and balance

Each holder comes with a complete lab report

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*


Collets
pg. 43


Nuts
pg. 58


Coolant
Rings
pg. 60


Retention
Knobs
pg. 204


Wrenches
pg. 208


Tightening
Stands
pg. 210

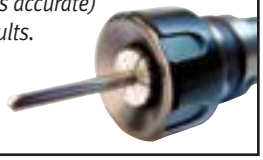
A PowerCOAT nut is included with each holder.

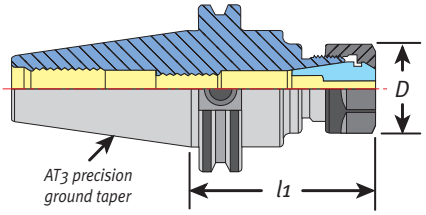
For ER16, and 20 slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number.

For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results.

See page 48.





CAT40 ER Toolholders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
22213-3	CAT40 x ER11 - 3", hex nut	3"	.748"	.275"	16081	04608
22225	CAT40 x ER16 - 2.76", hex nut	2.76"	1.08"	.406"	16083	04609
22227	CAT40 x ER16 - 4", hex nut	4"	1.08"	.406"	16083	04609
22231	CAT40 x ER16 - 6", hex nut	6"	1.08"	.406"	16083	04609
22233	CAT40 x ER16 - 8", hex nut	8"	1.08"	.406"	16083	04609
22235	CAT40 x ER20 - 2.76", hex nut	2.76"	1.34"	.512"	16087	04610
22237	CAT40 x ER20 - 4", hex nut	4"	1.34"	.512"	16087	04610
22239	CAT40 x ER20 - 6", hex nut	6"	1.34"	.512"	16087	04610
22243-2.5	CAT40 x ER25 - 2.5", slotted nut	2.5"	1.65"	.630"	16089	04615
22243	CAT40 x ER25 - 2.76", slotted nut	2.76"	1.65"	.630"	16089	04615
22245	CAT40 x ER25 - 4", slotted nut	4"	1.65"	.630"	16089	04615
22247	CAT40 x ER25 - 6", slotted nut	6"	1.65"	.630"	16089	04615
22251	CAT40 x ER25 - 8", slotted nut	8"	1.65"	.630"	16089	04615
22253	CAT40 x ER32 - 2.76", slotted nut	2.76"	1.97"	.788"	16089	04616
22255	CAT40 x ER32 - 4", slotted nut	4"	1.97"	.788"	16089	04616
22257	CAT40 x ER32 - 6", slotted nut	6"	1.97"	.788"	16089	04616
22259	CAT40 x ER32 - 8", slotted nut	8"	1.97"	.788"	16089	04616
22261	CAT40 x ER40 - 3.15", slotted nut	3.15"	2.48"	1.023"	16091	04617
22263	CAT40 x ER40 - 4", slotted nut	4"	2.48"	1.023"	16091	04617
22265	CAT40 x ER40 - 6", slotted nut	6"	2.48"	1.023"	16091	04617
22269	CAT40 x ER50 - 4", slotted nut	4"	3.07"	1.338"	16093	04618

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

CAT40 Precision CoolFLEX ER Toolholders



Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

Features

- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" or better from taper to collet pocket*

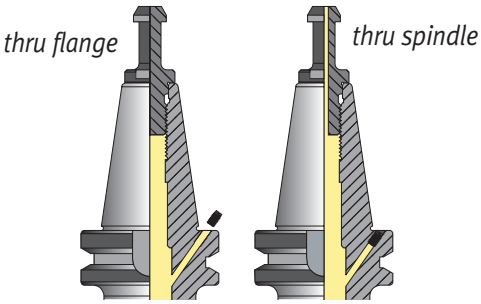
CoolFLEX Feature

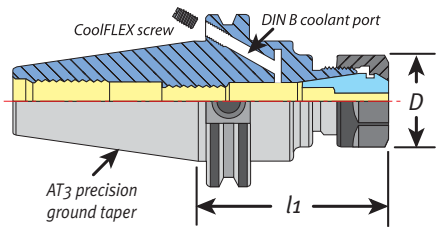
CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.

A PowerCOAT nut is included with each holder.

For ER16, and 20 slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number.





Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw

CAT40 CoolFLEX Coolant -Thru Spindle or Flange (DIN B)

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
22225F	CAT40 x ER16 - 2.76", hex nut	2.76"	1.08"	.406"	16083	04609
22227F	CAT40 x ER16 - 4", hex nut	4"	1.08"	.406"	16083	04609
22231F	CAT40 x ER16 - 6", hex nut	6"	1.08"	.406"	16083	04609
22233F	CAT40 x ER16 - 8", hex nut	8"	1.08"	.406"	16083	04609
22235F	CAT40 x ER20 - 2.76", hex nut	2.76"	1.34"	.512"	16087	04610
22237F	CAT40 x ER20 - 4", hex nut	4"	1.34"	.512"	16087	04610
22239F	CAT40 x ER20 - 6", hex nut	6"	1.34"	.512"	16087	04610
22243F	CAT40 x ER25 - 2.76", slotted nut	2.76"	1.65"	.630"	16089	04615
22245F	CAT40 x ER25 - 4", slotted nut	4"	1.65"	.630"	16089	04615
22247F	CAT40 x ER25 - 6", slotted nut	6"	1.65"	.630"	16089	04615
22251F	CAT40 x ER25 - 8", slotted nut	8"	1.65"	.630"	16089	04615
22253F	CAT40 x ER32 - 2.76", slotted nut	2.76"	1.97"	.788"	16089	04616
22255F	CAT40 x ER32 - 4", slotted nut	4"	1.97"	.788"	16089	04616
22257F	CAT40 x ER32 - 6", slotted nut	6"	1.97"	.788"	16089	04616
22259F	CAT40 x ER32 - 8", slotted nut	8"	1.97"	.788"	16089	04616
22261F	CAT40 x ER40 - 3.15", slotted nut	3.15"	2.48"	1.023"	16091	04617
22263F	CAT40 x ER40 - 4", slotted nut	4"	2.48"	1.023"	16091	04617

CAT40 Precision ER Mini Nut Holders



Features

- *Narrow nut diameter for better clearance*
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*


Collets pg. 43


Nuts pg. 58


Coolant Rings pg. 60


Retention Knobs pg. 204


Wrenches pg. 208

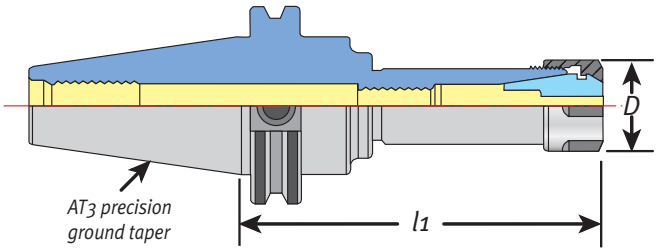

Tightening Stands pg. 210

PowerCOAT nut is included with each holder Techniks Certified for accuracy and balance. Each holder comes with a complete lab report



Coolant Options

- *ER coolant rings (pg. 60)*
- *ER Steel Sealed collets (pg. 50)*
- *ER coolant collets (pg. 52)*



CAT40 ER Mini Nut Holders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
22352	CAT40 x ER11 - 2.75", mini nut	2.75"	.63"	.275"	16081	04621
22354	CAT40 x ER11 - 4", mini nut	4"	.63"	.275"	16081	04621
22354-6	CAT40 x ER11 - 6", mini nut	6"	.63"	.275"	16081	04621
22354-8.5	CAT40 x ER11 - 8.5", mini nut	8.5"	.63"	.275"	16081	04621
22356	CAT40 x ER16 - 2.76", mini nut	2.76"	.87"	.406"	16083	04622
22358	CAT40 x ER16 - 4", mini nut	4"	.87"	.406"	16083	04622
22359	CAT40 x ER16 - 6", mini nut	6"	.87"	.406"	16083	04622
22359-8	CAT40 x ER16 - 8", mini nut	8"	.87"	.406"	16083	04622
22360	CAT40 x ER20 - 2.76", mini nut	2.76"	1.102"	.512"	16087	04623
22362	CAT40 x ER20 - 4", mini nut	4"	1.102"	.512"	16087	04623

CAT40 Precision SuperRIGID Holders



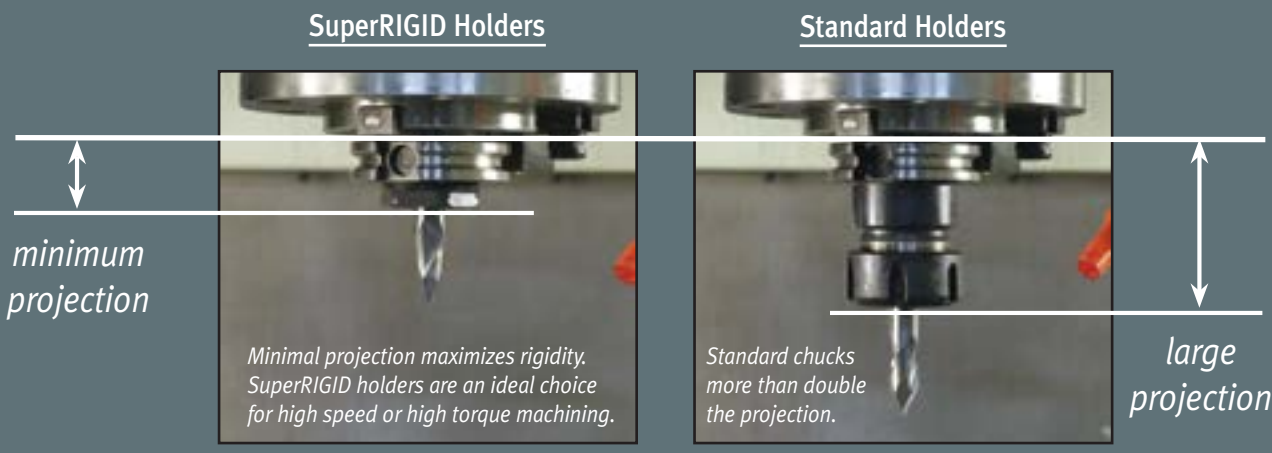
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report
Collet nut is included with each holder

Features

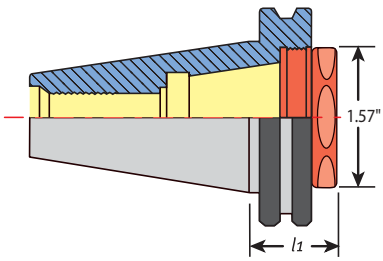
- *Balanced to 25,000 RPM at G2.5*
- *Best T.I.R. and Z axis of any collet chuck*
- *SuperRIGID for high torque or high speed machining*



Use SuperRIGID holders with ER32 collets.



Minimum projection = increased rigidity, better T.I.R. and extended cutter life.





PowerCOAT TE-22HN Nut

CAT40 SuperRIGID ER Toolholders

Part No.	Description	l1	Collet	Max. Shank	Wrench
22253S	CAT40 x ER32	1.10"	ER32	3/4" or 20mm	894-36
TE-22HN	hex style PowerCOAT replacement nut				

CAT40 DualDRIVE for Dual-Contact Spindles



Features

- *New one-piece design for dual-contact spindles*
- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*

Benefits

- *Better rigidity and reduced vibration*
- *Improved performance at high metal removal rates and when machining at extended lengths*

Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

A PowerCOAT nut is included with each holder.

For ER16, and 20 slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number.

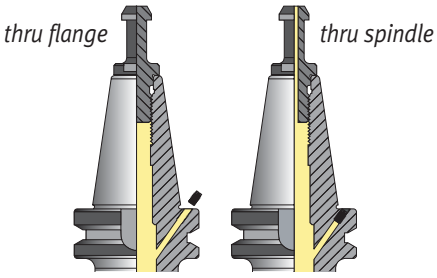
See an on machine demonstration video of DualDRIVE compared to standard toolholders at:
http://ow.ly/sUOqL

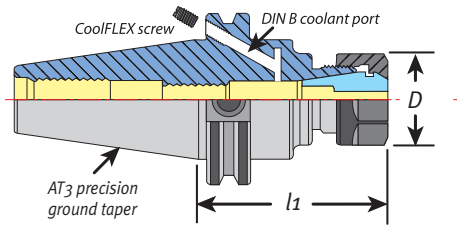


Dual-Contact Spindles

Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.





CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.

Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw

CAT40 DualDRIVE Coolant -Thru Spindle or Flange (DIN B)

Coolant Set Screws page 41.

Part No.	Description - L1	L1	D	Collet	Max. Shank	Set Screw	Wrench
46.122.16.276	CAT40 x ER16 -2.76" DualDRIVE	2.76"	1.08"	ER16	.406"	16083	04609
46.122.16.400	CAT40 x ER16 - 4" DualDRIVE	4"	1.08"	ER16	.406"	16083	04609
46.122.16.600	CAT40 x ER16 - 6" DualDRIVE	6"	1.08"	ER16	.406"	16083	04609
46.122.16.800	CAT40 x ER16 - 8" DualDRIVE	8"	1.08"	ER16	.406"	16083	04609
46.122.32.276	CAT40 x ER32 - 2.76" DualDRIVE	2.76"	1.97"	ER32	.788"	16089	04616
46.122.32.400	CAT40 x ER32 - 4" DualDRIVE	4"	1.97"	ER32	.788"	16089	04616
46.122.32.600	CAT40 x ER32 - 6" DualDRIVE	6"	1.97"	ER32	.788"	16089	04616
46.122.40.315	CAT40 x ER40 - 3.15" DualDRIVE	3.15"	2.48"	ER40	1.023"	16091	04617

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

CAT40, 50 Precision SlimFIT Toolholders



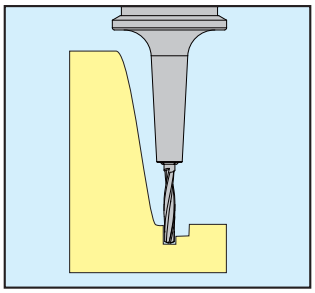
Internal drawbar collet eliminates need for clamping nut to permit narrow nose diameter. 4˚ collet provides greater holding power and improved accuracy.

Features

- *Maximum T.I.R. 0.0001" from taper to collet pocket*
- *Balanced to 25,000 RPM at G2.5*
- *Nose diameter only .55"*



Coolant-thru toolholder



Maximum nose clearance

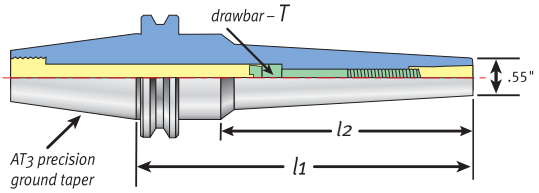


Use with SlimFIT collets for shank sizes 3/32" – 1/4"

Collet Set

Part No.	Description
18743-12IMS	SlimFIT 6 - 12 pc. set

1/8" – 1/4" by 64ths (except no 5/32 or 7/32) 3mm – 6mm by 1mm



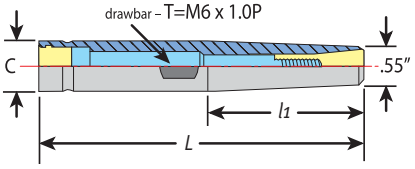
SlimFIT CAT40, CAT50 Toolholders

Part No.	Description	l1	l2	Drawbar-T
23654	CAT40 x SBL6 - 3" SlimFIT	3"	1.625"	SYIC-SBL-M6C-60
23656	CAT40 x SBL6 - 4" SlimFIT	4"	2.625"	SYIC-SBL-M6C-35
23658	CAT40 x SBL6 - 6" SlimFIT	6"	4.625"	SYIC-SBL-M6C-80
23659	CAT40 x SBL6 - 8" SlimFIT	8"	6.622"	SYIC-SBL-M6C-130
23672	CAT50 x SBL6-3.5" SlimFIT	3.5"	2.12"	SYIC-SBL-M6C-65
23676	CAT50 x SBL6-6" SlimFIT	6"	4.622"	SYIC-SBL-M6C-80



Features

- *Use with any toolholder*
- *Extremely accurate drawbar collet*
- *Use with SlimFIT 6 collets*



SlimFIT Extensions

Part No.	Description	L	l1	C
06032-3	1/2" x OLP6-3" extension	3"	1.89"	.50"
06032	1/2" x OLP6-5" extension	5"	1.89"	.50"
06034	1/2" x OLP6-6" extension	6"	1.89"	.50"
06038	5/8" x OLP6-5" extension	5"	1.89"	.625"
06040	5/8" x OLP6-6" extension	6"	1.89"	.625"
06042	5/8" x OLP6-8" extension	8"	1.89"	.625"



SlimFIT Inch Size Collets

Part No.	Description
18851-3/32	SlimFIT 6 - 3/32" collet
18851-7/64	SlimFIT 6 - 7/64" collet
18851-1/8	SlimFIT 6 - 1/8" collet
18851-9/64	SlimFIT 6 - 9/64" collet
18851-5/32	SlimFIT 6 - 5/32" collet
18851-11/64	SlimFIT 6 - 11/64" collet
18851-3/16	SlimFIT 6 - 3/16" collet
18851-13/64	SlimFIT 6 - 13/64" collet
18851-7/32	SlimFIT 6 - 7/32" collet
18851-15/64	SlimFIT 6 - 15/64" collet
18851-1/4	SlimFIT 6 - 1/4" collet

SlimFIT Metric Size Collets

Part No.	Description
18851-03	SlimFIT 6 - 3mm collet
18851-04	SlimFIT 6 - 4mm collet
18851-05	SlimFIT 6 - 5mm collet
18851-05.5	SlimFIT 6 - 5.5mm collet
18851-06	SlimFIT 6 - 6mm collet

CAT50 Precision ER Toolholders



Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*


Collets
pg. 43

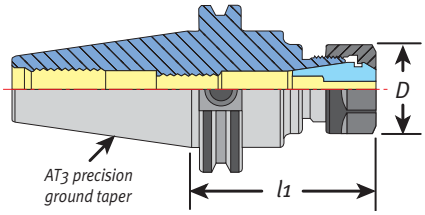

Nuts
pg. 58


Coolant
Rings
pg. 60


Retention
Knobs
pg. 204


Wrenches
pg. 208


Tightening
Stands
pg. 210



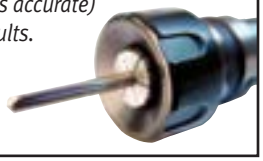
A PowerCOAT nut is included with each holder.

For ER16, and 20 slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number. Coolant nuts are not available for ER50.

For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results.

See page 48.



CAT50 ER Toolholders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
22281	CAT50 x ER16 - 4", hex nut	4"	1.08"	.406"	16083	04609
22285	CAT50 x ER16 - 6", hex nut	6"	1.08"	.406"	16083	04609
22287	CAT50 x ER16 - 8", hex nut	8"	1.08"	.406"	16083	04609
22291	CAT50 x ER20 - 4", hex nut	4"	1.34"	.512"	16087	04610
22293	CAT50 x ER20 - 6", hex nut	6"	1.34"	.512"	16087	04610
22295	CAT50 x ER20 - 8", hex nut	8"	1.34"	.512"	16087	04610
22303	CAT50 x ER25 - 4", slotted nut	4"	1.65"	.630"	16089	04615
22305	CAT50 x ER25 - 6", slotted nut	6"	1.65"	.630"	16089	04615
22307	CAT50 x ER25 - 8", slotted nut	8"	1.65"	.630"	16089	04615
22307-9	CAT50 x ER25 - 9", slotted nut	9"	1.65"	.630"	16089	04615
22311	CAT50 x ER32 - 4", slotted nut	4"	1.97"	.788"	16089	04616
22313	CAT50 x ER32 - 6", slotted nut	6"	1.97"	.788"	16089	04616
22317	CAT50 x ER32 - 8", slotted nut	8"	1.97"	.788"	16089	04616
22321	CAT50 x ER40 - 4", slotted nut	4"	2.48"	1.023"	16091	04617
22325	CAT50 x ER40 - 6", slotted nut	6"	2.48"	1.023"	16091	04617
22327	CAT50 x ER40 - 8", slotted nut	8"	2.48"	1.023"	16091	04617
22331	CAT50 x ER50 - 4", slotted nut	4"	3.07"	1.338"	16093	04618
22335	CAT50 x ER50 - 6", slotted nut	6"	3.07"	1.338"	16093	04618
22337	CAT50 x ER50 - 8", slotted nut	8"	3.07"	1.338"	16093	04618

Properly torque down the nut for best tool life. See the Torque Chart on page 41.

SYIC

CAT50 Precision CoolFLEX Toolholders



Features

- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" or better from taper to collet pocket*

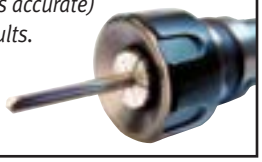
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.

For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results.

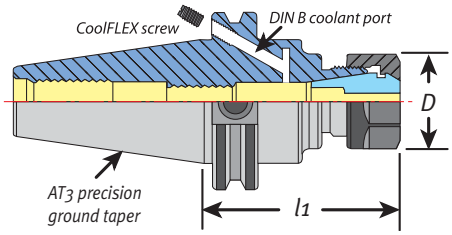
See page 48.

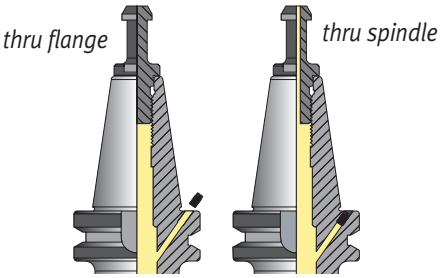


A PowerCOAT nut is included with each holder.

For ER16, and 20 slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number.





Replacement CoolFLEX Screws

Part No.	Description
HSA-6-6	50 taper DIN B screw

CAT50 CoolFLEX Coolant -Thru Spindle or Flange (DIN B)

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
22281F	CAT50 x ER16 - 4", hex nut	4"	1.08"	.406"	16083	04609
22285F	CAT50 x ER16 - 6", hex nut	6"	1.08"	.406"	16083	04609
22291F	CAT50 x ER20 - 4", hex nut	4"	1.34"	.512"	16087	04610
22293F	CAT50 x ER20 - 6", hex nut	6"	1.34"	.512"	16087	04610
22295F	CAT50 x ER20 - 8", hex nut	8"	1.34"	.512"	16087	04610
22303F	CAT50 x ER25 - 4", slotted nut	4"	1.65"	.630"	16089	04615
22311F	CAT50 x ER32 - 4", slotted nut	4"	1.97"	.788"	16089	04616
22313F	CAT50 x ER32 - 6", slotted nut	6"	1.97"	.788"	16089	04616
22317F	CAT50 x ER32 - 8", slotted nut	8"	1.97"	.788"	16089	04616
22321F	CAT50 x ER40 - 4", slotted nut	4"	2.48"	1.023"	16091	04617
22327F	CAT50 x ER40 - 8", slotted nut	8"	2.48"	1.023"	16091	04617

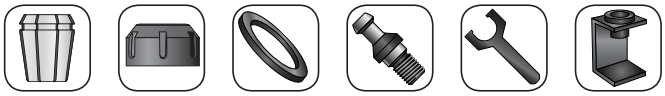
CAT50 Precision ER Mini Nut Holders



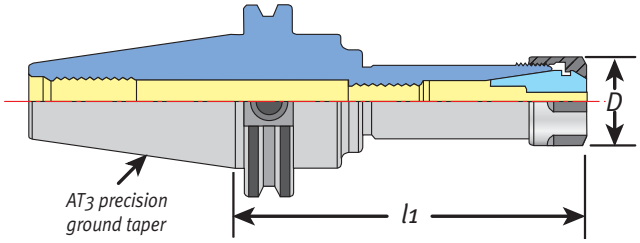
Features

- *Narrow nut diameter for better clearance*
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*

A PowerCOAT mini nut is included with each holder.
Techniks Certified for accuracy and balance.
Each holder comes with a complete lab report.



Collets pg. 48 | Nuts pg. 62 | Coolant Rings pg. 64 | Retention Knobs pg. 200 | Wrenches pg. 204 | Tightening Stands pg. 206





Coolant Options

- *ER coolant rings (pg. 60)*
- *ER Steel Sealed collets (pg. 50)*
- *ER coolant collets (pg. 52)*

CAT50 ER Mini Nut Holders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
22364	CAT50 x ER16 - 4", mini nut	4"	.87"	.406"	16083	04622
22366	CAT50 x ER16 - 6", mini nut	6"	.87"	.406"	16083	04622
22368	CAT50 x ER20 - 4", mini nut	4"	1.102"	.512"	16087	04623
22370	CAT50 x ER20 - 6", mini nut	6"	1.102"	.512"	16087	04623

CAT50 Precision ER32 SuperRIGID Holders



Features

- *Balanced to 25,000 RPM at G2.5*
- *Best T.I.R. and Z axis of any collet chuck*
- *SuperRIGID for high torque or high speed machining*

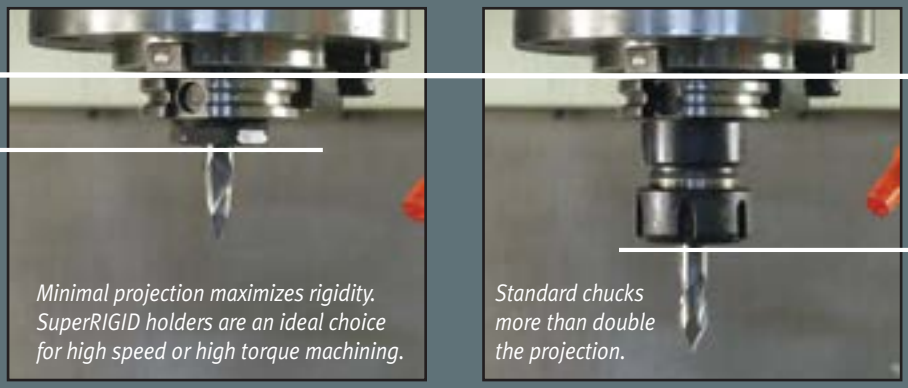
Techniks Certified for accuracy and balance.
Each holder comes with a complete lab report.
Collet nut is included with each holder.



Use SuperRIGID holders with ER32 collets.

SuperRIGID Holders

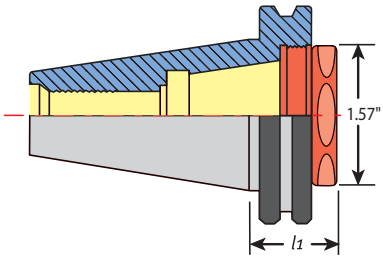
Standard Holders



Minimal projection maximizes rigidity. SuperRIGID holders are an ideal choice for high speed or high torque machining.

Standard chucks more than double the projection.

Minimum projection = increased rigidity, better T.I.R. and extended cutter life.





PowerCOAT TE-22HN Nut

CAT50 SuperRIGID ER Toolholders

Part No.	Description	l1	Collet	Max. Shank	Wrench
22311S	CAT50 x ER32	1.10"	ER32	3/4" or 20mm	894-36
TE-22HN	hex style PowerCOAT nut				

CAT50 DualDRIVE for Dual-Contact Spindles



Features

- *New one-piece design for dual-contact spindles*
- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*

Benefits

- *Better rigidity and reduced vibration*
- *Improved performance at high metal removal rates and when machining at extended lengths*

Techniks Certified for accuracy and balance
Each holder comes with a complete lab report


Collets pg. 43


Nuts pg. 58


Coolant Rings pg. 60


Retention Knobs pg. 204


Wrenches pg. 208


Tightening Stands pg. 210

Dual-Contact Spindles

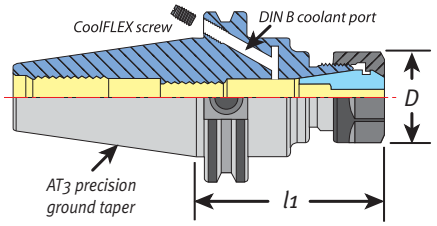
Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.

A PowerCOAT nut is included with each holder.

ER16 holders come with hex nuts. For slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number.

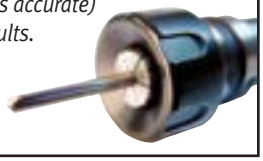


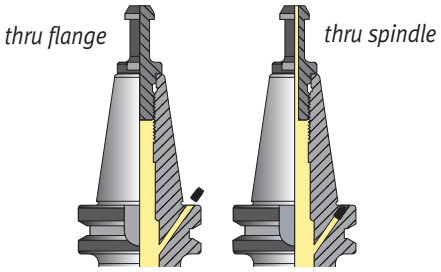
See an on machine demonstration video of DualDRIVE compared to standard toolholders at: http://ow.ly/sUOqL



For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results.

See page 48.





CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.

Replacement CoolFLEX Screws

Part No.	Description
HSA-6-6	50 taper DIN B screw

CAT50 ER DualDRIVE Coolant -Thru Spindle or Flange (DIN B)

Coolant Set Screws page 41.

Part No.	Description - l1	l1	D	Collet	Max. Shank	Set Screw	Wrench
47.122.16.400	CAT50 x ER16 - 4" DualDRIVE	4"	1.08"	ER16	.406"	16083	04609
47.122.16.600	CAT50 x ER16 - 6" DualDRIVE	6"	1.08"	ER16	.406"	16083	04609
47.122.16.800	CAT50 x ER16 - 8" DualDRIVE	8"	1.08"	ER16	.406"	16083	04609
47.122.32.400	CAT50 x ER32 - 4" DualDRIVE	4"	1.97"	ER32	.788"	16089	04616
47.122.32.600	CAT50 x ER32 - 6" DualDRIVE	6"	1.97"	ER32	.788"	16089	04616
47.122.32.800	CAT50 x ER32 - 8" DualDRIVE	8"	1.97"	ER32	.788"	16089	04616
47.122.40.400	CAT50 x ER40 - 4" DualDRIVE	4"	2.48"	ER40	1.023"	16091	04617

Properly torque down the nut for best tool life. See the Torque Chart on page 41.

BT30 Precision ER Toolholders and Mini Nut Holders

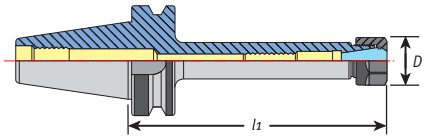


PowerCOAT nut is included with each holder. Techniks Certified for accuracy and balance.

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *Taper ground to AT3 accuracy or better*

NOTE: ER16 and 20 toolholders come with hex nut as standard.
For slotted nuts simply add SLOTNUT to the end of the part number.
For holders with coolant nut included add -C to the end of the part number.



BT30 Precision ER Toolholders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
16102	BT30 x ER16 - 60mm, hex nut	60mm	1.08"	.406"	16083	04609
16101	BT30 x ER16 - 70mm, hex nut	70mm	1.08"	.406"	16083	04609
16103	BT30 x ER16 - 90mm, hex nut	90mm	1.08"	.406"	16083	04609
16104	BT30 x ER16 - 100mm, hex nut	100mm	1.08"	.406"	16083	04609
16105	BT30 x ER16 - 120mm, hex nut	120mm	1.08"	.406"	16083	04609
16106	BT30 x ER20 - 70mm, hex nut	70mm	1.34"	.512"	16087	04610
16107	BT30 x ER20 - 135mm, hex nut	135mm	1.34"	.512"	16087	04610
16108-2.5	BT30 x ER20 - 63.5mm, hex nut	63.5mm	1.34"	.512"	16087	04610
16109	BT30 x ER25 - 70mm, slotted nut	70mm	1.65"	.63"	16089	04615
16110	BT30 x ER25 - 60mm, slotted nut	60mm	1.65"	.63"	16089	04615
16111-90	BT30 x ER25 - 90mm, slotted nut	90mm	1.65"	.63"	16089	04615
16111	BT30 x ER25 - 135mm, slotted nut	135mm	1.65"	.63"	16089	04615
16112	BT30 x ER32 - 60mm, slotted nut	60mm	1.97"	.788"	16089	04616
16113	BT30 x ER32 - 70mm, slotted nut	70mm	1.97"	.788"	16089	04616
16114	BT30 x ER32 - 100mm, slotted nut	100mm	1.97"	.788"	16089	04616
16115	BT30 x ER40 - 80mm, slotted nut	80mm	2.48"	1.023"	16089	04617



Features

- *Narrow nut diameter for better clearance*
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*

BT30 Precision ER Mini Nut Holders

For coolant applications use ER16 or ER20 coolant mini nut (pg. 59) Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
16302	BT30 x ER11 - 70mm, mini nut	70	.63"	.275"	16081	04621
16304	BT30 x ER11 - 100mm, mini nut	100mm	.63"	.275"	16081	04621
16308	BT30 x ER16 - 70mm, mini nut	70mm	.87"	.406"	16083	04622
16312	BT30 x ER16 - 120mm, mini nut	120mm	.87"	.406"	16083	04622
16313	BT30 x ER20 - 70mm, mini nut	70mm	1.34"	.512"	16087	04610
16314	BT30 x ER20 - 100mm, mini nut	100mm	1.102"	.512"	16087	04623
16318	BT30 x ER20 - 150mm, mini nut	150mm	1.102"	.512"	16087	04623

BT30 DualDRIVE for Dual-Contact Spindles



Features

- *New one-piece design for dual-contact spindles*
- *Improves rigidity and reduces vibration*
- *Balanced to 25,000 RPM at G2.5*

Benefits

- *Better rigidity and reduced vibration*
- *Improved performance at high metal removal rates and when machining at extended lengths*

PowerCOAT nut is included with each holder
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report


Collets
pg. 43


Nuts
pg. 58


Coolant Rings
pg. 60


Retention Knobs
pg. 204


Wrenches
pg. 208


Tightening Stands
pg. 210

See an on machine demonstration video of DualDRIVE compared to standard toolholders at:
http://ow.ly/sUOqL



Dual-Contact Spindles

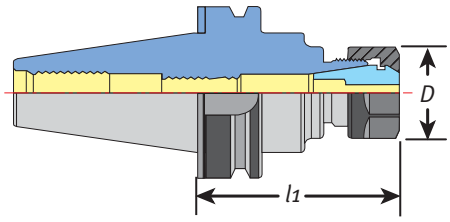
Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.



Coolant Options

- *ER coolant rings (pg. 60)*
- *ER Steel Sealed collets (pg. 50)*
- *ER coolant collets (pg. 52)*



BT30 ER DualDRIVE Toolholders

Coolant Set Screws page 41.

Part No.	Description - l1	l1	D	Collet	Max. Shank	Set Screw	Wrench
25.122.16.060	BT30 x ER16 - 60mm DualDRIVE	60mm	27.43mm	ER16	.406"	16083	04609
25.122.16.090	BT30 x ER16 - 90mm DualDRIVE	90mm	27.43mm	ER16	.406"	16083	04609
25.122.16.105	BT30 x ER16 - 105mm DualDRIVE	105mm	27.43mm	ER16	.406"	16083	04609
25.122.20.105	BT30 x ER20 - 105mm DualDRIVE	105mm	34.04mm	ER20	.512"	16087	04610
25.122.20.060	BT30 x ER20 - 60mm DualDRIVE	60mm	34.04mm	ER20	.512"	16087	04610
25.122.20.090	BT30 x ER20 - 90mm DualDRIVE	90mm	34.04mm	ER20	.512"	16087	04610
25.122.25.060	BT30 x ER25 - 60mm DualDRIVE	60mm	41.91mm	ER25	.63"	16089	04615
25.122.32.060	BT30 x ER32 - 60mm DualDRIVE	60mm	50.04mm	ER32	.788"	16089	04616
25.122.32.090	BT30 x ER32 - 90mm DualDRIVE	90mm	50.04mm	ER32	.788"	16089	04616
25.122.40.080	BT30 x ER40 - 80mm DualDRIVE	80mm	62.99mm	ER40	1.023"	16091	04617

Properly torque down the nut for best tool life. See the Torque Chart on page 41.

BT30 and BT40 Precision SlimFIT Toolholders



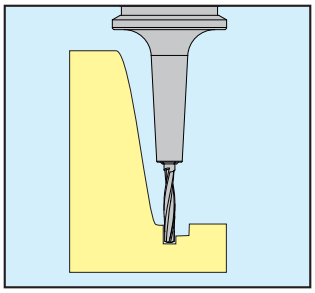
Internal drawbar collet eliminates need for clamping nut to permit narrow nose diameter. 4˚ collet provides greater holding power and improved accuracy.

Features

- *Maximum T.I.R. 0.0001" from taper to collet pocket*
- *Balanced to 25,000 RPM at G2.5*
- *Nose diameter only .55"*



Coolant-thru toolholder



Maximum nose clearance

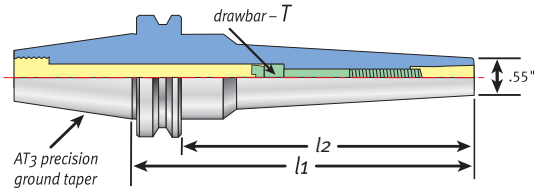


Use with SlimFIT collets for shank sizes 3/32" – 1/4"

Collet Set

Part No.	Description
18743-12IMS	SlimFIT 6 - 12 pc. set

1/8" – 1/4" by 64ths (except no 5/32 or 7/32) 3mm – 6mm by 1mm





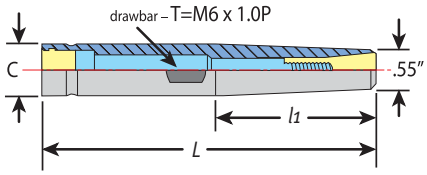
SlimFIT BT30, BT40 Toolholders

Part No.	Description	l1	l2	Drawbar-T
18854	BT30 x SBL6-70	70mm	48mm	SYIC-SBL-M6C-45
18856	BT30 x SBL6-100	100mm	78mm	SYIC-SBL-M6C-65
18866	BT40 x SBL6-70	70mm	43mm	SYIC-SBL-M6C-45
18868	BT40 x SBL6-100	100mm	73mm	SYIC-SBL-M6C-80
18868-150	BT40 x SBL6-150	150mm	123mm	SYIC-SBL-M6C-65
18869	BT40 x SBL6-200	200mm	173mm	SYIC-SBL-M6C-130



Features

- *Use with any toolholder*
- *Extremely accurate drawbar collet*
- *Use with SlimFIT 6 collets*



SlimFIT Extensions

Part No.	Description	L	l1	C
06032-3	1/2" x OLP6-3" extension	3"	1.89"	.50"
06032	1/2" x OLP6-5" extension	5"	1.89"	.50"
06034	1/2" x OLP6-6" extension	6"	1.89"	.50"
06038	5/8" x OLP6-5" extension	5"	1.89"	.625"
06040	5/8" x OLP6-6" extension	6"	1.89"	.625"
06042	5/8" x OLP6-8" extension	8"	1.89"	.625"

SlimFIT Inch Size Collets

Part No.	Description
18851-3/32	SlimFIT 6 - 3/32" collet
18851-7/64	SlimFIT 6 - 7/64" collet
18851-1/8	SlimFIT 6 - 1/8" collet
18851-9/64	SlimFIT 6 - 9/64" collet
18851-5/32	SlimFIT 6 - 5/32" collet
18851-11/64	SlimFIT 6 - 11/64" collet
18851-3/16	SlimFIT 6 - 3/16" collet
18851-13/64	SlimFIT 6 - 13/64" collet
18851-7/32	SlimFIT 6 - 7/32" collet
18851-15/64	SlimFIT 6 - 15/64" collet
18851-1/4	SlimFIT 6 - 1/4" collet

SlimFIT Metric Size Collets

Part No.	Description
18851-03	SlimFIT 6 - 3mm collet
18851-04	SlimFIT 6 - 4mm collet
18851-05	SlimFIT 6 - 5mm collet
18851-05.5	SlimFIT 6 - 5.5mm collet
18851-06	SlimFIT 6 - 6mm collet

BT40 Precision ER Toolholders



Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*


Collets
pg. 43


Nuts
pg. 58


Coolant
Rings
pg. 60


Retention
Knobs
pg. 204

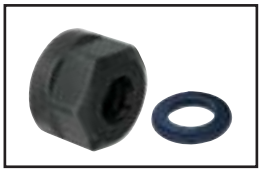

Wrenches
pg. 208


Tightening
Stands
pg. 210

A PowerCOAT nut is included with each holder.

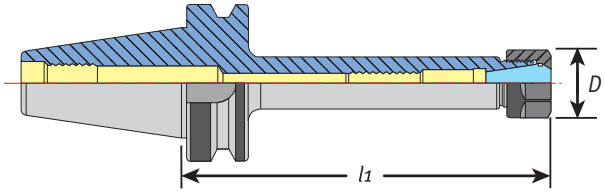
ER16 holders come with hex nuts. For slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number.



Coolant Options

- *ER coolant rings (pg. 64)*
- *ER Steel Sealed collets (pg. 54)*
- *ER coolant collets (pg. 56)*



BT40 ER Toolholders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
16151	BT40 x ER16 - 70mm, hex nut	70mm	1.08"	.406"	16083	04609
16153	BT40 x ER16 - 100mm, hex nut	100mm	1.08"	.406"	16083	04609
16155	BT40 x ER16 - 125mm, hex nut	125mm	1.08"	.406"	16083	04609
16157	BT40 x ER16 - 150mm, hex nut	150mm	1.08"	.406"	16083	04609
16158	BT40 x ER16 - 180mm, hex nut	180mm	1.08"	.406"	16083	04609
16159	BT40 x ER20 - 70mm, hex nut	70mm	1.34"	.512"	16085	04610
16162	BT40 x ER20 - 100mm, hex nut	100mm	1.34"	.512"	16085	04610
16165	BT40 x ER20 - 135mm, hex nut	135mm	1.34"	.512"	16085	04610
16167	BT40 x ER20 - 150mm, hex nut	150mm	1.34"	.512"	16085	04610
16169	BT40 x ER25 - 70mm, slotted nut	70mm	1.65"	.630"	16089	04615
16171	BT40 x ER25 - 100mm, slotted nut	100mm	1.65"	.630"	16089	04615
16175	BT40 x ER25 - 150mm, slotted nut	150mm	1.65"	.630"	16089	04615
16177	BT40 x ER32 - 70mm, slotted nut	70mm	1.97"	.788"	16089	04616
16179	BT40 x ER32 - 100mm, slotted nut	100mm	1.97"	.788"	16089	04616
16181	BT40 x ER32 - 150mm, slotted nut	150mm	1.97"	.788"	16089	04616
16183	BT40 x ER40 - 80mm, slotted nut	80mm	2.48"	1.023"	16089	04617
16185	BT40 x ER40 - 100mm, slotted nut	100mm	2.48"	1.023"	16089	04617
16189	BT40 x ER40 - 150mm, slotted nut	150mm	2.48"	1.023"	16089	04617

Need it FAST? We offer Same Day Shipping until 6:00 pm E.S.T.

BT40 Precision ER CoolFLEX Toolholders



Features

- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" or better from taper to collet pocket*

Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

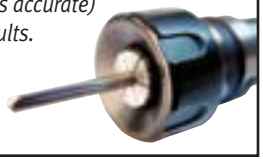
A PowerCOAT nut is included with each holder.

ER16 holders come with hex nuts. For slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number.

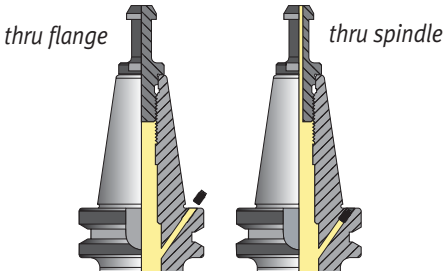
For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results.

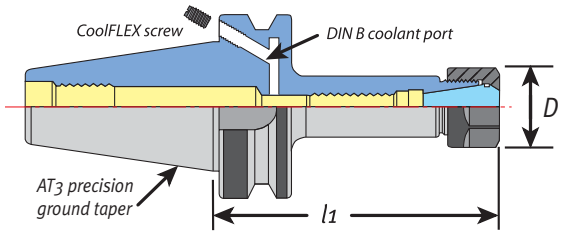
See page 48.



CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.





Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw

BT40 CoolFLEX Coolant -Thru Spindle or Flange (DIN B)

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
16151F	BT40 x ER16 - 70mm, hex nut, CoolFLEX	70mm	1.08"	.406"	16083	04609
16153F	BT40 x ER16 - 100mm, hex nut, CoolFLEX	100mm	1.08"	.406"	16083	04609
16157F	BT40 x ER16 - 150mm, hex nut, CoolFLEX	150mm	1.08"	.406"	16083	04609
16159F	BT40 x ER20 - 70mm, hex nut, CoolFLEX	70mm	1.34"	.512"	16085	04610
16162F	BT40 x ER20 - 100mm, hex nut, CoolFLEX	100mm	1.34"	.512"	16085	04610
16167F	BT40 x ER20 - 150mm, hex nut, CoolFLEX	150mm	1.34"	.512"	16085	04610
16177F	BT40 x ER32 - 70mm, slotted, CoolFLEX	70mm	1.97"	.788"	16089	04616
16181F	BT40 x ER32 - 150mm, slotted, CoolFLEX	150mm	1.97"	.788"	16089	04616

BT40 Precision ER Mini Nut Holders



Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *Taper ground to AT3 accuracy or better*

PowerCOAT nut is included with each holder
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

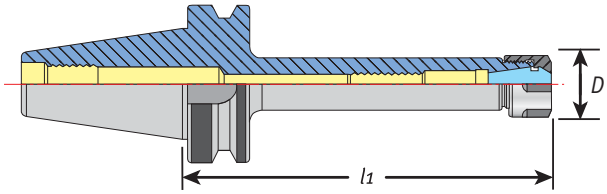


See page 59 for replacement Mini Nuts.



Coolant Options

- *ER coolant rings (pg. 60)*
- *ER Steel Sealed collets (pg. 50)*
- *ER coolant collets (pg. 52)*



BT40 ER Mini Nut Holders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
16321	BT40 x ER11 - 70mm, mini nut	70mm	16mm	.275"	16081	04621
16324	BT40 x ER11 - 150mm, mini nut	150mm	16mm	.275"	16081	04621
16325	BT40 x ER16 - 70mm, mini nut	70mm	22mm	.406"	16083	04622
16328	BT40 x ER16 - 150mm, mini nut	150mm	22mm	.406"	16083	04622
16328-200	BT40 x ER16 - 200mm, mini nut	200mm	22mm	.406"	16083	04622
16329	BT40 x ER20 - 70mm, mini nut	70mm	28mm	.512"	16087	04623
16330	BT40 x ER20 - 100mm, mini nut	100mm	28mm	.512"	16087	04623
16332	BT40 x ER20 - 150mm, mini nut	150mm	28mm	.512"	16087	04623

Properly torque down the nut for best tool life. See the Torque Chart on page 41.

BT40 Precision SuperRIGID Holders



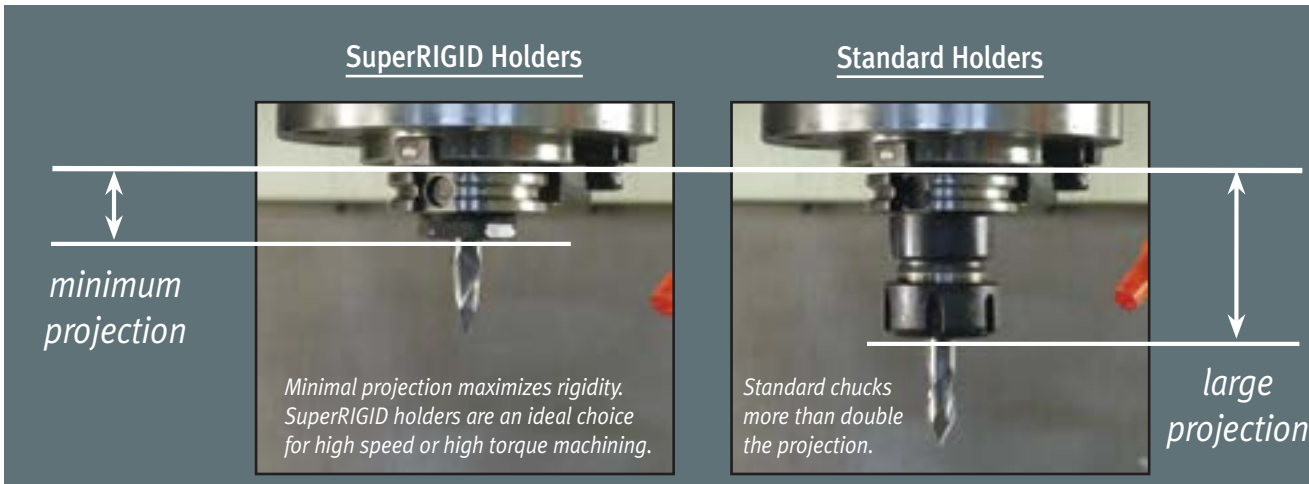
Features

- *Balanced to 25,000 RPM at G2.5*
- *Best T.I.R. and Z axis of any collet chuck*
- *SuperRIGID for high torque or high speed machining*

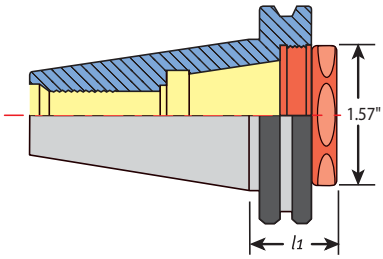
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report
Collet nut is included with each holder



Use SuperRIGID holders with ER32 collets.



Minimum projection = increased rigidity, better T.I.R. and extended cutter life.





PowerCOAT TE-22HN Nut

BT40 SuperRIGID ER Toolholders

Part No.	Description	l1	Collet	Max. Shank	Wrench
16177S	BT40 x ER32	36mm	ER32	3/4" or 20mm	894-36
TE-22HN	hex style PowerCOAT nut				

BT50 Precision ER Toolholders



Techniks Certified for accuracy and balance
Each holder comes with a complete lab report



Coolant Options

- *ER coolant rings (pg. 60)*
- *ER Steel Sealed collets (pg. 50)*
- *ER coolant collets (pg. 52)*

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*


Collets
pg. 43


Nuts
pg. 58


Coolant Rings
pg. 60

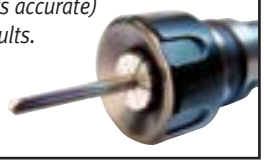

Retention Knobs
pg. 204


Wrenches
pg. 208


Tightening Stands
pg. 210

For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results.

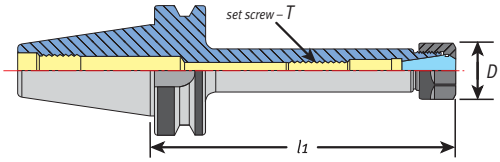
See page 48.



A PowerCOAT nut is included with each holder.

ER16 holders come with hex nuts. For slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number. Coolant nuts are not available for ER50.



BT50 Precision Toolholders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Max. Shank	Set Screw	Wrench
16251	BT50 x ER16 - 70mm, hex nut	70mm	1.08"	.406"	16083	04609
16252	BT50 x ER16 - 90mm, hex nut	90mm	1.08"	.406"	16083	04609
16253	BT50 x ER16 - 105mm, hex nut	105mm	1.08"	.406"	16083	04609
16254	BT50 x ER16 - 135mm, hex nut	135mm	1.08"	.406"	16083	04609
16255	BT50 x ER16 - 150mm, hex nut	150mm	1.08"	.406"	16083	04609
16263	BT50 x ER20 - 90mm, hex nut	90mm	1.34"	.512"	16087	04610
16265	BT50 x ER20 - 105mm, hex nut	105mm	1.34"	.512"	16087	04610
16267	BT50 x ER20 - 135mm, hex nut	135mm	1.34"	.512"	16087	04610
16271	BT50 x ER20 - 165mm, hex nut	165mm	1.34"	.512"	16087	04610
16275	BT50 x ER25 - 105mm, slotted nut	105mm	1.65"	.630"	16089	04615
16277	BT50 x ER25 - 135mm, slotted nut	135mm	1.65"	.630"	16089	04615
16279	BT50 x ER25 - 165mm, slotted nut	165mm	1.65"	.630"	16089	04615
16281	BT50 x ER32 - 80mm, slotted nut	80mm	1.97"	.788"	16089	04616
16283	BT50 x ER32 - 120mm, slotted nut	120mm	1.97"	.788"	16089	04616
16284	BT50 x ER32 - 150mm, slotted nut	150mm	1.97"	.788"	16089	04616
16285	BT50 x ER40 - 80mm, slotted nut	80mm	2.48"	1.023"	16091	04617
16289	BT50 x ER40 - 135mm, slotted nut	135mm	2.48"	1.023"	16091	04617
06291	BT50 x ER50 - 90mm, slotted nut	90mm	3.07"	1.338"	16093	04618

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

HSK32A, 40A, 50A, 63A, 100A Precision ER Toolholders



Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

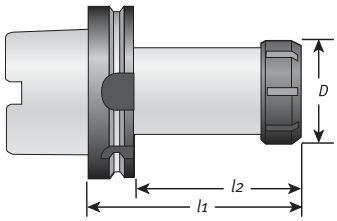
Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*

A PowerCOAT nut is included with each holder.

ER16 holders come with hex nuts. For slotted nuts, simply add SLOTNUT to the end of the part number.

For holders with coolant nut included add -C to the end of the part number. Coolant nuts are not available for ER50.

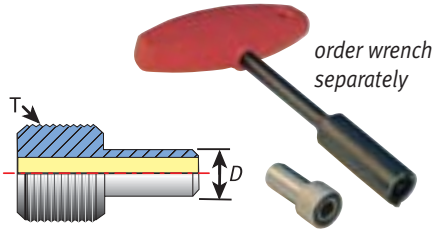


HSK32A, 40A, 50A, 63A, 100A Toolholders

Part No.	Description	l1	l2	D	Wrench
31278	HSK32A x ER20 - 80mm, slotted nut	80mm	60mm	34mm	04614
31284	HSK32A x ER25 - 80mm, mini nut	80mm	60mm	35mm	04624
31374	HSK40A x ER11 - 80mm, mini nut	80mm	60mm	16mm	04621
31376	HSK40A x ER16 - 80mm, hex nut	80mm	54mm	28mm	04609
31384	HSK40A x ER25 - 80mm, slotted nut	80mm	60mm	35mm	04624
31385	HSK40A x ER32 - 80mm, slotted nut	80mm	60mm	50mm	04616
31420	HSK50A x ER32 - 100mm, slotted nut	100mm	74mm	50mm	04616
31432	HSK63A x ER16 - 80mm, hex nut	80mm	54mm	28mm	04609
31434	HSK63A x ER16 - 100mm, hex nut	100mm	74mm	28mm	04609
31438	HSK63A x ER16 - 160mm, hex nut	160mm	134mm	28mm	04609
31440	HSK63A x ER20 - 80mm, hex nut	80mm	54mm	34mm	04610
31446	HSK63A x ER20 - 160mm, hex nut	160mm	134mm	34mm	04610
31462	HSK63A x ER32 - 100mm, slotted nut	100mm	74mm	50mm	04616
31468	HSK63A x ER40 - 80mm, slotted nut	80mm	54mm	63mm	04617
31472	HSK63A x ER40 - 120mm, slotted nut	120mm	94mm	63mm	04617
31484	HSK100A x ER16 - 100mm, hex nut	100mm	74mm	28mm	04609
31486	HSK100A x ER16 - 160mm, hex nut	160mm	134mm	28mm	04609
31498	HSK100A x ER32 - 100mm, slotted nut	100mm	71mm	50mm	04616
31503	HSK100A x ER32 - 160mm, slotted nut	160mm	134mm	50mm	04616
31506	HSK100A x ER40 - 120mm, slotted nut	120mm	91mm	63mm	04617

HSKA Coolant Pipe and Wrench

Part No.	Description	HSK-A	D	T	Wrench
92002	Coolant Pipe	40	8mm	M12 x 1	91.11.026.002
92003	Coolant Pipe	50	10mm	M16 x 1	92.11.026.003
92004	Coolant Pipe	63	12mm	M18 x 1	93.11.026.004
92005	Coolant Pipe	100	16mm	M24 x 1.5	95.11.026.005



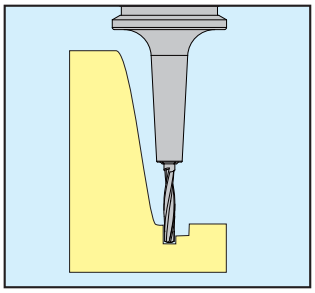
HSK63A Precision SlimFIT Toolholders



Internal drawbar collet eliminates need for clamping nut to permit narrow nose diameter. 4˚ collet provides greater holding power and improved accuracy.



Coolant-thru design



Maximum nose clearance

Features

- *Maximum T.I.R. 0.0001" from taper to collet pocket*
- *Balanced to 25,000 RPM at G2.5*
- *Nose diameter only .55"*

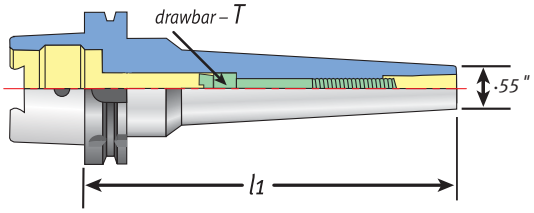


Use with SlimFIT collets for shank sizes 3/32" – 1/4"

Collet Set

Part No.	Description
18743-12IMS	SlimFIT 6 - 12 pc. set

1/8" – 1/4" by 64ths (except no 5/32 or 7/32) 3mm – 6mm by 1mm





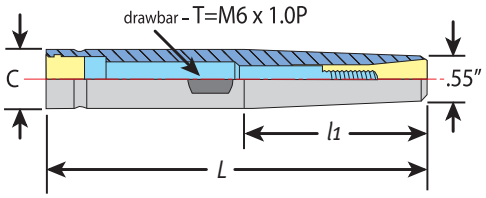
SlimFIT HSK63A Toolholders

Part No.	Description	l1	l2	Drawbar-T
35470	HSK63A x SBL6-80 SlimFIT	80mm	54mm	SYIC-SBL-M6C-15
35472	HSK63A x SBL6-120 SlimFIT	120mm	94mm	SYIC-SBL-M6C-50



Features

- *Use with any toolholder*
- *Extremely accurate drawbar collet*
- *Use with SlimFIT 6 collets*



SlimFIT Extensions

Part No.	Description	L	l1	C
06032-3	1/2" x OLP6-3" extension	3"	1.89"	.50"
06032	1/2" x OLP6-5" extension	5"	1.89"	.50"
06034	1/2" x OLP6-6" extension	6"	1.89"	.50"
06038	5/8" x OLP6-5" extension	5"	1.89"	.625"
06040	5/8" x OLP6-6" extension	6"	1.89"	.625"
06042	5/8" x OLP6-8" extension	8"	1.89"	.625"

SlimFIT Inch Size Collets

Part No.	Description
18851-3/32	SlimFIT 6 - 3/32" collet
18851-7/64	SlimFIT 6 - 7/64" collet
18851-1/8	SlimFIT 6 - 1/8" collet
18851-9/64	SlimFIT 6 - 9/64" collet
18851-5/32	SlimFIT 6 - 5/32" collet
18851-11/64	SlimFIT 6 - 11/64" collet
18851-3/16	SlimFIT 6 - 3/16" collet
18851-13/64	SlimFIT 6 - 13/64" collet
18851-7/32	SlimFIT 6 - 7/32" collet
18851-15/64	SlimFIT 6 - 15/64" collet
18851-1/4	SlimFIT 6 - 1/4" collet

SlimFIT Metric Size Collets

Part No.	Description
18851-03	SlimFIT 6 - 3mm collet
18851-04	SlimFIT 6 - 4mm collet
18851-05	SlimFIT 6 - 5mm collet
18851-05.5	SlimFIT 6 - 5.5mm collet
18851-06	SlimFIT 6 - 6mm collet

Need it FAST? We offer Same Day Shipping until 6:00 pm E.S.T.

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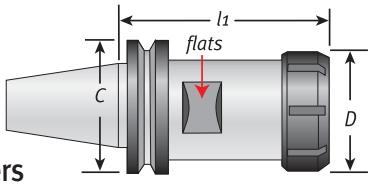
ISO and SK Precision CNC Router Toolholders



Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

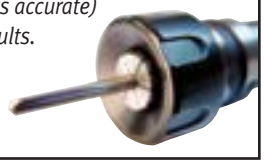
Features

- *Balanced up to 40,000 RPM at G2.5*
- *T.I.R. 0.0001" or better from taper to collet pocket*
- *PowerCOAT nut and retention knob included*



For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results.

See page 48.



ISO 20 and ISO 25 Toolholders for CNC Routers

Part No.	Description	l1	C	D	Nut	Wrench	Flats
16000-2016MC	*ISO 20 x ER16 - 52mm, HS mini nut & pull stud	52mm	30mm	22mm	53116	04622	17
16000-2516	ISO 20 x ER16 - 52mm, slotted nut & pull stud	52mm	30mm	32mm	46116	04613	17
16000-2520	ISO 20 x ER20 - 52mm, slotted nut & pull stud	52mm	30mm	35mm	46120	04614	17
12194-ISO25	ISO 25 x ER25 - 50mm, slotted nut & pull stud	50mm	38mm	42mm	46125	04615	27
25077	ISO 25 x ER25 - 65mm, slotted nut & pull stud	65mm	38mm	42mm	23111	04615	27

*Balanced to 40,000 RPM. Use for Haas OM-1A, OM-2A Office Mills. Haas is trademark of Haas Automation and used here for identification only.



Taper ground to AT3 accuracy or better
Techniks Certified for accuracy and balance

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" or better from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*


Collets
pg. 43


Nuts
pg. 58


Coolant Rings
pg. 60


Retention Knobs
pg. 204


Wrenches
pg. 208


Tightening Stands
pg. 210

ISO 30 and SK 30 Toolholders for CNC Routers

Part No.	Description	l1	C	D	Nut	Wrench	Flats
42407-W	ISO 30 x ER11 - 100mm, mini nut	100mm	50mm	16mm	23111	04621	14
42213-W-50	ISO 30 x ER32 - 50mm, slotted nut	50mm	50mm	50mm	46132	04616	47
42213-W-63	ISO 30 x ER32 - 63mm, slotted nut	63mm	50mm	50mm	46132	04616	36
42213-W-90	ISO 30 x ER32 - 90mm, slotted nut	90mm	50mm	50mm	46132	04616	36
12000-CMS	ISO 30 x ER32 - CMS toolholder	58mm	46mm	50mm	46132	04616	36
12040-CMS	ISO 30 x ER40 - CMS toolholder	66mm	46mm	63mm	46140	04617	42
42215-W-57	ISO 30 x ER40 - 57mm, slotted nut	57mm	50mm	63mm	46140	04617	47
42261-W	ISO 40 x ER40 - 70mm, slotted nut	70mm	63.55mm	63mm	46140	04617	46
NT-54300130	SK-30 x SYOZ 25 toolholder	63mm	50mm	60mm	83632	03691	38

BT30 and BT 35 Precision CNC Router Toolholders



PowerCOAT nut is included with each holder
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*


Collets
pg. 43


Nuts
pg. 58

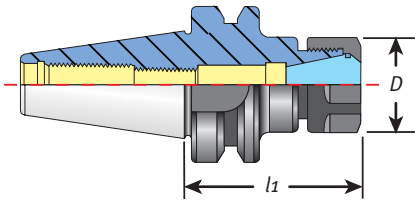

Coolant Rings
pg. 60


Retention Knobs
pg. 204


Wrenches
pg. 208


Tightening Stands
pg. 210

Don't see what you are looking for? See page 25–27 for the rest of our BT30 collet chucks, or your can request a special order if needed.





Scan the QR code with a smartphone or enter this url: http://ow.ly/rKs6W to request our new 76 page CNC Router Tooling catalog. Or, you can call us at (800) 597-3921 to have it sent to you.

BT30, ER Toolholders

Coolant Set Screws page 41.

Part No.	Description	l1	D	Collet Nut	Set Screw	Wrench
16106-W	BT30 x ER20 - 70 without slots	70mm	34mm	41120	16087	04614
16121	BT30 x ER32 - 60, 41mm flats - Komo	60mm	50mm	46132	16089	04616
16131	BT30 x ER32 - 90 38mm flats - Komo	90mm	50mm	46132	16089	04616

BT30, SYOZ 25 Toolholders

Part No.	Description	l1	D	Collet Nut	Wrench
16001-W	BT30 x SYOZ 25 - 70, 38mm flats	70mm	60mm	83632	03691
16001	BT30 x SYOZ 25 - 70 with nut	70mm	60mm	83632	03691

BT 35, ER32, SYOZ 25 Toolholders for Heian Routers

Part No.	Description	l1	D	Collet Nut	Wrench
16010	BT 35 x SYOZ 25 - 76 with nut	76mm	60mm	83632	03691
161-BT35-ER32 76	BT 35 x ER32 - 76	76mm	50mm	46132	04616

See our product application videos at: www.techniksusa.com

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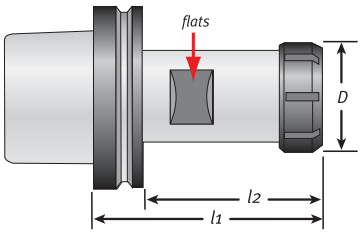
HSK E and HSK F Precision CNC Router Toolholders



Techniks Certified for accuracy and balance

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*



HSK32E, 40E, 50E, 63E Toolholders for HSK E Type Spindle

Coolant Set Screws page 41.

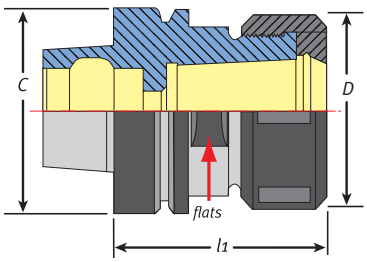
Part No.	Description	l1	l2	D	Nut	Set Screw	Wrench	Flats
31374-60-E	HSK32E x ER25 - 60mm, slotted nut	60mm	27mm	42mm	46125	16089	04615	22mm
31376-E	HSK40E x ER16 - 65mm, slotted nut	65mm	45mm	32mm	46116	16083	04613	24mm
31383-E	HSK40E x ER25 - 75mm, slotted nut	75mm	55mm	42mm	46125	16089	04615	27mm
31386-E	HSK40E x ER32 - 100mm, slotted nut	100mm	80mm	50mm	46132	16089	04616	35mm
31402-E	HSK50E x ER16 - 80mm, slotted nut	80mm	60mm	28mm	46116	16083	04613	27mm
31419-E	HSK50E x ER32 - 85mm, slotted nut	85mm	59mm	50mm	46132	16089	04616	36mm
31456-E	HSK63E x ER32 - 90mm, slotted nut	90mm	64mm	50mm	46132	16089	04616	36mm
31472-E	HSK63E x ER40 - 120mm, slotted nut	120mm	94mm	63mm	46140	16091	04617	46mm
50001	HSK63E x ER40 -75mm, slotted nut	75mm	49mm	63mm	46140	16091	04617	46mm



Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" or better from taper to collet pocket*

PowerCOAT nut is included with each holder
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report



HSK50F, 63F Toolholders for CNC Routers

Part No.	Description	l1	D	Nut	Wrench	Flats
31419-F	HSK50F x ER32 - 80mm, slotted nut	80mm	50mm	46132	04616	36mm
31431-F	HSK63F x ER16 - 60mm, slotted nut	60mm	32mm	46116	04613	26mm
31434-F	HSK63F x ER16 - 100mm, slotted nut	100mm	32mm	46116	04613	26mm
30000	HSK63F x ER32 - 70mm, slotted nut	70mm	50mm	46132	04616	36mm
30001	HSK63F x ER40 - 75mm, slotted nut	75mm	63mm	46140	04617	46mm
30001-L	HSK63F x ER40 - 75mm, left-hand thread	75mm	63mm	46140-L	04617	46mm
30002	HSK63F x ER40 - 90mm, slotted nut	90mm	63mm	46140	04617	46mm
30002-P	HSK63F x ER40 - 90mm, slotted nut w/coolant pipe	90mm	63mm	46140	04617	46mm
30003	HSK63F x ER40 - 115mm, slotted nut	115mm	63mm	46140	04617	46mm
30005	HSK63F x ER40 - 125mm, slotted nut	125mm	63mm	46140	04617	46mm
31025F	HSK63 F x SYOZ 25 - 80mm, slotted nut	80mm	60mm	83632	03691	38mm

Precision ER Mini-Nut and Straight Shank Extensions

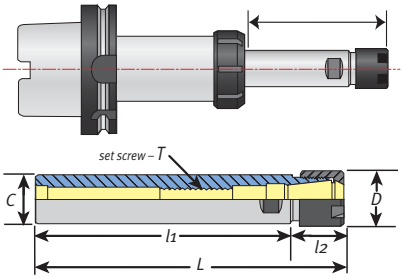


Features

- *Collet pocket T.I.R. 0.0001"*
- *All surfaces precision ground*

Extension length should not exceed a 4 : 1 ratio of length to diameter.

For example, a 1/2" shank should not extend more than 2" in front of the holder.



Mini-Nut ER Straight Shank Extensions

Coolant Set Screws page 41.

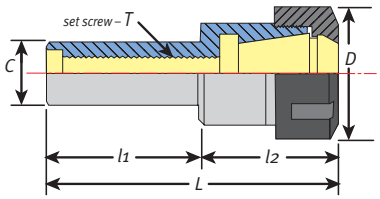
Part No.	Description	C	L	l1	l2	D	Set Screw	Wrench
04889	3/8" x ER8, - 100mm	3/8"	124mm	100mm	24mm	12mm	-	04620
04891	1/2" x ER11, - 140mm	1/2"	166.5mm	140mm	26.5mm	16mm	-	04621
04893	5/8" x ER11, - 140mm	5/8"	158.5mm	140mm	18.5mm	16mm	-	04621
04895	1/2" x ER16, - 140mm	1/2"	177mm	140mm	37mm	22mm	-	04622
04896	3/4" x ER16, - 140mm	3/4"	165mm	140mm	25mm	22mm	16083	04622
04892	1/2" x ER20, - 140mm	1/2"	180mm	140mm	40mm	28mm	16083	04623
04894	3/4" x ER20, - 140mm	3/4"	180mm	140mm	40mm	28mm	16083	04623
04881	20mm x ER20, - 180mm	20mm	220mm	180mm	40mm	28mm	16083	04623
04897	1.0" x ER20, - 140mm	1.0"	168mm	140mm	28mm	28mm	16083	04623
04898	3/4" x ER25, - 100mm	3/4"	149mm	100mm	49mm	35mm	16087	04624
04888	1.0" x ER25, - 140mm	1.0"	190mm	140mm	50mm	35mm	16083	04624



Features

- *Collet pocket T.I.R. 0.0001"*
- *All surfaces precision ground*

For shank sizes 1/8" (3mm) or smaller use our DNA (dead nuts accurate) collets for best results. (pg 48)



ER Straight Shank Extensions

Coolant Set Screws page 41.

Part No.	Description	C	L	l1	l2	D	Set Screw	Wrench
04851	16mm x ER11, - 140mm, hex nut	16mm	174.5mm	140mm	21.6mm	19mm	-	04608
04855	1/2" x ER11, - 140mm, hex nut	1/2"	174.5mm	140mm	21.6mm	19mm	-	04608
04854	5/8" x ER11, - 140mm, hex nut	5/8"	174.5mm	140mm	21.6mm	19mm	-	04608
04832	5/8" x ER16, - 60mm, hex nut	5/8"	95.1mm	60mm	35.1mm	28mm	-	04609
04834	3/4" x ER16, - 50mm, hex nut	3/4"	85.1mm	50mm	35.1mm	28mm	16083	04609
04835	3/4" x ER16, - 100mm, hex nut	3/4"	135.1mm	100mm	35.1mm	28mm	16083	04609
04856	3/4" x ER16, - 140mm, hex nut	3/4"	175.1mm	140mm	35.1mm	28mm	16083	04609
04836-2.5	3/4" x ER20, - 2-1/2", hex nut	3/4"	100mm	2-1/2"	38mm	34mm	16083	04610
04858	1.0" x ER20, - 140mm, hex nut	1.0"	180.5mm	140mm	40.5mm	34mm	16083	04610
04837	1.0" x ER25, - 50mm, slotted nut	1.0"	101mm	50mm	51mm	42mm	16089	04615
04817	20mm x ER32, - 50mm, slotted nut	20mm	97.1mm	50mm	47mm	50mm	16089	04616
04818	20mm x ER32, - 100mm, slotted nut	20mm	146.5mm	100mm	47mm	50mm	16083	04616
04839	1.0" x ER32, - 50mm, slotted nut	1.0"	101.5mm	50mm	51.5mm	50mm	16089	04616
04839-140	1.0" x ER32, - 140mm, slotted nut	1.0"	191.5mm	140mm	51.5mm	50mm	16083	04616
04843	1-1/4" x ER32, - 60mm, slotted nut	1-1/4"	111.5mm	60mm	51.5mm	50mm	16089	04616
04841	1.0" x ER40, - 50mm, slotted nut	1.0"	115mm	50mm	65mm	63mm	16083	04617

Properly torque down the nut for best tool life. See the Torque Chart on page 41.

SYIC

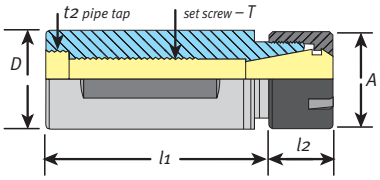
Precision ER Coolant-Thru Shanks and ER Double Ended



No. 04805-C

Features

- *For coolant up to 1,500 PSI*
- *Collet pocket T.I.R. 0.0001"*
- *PowerCOAT coolant nut included*



Use with Black Gold ER coolant rings for coolant-thru 04808C available with 1/8" NPT side entry coolant.
Mini Coolant nuts page 59. Coolant-thru-tool set screws page 41.

Coolant-Thru Straight Shank Extensions

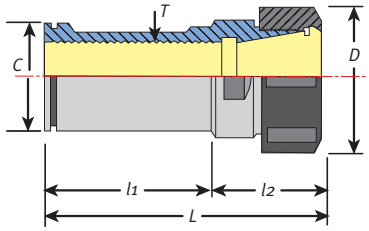
Part No.	Description	l1	l2	D	T	t2	A	Wrench
04802-C	3/4" x ER16, - 2" shank, coolant mini nut	1.65"	.916"	3/4"	m10 x 1.5	1/4" NPT	22mm	04622
04803-C	3/4" x ER16, - 3" shank, coolant mini nut	2.44"	.916"	3/4"	m10 x 1.5	1/4" NPT	22mm	04622
04804-C	3/4" x ER16, - 4" shank, coolant mini nut	3.42"	.916"	3/4"	m10 x 1.5	1/4" NPT	22mm	04622
04805-C	1.0" x ER20, - 3" shank, coolant mini nut	2.01"	1.07"	1.0"	m12 x 1.75	3/8" NPT	1.10"	04623
04806-C	1.0" x ER20, - 4" shank, coolant mini nut	3.31"	1.07"	1.0"	m12 x 1.75	3/8" NPT	1.10"	04623
04808-C	1.25" x ER32, - 2.36" shank, slotted nut	2.36"	2.16"	1-1/4"	m12 x 1.75	3/8" NPT	1.97"	04616



O-ring seals coolant

Features

- *For coolant up to 1,500 PSI*
- *Collet pocket T.I.R. 0.0001"*
- *PowerCOAT nut included*



This ER collet chuck fits CNC lathes and can also be used for tapping applications. It seals coolant from the turret to the shank with an o-ring on the end of the shank. Use black gold coolant rings (page 60) and PowerCOAT coolat nuts for coolant-thru tools, or CoolBLAST coolant for standard tools.

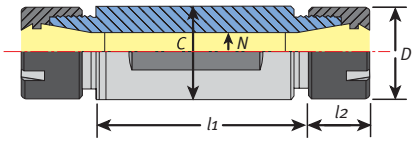
CNC Lathe Coolant-thru Straight Shanks

Part No.	Description	C	l1	L	l2	D	T	Wrench
04782	1-1/4" x ER25, - 60mm shank	1-1/4"	60mm	97mm	37mm	42mm	M18 x 1.5	04615
04784	1-1/4" x ER32, - 60mm shank	1-1/4"	60mm	103mm	43mm	50mm	M22 x 1.5	04616
04788	1-1/2" x ER32, - 80mm shank	1-1/2"	80mm	118mm	38mm	50mm	M22 x 1.5	04616
04786	1-1/4" x ER40, - 60mm shank	1-1/4"	60mm	120mm	60mm	63mm	M28 x 1.5	04617
04790	1-1/2" x ER40, - 75mm shank	1-1/2"	75mm	135mm	60mm	63mm	M28 x 1.5	04617



Features

- *Collet pocket T.I.R. 0.0001"*
- *Wrench flats extend full length of shank*



Double-Ended Straight Shank for CNC Swiss Machines

Part No.	Description	C	D	L1	L2	N	Wrench
04801-DE	3/4" x ER11, - 2.5" shank, double ended mini nut	3/4"	16mm	44mm	12mm	8mm	04621
04802-DE	3/4" x ER11, - 3.35" shank, double ended mini nut	3/4"	16mm	65mm	12mm	8mm	04621
04803-DE	3/4" x ER11, - 4.0" shank, double ended mini nut	3/4"	16mm	77mm	12mm	8mm	04621
04804-DE	3/4" x ER11, - 5.0" shank, double ended mini nut	3/4"	16mm	99.5mm	12mm	8mm	04621

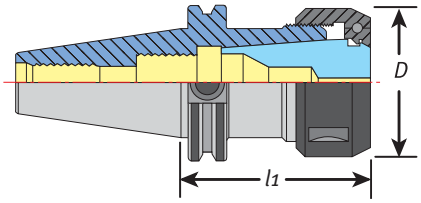
TG75 and TG100 Precision Toolholders



Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured from taper to collet pocket*
- *PowerCOAT nut included for 75% more clamping power*



TG75 and TG100 Precision Toolholders

Coolant Set Screws page 41.

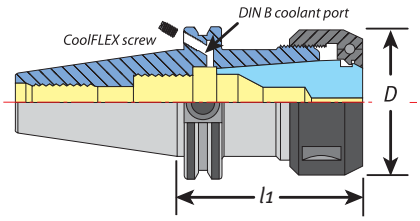
Part No.	Description	l1	D	Collet Range	Set Screw	Wrench
23008	CAT40 x TG75 - 2.75"	2.75"	1.88"	.094 - .750"	16089	04616
23014	CAT40 x TG100 - 3"	3"	2.362"	.094 - 1.0"	16093	03691
23016	CAT40 x TG100 - 4"	4"	2.362"	.094 - 1.0"	16093	03691
23018	CAT40 x TG100 - 6"	6"	2.362"	.094 - 1.0"	16093	03691
23030	CAT50 x TG100 - 3"	3"	2.362"	.094 - 1.0"	16093	03691
23032	CAT50 x TG100 - 4"	4"	2.362"	.094 - 1.0"	16093	03691
23034	CAT50 x TG100 - 6"	6"	2.362"	.094 - 1.0"	16093	03691
23035	CAT50 x TG100 - 8"	8"	2.362"	.094 - 1.0"	16093	03691



PowerCOAT nut is included with each holder
Techniks Certified for accuracy and balance
Each holder comes with a complete lab report

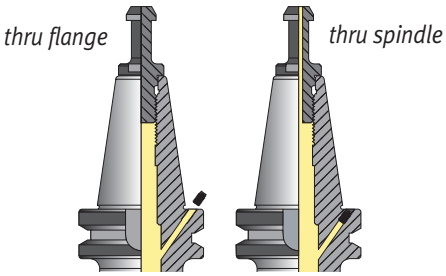
Features

- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" or better from taper to collet pocket*



CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.



Part No.	CoolFLEX Screws
HSA-4-6	40 taper DIN B screw
HSA-6-6	50 taper DIN B screw

TG100 CoolFLEX Coolant -Thru Spindle or Flange (DIN B)

Coolant Set Screws page 41.

Part No.	Description	l1	D	Collet	Collet Range	Set Screw	Wrench
23014F	CAT40 CoolFLEX x TG100 - 3"	3"	2.362"	TG100	.094 - 1.0"	16093	03691
23016F	CAT40 CoolFLEX x TG100 - 4"	4"	2.362"	TG100	.094 - 1.0"	16093	03691
23018F	CAT40 CoolFLEX x TG100 - 6"	6"	2.362"	TG100	.094 - 1.0"	16093	03691
23030F	CAT50 CoolFLEX x TG100 - 3"	3"	2.362"	TG100	.094 - 1.0"	16093	03691

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

Recommended Torque Values & Coolant Set Screws



Always use a torque wrench and tightening stand when tightening collet nuts and retention knobs. Overtightening collet nuts will cause premature damage to collets and increase run-out.


Collets pg. 43


Nuts pg. 58


Coolant Rings pg. 60


Retention Knobs pg. 204


Wrenches pg. 208


Tightening Stands pg. 210

Recommended Collet Nut & Retention Knob Tightening Torque

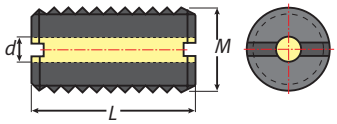
Collet	Nut Type	Collets I.D. OVER 1/16" (2mm)	Collets I.D. UNDER 1/16" (2mm)	Order Torque Wrench Adapter
ER16	slotted	42 ft/lbs	30 ft/lbs	04580-16
ER16	hex	42 ft/lbs	30 ft/lbs	04601-16
ER20	slotted	59 ft/lbs	24 ft/lbs	04580-20
ER20	hex	59 ft/lbs	24 ft/lbs	04602-20
ER25	slotted	77 ft/lbs	77 ft/lbs	04503-25
ER25	mini nut	25 ft/lbs	25 ft/lbs	04587
ER32	slotted	100 ft/lbs	100 ft/lbs	04604-32
ER40	slotted	130 ft/lbs	130 ft/lbs	04605-40
SYOZ 25	hook	90 ft/lbs	90 ft/lbs	03690-25
TG75	slotted	90 ft/lbs	90 ft/lbs	04604-32
TG100	hook	90 ft/lbs	90 ft/lbs	03690-25

Always tighten retention knobs to exact specification or damage to tooling or bodily harm may occur.

Retention Knobs	Wrench Flats	Drive	Torque	Order Socket
BT30 Taper	0.535"	1/4"	36 ft/lbs	PSS-30BT
ISO 30 Taper	0.535"	3/8"	36 ft/lbs	PSS-30ISO
Any 40 Taper	0.750"	3/8"	76 ft/lbs	PSS-40
BT50 Taper	1.187"	1/2"	99 ft/lbs	PSC-50
CAT50 Taper	1.250"	1/2"	99 ft/lbs	PSC-50

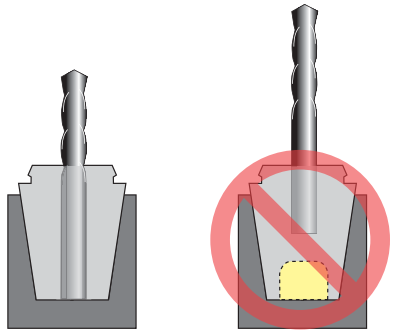


Use coolant set screws for coolant-thru tools or use with Black Gold Rings for CoolBLAST option using standard cutting tools. See page 61 for more information.



Coolant Set Screws

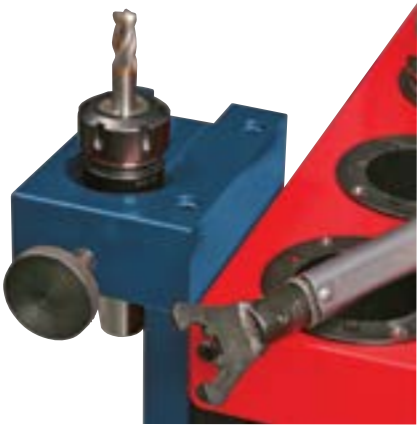
Part No.	Description	M	L	d
16080C-20	Coolant Set Screw	M5 x 0.8P	20mm	2.5
16082C-20	Coolant Set Screw	M8 x 1.25P	20mm	4
16083C-20	Coolant Set Screw	M10 x 1.5P	20mm	4
16085C-20	Coolant Set Screw	M12 x 1.75P	20mm	4
16089C-20	Coolant Set Screw	M16 x 02.0P	20mm	5
16091C-20	Coolant Set Screw	M20 x 2.0P	20mm	5



For maximum holding power fill the collet all the way with the tool shank (left) and use a PowerCOAT nut.

DIRECTIONS

1. *Snap collet into nut.*
2. *Insert cutting tool into collet. Make sure shank extends to the bottom of the collet.*
3. *Hand tighten collet nut assembly into toolholder.*
4. *Insert toolholder assembly into tightening fixture and secure it.*
5. *Tighten collet nut to recommended torque using a torque wrench and adapter.*



Tightening fixtures page 210.

Measurement Guide for Special Order Toolholders

V-flange CNC machine make, model and spindle

Fill in all the required dimensions (left). Then, fax or phone in your order for a fast quote.

v-flange tool #1 dimensions

D = _____

F = _____

W =

A = _____

N = _____

v-flange tool #2 dimensions

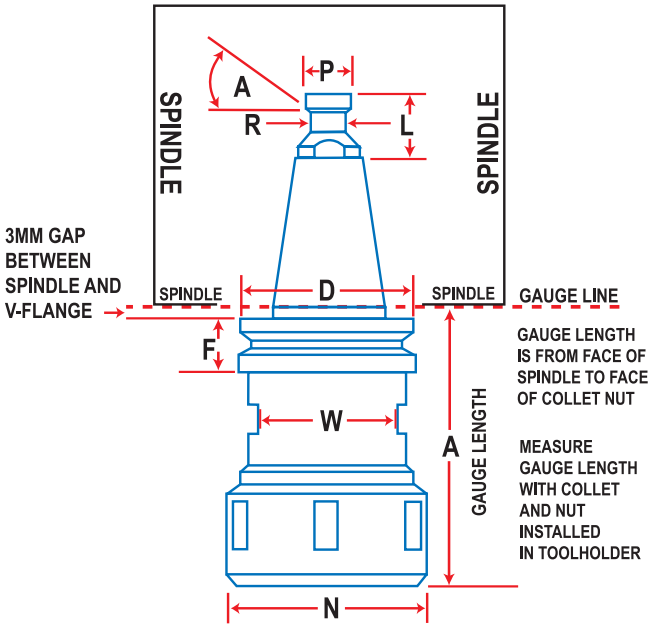
D =

F =

W =

A = _____

N = _____



HSK CNC machine make, model and spindle

HSK tool #1 dimensions

D = _____

F = _____

W =

A = _____

N = _____

HSK tool #2 dimensions

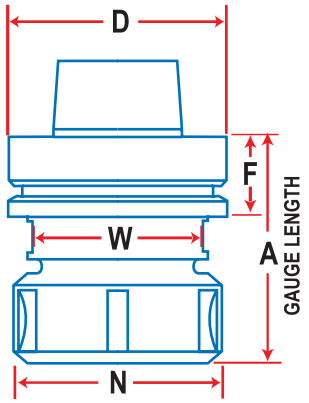
D = _____

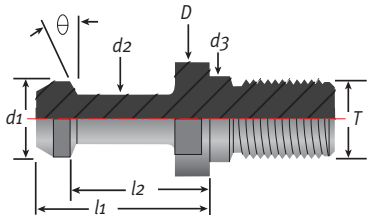
F = _____

W =

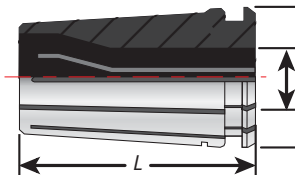
A = _____

N = _____





For special order retention knobs see page 207 or call (800) 597-3921



For special order collets see page 68 or call (800) 597-3921

Properly torque down the nut for best tool life. See the Torque Chart on page 41.

SYIC

Precision ER Collets, PowerCOAT Nuts, Other Collets

Full Line of ER Collets

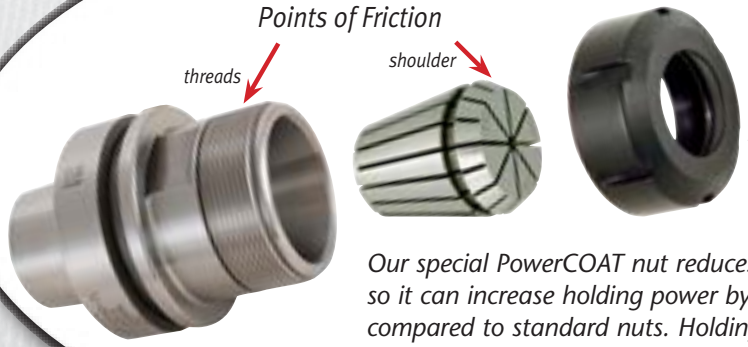
Made from high-carbon bearing steel and heat treated for improved flexibility and longer life.



ER Inch Sizes | *Sealed Coolant* | *Steel Sealed Coolant* | *ER Metric Sizes* | *Quick-Change Tap Collet* | *Floating Tap Collet* | *Rigid Tap Collet*

PowerCOAT Nut

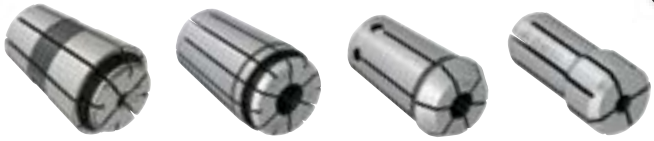
Points of Friction



Balanced up to to 70,000 RPMs

Our special PowerCOAT nut reduces friction so it can increase holding power by 75% compared to standard nuts. Holding power increases cutting tool life.

Other Collet Styles



DNA Dead Nuts Accurate ER | *TG75, TG100, TG150* | *SYOZ / EOC Perske* | *DA Double Angle*

http://ow.ly/rlisq
View the video.

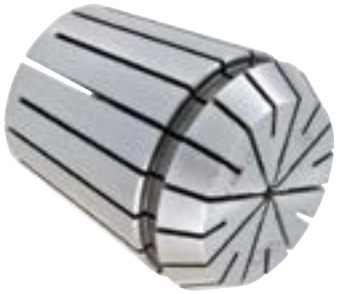
TECHNIKS
BUILT FOR SPEED
www.techniksusa.com
a Quintec Company

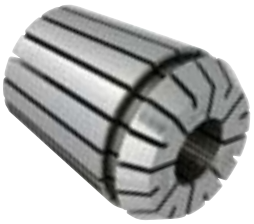
You lose 10% of tool life for every .0001" of T.I.R. The holding power and accuracy of Techniks collets and PowerCOAT nuts extend cutting tool life.

Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!

Inch Size Precision ER Collets and Collet Sets





Inch Size ER Collet Features

- *Average .0002" T.I.R.*
- *Clamping range: .039"*
- *Use with PowerCOAT nut (pg. 58) for best holding power and cutting tool life.*

Compatible with DR, RD, ESX, AR, & BR series collets.

Ultra Precision Collets

- *.0002" T.I.R. or better*
- *To order put "UP" in front of the part number*





Nuts
pg. 58



Coolant Rings
pg. 60



Retention Knobs
pg. 204



Wrenches
pg. 208

ER8 Inch Size Collets

Part No.	Inch Range	Shank
04208-1/16	.043 – .062"	1/16"
04208-1/8	.086 – .125"	1/8"
04208-3/16	.148 – .187"	3/16"

ER Inch Size Collet Sets

Part No.	Size	Pieces	Collets Included	Fits Shank Sizes
04208IS	ER11	7	1/16 – 1/4" by 32nds	1/32 - 1/4"
04209IS	ER16	10	3/32 – 3/8" by 32nds	1/16 - 3/8"
04210IS	ER20	12	5/32 – 1/2" by 32nds	1/8 - 1/2"
04211IS	ER25	16	5/32 – 5/8" by 32nds	1/8 - 5/8"
04212IS	ER32	18	7/32 – 3/4" by 32nds	3/16 - 3/4"
04213IS	ER40	13	1/8 – 1.0" by 16ths	1/8 - 1.0"

ER11 Inch Size Collets

Part No.	Inch Range	Shank
04211-1/16	.043 – .062"	1/16"
04211-3/32	.054 – .093"	3/32"
04211-1/8	.086 – .125"	1/8"
04211-5/32	.117 – .156"	5/32"
04211-3/16	.148 – .187"	3/16"
04211-7/32	.179 – .218"	7/32"
04211-1/4	.211 – .250"	1/4"
04211-9/32	.242 – .281"	9/32"

ER16 Inch Size Collets

Part No.	Inch Range	Shank
04216-1/16	.043 – .062"	1/16"
04216-3/32	.054 – .093"	3/32"
04216-1/8	.086 – .125"	1/8"
04216-5/32	.117 – .156"	5/32"
04216-3/16	.148 – .187"	3/16"
04216-7/32	.179 – .218"	7/32"
04216-1/4	.211 – .250"	1/4"
04216-9/32	.242 – .281"	9/32"
04216-5/16	.273 – .312"	5/16"
04216-11/32	.304 – .343"	11/32"
04216-3/8	.336 – .375"	3/8"
04216-13/32	.367 – .406"	13/32"

ER20 Inch Size Collets

Part No.	Inch Range	Shank
04220-1/16	.043 – .062"	1/16"
04220-3/32	.054 – .093"	3/32"
04220-1/8	.086 – .125"	1/8"
04220-5/32	.117 – .156"	5/32"
04220-3/16	.148 – .187"	3/16"
04220-7/32	.179 – .218"	7/32"
04220-1/4	.211 – .250"	1/4"
04220-9/32	.242 – .281"	9/32"
04220-5/16	.273 – .312"	5/16"
04220-11/32	.304 – .343"	11/32"
04220-3/8	.336 – .375"	3/8"
04220-13/32	.367 – .406"	13/32"
04220-7/16	.398 – .437"	7/16"
04220-15/32	.429 – .468"	15/32"
04220-1/2	.461 – .500"	1/2"

Distributors - Call to register for our Distributors Webstore for full online access.

SYIC

Inch Size Precision ER Collets

ER25 Inch Size Collets

Part No.	Inch Range	Shank
04225-3/32	.054 – .093"	3/32"
04225-1/8	.086 – .125"	1/8"
04225-5/32	.117 – .156"	5/32"
04225-3/16	.148 – .187"	3/16"
04225-7/32	.179 – .218"	7/32"
04225-1/4	.211 – .250"	1/4"
04225-9/32	.242 – .281"	9/32"
04225-5/16	.273 – .312"	5/16"
04225-11/32	.304 – .343"	11/32"
04225-3/8	.336 – .375"	3/8"
04225-13/32	.367 – .406"	13/32"
04225-7/16	.398 – .437"	7/16"
04225-15/32	.429 – .468"	15/32"
04225-1/2	.461 – .500"	1/2"
04225-17/32	.492 – .531"	17/32"
04225-9/16	.523 – .562"	9/16"
04225-19/32	.554 – .593"	19/32"
04225-5/8	.586 – .625"	5/8"
04225-3/4	.711 – .750"	3/4"

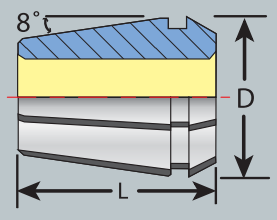
ER32 Inch Size Collets

Part No.	Inch Range	Shank
04232-1/16	.043 – .062"	1/16"
04232-3/32	.054 – .093"	3/32"
04232-1/8	.086 – .125"	1/8"
04232-5/32	.117 – .156"	5/32"
04232-3/16	.148 – .187"	3/16"
04232-7/32	.179 – .218"	7/32"
04232-1/4	.211 – .250"	1/4"
04232-9/32	.242 – .281"	9/32"
04232-5/16	.273 – .312"	5/16"
04232-11/32	.304 – .343"	11/32"
04232-3/8	.336 – .375"	3/8"
04232-13/32	.367 – .406"	13/32"
04232-7/16	.398 – .437"	7/16"
04232-15/32	.429 – .468"	15/32"
04232-1/2	.461 – .500"	1/2"
04232-17/32	.492 – .531"	17/32"
04232-9/16	.523 – .562"	9/16"
04232-19/32	.554 – .593"	19/32"
04232-5/8	.586 – .625"	5/8"
04232-21/32	.617 – .656"	21/32"
04232-11/16	.648 – .687"	11/16"
04232-23/32	.679 – .718"	23/32"
04232-3/4	.711 – .750"	3/4"

ER40 Inch Size Collets

Part No.	Inch Range	Shank
04240-1/8	.086 – .125"	1/8"
04240-5/32	.117 – .156"	5/32"
04240-3/16	.148 – .187"	3/16"
04240-7/32	.179 – .218"	7/32"
04240-1/4	.211 – .250"	1/4"
04240-9/32	.242 – .281"	9/32"
04240-5/16	.273 – .312"	5/16"
04240-11/32	.304 – .343"	11/32"
04240-3/8	.336 – .375"	3/8"
04240-13/32	.367 – .406"	13/32"
04240-7/16	.398 – .437"	7/16"
04240-15/32	.429 – .468"	15/32"
04240-1/2	.461 – .500"	1/2"
04240-17/32	.492 – .531"	17/32"
04240-9/16	.523 – .562"	9/16"
04240-19/32	.554 – .593"	19/32"
04240-5/8	.586 – .625"	5/8"
04240-21/32	.617 – .656"	21/32"
04240-11/16	.648 – .687"	11/16"
04240-23/32	.679 – .718"	23/32"
04240-3/4	.711 – .750"	3/4"
04240-25/32	.742 – .781"	25/32"
04240-13/16	.773 – .812"	13/16"
04240-27/32	.807 – .843"	27/32"
04240-7/8	.836 – .875"	7/8"
04240-29/32	.867 – .906"	29/32"
04240-15/16	898 – .937"	15/16"
04240-31/32	.929 – .968"	31/32"
04240-1	.961 – 1.00"	1.0"

Use the table (below) for selecting your replacement collets. ER collets all have unique length and diameter measurements.

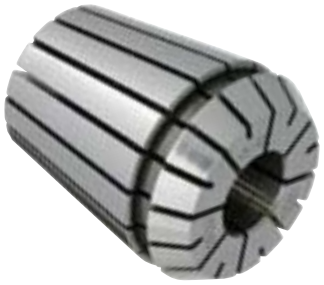


ER Size	L	D
ER8	13mm (.51")	8.5mm (.33")
ER11	18mm (.708")	11.5mm (.45")
ER16	27.5mm (1.08")	17mm (.67")
ER20	31.5mm (1.24")	21mm (.83")
ER25	34mm (1.34")	26mm (1.02")
ER32	40mm (1.57")	33mm (1.3")
ER40	46mm (1.81")	41mm (1.61")
ER50	60 mm (2.36")	52mm (2.05")

ER50 Inch Size Collets

Part No.	Inch Range	Shank
04250-1/2	.461 – .500"	1/2"
04250-5/8	.586 – .625"	5/8"
04250-3/4	.711 – .750"	3/4"
04250-7/8	.836 – .875"	7/8"
04250-1	.961 – 1.00"	1.0"
04250-1-1/4	1.211 – 1.250	1-1/4"

Metric Size Precision ER Collets and Collet Sets



Compatible with DR, RD, ESX, AR, & BR series collets.

To Order Ultra Precision Collets

Hand-selected Ultra Precision collets are guaranteed .0002" T.I.R. or better. Just place "UP" in front of the regular part number when ordering.



Metric ER Precision Collet Features

- *Average .0002" T.I.R.*
- *Clamping range: .039"*
- *Use with PowerCOAT nut (pg. 58) for best holding power and cutting tool life.*

ER Metric Collet Sets

Part No.	Size	Pieces	Collets Included	Fits Shank Sizes
04200MS	ER8	9	1 - 5mm by 0.5mm	.5 – 5mm
04201MS	ER11	13	1 - 7mm by 0.5mm	.5 – 7mm
04202MS	ER16	10	1 - 10mm by 1mm	.5 – 10mm
04203MS	ER20	12	2 - 13mm by 1mm	1.0 – 13mm
04204MS	ER25	15	2 - 16mm by 1mm	1.0 – 16mm
04205MS	ER32	18	3 - 20mm by 1mm	2 – 20mm
04206MS	ER40	23	4 - 26mm by 1mm	3 – 26mm
04207MS	ER50	17	6 - 34mm by 2 mm	5 – 34mm

ER8 Precision Metric Collets

Part No.	Inch Range	Shank
04208-01.0	.019 – .039"	0.5 – 1.0
04208-01.5	.039 – .059"	1.0 – 1.5
04208-02.0	.059 – .079"	1.5 – 2.0
04208-02.5	.079 – .098"	2.0 – 2.5
04208-03.0	.098 – .118"	2.5 – 3.0
04208-03.5	.118 – .138"	3.0 – 3.5
04208-04.0	.138 – .157"	3.5 – 4.0
04208-04.5	.157 – .177"	4.0 – 4.5
04208-05.0	.177 – .197"	4.5 – 5.0

ER11 Precision Metric Collets

Part No.	Inch Range	Shank
04211-01.0	.019 – .039"	0.5 – 1.0
04211-01.5	.039 – .059"	1.0 – 1.5
04211-02.0	.059 – .079"	1.5 – 2.0
04211-02.5	.079 – .098"	2.0 – 2.5
04211-03.0	.098 – .118"	2.5 – 3.0
04211-03.5	.118 – .138"	3.0 – 3.5
04211-04.0	.138 – .157"	3.5 – 4.0
04211-04.5	.157 – .177"	4.0 – 4.5
04211-05.0	.177 – .197"	4.5 – 5.0
04211-05.5	.197 – .217"	5.0 – 5.5
04211-06.0	.217 – .236"	5.5 – 6.0
04211-06.5	.236 – .256"	6.0 – 6.5
04211-07.0	.256 – .276"	6.5 – 7.0

ER16 Precision Metric Collets

Part No.	Inch Range	Shank
04216-01	.019 – .039"	0.5–1
04216-01.5	.039 – .059"	1.0–1.5
04216-02	.039 – .079"	1.5–2
04216-02.5	.059 – .098"	1.5–2.5
04216-03	.079 – .118"	2–3
04216-03.5	.098 – .137"	2.5–3.5
04216-04	.118 – .157"	3–4
04216-04.5	.137 – .177"	3.5–4.5
04216-05	.157 – .197"	4–5
04216-05.5	.177 – .216"	4.5–5.5
04216-06	.197 – .236"	5–6
04216-06.5	.216 – .255"	5.5–6.5
04216-07	.236 – .276"	6–7
04216-07.5	.255 – .295"	6.5–7.5
04216-08	.276 – .315"	7–8
04216-08.5	.295 – .334"	7.5–8.5
04216-09	.315 – .354"	8–9
04216-09.5	.334 – .374"	8.5–9.5
04216-10	.354 – .394"	9–10
04216-10.5	.374 – .413"	9.5–10.5

ER20 Precision Metric Collets

Part No.	Inch Range	Shank
04220-01	.019 – .039"	0.5–1
04220-01.5	.039 – .059"	1.0–1.5
04220-02	.039 – .079"	1.5–2
04220-02.5	.059 – .098"	1.5–2.5
04220-03	.079 – .118"	2–3
04220-03.5	.098 – .137"	2.5–3.5
04220-04	.118 – .157"	3–4
04220-04.5	.137 – .177"	3.5–4.5
04220-05	.157 – .197"	4–5
04220-05.5	.177 – .216"	4.5–5.5
04220-06	.197 – .236"	5–6
04220-06.5	.216 – .255"	5.5–6.5
04220-07	.236 – .276"	6–7
04220-07.5	.255 – .295"	6.5–7.5
04220-08	.276 – .315"	7–8
04220-08.5	.295 – .334"	7.5–8.5
04220-09	.315 – .354"	8–9
04220-09.5	.334 – .374"	8.5–9.5
04220-10	.354 – .394"	9–10
04220-10.5	.374 – .413"	9.5–10.5
04220-11	.394 – .433"	10–11
04220-11.5	.413 – .452"	10.5–11.5
04220-12	.433 – .472"	11–12
04220-12.5	.452" – .492"	11.5–12.5
04220-13	.472 – .512"	12–13
04220-13.5	.492 – .531"	12.5–13.5
04220-14	.512 – .551"	13–14

Refer to the Torque Chart on page 41 for tightening specifications.

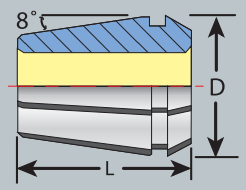
SYIC

Metric Size Precision ER Collets

ER25 Precision Metric Collets

Part No.	Inch Range	Shank mm
04225-02	.039 – .079"	1.5–2
04225-02.5	.059 – .098"	2–2.5
04225-03	.079 – .118"	2–3
04225-03.5	.098 – .137"	2.5–3.5
04225-04	.118 – .157"	3–4
04225-05	.157 – .197"	4–5
04225-06	.197 – .236"	5–6
04225-07	.236 – .276"	6–7
04225-08	.276 – .315"	7–8
04225-09	.315 – .354"	8–9
04225-10	.354 – .394"	9–10
04225-11	.394 – .433"	10–11
04225-12	.433 – .472"	11–12
04225-13	.472 – .512"	12–13
04225-14	.512 – .551"	13–14
04225-15	.551 – .591"	14–15
04225-16	.591 – .630"	15–16
04225-17	.630 – .669"	16–17

Use the table (below) for selecting your replacement collets. ER collets all have unique length and diameter measurements.



Size	L	D
ER8	13mm (.51")	8.5mm (.33")
ER11	18mm (.708")	11.5mm (.45")
ER16	27.5mm (1.08")	17mm (0.67")
ER20	31.5mm (1.24")	21mm (0.83")
ER25	34mm (1.34")	26mm (1.02")
ER32	40mm (1.57")	33mm (1.3")
ER40	46mm (1.81")	41mm (1.61")
ER50	60mm (2.36")	52mm (2.05")

ER32 Precision Metric Collets

Part No.	Inch Range	Shank mm
04232-03	.079 – .118"	2–3
04232-03.5	.098 – .137"	2.5–3.5
04232-04	.118 – .157"	3–4
04232-04.5	.137 – .177"	3.5–4.5
04232-05	.157 – .197"	4–5
04232-05.5	.177 – .216"	4.5–5.5
04232-06	.197 – .236"	5–6
04232-06.5	.216 – .255"	5.5–6.5
04232-07	.236 – .276"	6–7
04232-07.5	.255 – .295"	6.5–7.5
04232-08	.276 – .315"	7–8
04232-08.5	.295 – .334"	7.5–8.5
04232-09	.315 – .354"	8–9
04232-09.5	.334 – .374"	8.5–9.5
04232-10	.354 – .394"	9–10
04232-10.5	.374 – .413"	9.5–10.5
04232-11	.394 – .433"	10–11
04232-11.5	.413 – .452"	10.5–11.5
04232-12	.433 – .472"	11–12
04232-12.5	.452 – .492"	11.5–12.5
04232-13	.472 – .512"	12–13
04232-13.5	.492 – .531"	12.5–13.5
04232-14	.512 – .551"	13–14
04232-14.5	.531 – .570"	13.5–14.5
04232-15	.551 – .591"	14–15
04232-15.5	.570 – .610"	14.5–15.5
04232-16	.591 – .630"	15–16
04232-16.5	.610" – .649"	15.5–16.5
04232-17	.630 – .669"	16–17
04232-17.5	.649 – .688"	16.5–17.5
04232-18	.669 – .709"	17–18
04232-18.5	.688 – .728"	17.5–18.5
04232-19	.709 – .748"	18–19
04232-19.5	.728 – .767"	18.5–19.5
04232-20	.748 – .787"	19–20
04232-21	.787 – .827"	20–21

ER40 Precision Metric Collets

Part No.	Inch Range	Shank mm
04240-04	.118 – .157"	3–4
04240-05	.157 – .197"	4–5
04240-06	.197 – .236"	5–6
04240-07	.236 – .276"	6–7
04240-08	.276 – .315"	7–8
04240-09	.315 – .354"	8–9
04240-10	.354 – .394"	9–10
04240-11	.394 – .433"	10–11
04240-12	.433 – .472"	11–12
04240-13	.472 – .512"	12–13
04240-14	.512 – .551"	13–14
04240-15	.551 – .591"	14–15
04240-16	.591 – .630"	15–16
04240-17	.630 – .669"	16–17
04240-18	.669 – .709"	17–18
04240-19	.709 – .748"	18–19
04240-20	.748 – .787"	19–20
04240-21	.787 – .827"	20–21
04240-22	.827 – .866"	21–22
04240-23	.866 – .906"	22–23
04240-24	.906 – .945"	23–24
04240-25	.945 – .984"	24–25
04240-26	.984 – 1.024"	25–26

ER50 Precision Metric Collets

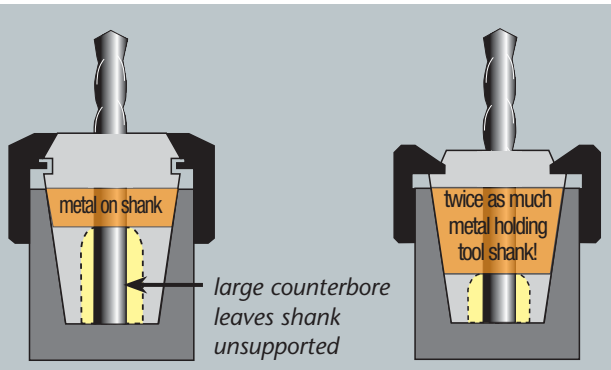
Part No.	Inch Range	Shank mm
04250-06	.197 – .236"	5–6
04250-07	.236 – .276"	6–7
04250-08	.276 – .315"	7–8
04250-09	.315 – .354"	8–9
04250-10	.354 – .394"	9–10
04250-12	.394 – .472"	10–12
04250-14	.472 – .551"	12–14
04250-16	.551 – .630"	14–16
04250-18	.630 – .709"	16–18
04250-20	.709 – .787"	18–20
04250-22	.787 – .866"	20–22
04250-24	.866 – .945"	22–24
04250-26	.945 – 1.024"	24–26
04250-28	1.024 – 1.102"	26–28
04250-30	1.102 – 1.181	28–30
04250-32	1.181 – 1.259"	30–32
04250-34	1.259 – 1.338"	32–34

DNA – Dead Nuts Accurate Collets (For Small Size Tools)

DNA Collets Features

- *.0002" T.I.R. extends cutting tool life!*
- *Best collet for tools 1/8" (6mm) and smaller*
- *More rigid and more accurate than ER, but works with your ER holders*





DNA collets hold small tools with greater rigidity and more accuracy (T.I.R.) for greatly improved tool life.

DNA 11 Dead Nuts Accurate Collets

Part No.	Shank Size inch/mm	Range inch /mm
05952-02	5/64" / 1.5 - 2mm	.059"- .079" / .5mm
05952-03	7/64" / 2.5- 3mm	.098" - .118" / .5mm
05952-03.5	1/8" / 3 - 3.5mm	.118" - .138" / .5mm
05952-04	5/32" / 3.5 - 4mm	.138" - .157" / .5mm
05952-05	3/16" / 4.5 - 5mm	.177" - .197" / .5mm
05952-06	15/64" / 5.5 - 6mm	.216" - .236" / .5mm
05952-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05952-3/16	exact size collet: 3/16"	.167" - .187" / .5mm
05952-1/4	exact size collet: 1/4"	.230" - .250" / .5mm
2011.0000	DNA 11 nut M14 x .75"	
04608	DNA 11 collet wrench	
DNA11TWA	DNA 11 torque wrench adapter	

DNA 16 Dead Nuts Accurate Collets

Part No.	Shank Size inch/mm	Range inch/mm
05954-0.3	.2 - .3mm	.007" - .011" / .10mm
05954-0.4	1/64" / .3 - .4mm	.011" - .015" / .10mm
05954-0.5	.4 - .5mm	.015" -.019" / .10mm
05954-0.6	.5 - .6mm	.019" - .023" / .10mm
05954-0.8	1/32" / .7 - .8mm	.027" - .031" / .10mm
05954-1.0	.9 - 1.0mm	.035" - .039" / .10mm
05954-1.2	3/64" / 1.1 - 1.2mm	.043" - .047" / .10mm
05954-1.25	1.0 - 1.25mm	.039" - .049" / .25mm
05954-1.5	1.25 - 1.5mm	.049" - .059" / .25mm
05954-1.75	1/16" / 1.5 - 1.75mm	.059" - .068" / .25mm
05954-02	5/64" / 1.75 - 2mm	.068" - .078" / .25mm
05954-2.25	2 - 2.25mm	.078" - .088" / .25mm
05954-2.5	3/32" / 2.25 - 2.5mm	.088" - .098" / .25mm
05954-03	2.5 - 3mm	.098" - .118" / .5mm
05954-3.5	1/8" / 3 - 3.5mm	.118" -.138" / .5mm
05954-04	5/32" / 3.5 - 4mm	.137" - .157" / .5mm
05954-4.5	4 - 4.5mm	.157" - .177" / .5mm
05954-05	3/16" / 4 - 5mm	.157" - .197" / .25mm
05954-06	7/32" / 5 - 6mm	.196" - .236" / 1.0mm
05954-07	1/4" / 6 - 7mm	.236" - .275" / 1.0mm
05954-08	5/16" / 7 - 8mm	.275" - .314" / 1.0mm
05954-09	11/32" / 8 - 9mm	.314" - .354" / 1.0mm
05954-10	3/8" / 9 - 10mm	.354" - .392" / 1.0mm
05954-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05954-3/16	exact size collet: 3/16"	.147" - .187" / 1.0mm
05954-1/4	exact size collet: 1/4"	.210" - .25" / 1.0mm
05954-3/8	exact size collet: 3/8"	.335 - .375" / 1.0mm

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For Best Results Use DNA Collets & Nuts



DNA 16 Nut

Coolant Nut for 1/8" and 3mm

DNA Sealed Nut



Coolant Rings pg. 60



Retention Knobs pg. 204



Wrenches pg. 208

DNA nuts feature PowerCOAT for 75% more holding power and best tool life.

DNA 16 Nuts, Sealed Nuts, Wrenches and TWAs

Part No.	Description
2016-2000	DNA16 Mini Nut - M19 x 1.0" x O.D. 25mm
27116	M22 x 1.5 nut, , O.D. 27mm
27216	M22 x 1.5 nut* 1/8" o-ring
27116-30	3.0 - 2.5mm sealed nut, O.D. 27mm
27116-40	4.0 - 3.5mm sealed nut, O.D. 27mm
27116-45	4.5 - 4.0mm sealed nut, O.D. 27mm
27116-50	5.0 - 4.5mm sealed nut, O.D. 27mm
27116-55	5.5 - 5mm sealed nut, O.D. 27mm
27116-60	6.0 - 5.5mm sealed nut, O.D. 27mm
27116-65	6.5 - 6mm sealed nut, O.D. 27mm
DNA16W	DNA 16 collet wrench
DNA16TWA	DNA 16 torque wrench adapter
894-22	DNA 16 mini nut wrench

DNA 20 Dead Nuts Accurate Collets

Part No.	Shank Size inch/mm	Range inch/mm
05956-03	2.5 - 3mm	.098" - .118" / .5mm
05956-3.5	1/8" / 3 - 3.5mm	.118" - .138" / .5mm
05956-04	5/32" / 3.5 - 4mm	.137" - .157" / .5mm
05956-05	3/16" / 4 - 5mm	.157" - .197" / 1.0mm
05956-06	7/32" 5 - 6mm	.197" - .236" / 1.0mm
05956-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05956-3/16	exact size collet: 3/16"	.147" - .187" / 1.0mm
05956-1/4	exact size collet: 1/4"	.210" - .250" / 1.0mm
05956-3/8	exact size collet: 3/8"	.335" - .375" / 1.0mm
2020.0000	DNA 20 nut, M25 x 1.5" x O.D. 32mm	
2020.0000C	DNA 20 coolant nut, uses ER20 rings on page 60	
DNA20W	DNA 20 collet wrench	
DNA20TWA	DNA 20 torque wrench adapter	

DNA 32 Dead Nuts Accurate Collets

Part No.	Shank Size inch/mm	Range inch/mm
05958-03	2.5 - 3mm	.098" - .118" / .5mm
05958-3.5	1/8" / 3 - 3.5mm	.118" - .138" / .5mm
05958-04	5/32" / 3.5 - 4mm	.137" - .157" / .5mm
05958-05	3/16" / 4 - 5mm	.157" - .197" / 1.0mm
05958-06	7/32" 5 - 6mm	.197" - .236" / 1.0mm
05958-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05958-3/16	exact size collet: 3/16"	.147" - .187" / 1.0mm
05958-1/4	exact size collet: 1/4"	.210" - .250" / 1.0mm
05958-3/8	exact size collet: 3/8"	.335" - .375" / 1.0mm
05958-1/2	exact size collet: 1/2"	.5"
05958-3/4	exact size collet: 3/4"	.75"
05958-13	exact size collet: 13mm	13mm
05958-20	exact size collet: 20m	20 mm
1132.0000	DNA 32 nut, M40 x 1.5" x O.D. 47.5mm	
1132.0000C	DNA 32 coolant nut, uses ER25 rings on page 60	
DNA32W	DNA 32 collet wrench	
DNA32TWA	DNA 32 torque wrench adapter	

Steel Sealed Precision ER Coolant Collets – Inch Size



Features

- *Sealed to 2000 PSI*
- *No plugs to fail*
- *Protects toolholder from contaminants*
- *Use with ER PowerCOAT nuts (page 58)*

Designed for use with on-size tools.

Use with ER, RD, DR, ESX or BR collet chucks.





Nuts
pg. 58



Coolant Rings
pg. 60



Retention Knobs
pg. 204



Wrenches
pg. 208

ER Inch Size Collet Sets

Part No.	Size	Pcs.	Fits Shank Sizes
04543IS	ER16	10	3/32 - 3/8"
04544IS	ER20	12	5/32 - 1/2"
04545IS	ER25	14	7/32 - 5/8"
04546IS	ER32	18	7/32 - 3/4"
04547IS	ER40	15	3/8 - 1.0"

ER16 Inch Size

Part No.	Shank
04543-3/32	3/32"
04543-1/8	1/8"
04543-5/32	5/32"
04543-3/16	3/16"
04543-7/32	7/32"
04543-1/4	1/4"
04543-9/32	9/32"
04543-5/16	5/16"
04543-11/32	11/32"
04543-3/8	3/8"
04543-13/32	13/32"

ER20 Inch Size

Part No.	Shank
04544-1/8	1/8"
04544-5/32	5/32"
04544-3/16	3/16"
04544-7/32	7/32"
04544-1/4	1/4"
04544-9/32	9/32"
04544-5/16	5/16"
04544-11/32	11/32"
04544-3/8	3/8"
04544-13/32	13/32"
04544-7/16	7/16"
04544-15/32	15/32"
04544-1/2	1/2"

ER25 Inch Size

Part No.	Shank
04545-7/32	7/32"
04545-1/4	1/4"
04545-9/32	9/32"
04545-5/16	5/16"
04545-11/32	11/32"
04545-3/8	3/8"
04545-13/32	13/32"
04545-7/16	7/16"
04545-15/32	15/32"
04545-1/2	1/2"
04545-17/32	17/32"
04545-9/16	9/16"
04545-19/32	19/32"
04545-5/8	5/8"

ER32 Inch Size

Part No.	Shank
04546-7/32	7/32"
04546-1/4	1/4"
04546-9/32	9/32"
04546-5/16	5/16"
04546-11/32	11/32"
04546-3/8	3/8"
04546-13/32	13/32"
04546-7/16	7/16"
04546-15/32	15/32"
04546-1/2	1/2"
04546-17/32	17/32"
04546-9/16	9/16"
04546-19/32	19/32"
04546-5/8	5/8"
04546-21/32	21/32"
04546-11/16	11/16"
04546-23/32	23/32"
04546-3/4	3/4"

ER40 Inch Size

Part No.	Shank
04547-3/8	3/8"
04547-13/32	13/32"
04547-7/16	7/16"
04547-15/32	15/32"
04547-1/2	1/2"
04547-17/32	17/32"
04547-9/16	9/16"
04547-19/32	19/32"
04547-5/8	5/8"
04547-21/32	21/32"
04547-11/16	11/16"
04547-23/32	23/32"
04547-3/4	3/4"
04547-7/8	7/8"
04547-1	1.0"

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Steel Sealed Precision ER Coolant Collets – Metric



Features

- *Sealed to 2000 PSI*
- *No plugs*
- *Protects toolholder from contaminants*
- *Use with ER PowerCOAT nuts (page 58)*

Designed for use with on-size tools.

Use with ER, RD, DR, ESX or BR collet chucks.



ER Metric Size Collet Sets

Part No.	Size	Pcs.	Fits Shank Sizes
04543MS	ER16	8	3 - 10mm
04544MS	ER20	11	3 - 13mm
04545MS	ER25	14	3 - 16mm
04546MS	ER32	18	3 - 20mm
04547MS	ER40	14	6 - 25mm

ER16 Metric Size

Part No.	Shank
04543-03	3mm
04543-04	4mm
04543-05	5mm
04543-06	6mm
04543-07	7mm
04543-08	8mm
04543-09	9mm
04543-10	10mm

ER20 Metric Size

Part No.	Shank
04544-03	3mm
04544-04	4mm
04544-05	5mm
04544-06	6mm
04544-07	7mm
04544-08	8mm
04544-09	9mm
04544-10	10mm
04544-11	11mm
04544-12	12mm
04544-13	13mm

ER25 Metric Size

Part No.	Shank
04545-03	3mm
04545-04	4mm
04545-05	5mm
04545-06	6mm
04545-07	7mm
04545-08	8mm
04545-09	9mm
04545-10	10mm
04545-11	11mm
04545-12	12mm
04545-13	13mm
04545-14	14mm
04545-15	15mm
04545-16	16mm

ER32 Metric Size

Part No.	Shank
04546-03	3mm
04546-04	4mm
04546-05	5mm
04546-06	6mm
04546-07	7mm
04546-08	8mm
04546-09	9mm
04546-10	10mm
04546-11	11mm
04546-12	12mm
04546-13	13mm
04546-14	14mm
04546-15	15mm
04546-16	16mm
04546-17	17mm
04546-18	18mm
04546-19	19mm
04546-20	20mm

ER40 Metric Size

Part No.	Shank
04547-06	6mm
04547-07	7mm
04547-08	8mm
04547-09	9mm
04547-10	10mm
04547-11	11mm
04547-12	12mm
04547-13	13mm
04547-14	14mm
04547-15	15mm
04547-16	16mm
04547-17	17mm
04547-18	18mm
04547-19	19mm
04547-20	20mm
04547-25	25mm

Precision ER Sealed Metric Coolant Collets



Features

- *For coolant up to 750 PSI*
- *Use with ER PowerCOAT nuts (page 58)*
- *Collapse range: 0.5mm*

Use with ER, RD, DR, ESX or BR collet chucks.

NOTE: Inch sizes are available for ER16 & ER20.

ER16 Sealed Collets

Part No.	Shank
08316-03.0	3mm
08316-03.5	3.5mm
08316-04.0	4mm
08316-04.5	4.5mm
08316-05.0	5mm
08316-05.5	5.5mm
08316-06.0	6mm
08316-1/4	1/4"
08316-06.5	6.5mm
08316-07.0	7mm
08316-07.5	7.5mm
08316-08.0	8mm
08316-08.5	8.5mm
08316-09.0	9mm
08316-09.5	9.5mm
08316-10.0	10mm

ER20 Sealed Collets

Part No.	Shank
08320-03.0	3mm
08320-03.5	3.5mm
08320-04.0	4mm
08320-04.5	4.5mm
08320-05.0	5mm
08320-05.5	5.5mm
08320-06.0	6mm
08320-1/4	1/4"
08320-06.5	6.5mm
08320-07.0	7mm
08320-07.5	7.5mm
08320-08.0	8mm
08320-08.5	8.5mm
08320-09.0	9mm
08320-09.5	9.5mm
08320-10.0	10mm
08320-10.5	10.5mm
08320-11.0	11mm
08320-11.5	11.5mm
08320-12.0	12mm
08320-12.5	12.5mm
08320-1/2	1/2"
08320-13.0	13mm

Sealed Collet Sets

Part No.	Description
08316MS	15 pcs. ER16
08320MS	21 pcs ER20
08325MS	27 pcs ER25
08332-35MS	35 pcs ER32
08340-41MS	41 pcs ER40

ER25 Sealed Collets

Part No.	Shank
08325-03.0	3mm
08325-03.5	3.5mm
08325-04.0	4mm
08325-04.5	4.5mm
08325-05.0	5mm
08325-05.5	5.5mm
08325-06.0	6mm
08325-1/4	1/4"
08325-06.5	6.5mm
08325-07.0	7mm
08325-07.5	7.5mm
08325-08.0	8mm
08325-08.5	8.5mm
08325-09.0	9mm
08325-09.5	9.5mm
08325-10.0	10mm
08325-10.5	10.5mm
08325-11.0	11mm
08325-11.5	11.5mm
08325-12.0	12mm
08325-12.5	12.5mm
08325-1/2	1/2"
08325-13.0	13mm
08325-13.5	13.5mm
08325-14.0	14mm
08325-14.5	14.5mm
08325-15.0	15mm
08325-15.5	15.5mm
08325-16.0	16mm

ER32 Sealed Collets

Part No.	Shank
08332-03.0	3mm
08332-03.5	3.5mm
08332-04.0	4mm
08332-04.5	4.5mm
08332-05.0	5mm
08332-05.5	5.5mm
08332-06.0	6mm
08332-1/4	1/4"
08332-06.5	6.5mm
08332-07.0	7mm
08332-07.5	7.5mm
08332-08.0	8mm
08332-08.5	8.5mm
08332-09.0	9mm
08332-09.5	9.5mm
08332-10.0	10mm
08332-10.5	10.5mm
08332-11.0	11mm
08332-11.5	11.5mm
08332-12.0	12mm
08332-12.5	12.5mm
08332-1/2	1/2"
08332-13.0	13mm
08332-13.5	13.5mm
08332-14.0	14mm
08332-14.5	14.5mm
08332-15.0	15mm
08332-15.5	15.5mm
08332-16.0	16mm
08332-16.5	16.5mm
08332-17.0	17mm
08332-17.5	17.5mm
08332-18.0	18mm
08332-18.5	18.5mm
08332-19	19mm
08332-3/4	3/4"
08332-19.5	19.5mm
08332-20.0	20mm

ER40 Sealed Collets

Part No.	Shank
08340-06.0	6mm
08340-1/4	1/4"
08340-06.5	6.5mm
08340-07.0	7mm
08340-07.5	7.5mm
08340-08.0	8mm
08340-08.5	8.5mm
08340-09.0	9mm
08340-09.5	9.5mm
08340-10.0	10mm
08340-10.5	10.5mm
08340-11.0	11mm
08340-11.5	11.5mm
08340-12.0	12mm
08340-12.5	12.5mm
08340-1/2	1/2"
08340-13.0	13mm
08340-13.5	13.5mm
08340-14.0	14mm
08340-14.5	14.5mm
08340-15.0	15mm
08340-15.5	15.5mm
08340-16.0	16mm
08340-16.5	16.5mm
08340-17.0	17mm
08340-17.5	17.5mm
08340-18.0	18mm
08340-18.5	18.5mm
08340-19.0	19mm
08340-3/4	3/4"
08340-19.5	19.5mm
08340-20.0	20mm
08340-20.5	20.5mm
08340-21.0	21mm
08340-21.5	21.5mm
08340-22.0	22mm
08340-22.5	22.5mm
08340-23.0	23mm
08340-23.5	23.5mm
08340-24.0	24mm
08340-24.5	24.5mm
08340-25.0	25mm
08340-25.5	25.5mm
08340-26.0	26mm
08340-1	25.4mm

Precision ER Floating Tap Collets and Collet Sets



Features

- *Axial compensation prevents breaking taps*
- *Replaces expensive tapping heads*
- *Locking feature prevents spinning the tap*
- *Reduce tapping clearance requirements*

Compatible with these standard collet chucks:
ER, DR, RD, ESX, BR or DIN 6499 collet pockets.


Nuts
pg. 58


Coolant Rings
pg. 60

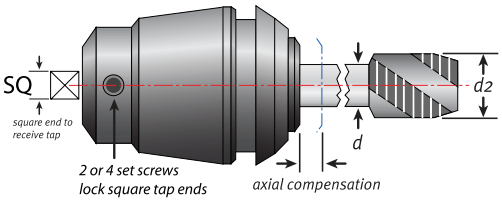

Retention Knobs
pg. 204


Wrenches
pg. 208

Applications: CNC lathes, VDI turrets, angle heads, CNC machine center, swiss style turning machines, and driven heads on CNC lathe turrets.

Simply program the machine 5% behind the recommended pitch feed of the tap to make the floating collet work. Return out of the tapped hole at 100%.

For best performance use FT tap collets with Techniks PowerCOAT nut.
See page 58.



FT Collet Sets

Part No.	Description
05916IS	4 piece FT-116 collet set
05920IS	5 piece FT-120 collet set
05925IS	9 FT-125 piece collet set
05932IS	11 piece collet set

FT-116 Floating Tap Collets

Part No.	d	SQ	Size (d2)
05916-141	.141"	.110"	1/8" or #6
05916-168	.168"	.131"	5/32" or #8
05916-194	.194"	.152"	3/16" or #10
05916-220	.220"	.165"	7/32" or #12

axial compensation = 7mm

FT-120 Floating Tap Collets

Part No.	d	SQ	Size (d2)
05920-141	.141"	.110"	1/8" or #6
05920-168	.168"	.131"	5/32" or #8
05920-194	.194"	.152"	3/16" or #10
05920-220	.220"	.165"	7/32" or #12
05920-255	.255"	.191"	1/4"

axial compensation = 7mm

FT-125 Floating Tap Collets

Part No.	d	SQ	Size (d2)
05925-141	.141"	.110"	1/8" or #6
05925-168	.168"	.131"	5/32" or #8
05925-194	.194"	.152"	3/16" or #10
05925-220	.220"	.165"	7/32" or #12
05925-255	.255"	.191"	1/4"
05925-318	.318"	.238"	5/16"
05925-323	.323"	.242"	7/16"
05925-367	.367"	.275"	1/2"
05925-381	.381"	.286"	3/8"

axial compensation = 8mm

FT-132 Floating Tap Collets

Part No.	d	SQ	Size (d2)
05932-168	.168"	.131"	5/32" or #8
05932-194	.194"	.152"	3/16" or #10
05932-220	.220"	.165"	7/32" or #12
05932-255	.255"	.191"	1/4"
05932-318	.318"	.238"	5/16"
05932-323	.323"	.242"	7/16"
05932-367	.367"	.275"	1/2"
05932-381	.381"	.286"	3/8"
05932-429	.429"	.322"	9/16"
05932-437	.437"	.328"	1/8" NPT
05932-480	.480"	.360"	5/8"

axial compensation = 10mm

Precision ER Rigid Tap Collets Inch Sizes

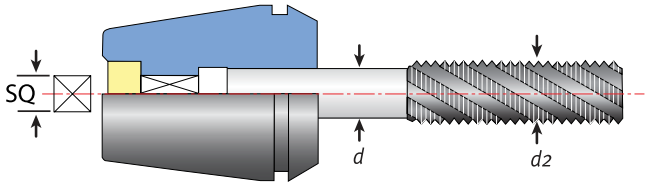


Features

- *Replaces expensive tap holders*
- *Reduce tapping clearance requirements*
- *Special design locks square in slots*

Compatible with ER, DR, RD, ESX, BR or DIN 6499 collet pockets.

For best results use with a PowerCOAT nut to increase clamping pressure up to 75%. See page 58.



Rigid Tap Collet Sets

Part No.	Description
05320-5(SET)	5 piece ER16 set
05320-9(SET)	9 piece ER16 set
05410-9(SET)	9 piece ER20 set
05510-11(SET)	11 piece ER25 set
05570-16(SET)	16 piece ER32 set
05710-21(SET)	21 piece ER40 set

ER16 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05320-141	.141"	.110"	1/8" or #6
05320-168	.168"	.131"	5/32" or #8
05320-194	.194"	.152"	3/16" or #10
05320-220	.220"	.165"	7/32" or #12
05320-255	.255"	.191"	1/4"
05320-318	.318"	.238"	5/16"
05320-323	.323"	.242"	7/16"
05320-367	.367"	.275"	1/2"
05320-381	.381"	.286"	3/8"

ER20 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05410-141	.141"	.110"	1/8" or #6
05410-168	.168"	.131"	5/32" or #8
05410-194	.194"	.152"	3/16" or #10
05410-220	.220"	.165"	7/32" or #12
05410-255	.255"	.191"	1/4"
05410-318	.318"	.238"	5/16"
05410-323	.323"	.242"	7/16"
05410-367	.367"	.275"	1/2"
05410-381	.381"	.286"	3/8"

ER25 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05510-141	.141"	.110"	1/8" or #6
05510-168	.168"	.131"	5/32" or #8
05510-194	.194"	.152"	3/16" or #10
05510-220	.220"	.165"	7/32" or #12
05510-255	.255"	.191"	1/4"
05510-318	.318"	.238"	5/16"
05510-323	.323"	.242"	7/16"
05510-367	.367"	.275"	1/2"
05510-381	.381"	.286"	3/8"
05510-429	.429"	.322"	9/16"
05510-437	.437"	.328"	1/8" NPT
05510-480	.480"	.360"	5/8"
05510-542	.542"	.406"	11/16"

ER32 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05570-141	.141"	.110"	1/8" or #6
05570-168	.168"	.131"	5/32" or #8
05570-194	.194"	.152"	3/16" or #10
05570-220	.220"	.165"	7/32" or #12
05570-255	.255"	.191"	1/4"
05570-318	.318"	.238"	5/16"
05570-323	.323"	.242"	7/16"
05570-367	.367"	.275"	1/2"
05570-381	.381"	.286"	3/8"
05570-429	.429"	.322"	9/16"
05570-437	.437"	.328"	1/8" NPT
05570-480	.480"	.360"	5/8"
05570-542	.542"	.406"	11/16"
05570-562	.562"	.421"	1/4" NPT
05570-590	.590"	.442"	3/4"
05570-652	.652"	.489"	13/16"

ER40 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05710-141	.141"	.110"	1/8" or #6
05710-168	.168"	.131"	5/32" or #8
05710-194	.194"	.152"	3/16" or #10
05710-220	.220"	.165"	7/32" or #12
05710-255	.255"	.191"	1/4"
05710-318	.318"	.238"	5/16"
05710-323	.323"	.242"	7/16"
05710-367	.367"	.275"	1/2"
05710-381	.381"	.286"	3/8"
05710-429	.429"	.322"	9/16"
05710-437	.437"	.328"	1/8" NPT
05710-480	.480"	.360"	5/8"
05710-542	.542"	.406"	11/16"
05710-562	.562"	.421"	1/4" NPT
05710-590	.590"	.442"	3/4"
05710-652	.652"	.489"	13/16"
05710-687	.687"	.515"	1/2" NPT
05710-697	.697"	.523"	7/8"
05710-700	.700"	.531"	3/8" NPT
05710-760	.760"	.570"	15/16"
05710-800	.800"	.600"	1"

Sign up to receive special offers at: www.techniksusa.com

SYIC

Precision ER Rigid Tap Collets Metric Sizes



Features

- *Replaces expensive tap holders*
- *Reduce tapping clearance requirements*
- *Special design locks square in slots*

Compatible with ER, DR, RD, ESX, BR or DIN 6499 collet pockets.

For best results use with a PowerCOAT nut to increase clamping pressure up to 75%. See page 58.


Nuts
pg. 58


Coolant Rings
pg. 60


Retention Knobs
pg. 204


Wrenches
pg. 208

Dimensions in mm.

ER16 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05326-DIN	2.8	2.1	M4
05330-DIN	3.5	2.7	M3
05336-DIN	4.5	3.4	M4
05342-DIN	6	4.9	M5/M6
05350-DIN	8	6.2	M8
05352	8.5	6.5	M12
05354-DIN	9	7	M12
05356-DIN	10	8	M10
05371	6	4.5	M6
05385	6.2	5	M8

ER20 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05428-DIN	4.5	3.4	M4
05434-DIN	6	4.9	M5/M6
05442-DIN	8	6.2	M8
05446-DIN	9	7	M12
05448-DIN	10	8	M10
05456-DIN	12	9	M16

ER25 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05526-DIN	4.5	3.4	M4
05534-DIN	6	4.9	M5/M6
05540-DIN	7	5.5	M10
05542-DIN	8	6.2	M8
05548-DIN	9	7	M12
05550	10	8	M10
05550-DIN	10	8	M10
05554-DIN	11	9	M14
05558-DIN	12	9	M16

ER32 Rigid Tap Collets

Part No.	d	SQ	Tap Size (d2)
05586-DIN	4.5	3.4	M4
05592-DIN	6	4.9	M5/M6
05598-M9	7	5.5	M9
05600-DIN	8	6.2	M8
05600-JIS	8	6	M11
05604-DIN	9	7	M12
05606-DIN	10	8	M10
05610	11	9	M14
05614-DIN	12	9	M16
05620-DIN	14	11	M18
05624-DIN	16	12	M20
05633	20	15	M27

Precision ER Quick-Change Rigid Tap Collets



Features

- *Quick-Change taps in seconds*
- *Replaces expensive tap holders*
- *Locking feature prevents spinning the tap*
- *Reduce tapping clearance requirements*


Nuts
pg. 58

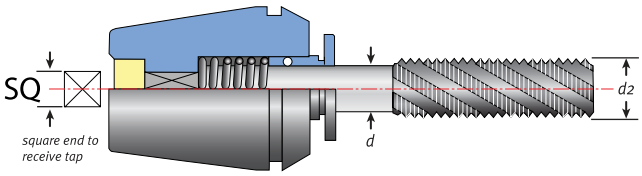

Coolant Rings
pg. 60


Retention Knobs
pg. 204


Wrenches
pg. 208

Compatible with these standard collet chucks:
ER, DR, RD, ESX, BR or DIN 6499 collet pockets.

For best tapping performance use with Techniks PowerCOAT nut for highest holding power and accuracy. See page 58.



Quick-Change Tap Collet Sets

Part No.	Description
05802-4(SET)	4 piece ER16 collet set
05804-8(SET)	8 piece ER20 collet set
0580611IS	11 piece ER25 collet set
05808-15(SET)	15 piece ER 32collet set

ER16 Quick-Change Rigid Tap

Part No.	d	SQ	Tap Size (d2)
05802-168	.168"	.131"	5/32" or #8
05802-194	.194"	.152"	3/16" or #10
05802-220	.220"	.165"	7/32" or #12
05802-255	.255"	.191"	1/4"

ER20 Quick-Change Rigid Tap

Part No.	d	SQ	Tap Size (d2)
05804-168	.168"	.131"	5/32" or #8
05804-194	.194"	.152"	3/16" or #10
05804-220	.220"	.165"	7/32" or #12
05804-255	.255"	.191"	1/4"
05804-318	.318"	.238"	5/16"
05804-323	.323"	.242"	7/16"
05804-367	.367"	.275"	1/2"
05804-381	.381"	.286"	3/8"

ER25 Quick-Change Rigid Tap

Part No.	d	SQ	Tap Size (d2)
05806-168	.168"	.131"	5/32" or #8
05806-194	.194"	.152"	3/16" or #10
05806-220	.220"	.165"	7/32" or #12
05806-255	.255"	.191"	1/4"
05806-318	.318"	.238"	5/16"
05806-323	.323"	.242"	7/16"
05806-367	.367"	.275"	1/2"
05806-381	.381"	.286"	3/8"
05806-429	.429"	.322"	9/16"
05806-437	.437"	.328"	1/8" NPT
05806-480	.480"	.360"	5/8"

ER32 Quick-Change Rigid Tap

Part No.	d	SQ	Tap Size (d2)
05808-168	.168"	.131"	5/32" or #8
05808-194	.194"	.152"	3/16" or #10
05808-220	.220"	.165"	7/32" or #12
05808-255	.255"	.191"	1/4"
05808-318	.318"	.238"	5/16"
05808-323	.323"	.242"	7/16"
05808-367	.367"	.275"	1/2"
05808-381	.381"	.286"	3/8"
05808-429	.429"	.322"	9/16"
05808-437	.437"	.328"	1/8" NPT
05808-480	.480"	.360"	5/8"
05808-542	.542"	.406"	11/16"
05808-562	.562"	.421"	1/4" NPT
05808-590	.590"	.442"	3/4"
05808-652	.652"	.489"	13/16"

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

ER, TG, DA Collet Storage Trays



Features

- *Prevent accidental damage to collets*
- *Keep collets organized and ready to use*
- *Exact fit for all your collets*



ER Collet Storage Trays

Part No.	Description
04282	ER8 wood Tray - 9 pcs.
04284	ER11 wood tray - 13 pcs.
04286	ER16 wood tray - 10 pcs.
04286-12	ER16 wood tray - 12 pcs.
04288	ER20 wood tray - 12 pcs.
04290	ER25 wood tray - 16 pcs.
04292	ER32 wood tray - 18 pcs.
04292-22	ER32 wood tray - 22 pcs.
04294	ER40 wood tray - 24 pcs.
04294-13	ER40 wood tray - 13 pcs.
04296	ER50 wood tray - 12 pcs.

DA Collet Storage Trays

Part No.	Description
04448	DA100 wood tray - 33 pcs
04449	DA100 wood tray - 8 pcs.
04450	DA100 wood tray - 15 pcs.
04451	DA100 wood tray - 21 pcs.
04452	DA100 wood tray - 29 pcs.
04453	DA180 wood tray - 9 pcs.
04454	DA180 wood tray - 17 pcs.
04455	DA180 wood tray - 21 pcs.
04456	DA180 wood tray - 33 pcs.
04457	DA180 wood tray - 41 pcs.
04459	DA200 wood tray - 9 pcs.
04460	DA200 wood tray - 21 pcs.
04461	DA200 wood tray - 17 pcs.
04462	DA300 wood tray - 7 pcs.
04464	DA300 wood tray - 14 pcs.

TG Collet Storage Trays

Part No.	Description
04466	TG75 wood tray - 11 pcs.
04468	TG75 wood tray - 22 pcs.
04470	TG75 wood tray - 43 pcs.
04472	TG100 wood tray - 15 pcs.
04474	TG100 wood tray - 21 pcs.
04476	TG100 wood tray - 30 pcs.
04478	TG100 wood tray - 41 pcs.
04480	TG100 wood tray - 59 pcs.
04482	TG150 wood tray - 17 pcs.
04484	TG150 wood tray - 33 pcs.
04486	TG150 wood tray - 65 pcs.

PowerCOAT ER Collet Nuts and Coolant Nuts



Features

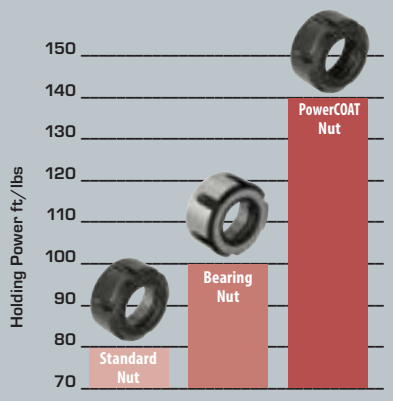
- *Increases holding power by 75%*
- *Balanced to 25,000 RPM*
- *Better rigidity and T.I.R. (runout)*

See Torque Chart on page 41.

PowerCOAT ER Collet Nuts

Part No.	Description	D	B	T	Wrench
41111	ER11 PowerCOAT hex nut	19mm	12mm	M14 x 0.75	04608
41116	ER16 PowerCOAT hex nut	27.5mm	18mm	M22 x 1.5	04609
41120	ER20 PowerCOAT hex nut	34mm	19mm	M25 x 1.5	04610
41916	ER16 PowerCOAT slot nut	32mm	18mm	M22 x 1.5	04613
41920	ER20 PowerCOAT slot nut	35mm	19.5mm	M25 x 1.5	04614
41925	ER25 PowerCOAT slot nut	42mm	21mm	M32 x 1.5	04615
41932	ER32 PowerCOAT slot nut	50mm	23mm	M40 x 1.5	04616
41940	ER40 PowerCOAT slot nut	63mm	26mm	M50 x 1.5	04617
41950	ER50 PowerCOAT slot nut	78mm	35mm	M64 x 2.0	04618

Holding Power Testing – ft/lbs



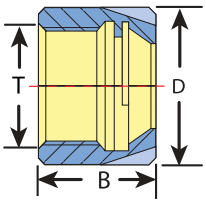
Each nut was tightened to 70 ft/lbs recommended torque before break-free testing of holding power.

Watch the Holding Power testing video at:

http://ow.ly/sV3UY

PowerCOAT Ultra High-Speed ER Nuts (balanced up to 70,000 RPM)

Part No.	Description	D	B	T	Wrench
46111	ER11 high speed hex nut	19mm	11.8mm	M14 x 0.75	04608
46116	ER16 high speed slot nut	27.5mm	18.0mm	M22 x 1.5	04613
46120	ER20 high speed slot nut	35mm	19.5mm	M25 x 1.5	04614
46125	ER25 high speed slot nut	42mm	20.5mm	M32 x 1.5	04615
46132	ER32 high speed slot nut	50mm	23.0mm	M40 x 1.5	04616
46140	ER40 high speed slot nut	63mm	26.0mm	M50 x 1.5	04617



For best performance use a torque wrench and tighten nut to proper torque specification. Snap collet into nut before assembly.

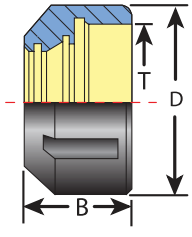


Features

- *Increases holding power by 75%*
- *Seals up to 1,500 P.S.I.*
- *Balanced to 25,000 RPM*
- *Use with coolant rings pg. 60*

PowerCOAT ER Coolant Nuts

Part No.	Description	D	B	T	Wrench
41616	ER16 coolant slot nut	32	22.5	M22x1.5	04613
41620	ER20 coolant slot nut	35	24	M25x1.5	04614
41625	ER25 coolant slot nut	42	25	M32x1.5	04615
41632	ER32 coolant slot nut	50	27.5	M40x1.5	04616
41640	ER40 coolant slot nut	63	30.7	M50x1.5	04617





Coolant ring snaps into the nut to seal the tool shank. (pg. 60) For coolant-thru tools.

Need it FAST? We offer Same Day Shipping until 6:00 pm E.S.T.

SYIC

PowerCOAT ER Mini Nuts



ER Mini Nut

Features

- *For minimum nose O.D. applications*
- *Increases holding power by 75%*
- *High speed nuts balanced to 20,000 RPM*


Collets pg. 44

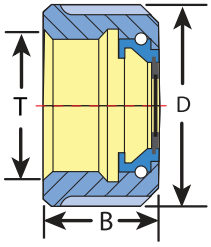

Coolant Rings pg. 60


Retention Knobs pg. 204


Wrenches pg. 208

PowerCOAT ER High Speed Mini Nuts (balanced to 20,000 RPM at G2.5)

Part No.	Description	D	B	T	Wrench
33108	ER8 high speed mini nut	12mm	11mm	M10 x 0.75	04620
33111	ER11 high speed mini nut	16mm	12mm	M13 x 0.75	04621
33116	ER16 high speed mini nut	22mm	18mm	M19 x 1.0	04622
33120	ER20 high speed mini nut	28mm	19.5mm	M24 x 1.0	04623
33125	ER25 high speed mini nut	35mm	21mm	M30 x 1.0	04624
33125-L	ER25 high speed left-hand mini nut	35mm	21mm	M30 x 1.0	04624



PowerCOAT ER Mini Nuts (balanced to 10,000 RPM at G2.5)

Part No.	Description	D	B	T	Wrench
23108	ER8 mini nut	12mm	11mm	M10 x 0.75	04620
23111	ER11 mini nut	16mm	12mm	M13 x 0.75	04621
23116	ER16 mini nut	22mm	18mm	M19 x 1.0	04622
23120	ER20 mini nut	28mm	19.5mm	M24 x 1.0	04623
23125	ER25 mini nut	35mm	21mm	M30 x 1.0	04624

PowerCOAT ER Mini Coolant Nuts (balanced to 10,000 RPM at G2.5)

Part No.	Description	Ring	D	B	T	Wrench
23616	ER16 mini coolant nut	ER16	22mm	24mm	M19 x 1.0	04622
23620	ER20 mini coolant nut	ER20	28mm	24mm	M24 x 1.0	04623
23625	ER25 mini coolant nut	ER25	35mm	26.5mm	M30 x 1.0	04624



Coolant Style Mini nut uses ER coolant rings (page 60)

Black Gold ER Coolant Rings



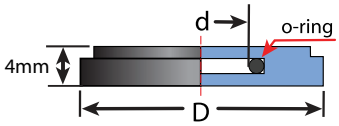
Snap ring into nut before ER collet

Features

- *Seals up to 1,500 P.S.I.*
- *Use with ER collets*
- *Use with PowerCOAT coolant nuts*



PowerCOAT coolant nuts pg. 58



Dimensions	D
ER16	12.9 mm
ER20	15.9 mm
ER25	21 mm
ER32	26.95 mm
ER40	33.3 mm

NOTE: Remove o-ring for coolant surround tool applications using non-coolant cutting tools. (see photos next page)

Black Gold ER16 Coolant Rings

Part No.	Shank mm	Shank inch
08516-03.5	3.5 – 3.0mm	1/8"
08516-04.0	4.0 – 3.5mm	5/32"
08516-04.5	4.5 – 4.0mm	11/64"
08516-05.0	5.0 – 4.5mm	3/16"
08516-05.5	5.5 – 5.0mm	13/64"
08516-06.0	6.0 – 5.5mm	7/32"
08516-06.5	6.5 – 6.0mm	1/4"
08516-07.0	7.0 – 6.5mm	17/64"
08516-07.5	7.5 – 7.0mm	9/32"
08516-08.0	8.0 – 7.5mm	5/16"
08516-08.5	8.5 – 8.0mm	21/64"
08516-09.0	9.0 – 8.5mm	11/32"
08516-09.5	9.5 – 9.0mm	3/8"
08516-10.0	10.0 – 9.5mm	25/64"

Black Gold ER20 Coolant Rings

Part No.	Shank mm	Shank inch
08520-03.5	3.5 – 3.0mm	1/8"
08520-04.0	4.0 – 3.5mm	5/32"
08520-04.5	4.5 – 4.0mm	11/64"
08520-05.0	5.0 – 4.5mm	3/16"
08520-05.5	5.5 – 5.0mm	13/64"
08520-06.0	6.0 – 5.5mm	7/32"
08520-06.5	6.5 – 6.0mm	1/4"
08520-07.0	7.0 – 6.5mm	17/64"
08520-07.5	7.5 – 7.0mm	9/32"
08520-08.0	8.0 – 7.5mm	5/16"
08520-08.5	8.5 – 8.0mm	21/64"
08520-09.0	9.0 – 8.5mm	11/32"
08520-09.5	9.5 – 9.0mm	3/8"
08520-10.0	10.0 – 9.5mm	25/64"
08520-10.5	10.5 – 10.0mm	13/32"
08520-11.0	11.0 – 10.5mm	27/64"
08520-11.5	11.5 – 11.0mm	7/16"
08520-12.0	12.0 – 11.5mm	15/32"
08520-12.5	12.5 – 12.0mm	31/64"
08520-13.0	13.0 – 12.5mm	1/2"

Black Gold ER25 Coolant Rings

Part No.	Shank mm	Shank inch
08525-03.5	3.5 – 3.0mm	1/8"
08525-04.0	4.0 – 3.5mm	5/32"
08525-04.5	4.5 – 4.0mm	11/64"
08525-05.0	5.0 – 4.5mm	3/16"
08525-05.5	5.5 – 5.0mm	13/64"
08525-06.0	6.0 – 5.5mm	7/32"
08525-06.5	6.5 – 6.0mm	1/4"
08525-07.0	7.0 – 6.5mm	17/64"
08525-07.5	7.5 – 7.0mm	9/32"
08525-08.0	8.0 – 7.5mm	5/16"
08525-08.5	8.5 – 8.0mm	21/64"
08525-09.0	9.0 – 8.5mm	11/32"
08525-09.5	9.5 – 9.0mm	3/8"
08525-10.0	10.0 – 9.5mm	25/64"
08525-10.5	10.5 – 10.0mm	13/32"
08525-11.0	11.0 – 10.5mm	27/64"
08525-11.5	11.5 – 11.0mm	7/16"
08525-12.0	12.0 – 11.5mm	15/32"
08525-12.5	12.5 – 12.0mm	31/64"
08525-13.0	13.0 – 12.5mm	1/2"
08525-13.5	13.5 – 13.0mm	17/32"
08525-14.0	14.0 – 13.5mm	35/64"
08525-14.5	14.5 – 14.0mm	9/16"
08525-15.0	15.0 – 14.5mm	37/64"
08525-15.5	15.5 – 15.0mm	19/32"
08525-16.0	16.0 – 15.5mm	5/8"

Black Gold ER32 TG100 Coolant Rings

Part No.	Shank mm	Shank inch
08532-03.5	3.5 – 3.0mm	1/8"
08532-04.0	4.0 – 3.5mm	5/32"
08532-04.5	4.5 – 4.0mm	11/64"
08532-05.0	5.0 – 4.5mm	3/16"
08532-05.5	5.5 – 5.0mm	13/64"
08532-06.0	6.0 – 5.5mm	7/32"
08532-06.5	6.5 – 6.0mm	1/4"
08532-07.0	7.0 – 6.5mm	17/64"
08532-07.5	7.5 – 7.0mm	9/32"
08532-08.0	8.0 – 7.5mm	5/16"
08532-08.5	8.5 – 8.0mm	21/64"
08532-09.0	9.0 – 8.5mm	11/32"
08532-09.5	9.5 – 9.0mm	3/8"
08532-10.0	10.0 – 9.5mm	25/64"
08532-10.5	10.5 – 10.0mm	13/32"
08532-11.0	11.0 – 10.5mm	27/64"
08532-11.5	11.5 – 11.0mm	7/16"
08532-12.0	12.0 – 11.5mm	15/32"
08532-12.5	12.5 – 12.0mm	31/64"
08532-13.0	13.0 – 12.5mm	1/2"
08532-13.5	13.5 – 13.0mm	17/32"
08532-14.0	14.0 – 13.5mm	35/64"
08532-14.5	14.5 – 14.0mm	9/16"
08532-15.0	15.0 – 14.5mm	37/64"
08532-15.5	15.5 – 15.0mm	19/32"
08532-16.0	16.0 – 15.5mm	5/8"
08532-16.5	16.5 – 16.0mm	41/64"
08532-17.0	17.0 – 16.5mm	21/32"
08532-17.5	17.5 – 17.0mm	11/16"
08532-18.0	18.0 – 17.5mm	45/64"
08532-18.5	18.5 – 18.0mm	23/32"
08532-19.0	19.0 – 18.5mm	3/4"
08532-19.5	19.5 – 19.0mm	49/64"
08532-20.0	20.0 – 19.5mm	25/32"

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

Black Gold ER Coolant Rings



Use ER Coolant Rings with o-ring for coolant-thru cutting tools.



Removing the o-ring creates a CoolBLAST coolant effect.

Use Black Gold Rings for Coolant Applications

It costs less money to use coolant rings and standard collets than coolant collets.

	ER32 Coolant Collet	ER32 Coolant Ring System
Cost of 320 collets	$16,000.00	$8,640.00
Cost of 20 nuts	$ 0.00 (supplied with holders)	$1,300.00 (includes rings)
Total 4 year cost	$16,000.00	$9,940.00
		$6,060.00 savings

Figures based on 20 toolholders, allowing 4 collets a year for each toolholder for a total of 320 collets, plus one nut for each toolholder over the four year period.

ER coolant rings are great for unattended operation - there are no rubber seals to blow out under high pressure.

ER Coolant Ring Sets

Part No.	Description
08516-14(SET)	14 piece ER16 coolant ring set
08520-20(SET)	20 piece ER20 coolant ring set
08525-26(SET)	26 piece ER25 coolant ring set
08532-34(SET)	34 piece ER32 coolant ring set
08540-46(SET)	46 piece ER40 coolant ring set

Black Gold ER40 Coolant Rings

Part No.	Shank mm	Shank inch
08540- 03.5	3.5 – 3.0mm	1/8"
08540-04.0	4.0 – 3.5mm	5/32"
08540-04.5	4.5 – 4.0mm	11/64"
08540-05.0	5.0 – 4.5mm	3/16"
08540-05.5	5.5 – 5.0mm	13/64"
08540-06.0	6.0 – 5.5mm	7/32"
08540-06.5	6.5 – 6.0mm	1/4"
08540-07.0	7.0 – 6.5mm	17/64"
08540-07.5	7.5 – 7.0mm	9/32"
08540-08.0	8.0 – 7.5mm	5/16"
08540-08.5	8.5 – 8.0mm	21/64"
08540-09.0	9.0 – 8.5mm	11/32"
08540-09.5	9.5 – 9.0mm	3/8"
08540-10.0	10.0 – 9.5mm	25/64"
08540-10.5	10.5 – 10.0mm	13/32"
08540-11.0	11.0 – 10.5mm	27/64"
08540-11.5	11.5 – 11.0mm	7/16"
08540-12.0	12.0 – 11.5mm	15/32"
08540-12.5	12.5 – 12.0mm	31/64"
08540-13.0	13.0 – 12.5mm	1/2"
08540-13.5	13.5 – 13.0mm	17/32"
08540-14.0	14.0 – 13.5mm	35/64"
08540-14.5	14.5 – 14.0mm	9/16"
08540-15.0	15.0 – 14.5mm	37/64"
08540-15.5	15.5 – 15.0mm	19/32"
08540-16.0	16.0 – 15.5mm	5/8"
08540-16.5	16.5 – 16.0mm	41/64"
08540-17.0	17.0 – 16.5mm	21/32"
08540-17.5	17.5 – 17.0mm	11/16"
08540-18.0	18.0 – 17.5mm	45/64"
08540-18.5	18.5 – 18.0mm	23/32"
08540-19.0	19.0 – 18.5mm	3/4"
08540-19.5	19.5 – 19.0mm	49/64"
08540-20.0	20.0 – 19.5mm	25/32"
08540-20.5	20.5 – 20.0mm	51/64"
08540-21.0	21.0 – 20.5mm	13/16"
08540-21.5	21.5 – 21.0mm	27/32"
08540-22.0	22.0 – 21.5mm	55/64"
08540-22.5	22.5 – 22.0mm	7/8"
08540-23.0	23.0 – 22.5mm	29/32"
08540-23.5	23.5 – 23.0mm	59/64"
08540-24.0	24.0 – 23.5mm	15/16"
08540-24.5	24.5 – 24.0mm	61/64"
08540-25.0	25.0 – 24.5mm	31/32"
08540-25.5	25.5 – 25.0mm	1.0"
08540-26.0	26.0 – 25.5mm	1 1/64"

Precision TG75 Collets and PowerCOAT Nut



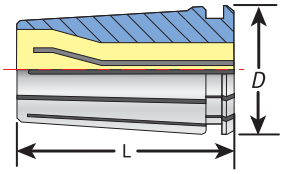
Features

- *.0004" T.I.R.*
- *Precision ground & hand inspected*
- *Clamping range: 1/64"*



Dimensions

Series	L	A
TG75	1.844"	1.062"



TG75 Sets

Part No.	Pieces	ID Sizes
04008-43S	43	1/8" - 3/4" by 64ths
04008-22S	22	1/8" - 3/4" by 32nds
04008-11S	11	1/8" - 3/4" by 16ths

TG75 Collets

Part No.	Shank
04008-3/32	3/32"
04008-7/64	7/64"
04008-1/8	1/8"
04008-9/64	9/64"
04008-5/32	5/32"
04008-11/64	11/64"
04008-3/16	3/16"
04008-13/64	13/64"
04008-7/32	7/32"
04008-15/64	15/64"
04008-1/4	1/4"

Part No.	Shank
04008-17/64	17/64"
04008-9/32	9/32"
04008-19/64	19/64"
04008-5/16	5/16"
04008-21/64	21/64"
04008-11/32	11/32"
04008-23/64	23/64"
04008-3/8	3/8"
04008-25/64	25/64"
04008-13/32	13/32"
04008-27/64	27/64"

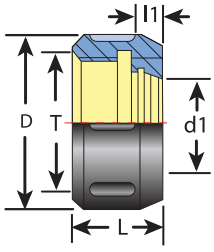
Part No.	Shank
04008-7/16	7/16"
04008-29/64	29/64"
04008-15/32	15/32"
04008-31/64	31/64"
04008-1/2	1/2"
04008-33/64	33/64"
04008-17/32	17/32"
04008-35/64	35/64"
04008-9/16	9/16"
04008-37/64	37/64"
04008-19/32	19/32"

Part No.	Shank
04008-39/64	39/64"
04008-5/8	5/8"
04008-41/64	41/64"
04008-21/32	21/32"
04008-43/64	43/64"
04008-11/16	11/16"
04008-45/64	45/64"
04008-23/32	23/32"
04008-47/64	47/64"
04008-3/4	3/4"



Features

- *Increases holding power by 75%*
- *Balanced to 25,000 RPM*
- *Better rigidity and less T.I.R. (runout)*



TG75 PowerCOAT Collet Nut

Part No.	Description	D	d1	T	l1	L	Wrench	Torque
84012	TG75 Collet Nut	1.88"	-	1 1/2 - 12"	0.32"	0.94"	04616	90 ft/lb

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SYIC

Precision TG100 Collets and PowerCOAT Nut



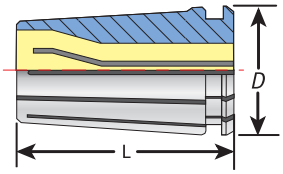
Features

- *.0004" T.I.R.*
- *Precision ground & hand inspected*
- *Clamping range: 1/64"*
- *Metric sizes in stock*



Dimensions

Series	L	A
TG100	2.375"	1.379"



TG100 Sets

Part No.	Pcs.	ID Sizes
04010-59S	59	3/32 - 1" by 64ths
04010-41S	41	3/8 - 1" by 64ths
04010-30S	30	3/32 - 1" by 32nds
04010-21S	21	3/8 - 1" by 32nds
04010-15S	15	1/8 - 1" by 16ths

TG100 Collets

Part No.	Shank
04010-3/32	3/32"
04010-7/64	7/64"
04010-1/8	1/8"
04010-9/64	9/64"
04010-5/32	5/32"
04010-11/64	11/64"
04010-3/16	3/16"
04010-13/64	13/64"
04010-7/32	7/32"
04010-15/64	15/64"
04010-1/4	1/4"
04010-17/64	17/64"
04010-9/32	9/32"
04010-19/64	19/64"
04010-5/16	5/16"

Part No.	Shank
04010-21/64	21/64"
04010-11/32	11/32"
04010-23/64	23/64"
04010-3/8	3/8"
04010-25/64	25/64"
04010-13/32	13/32"
04010-27/64	27/64"
04010-7/16	7/16"
04010-29/64	29/64"
04010-15/32	15/32"
04010-31/64	31/64"
04010-1/2	1/2"
04010-33/64	33/64"
04010-17/32	17/32"
04010-35/64	35/64"

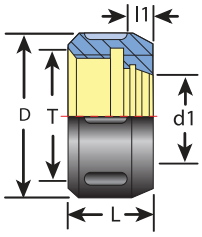
Part No.	Shank
04010-9/16	9/16"
04010-37/64	37/64"
04010-19/32	19/32"
04010-39/64	39/64"
04010-5/8	5/8"
04010-41/64	41/64"
04010-21/32	21/32"
04010-43/64	43/64"
04010-11/16	11/16"
04010-45/64	45/64"
04010-23/32	23/32"
04010-47/64	47/64"
04010-3/4	3/4"
04010-49/64	49/64"
0410-20	20mm

Part No.	Shank
04010-25/32	25/32"
04010-51/64	51/64"
04010-13/16	13/16"
04010-53/64	53/64"
04010-27/32	27/32"
04010-55/64	55/64"
04010-7/8	7/8"
04010-57/64	57/64"
04010-29/32	29/32"
04010-59/64	59/64"
04010-15/16	15/16"
04010-61/64	61/64"
04010-31/32	31/32"
04010-63/64	63/64"
04010-1	1.0"



Features

- *Increases holding power by 75%*
- *Balanced to 25,000 RPM*
- *Better rigidity and less T.I.R. (runout) increase cutting tool life*



TG100 PowerCOAT Nut

Part No.	Description	D	d1	T	l1	L	Spanner	Torque
28110	TG100 Collet Nut	2.35"	1.12"	1 7/8 - 12"	0.44"	1.18"	03691	90 ft/lb

Precision TG100 Coolant Collets and PowerCOAT Nut



Features

- *Up to 750 PSI coolant*
- *.0004" T.I.R.*
- *Clamping range: 1/64"*

Use with TG PowerCOAT Nut


Nuts
pg. 58


Coolant
Rings
pg. 60

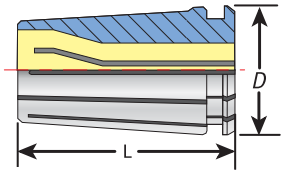

Retention
Knobs
pg. 204


Wrenches
pg. 208



Dimensions

Series	L	A
TG100	2.375"	1.379"



TG100 Coolant Collet Sets

Part No.	Pcs.	ID Sizes
84063-25(SET)	25	1/4" - 1.0" by 64ths

TG100 Coolant Collets

Part No.	Shank Size
84063-1/4	1/4"
84063-9/32	9/32"
84063-5/16	5/16"
84063-11/32	11/32"
84063-3/8	3/8"
84063-13/32	13/32"

Part No.	Shank Size
84063-7/16	7/16"
84063-15/32	15/32"
84063-1/2	1/2"
84063-17/32	17/32"
84063-9/16	9/16"
84063-19/32	19/32"

Part No.	Shank Size
84063-5/8	5/8"
84063-21/32	21/32"
84063-11/16	11/16"
84063-23/32	23/32"
84063-3/4	3/4"
84063-25/32	25/32"

Part No.	Shank Size
84063-13/16	13/16"
84063-27/32	27/32"
84063-7/8	7/8"
84063-29/32	29/32"
84063-15/16	15/16"
84063-31/32	31/32"
84063-1	1.0"



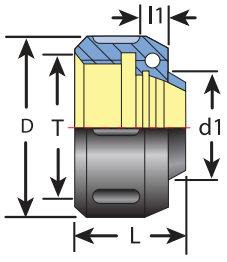
Use with ER32 coolant rings page 60.

Features

- *Works with TG100 collets*
- *Up to 1,500 PSI coolant*
- *Increases holding power by 75%*



ER32 coolant ring snaps into the nut to seal the tool shank.



PowerCOAT TG100 Coolant Nut

Part No.	Description	D	d1	T	I1	L	Wrench	Torque
28210	TG100 Coolant Nut	2.35"	0.95"	1 7/8 - 12"	0.44"	1.41"	03691	90 ft/lb

Need it FAST? We offer Same Day Shipping until 6:00 pm E.S.T.

SYIC

Precision TG150 Collets and Collet Sets



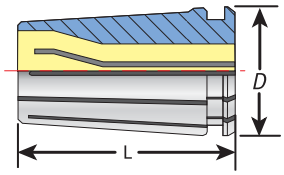
Features

- *.0004" T.I.R.*
- *Precision ground & hand inspected*
- *Clamping range: 1/64"*



Dimensions

Series	L	A
TG150	3.0"	2.001"



TG150 Sets

Part No.	Pcs.	ID Sizes
04011-65S	65	1/2 - 1 1/2" by 64ths
04011-33S	33	1/2 - 1 1/2" by 32nds
04011-17S	17	1/2 - 1 1/2" by 16ths

TG150 Collets

Part No.	Shank
04011-17/64	17/64"
04011-3/8	38"
04011-7/32	7/32"
04011-1/2	1/2"
04011-33/64	33/64"
04011-17/32	17/32"
04011-35/64	35/64"
04011-9/16	9/16"
04011-37/64	37/64"
04011-19/32	19/32"
04011-39/64	39/64"
04011-5/8	5/8"
04011-41/64	41/64"
04011-21/32	21/32"
04011-43/64	43/64"
04011-11/16	11/16"
04011-45/64	45/64"

Part No.	Shank
04011-23/32	23/32"
04011-47/64	47/64"
04011-3/4	3/4"
04011-49/64	49/64"
04011-25/32	25/32"
04011-51/64	51/64"
04011-13/16	13/16"
04011-53/64	53/64"
04011-27/32	27/32"
04011-55/64	55/64"
04011-7/8	7/8"
04011-57/64	57/64"
04011-29/32	29/32"
04011-59/64	59/64"
04011-15/16	15/16"
04011-61/64	61/64"

Part No.	Shank
04011-31/32	31/32"
04011-63/64	63/64"
04011-1	1.0"
04011-1.1/64	1-1/64"
04011-1.3/64	1-3/64"
04011-1.1/16	1-1/16"
04011-1.5/64	1-5/64"
04011-1.3/32	1-3/32"
04011-1.7/64	1-7/64"
04011-1.1/8	1-1/8"
04011-1.9/64	1-9/64"
04011-1.5/32	1-5/32"
04011-1.11/64	1-11/64"
04011-1.3/16	1-3/16"
04011-1.13/64	1-13/64"
04011-1.7/32	1-7/32"
04011-1.15/64	1-15/64"

Part No.	Shank
04011-1.1/4	1-1/4"
04011-1.17/64	1-17/64"
04011-1.9/32	1-9/32"
04011-1.19/64	1-19/64"
04011-1.5/16	1-5/16"
04011-1.21/64	1-21/64"
04011-1.11/32	1-11/32"
04011-1.23/64	1-23/64"
04011-1.3/8	1-3/8"
04011-1.25/64	1-25/64"
04011-1.13/32	1-13/32"
04011-1.27/64	1-27/64"
04011-1.7/16	1-7/16"
04011-1.29/64	1-29/64"
04011-1.15/32	1-15/32"
04011-1.31/64	1-31/64"
04011-1.1/2	1-1/2"

SYOZ / EOC (DIN 6388) Perske Style



Features

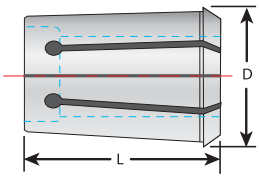
- *T.I.R. (runout) .0004"*
- *Collapse range: 1/64"*
- *Made from high-carbon steel*

These collets and collet nuts conform to DIN 6388 standards. Snap collet into the nut before screwing the nut on to the spindle or holder.


Retention Knobs pg. 206


Wrenches pg. 208


Tightening Stands pg. 210



SYOZ20 / EOC 12 Collets

Part No.	Shank Size
83512-1/8	1/8"
83512-3/16	3/16"
83512-1/4	1/4"
83512-5/16	5/16"
83512-3/8	3/8"
83512-7/16	7/16"
83512-1/2	1/2"
83512-10	10mm

SYOZ25 Collets

Part No.	Shank Size
83868-1/8	1/8"
83868-3/16	3/16"
83868-1/4	1/4"
83868-5/16	5/16"
83868-3/8	3/8"
83868-7/16	7/16"
83868-1/2	1/2"
83868-9/16	9/16"
83868-5/8	5/8"
83868-3/4	3/4"
83868-7/8	7/8"
83868-1	1.0"
83868-10	10mm
83868-16	16mm
83868-20	20mm
83868-25	25mm

SYOC / EOC Collet Dimensions

Part No.	L	D
SYOZ20	34mm	20mm
SYOZ25	52mm	35mm
EOC 08	26mm	14.4mm
EOC16	40mm	25.5mm

EOC8 Collets

Part No.	Shank Size
83508-1/8	1/8"
83508-3/16	3/16"
83508-1/4	1/4"
03508-5/16	5/16"

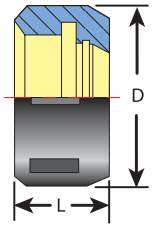
SYOZ20/EOC 12 Collets

Various metric and inch sizes available from stock.

EOC16 Collets

Part No.	Shank Size
83508-1/8	1/8"
83508-3/16	3/16"
83508-1/4	1/4"
03508-5/16	5/16"
83531-3/8	3/8"
83531-7/16	7/16"
83531-1/2	1/2"
83531-9/16	9/16"
83531-5/8	5/8"
83531-10	10mm
83531-16	16mm





DIN 6388 Nuts and Wrenches

Part No.	Descripton	L	D	Wrench
83508-NUT	EOC08 nut	19	30	-
03636-NUT	EOC16 nut	24	43	03636
83634	SYOZ20/EOC 12 nut	20	35	22220
83634-L	SYOZ20/EOC 12 left-hand nut	20	35	22220
83632	SYOZ25 PowerCOAT nut	30	60	03691

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

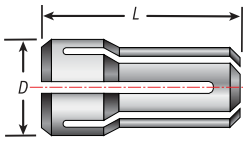
SYIC

Precision Double Angle (DA) Collets



Features

- *Collapse range: 1/64”*
- *Made from high-carbon steel*



Dimensions

Series	L	D
DA180	1.625"	1.035"
DA100	1.438"	0.769"
DA200	1.188"	0.531"
DA300	1.000"	0.375"

Double Angle Collet Sets*

DA180	Description
01618-9S	9pc $^1/_4$ - $^3/_4$" by 16^{ths}
01618-17S	17pc $^1/_4$ - $^3/_4$" by 32^{nds}
01618-21S	21pc $^1/_8$ - $^3/_4$" by 32^{nds}
01618-33S	33pc $^1/_4$ - $^3/_4$" by 64^{ths}
01618-41S	41pc $^1/_8$ - $^3/_4$" by 64^{ths}

DA100	Description
01610-8S	8pc $^1/_8$ - $^9/_{16}$" by 16^{ths}
01610-15S	15pc $^1/_8$ - $^9/_{16}$" by 32^{nds}
01610-21S	21pc $^1/_4$ - $^9/_{16}$" by 64^{ths}
01610-29S	29pc $^1/_8$ - $^9/_{16}$" by 64^{ths}
01610-33S	33pc $^1/_{16}$ - $^9/_{16}$" by 64^{ths}

DA200	Description
01620-9S	9pc $^1/_8$ - $^3/_8$" by 32^{nds}
01620-17S	17pc $^1/_8$ - $^3/_8$" by 64^{ths}
01620-21S	21pc $^1/_{16}$ - $^3/_8$" by 64^{ths}

DA300	Description
01630-7S	7pc $^1/_{16}$ - $^1/_4$" by 32^{nds}
01630-14S	14pc $^3/_{64}$ - $^1/_4$" by 64^{ths}

*The last number in the part number indicates the number of collets in the set.

DA180 Collets	Size
01618-1/16	1/16"
01618-5/64	5/64"
01618-3/32	3/32"
01618-7/64	7/64"
01618-1/8	1/8"
01618-9/64	9/64"
01618-5/32	5/32"
01618-11/64	11/64"
01618-3/16	3/16"
01618-13/64	13/64"
01618-7/32	7/32"
01618-15/64	15/64"
01618-1/4	1/4"
01618-17/64	17/64"
01618-9/32	9/32"
01618-19/64	19/64"
01618-5/16	5/16"
01618-21/64	21/64"
01618-11/32	11/32"
01618-23/64	23/64"
01618-3/8	3/8"
01618-25/64	25/64"
01618-13/32	13/32"
01618-27/64	27/64"
01618-7/16	7/16"
01618-29/64	29/64"
01618-15/32	15/32"
01618-31/64	31/64"
01618-1/2	1/2"
01618-33/64	33/64"

DA180 Collets	Size
01618-17/32	17/32"
01618-35/64	35/64"
01618-9/16	9/16"
01618-37/64	37/64"
01618-19/32	19/32"
01618-39/64	39/64"
01618-5/8	5/8"
01618-41/64	41/64"
01618-21/32	21/32"
01618-43/64	43/64"
01618-11/16	11/16"
01618-45/64	45/64"
01618-23/32	23/32"
01618-47/64	47/64"
01618-3/4	3/4"

DA100 Collets	Size
01610-1/16	1/16"
01610-5/64	5/64"
01610-3/32	3/32"
01610-7/64	7/64"
01610-1/8	1/8"
01610-9/64	9/64"
01610-5/32	5/32"
01610-11/64	11/64"
01610-3/16	3/16"
01610-13/64	13/64"
01610-7/32	7/32"
01610-15/64	15/64"
01610-1/4	1/4"

DA100 Collets	Size
01610-17/64	17/64"
01610-9/32	9/32"
01610-19/64	19/64"
01610-5/16	5/16"
01610-21/64	21/64"
01610-11/32	11/32"
01610-23/64	23/64"
01610-3/8	3/8"
01610-25/64	25/64"
01610-13/32	13/32"
01610-27/64	27/64"
01610-7/16	7/16"
01610-29/64	29/64"
01610-15/32	15/32"
01610-31/64	31/64"
01610-1/2	1/2"
01610-33/64	33/64"
01610-17/32	17/32"
01610-35/64	35/64"
01610-9/16	9/16"

DA200 Collets	Size
01620-3/64	3/64"
01620-1/16	1/16"
01620-5/64	5/64"
01620-3/32	3/32"
01620-7/64	7/64"
01620-1/8	1/8"
01620-9/64	9/64"
01620-5/32	5/32"

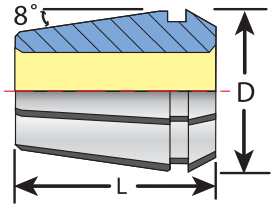
DA200 Collets	Size
01620-11/64	11/64"
01620-3/16	3/16"
01620-13/64	13/64"
01620-7/32	7/32"
01620-15/64	15/64"
01620-1/4	1/4"
01620-17/64	17/64"
01620-9/32	9/32"
01620-19/64	19/64"
01620-5/16	5/16"
01620-21/64	21/64"
01620-11/32	11/32"
01620-23/64	23/64"
01620-3/8	3/8"

DA300 Collets	Size
01630-3/64	3/64"
01630-1/16	1/16"
01630-5/64	5/64"
01630-3/32	3/32"
01630-7/64	7/64"
01630-1/8	1/8"
01630-9/64	9/64"
01630-5/32	5/32"
01630-11/64	11/64"
01630-3/16	3/16"
01630-13/64	13/64"
01630-7/32	7/32"
01630-15/64	15/64"
01630-1/4	1/4"

CNC Collet Identification and Special Orders Guide

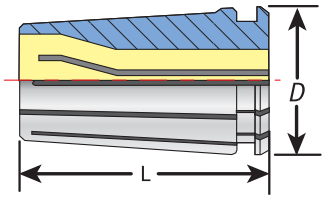
Use the guide below for selecting replacement collets. The best way to tell what type of collet you have is to measure the length of the collet. ER, TG, and SYOZ collets all have unique measurements. For best results always use a PowerCOAT nut tightened to proper specification using an accurate torque wrench.

ER Collet	L	D	Torque Spec
ER8	13mm (.51")	8.5mm (.33")	-
ER11	18mm (.708")	11.5mm (.45")	17 ft/lbs
ER16	27.5mm (1.08")	17mm (.67")	42 ft/lbs
ER20	31.5mm (1.24")	21mm (.83")	59 ft/lbs
ER25	34mm (1.34")	26mm (1.02")	77 ft/lbs
ER32	40mm (1.57")	33mm (1.3")	100 ft/lbs
ER40	46mm (1.81")	41mm (1.61")	130 ft/lbs
ER50	60 mm (2.36")	52mm (2.05")	130 ft/lbs



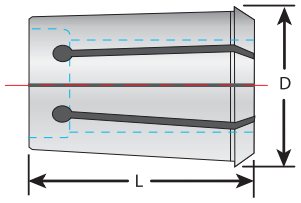
ER Collet Style

TG Collet	L	D	Torque Spec
TG75	47mm (1.85")	27mm (1.06")	90 ft/lbs
TG100	60mm (2.36")	35mm (1.38")	90 ft/lbs
TG150	76mm (3")	51mm (2")	110 ft/lbs



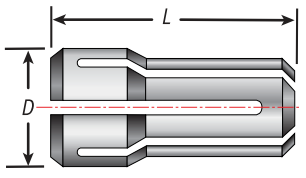
TG Collet Style

SYOZ / EOC Collet	L	D
EOC8	26mm (1.026")	14.4mm (.567")
SYOZ20	34mm (1.34")	20mm (.78")
RDO 20	34mm (1.34")	20mm (.78")
407E	34mm (1.34")	20mm (.78")
EOC 12	34mm (1.34")	20mm (.78")
SYOZ25	52mm (2.06")	35mm (1.38")
RDO 35	52mm (2.06")	35mm (1.38")
462E / SYOZ25	52mm (2.06")	35mm (1.38")
EOC 32	60mm (2.36")	43.7mm (1.72")



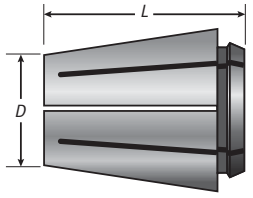
SYOZ Collet Style

DA Collet	L	D
DA180	1.625"	1.035"
DA100	1.438"	.769"
DA200	1.188"	.531"
DA300	1.000"	.375"



DA Collet Style

DNA Collet	L	D
DNA 11	16.9mm (0.67")	11.5mm (0.45")
DNA 16	24mm (0.94")	17mm (0.67")
DNA 20	30.42mm (1.20")	21.10mm (0.83")
DNA 32	40mm (1.57")	33.25mm (1.31")



DNA Collet Style

Special Order Collets Call 800-597-3921

Length _____ Diameter _____ Other Markings _____

Length _____ Diameter _____ Other Markings _____

Precision End Mill Holders

Double your tool life or better with our high-precision End Mill holders.

Manufactured to an H5 Bore Tolerance



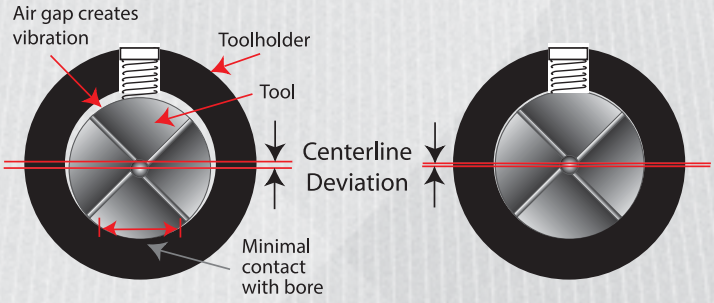
H5 is the most accurate bore I.D., and provides improved T.I.R. for extended cutting tool life. (see T.I.R. diagram below)

CoolBLAST ports

CoolBLAST and DIN B Coolant Available

CoolBLAST coolant ports blast coolant on tool path. CoolFLEX holders feature coolant-thru tool or DIN B coolant.

Others T.I.R. .0008" ***Techniks .0002"***



http://ow.ly/rIk7B
View the video.

TECHNIKS
BUILT FOR SPEED
www.techniksusa.com
a Quintec Company

You lose 10% of tool life for every .0001" of T.I.R. Techniks End Mill holders are manufactured to an H5 bore tolerance to extend cutting tool life.

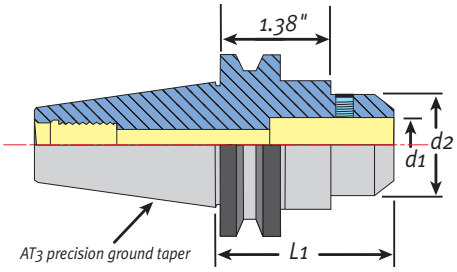
Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!

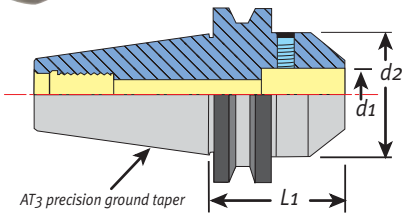
CAT40 Precision End Mill Holders



Techniks Certified for bore and taper tolerances



Stubby



Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*

CAT40 Stubby Length End Mill Holders

Part No.	Description	d1	L1	d2
22907-1.75	CAT40 x 1/8" I.D. - 1.75"	1/8"	1.75"	.75"
22909-1.75	CAT40 x 3/16" I.D. - 1.75"	3/16"	1.75"	.79"
22911-1.75	CAT40 x 1/4" I.D. - 1.75"	1/4"	1.75"	.79"
22913-1.75	CAT40 x 5/16" I.D. - 1.75"	5/16"	1.75"	.88"
22915-1.75	CAT40 x 3/8" I.D. - 1.75"	3/8"	1.75"	.88"
22916-1.75	CAT40 x 7/16" I.D. - 1.75"	7/16"	1.75"	1.12"
22917-1.75	CAT40 x 1/2" I.D. - 1.75"	1/2"	1.75"	1.50"
22919-1.75	CAT40 x 5/8" I.D. - 1.75"	5/8"	1.75"	1.50"
22921-1.75	CAT40 x 3/4" I.D. - 1.75"	3/4"	1.75"	1.75"
22925A-1.75	CAT40 x 1.0" I.D. - 1.75"	1.0"	1.75"	2"
22927A-2	CAT40 x 1-1/4" I.D. - 2"	1-1/4"	2"	2.5"

CAT40 End Mill Holders Inch Size

Part No.	Description	d1	L1	d2
22907	CAT40 x 1/8" I.D. - 2.37"	1/8"	2.37"	.69"
22909	CAT40 x 3/16" I.D. - 2.5"	3/16"	2.5"	.69"
22911	CAT40 x 1/4" I.D. - 3"	1/4"	3"	.78"
22911-2.5	CAT40 x 1/4" I.D. - 2.5	1/4"	2.5"	.78"
22913	CAT40 x 5/16" I.D. - 3"	5/16"	3"	.88"
22913-2.5	CAT40 x 5/16" I.D. - 2.5"	5/16"	2.5"	.88"
22915	CAT40 x 3/8" I.D. - 3"	3/8"	3"	1.0"
22915-2.5	CAT40 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
22916-2.5	CAT40 x 7/16" I.D. - 2.5"	7/16"	2.5"	1.13"
22917	CAT40 x 1/2" I.D. - 3"	1/2"	3"	1.25"
22917-2.5	CAT40 x 1/2" I.D. - 2.5"	1/2"	2.5"	1.25"
22917-2.63	CAT40 x 1/2" I.D. - 2.63"	1/2"	2.63"	1.25"
22919	CAT40 x 5/8" I.D. - 3"	5/8"	3"	1.5"
22920	CAT40 x 5/8' I.D. - 3.75"	5/8'	3.75"	1.5"
22921	CAT40 x 3/4" I.D. - 3.5"	3/4"	3.5"	1.75"
22921-3	CAT40 x 3/4" I.D. - 3"	3/4"	3"	1.75"
22923	CAT40 x 7/8" I.D. - 3.5"	7/8"	3.5"	1.88"
22925-3	CAT40 x 1.0" I.D. - 3"	1.0"	3"	2"
22925	CAT40 x 1.0" I.D. - 4"	1.0"	4"	2"
22927	CAT40 x 1.25" I.D. - 4.6"	1.25"	4.6"	2.5"
22927-4	CAT40 x 1.25" I.D. - 4"	1.25"	4"	2.5"
22929	CAT40 x 1.5" I.D. - 4.5"	1.5"	4.5"	2.5"

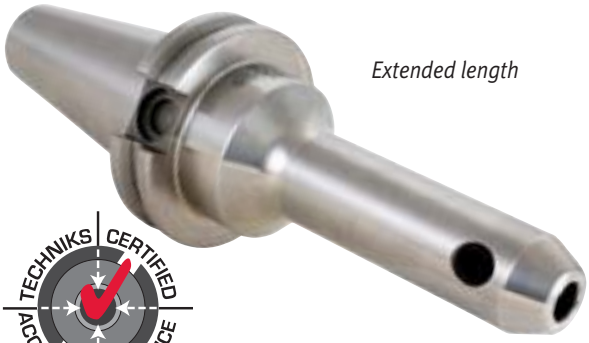
CAT40 End Mill Holders Metric Size

Part No.	Description	d1	L1	d2
22963	CAT40 x 6mm I.D. - 2.5"	6mm	2.5"	25mm
22965	CAT40 x 8mm I.D. - 2.5"	8mm	2.5"	28mm
22967	CAT40 x 10mm I.D. - 2.5"	10mm	2.5"	35mm
22969	CAT40 x 12mm I.D. - 2.5"	12mm	2.5"	42mm
22971	CAT40 x 16mm I.D. - 2.5"	16mm	2.5"	48mm
22973	CAT40 x 20mm I.D. - 3"	20mm	3"	52mm
22975	CAT40 x 25mm I.D. - 4"	25mm	4"	65mm
22977	CAT40 x 32mm I.D. - 4"	32mm	4"	72mm

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

CAT40 Precision End Mill Holders

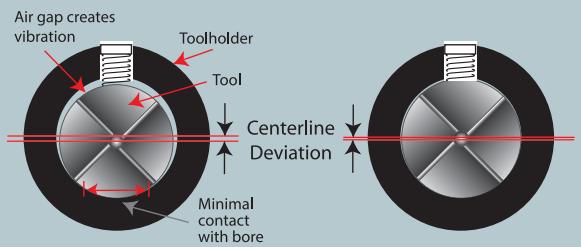


Extended length

Techniks Certified for bore and taper tolerances

Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life
for every .0001" of T.I.R.



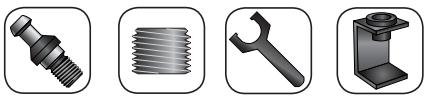
Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*

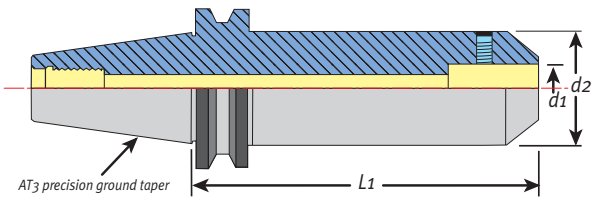


Rigid Reach

Our Rigid Reach End Mill holders are great for machining in tight areas at extended length where tolerance is important. The tapered design improves rigidity and overall cutting performance.



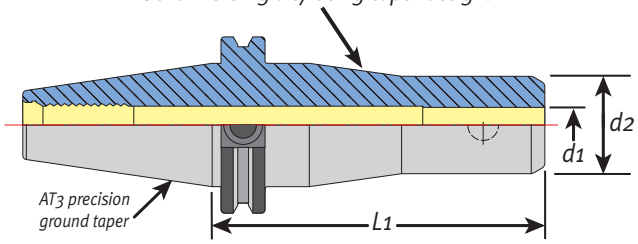
Retention Knobs pg. 204 | Lock Screws pg. 85 | Wrenches pg. 208 | Tightening Stands pg. 210



CAT40 Extended Length End Mill Holders

Part No.	Description	d1	L1	d2
22907-6	CAT40 x 1/8" I.D. - 6"	1/8"	6"	.69"
22909-6	CAT40 x 3/16" I.D. - 6"	3/16"	6"	.69"
22911-6	CAT40 x 1/4" I.D. - 6"	1/4"	6"	.78"
22915-5	CAT40 x 3/8" I.D. - 5"	3/8"	5"	1.0"
22917-4.63	CAT40 x 1/2" I.D. - 4.63"	1/2"	4.63"	1.25"
22920-5.75	CAT40 x 5/8" I.D. - 5.75"	5/8"	5.75"	1.5"
22921-5	CAT40 x 3/4" I.D. - 5"	3/4"	5"	1.75"
22925-6	CAT40 x 1.0" I.D. - 6"	1.0"	6"	2"
22927-6	CAT40 x 1 -1/4" I.D. - 6"	1 -1/4"	6"	2.5"

30% more rigidity using taper design.



CAT40 Rigid Reach End Mill Holders

Part No.	Description	d1	L1	d2
22907-5.00-RR	CAT40 x 1/8" I.D. - 5"	1/8"	5"	.78"
22909-4.72-RR	CAT40 x 3/16" I.D. - 4.72"	3/16"	4.72"	.78"
22911-4.72-RR	CAT40 x 1/4" I.D. - 4.72"	1/4"	4.72"	.78"
22913-4.72-RR	CAT40 x 5/16" I.D. - 4.72"	5/16"	4.72"	.86"
22915-4.72-RR	CAT40 x 3/8" I.D. - 4.72"	3/8"	4.72"	1.0"
22917-4.72-RR	CAT40 x 1/2" I.D. - 4.72"	1/2"	4.72"	1.38"

CAT40 Precision CoolBLAST End Mill Holders



CoolBLAST Features

- *Blast coolant directly on tool path*
- *No need for expensive coolant-thru tools*
- *High precision bore (H5) is best in industry*

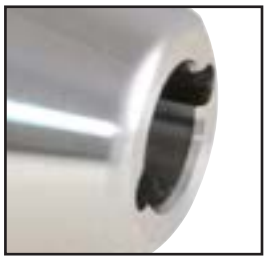
Techniks Certified for bore and taper tolerances


Retention Knobs pg. 204


Lock Screws pg. 85


Wrenches pg. 208


Tightening Stands pg. 210

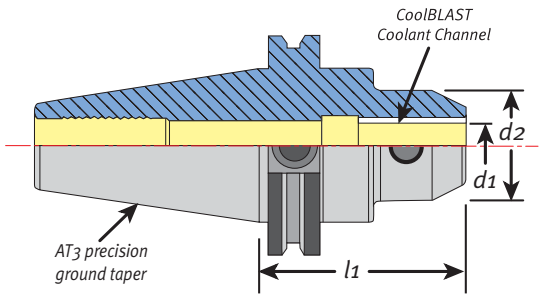




CoolBLAST in-the-bore coolant ports blast coolant on the tool path, even at high RPMs.

CAT40 CoolBLAST End Mill Holders

Part No.	Description	d1	l1	d2
22909-6B	CAT40 x 3/16" I.D. - 6"	3/16"	6"	.69"
22911-2.5B	CAT40 x 1/4" I.D. - 2.5"	1/4"	2.5"	.78"
22911-6B	CAT40 x 1/4" I.D. - 6"	1/4"	6"	.78"
22915-2.5B	CAT40 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
22915-4B	CAT40 x 3/8" I.D. - 4"	3/8"	4"	1.0"
22917-2.5B	CAT40 x 1/2" I.D. - 2.5"	1/2"	2.5"	1.25"
22917B	CAT40 x 1/2" I.D. - 3"	1/2"	3"	1.25"
22917-4B	CAT40 x 1/2" I.D. - 4"	1/2"	4"	1.25"
22919B	CAT40 x 5/8" I.D. - 3"	5/8"	3"	1.5"
22919-4B	CAT40 x 5/8" I.D. - 4"	5/8"	4"	1.5"
22921-1.75B	CAT40 x 3/4" I.D. - 1.75"	3/4"	1.75"	1.75"
22921-3B	CAT40 x 3/4" I.D. - 3"	3/4"	3"	1.75"
22921-4B	CAT40 x 3/4" I.D. - 4"	3/4"	4"	1.75"
22925B	CAT40 x 1.0" I.D. - 4"	1.0"	4"	2"



Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

CAT40 Precision CoolFLEX End Mill Holders



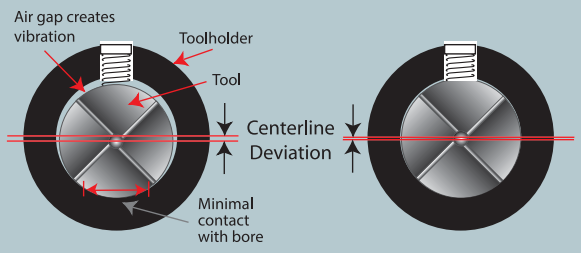
CoolFLEX Features

- *Coolant-thru spindle or thru flange (DIN B)*
- *No need for expensive coolant-thru tools*
- *H5 bore tolerance to increase tool life*

Techniks Certified for bore and taper tolerances

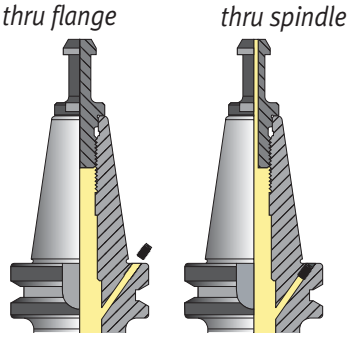
Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life for every .0001" of T.I.R.



CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.

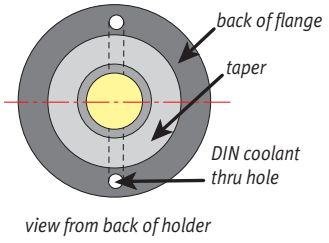


CAT40 CoolFLEX End Mill Holders

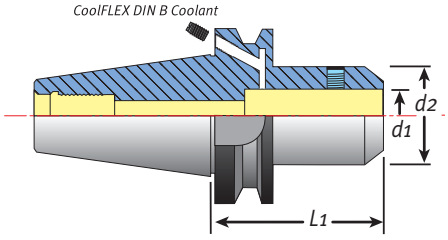
Part No.	Description	d1	l1	d2
22911F	CAT40 x 1/4" I.D. - 3"	1/4"	3"	.78"
22911-2.5F	CAT40 x 1/4" I.D. - 2.5"	1/4"	2.5"	.78"
22913-2.5F	CAT40 x 5/16" I.D. - 2.5"	5/16"	2.5"	.88"
22913F	CAT40 x 5/16" I.D. - 3	5/16"	3"	.88"
22915-2.5F	CAT40 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
22915F	CAT40 x 3/8" I.D. - 3"	3/8"	3"	1.0"
22915-5F	CAT40 x 3/8" I.D. - 5"	3/8"	5"	1.0"
22916-2.5F	CAT40 x 7/16" I.D. - 2.5"	7/16"	2.5"	1.13"
22917F	CAT40 x 1/2" I.D. - 3"	1/2"	3"	1.25"
22919-1.75F	CAT40 x 5/8" I.D. - 1.75"	5/8"	1.75"	1.5"
22919F	CAT40 x 5/8" I.D. - 3"	5/8"	3"	1.5"
22921-1.75F	CAT40 x 3/4" I.D. - 1.75"	3/4"	1.75"	1.75"
22921-3F	CAT40 x 3/4" I.D. - 3"	3/4"	3"	1.75"
22921-5F	CAT40 x 3/4" I.D. - 5"	3/4"	5"	1.75"
22925-1.75F	CAT40 x 1.0" I.D. - 1.75"	1.0"	1.75"	2"
22925F	CAT40 x 1.0" I.D. - 4"	1.0"	4"	2"
22927F	CAT40 x 1-1/4" I.D. - 4.6"	1-1/4"	4.6"	2.5"
22929F	CAT40 x 1-1/2" I.D. - 4.5"	1-1/2"	4.5"	2.5"

Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw



view from back of holder



CAT40 Precision CoolBLAST/CoolFLEX End Mill Holders



Techniks Certified for bore and taper tolerances

CoolBLAST Features

- *Blast coolant directly on tool path*
- *No need for expensive coolant-thru tools*
- *High precision bore (H5) is best in industry*

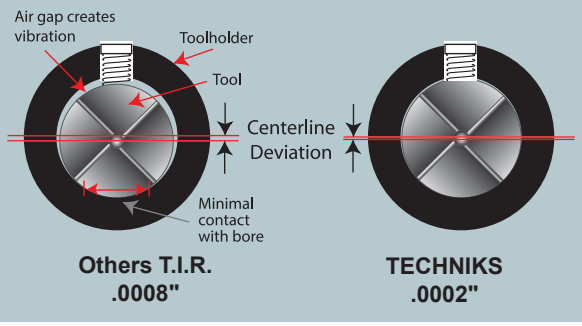


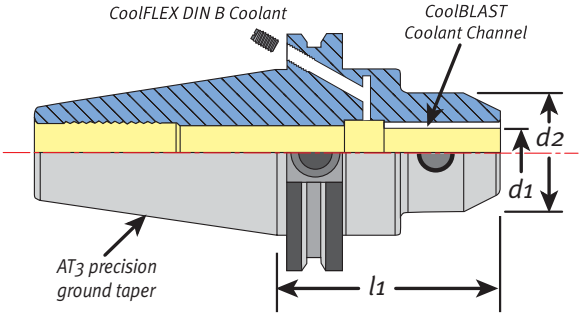


CoolBLAST in-the-bore coolant ports blast coolant on the tool path, even at high RPMs.

Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life for every .0001" of T.I.R.



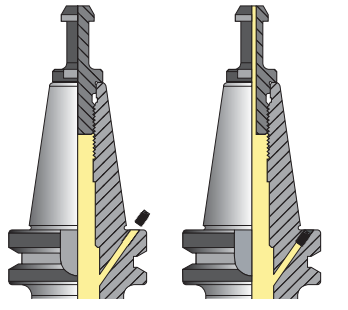


CAT40 CoolBLAST Holders with CoolFLEX

Part No.	Description	d1	l1	d2
22909-6FB	CAT40 x 3/16" I.D. - 6"	3/16"	6"	.69"
22911-2.5FB	CAT40 x 1/4" I.D. - 2.5"	1/4"	2.5"	.78"
22911-4FB	CAT40 x 1/4" I.D. - 4"	1/4"	4"	.78"
22911-6FB	CAT40 x 1/4" I.D. - 6"	1/4"	6"	.78"
22913-6FB	CAT40 x 5/16" I.D. - 6"	5/16"	6"	.88"
22915-2.5FB	CAT40 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
22915-5FB	CAT40 x 3/8" I.D. - 5"	3/8"	5"	1.0"
22917-2.5FB	CAT40 x 1/2" I.D. - 2.5"	1/2"	2.5"	1.25"
22917-4FB	CAT40 x 1/2" I.D. - 4"	1/2"	4"	1.25"
22919-1.75FB	CAT40 x 5/8" I.D. - 1.75"	5/8"	1.75"	1.5"
22920-6FB	CAT40 x 5/8" I.D. - 6	5/8"	6"	1.5"
22921-3FB	CAT40 x 3/4" I.D. - 3"	3/4"	3"	1.75"
22925FB	CAT40 x 1.0" I.D. - 4"	1.0"	4"	2"

CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.



Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw

Distributors - Call to register for our Distributors Webstore for full online access.

CAT40 DualDRIVE for Dual-Contact Spindles



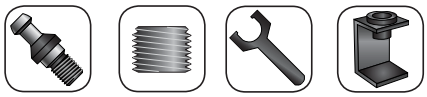
Features

- *New one-piece design for dual-contact spindles*
- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*

Benefits

- *Better rigidity and reduced vibration (chatter)*
- *Improved performance at high metal removal rates and when machining at extended lengths*

Techniks Certified for bore and taper tolerances



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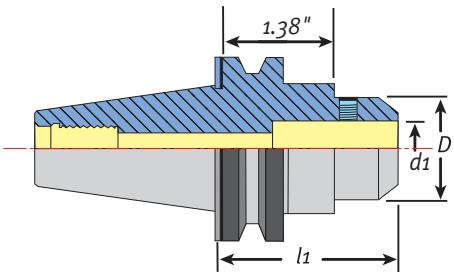
See an on machine demonstration video of DualDRIVE compared to standard toolholders at:
http://ow.ly/sUOqL



Dual-Contact Spindles

Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.



CAT40 DualDRIVE End Mill Holders

Part No.	Description d1 – l1	l1	d1	D
43.653.56.300	CAT40 x SLN 3/8" - 3" DualDRIVE toolholder	3"	3/8"	1"
43.653.56.500	CAT40 x SLN 3/8" - 5" DualDRIVE toolholder	5"	3/8"	1"
43.653.58.300	CAT40 x SLN 1/2" - 3" DualDRIVE toolholder	3"	1/2"	1.25"
43.653.58.463	CAT40 x SLN 1/2" - 4.63" DualDRIVE toolholder	4.63"	1/2"	1.25"
43.653.61.300	CAT40 x SLN 5/8" - 3" DualDRIVE toolholder	3"	5/8"	1.5"
43.653.61.375	CAT40 x SLN 5/8" - 3.75" DualDRIVE toolholder	3.75"	5/8"	1.5"
43.653.61.575	CAT40 x SLN 5/8" - 5.75" DualDRIVE toolholder	5.75"	5/8"	1.5"
43.653.64.350	CAT40 x SLN 3/4" - 3.5" DualDRIVE toolholder	3.5"	3/4"	1.75"
43.653.64.500	CAT40 x SLN 3/4" - 5" DualDRIVE toolholder	5"	3/4"	1.75"
43.653.68.400	CAT40 x SLN 1.0" - 4" DualDRIVE toolholder	4"	1.0"	2"
43.653.68.600	CAT40 x SLN 1.0" - 6" DualDRIVE toolholder	6"	1.0"	2"
43.653.72.460	CAT40 x SLN 1-1/4" - 4.6" DualDRIVE toolholder	4.6"	1-1/4"	2.5"
43.653.72.400	CAT40 x SLN 1-1/4" - 4" DualDRIVE toolholder	4"	1-1/4"	2.5"
43.653.72.600	CAT40 x SLN 1-1/4" - 6" DualDRIVE toolholder	6"	1-1/4"	2.5"
43.653.77.450	CAT40 x SLN 1-1/2" - 4 1/2" DualDRIVE toolholder	4.5"	1-1/2"	2.5"

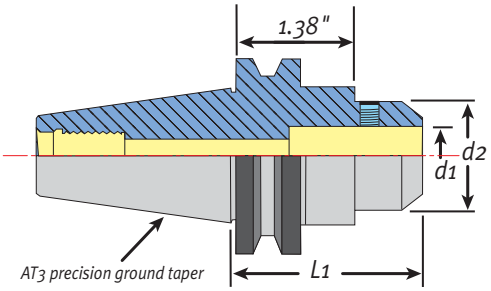
CAT50 Precision End Mill Holders



Techniks Certified for bore and taper tolerances

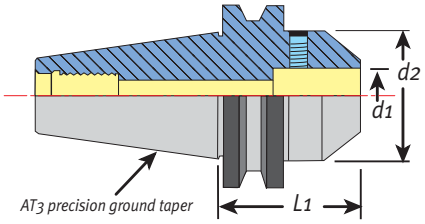
Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*





Stubby



CAT50 End Mill Holders Inch Size

Part No.	Description	d1	L1	d2
22931	CAT50 x 1/4" I.D. - 4"	1/4"	4"	.78"
22933	CAT50 x 5/16" I.D. - 4"	5/16"	4"	.88"
22935	CAT50 x 3/8" I.D. - 4"	3/8"	4"	1.0"
22937	CAT50 x 1/2" I.D. - 4"	1/2"	4"	1.25"
22939-3	CAT50 x 5/8" I.D. - 3"	5/8"	3"	1.5"
22939	CAT50 x 5/8" I.D. - 4"	5/8"	4"	1.5"
22941-3	CAT50 x 3/4" I.D. - 3"	3/4"	3"	1.75"
22941	CAT50 x 3/4" I.D. - 4"	3/4"	4"	1.75"
22943	CAT50 x 7/8" I.D. - 4"	7/8"	4"	1.88"
22945	CAT50 x 1.0" I.D. - 4"	1.0"	4"	2"
22947	CAT50 x 1-1/4" I.D. - 4.6"	1-1/4"	4.6"	2.5"
22949	CAT50 x 1-1/2" I.D. - 4.6"	1-1/2"	4.6"	2.5"

CAT50 Stubby Length End Mill Holders

Part No.	Description	d1	L1	d2
22931-2 1/2	CAT50 x 1/4" I.D. - 2.5"	1/4"	2.5"	.78"
22935-2 1/2	CAT50 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
22937-2 5/8	CAT50 x 1/2" I.D. - 2.67"	1/2"	2.67"	1.5"
22939-9/16-1.44	CAT50 x 9/16" I.D. - 1.44"	9/16"	1.44"	1.5"
22939-9/16-3	CAT50 x 9/16" I.D. - 3"	9/16"	3"	1.5"
22939-1.44	CAT50 x 5/8" I.D. - 1.44"	5/8"	1.44"	1.5"
22941-1.44	CAT50 x 3/4" I.D. - 1.44"	3/4"	1.44"	1.75"
22945-2.62	CAT50 x 1.0" I.D. - 2.62"	1"	2.62"	2"
22947-2.62	CAT50 x 1-1/4" I.D. - 2.62"	1-1/4"	2.62"	2.5"
22949-2	CAT50 x 1-1/2" I.D. - 2"	1-1/2"	2"	2.75"

CAT50 End Mill Holders Metric Size

Part No.	Description	d1	L1	d2
22981	CAT50 x 6mm I.D. - 4"	6mm	4"	25mm
22983	CAT50 x 8mm I.D. - 4"	8mm	4"	28mm
22985	CAT50 x 10mm I.D. - 4"	10mm	4"	35mm
22987	CAT50 x 12mm I.D. - 4"	12mm	4"	42mm
22989	CAT50 x 16mm I.D. - 4"	16mm	4"	48mm
22990	CAT50 x 20mm I.D. - 3"	20mm	3"	52mm
22993	CAT50 x 25mm I.D. - 4"	25mm	4"	65mm
22996	CAT50 x 32mm I.D. - 4.6"	32mm	4.6"	72mm

Need it FAST? We offer Same Day Shipping until 6:00 pm E.S.T.

SYIC

CAT50 Precision End Mill Holders



Extended length

Techniks Certified for bore and taper tolerances



Retention Knobs pg. 204



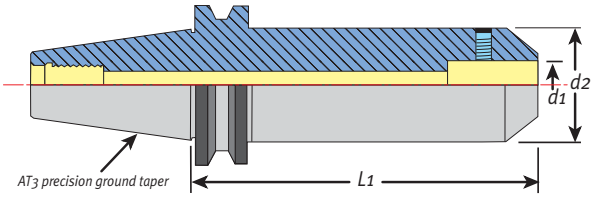
Lock Screws pg. 85



Wrenches pg. 208



Tightening Stands pg. 210



Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*

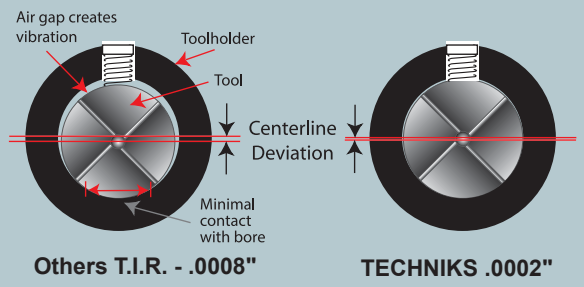


Rigid Reach

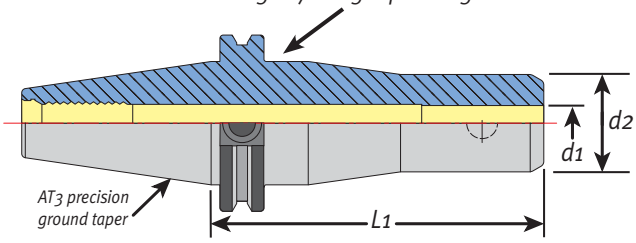
Our Rigid Reach End Mill holders are great for machining in tight areas at extended length where tolerance is important. The tapered design improves rigidity and overall cutting performance.

Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life for every .0001" T.I.R.



30% more rigidity using taper design.



CAT50 Extended Length End Mill Holders

Part No.	Description	d1	L1	d2
22935-6	CAT50 x 3/8" I.D. - 6"	3/8"	6"	1.0"
22936-8	CAT50 x 3/8" I.D. - 8"	3/8"	8"	1.0"
22937-6	CAT50 x 1/2" I.D. - 6"	1/2"	6"	1.25"
22937-8	CAT50 x 1/2" I.D. - 8"	1/2"	8"	1.25"
22939-6	CAT50 x 5/8" I.D. - 6"	5/8"	6"	1.5"
22939-8	CAT50 x 5/8" I.D. - 8"	5/8"	8"	1.5"
22941-5.75	CAT50 x 3/4" I.D. - 5.75"	3/4"	5.75"	1.75"
22941-6	CAT50 x 3/4" I.D. - 6"	3/4"	6"	1.75"
22941-8	CAT50 x 3/4" I.D. - 8"	3/4"	8"	1.75"
22943-6	CAT50 x 7/8" I.D. - 6"	7/8"	6"	1.88"
22943-8	CAT50 x 7/8" I.D. - 8"	7/8"	8"	1.88"
22945-6	CAT50 x 1.0" I.D. - 6"	1.0"	6"	2"
22946-8	CAT50 x 1.0" I.D. - 8"	1.0"	8"	2"
22947-6	CAT50 x 1-1/4" I.D. - 6"	1-1/4"	6"	2.5"
22947-8	CAT50 x 1-1/4" I.D. - 8"	1-1/4"	8"	2.5"
22951	CAT50 x 2" I.D. - 6"	2"	6"	3.75"

CAT50 Rigid Reach End Mill Holders

Part No.	Description	d1	L1	d2
22931-6.5-RR	CAT50 x 1/4" I.D. - 6.5"	1/4"	6.5"	.78"
22935-6.5-RR	CAT50 x 3/8" I.D. - 6.5"	3/8"	6.5"	1.0"
22937-6.5-RR	CAT50 x 1/2" I.D. - 6.5"	1/2"	6.5"	1.38"
22939-7.25-RR	CAT50 x 5/8" I.D. - 7.25"	5/8"	7.25"	1.5"
22941-7.25-RR	CAT50 x 3/4" I.D. - 7.25"	3/4"	7.25"	1.75"
22945-8-RR	CAT50 x 1.0" I.D. - 8"	1.0"	8"	2"

CAT50 Precision CoolBLAST End Mill Holders



Techniks Certified for bore and taper tolerances

CoolBLAST Features

- *Blast coolant directly on tool path*
- *No need for expensive coolant-thru tools*
- *High precision bore (H5) is best in industry*



Retention Knobs pg. 204



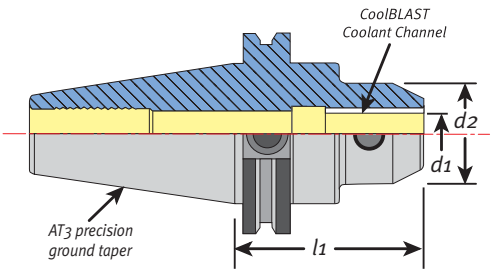
Lock Screws pg. 85



Wrenches pg. 208



Tightening Stands pg. 210







CoolBLAST in-the-bore coolant ports blast coolant on the tool path, even at high RPMs.

CAT50 CoolBLAST End Mill Holders

Part No.	Description	d1	l1	d2
22931-2.5B	CAT50 x 1/4" I.D. - 2.5"	1/4"	2.5"	.78"
22931B	CAT50 x 1/4" I.D. - 4"	1/4"	4"	.78"
22931-6B	CAT50 x 1/4" I.D. 6"	1/4"	6"	.78"
22935-2.5B	CAT50 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
22935B	CAT50 x 3/8" I.D. - 4"	3/8"	4"	1.0"
22935-6B	CAT50 x 3/8" I.D. - 6"	3/8"	6"	1.0"
22935-8B	CAT50 x 3/8" I.D. - 8"	3/8"	8"	1.0"
22937-2.625B	CAT50 x 1/2" I.D. - 2-5/8"	1/2"	2-5/8"	1.25"
22937B	CAT50 x 1/2" I.D. - 4"	1/2"	4"	1.25"
22937-6B	CAT50 x 1/2" I.D. - 6"	1/2"	6"	1.25"
22937-8B	CAT50 x 1/2" I.D. - 8"	1/2"	8"	1.25"
22939-3B	CAT50 x 5/8" I.D. - 3"	5/8"	3"	1.5"
22939B	CAT50 x 5/8" I.D. - 4"	5/8"	4"	1.5"
22939-6B	CAT50 x 5/8" I.D. - 6"	5/8"	6"	1.5"
22941-1.44B	CAT50 x 3/4" I.D. - 1.44"	3/4"	1.44"	1.75"

Part No.	Description	d1	l1	d2
22941-3B	CAT50 x 3/4" I.D. - 3"	3/4"	3"	1.75"
22941B	CAT50 x 3/4" I.D. - 4"	3/4"	4"	1.75"
22941-6B	CAT50 x 3/4" I.D. - 6"	3/4"	6"	1.75"
22941-8B	CAT50 x 3/4" I.D. - 8"	3/4"	8"	1.75"
22943-6B	CAT50 x 7/8" I.D. - 6"	7/8"	6"	1.88"
22943-8B	CAT50 x 7/8" I.D. - 8"	7/8"	8"	2"
22945B	CAT50 x 1.0" I.D. - 4"	1.0 "	4"	2"
22945-6B	CAT50 x 1.0" I.D. - 6"	1.0"	6"	2"
22946-8B	CAT50 x 1.0" I.D. - 8"	1.0"	8"	2"
22947-2.62B	CAT50 x 1-1/4" I.D. - 2.62"	1-1/4"	2.62"	2.5"
22947B	CAT50 x 1-1/4" I.D. - 4.6"	1-1/4"	4.6"	2.5"
22947-6B	CAT50 x 1-1/4" I.D. - 6"	1-1/4"	6"	2.5"
22947-8B	CAT50 x 1-1/4" I.D. - 8"	1-1/4"	8"	2.5"
22949B	CAT50 x 1-1/2" I.D. - 4.6"	1-1/2"	4.6"	2.5"
22951B	CAT50 x 2" I.D. - 6"	2"	6"	3.75"

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

CAT50 Precision CoolFLEX End Mill Holders



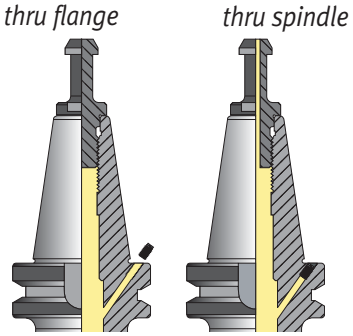
Techniks Certified for bore and taper tolerances

CoolFLEX Features

- *Coolant-thru spindle or thru flange (DIN B)*
- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*

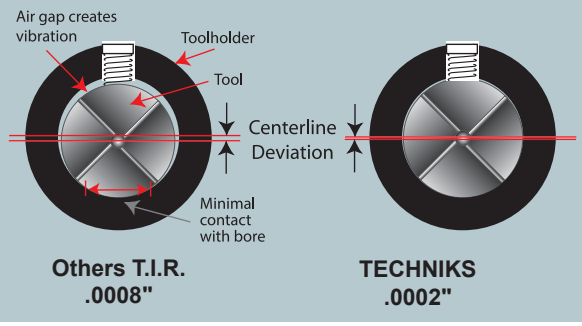
CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.



Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life for every .0001" of T.I.R.

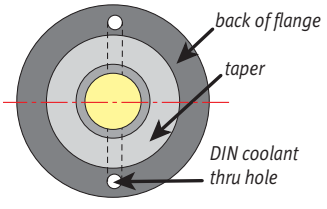


Replacement CoolFLEX Screws

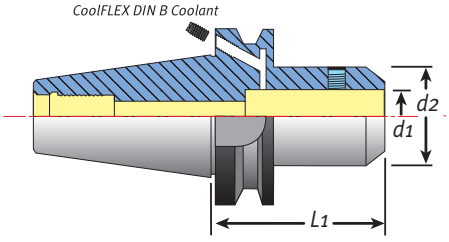
Part No.	Description
HSA-6-6	50 taper DIN B screw

CAT50 CoolFLEX End Mill Holders

Part No.	Description	d1	l1	d2
22931F	CAT50 x 1/4" I.D. - 4"	1/4"	4"	.78"
22935F	CAT50 x 3/8" I.D. - 4"	1/4"	4"	1.00"
22937F	CAT50 x 1/2" I.D. - 4"	1/2"	4"	1.25"
22937-6F	CAT50 x 1/2" I.D. - 6"	1/2"	6"	1.25"
22937-8F	CAT50 x 1/2" I.D. - 8"	1/2"	8"	1.25"
22939F	CAT50 x 5/8" I.D. - 4"	5/8"	4"	1.5"
22941-3F	CAT50 x 3/4" I.D. - 3"	3/4"	3"	1.75
22941F	CAT50 x 3/4" I.D. - 4"	3/4"	4"	1.75"
22945-2.62F	CAT50 x 1" I.D. - 2.62"	1.0"	2.62"	2"
22945F	CAT50 x 1.0" I.D. - 4"	1.0"	4"	2"
22947F	CAT50 x 1-1/4" I.D. - 4.6"	1-1/4"	4.6"	2.5"
22949F	CAT50 x 1-1/2" I.D. - 4.6"	1-1/2"	4.6"	2.5"



view from back of holder



CAT50 DualDRIVE for Dual-Contact Spindles



Techniks Certified for bore and taper tolerances

Features

- *New one-piece design for dual-contact spindles*
- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*

Benefits

- *Better rigidity and reduced vibration (chatter)*
- *Improved performance at high metal removal rates and when machining at extended lengths*

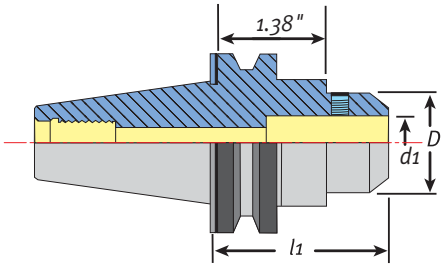
See an on machine demonstration video of DualDRIVE compared to standard toolholders at: http://ow.ly/sUOqL



Dual-Contact Spindles

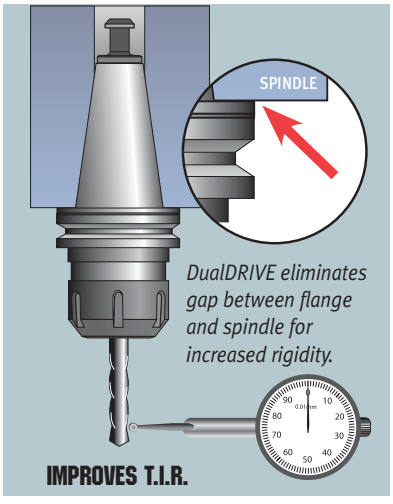
Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.



CAT50 DualDRIVE End Mill Holders

Part No.	Description d1 – L1	l1	d1	D
44.653.58.400	CAT50 x SLN 1/2" - 4" DualDRIVE	4"	1/2"	1.25"
44.653.58.600	CAT50 x SLN 1/2" - 6" DualDRIVE	6"	1/2"	1.25"
44.653.61.400	CAT50 x SLN 5/8" - 4" DualDRIVE	4"	5/8"	1.5"
44.653.61.600	CAT50 x SLN 5/8" - 6" DualDRIVE	6"	5/8"	1.5"
44.653.64.144	CAT50 x SLN 3/4" - 1.44" DualDRIVE	1.44"	3/4"	1.75"
44.653.64.300	CAT50 x SLN 3/4" - 3" DualDRIVE	3"	3/4"	1.75"
44.653.64.400	CAT50 x SLN 3/4" - 4" DualDRIVE	4"	3/4"	1.75"
44.653.64.600	CAT50 x SLN 3/4" - 6" DualDRIVE	6"	3/4"	1.75"
44.653.68.400	CAT50 x SLN 1.0" - 4" DualDRIVE	4"	1.0"	2"
44.653.68.262	CAT50 x SLN 1.0" - 2.62" DualDRIVE	2.62"	1.0"	2.484"
44.653.68.600	CAT50 x SLN 1.0" - 6" DualDRIVE	6"	1.0"	2.484"
44.653.72.262	CAT50 x SLN 1-1/4" - 2.62" DualDRIVE	2.62"	1-1/4"	2.75"
44.653.72.460	CAT50 x SLN 1-1/4" - 4.6" DualDRIVE	4.6"	1-1/4"	2.5"
44.653.72.600	CAT50 x SLN 1-1/4" - 6" DualDRIVE	6"	1-1/4"	2.75"
44.653.72.800	CAT50 x SLN 1-1/4" - 8" DualDRIVE	8"	1-1/4"	2.5"
44.653.77.460	CAT50 x SLN 1-1/2" - 4.6" DualDRIVE	4.6"	1-1/2"	2.5"
44.653.77.800	CAT50 x SLN 1-1/2" - 8" DualDRIVE	8"	1-1/2"	2.5"



Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

BT30 and BT30 DualDRIVE for Dual-Contact Spindles



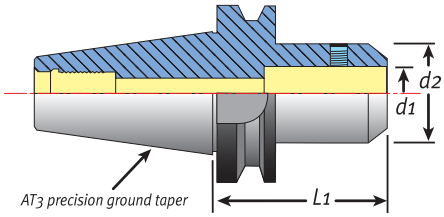
Techniks Certified for bore and taper tolerances

Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*

BT30 End Mill Holders

Part No.	Description	d1	L1	d2
17130-1/8	BT30 x 1/8" I.D. - 2.36" End Mill holder	1/8"	2.36"	.68"
17130-3/16	BT30 x 3/16" I.D. - 2.36" End Mill holder	3/16"	2.36"	.68"
17130-1/4	BT30 x 1/4" I.D. - 2.36" End Mill holder	1/4"	2.36"	.78"
17130-5/16	BT30 x 5/16" I.D. - 2.36" End Mill holder	5/16"	2.36"	.88"
17130-3/8	BT30 x 3/8" I.D. - 2.36" End Mill holder	3/8"	2.36"	1.0"
17130-7/16	BT30 x 7/16" I.D. - 2.36" End Mill holder	7/16"	2.36"	1.12"
17130-1/2	BT30 x 1/2" I.D. - 2.36" End Mill holder	1/2"	2.36"	1.25"
17130-5/8	BT30 x 5/8" I.D. - 2.36" End Mill holder	5/8"	2.36"	1.5"
17130-3/4	BT30 x 3/4" I.D. - 2.36" End Mill holder	3/4"	2.36"	1.75"





Techniks Certified for bore and taper tolerances

Features

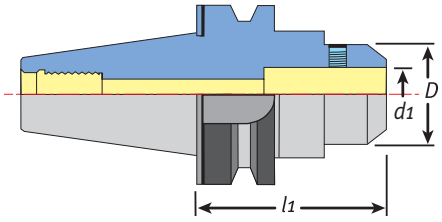
- *New one-piece design for dual-contact spindles*
- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*

Benefits

- *Better rigidity and reduced vibration*
- *Improved performance at high metal removal rates or extended lengths*

BT30 DualDRIVE End Mill Holders

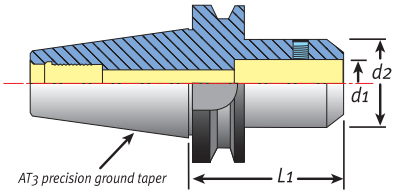
Part No.	Description d1 – l1	l1	d1	D
25.653.52.250	BT30 x SLN 1/8" - 2.5" DualDRIVE	2.5"	1/8"	.68"
25.653.53.250	BT30 x SLN 3/16" - 2.5" DualDRIVE	2.5"	3/16"	.68"
25.653.54.250	BT30 x SLN 1/4" - 2.5" DualDRIVE	2.5"	1/4"	.78"
25.653.56.250	BT30 x SLN 3/8" - 2.5" DualDRIVE	2.5"	3/8"	1.0"
25.653.58.250	BT30 x SLN 1/2" - 2.5" DualDRIVE	2.5"	1/2"	1.25"
25.653.61.250	BT30 x SLN 5/8" - 2.5" DualDRIVE	2.5"	5/8"	1.5"
25.653.64.300	BT30 x SLN 3/4" - 3" DualDRIVE	3"	3/4"	1.75"



BT40 Precision End Mill Holders



Techniks Certified for bore and taper tolerances

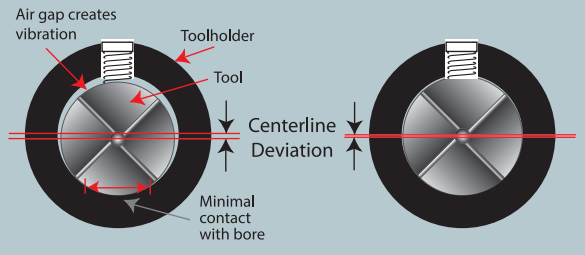


Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*

Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life
for every .0001" of T.I.R.



BT40 End Mill Holders Inch Size

Part No.	Description	d1	L1	d2
17140-1/8	BT40 x 1/8" I.D. - 2.5"	1/8"	2.5"	.68"
17140-3/16	BT40 x 3/16" I.D. - 2.5"	3/16"	2.5"	.68"
17140-1/4	BT40 x 1/4" I.D. - 2.5"	1/4"	2.5"	.78"
17140-5/16	BT40 x 5/16" I.D. - 2.5"	5/16"	2.5"	.88"
17140-3/8	BT40 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
17140-7/16	BT40 x 7/16" I.D. - 2.5"	7/16"	2.5"	1.10"
17140-1/2	BT40 x 1/2" I.D. - 2.5"	1/2"	2.5"	1.25"
17140-5/8	BT40 x 5/8" I.D. - 2.5"	5/8"	2.5"	1.50"
17140-3/4	BT40 x 3/4" I.D. - 2.5"	3/4"	2.5"	1.75"
17140-1	BT40 x 1.0" I.D. - 3.56"	1.0"	3.56"	2"
17140-1-1/4	BT40 x 1-1/4" I.D. - 3.56"	1-1/4"	3.56"	2.5"
17140-1-1/2	BT40 x 1-1/2" I.D. - 3.56"	1-1/2"	3.56"	2.5"

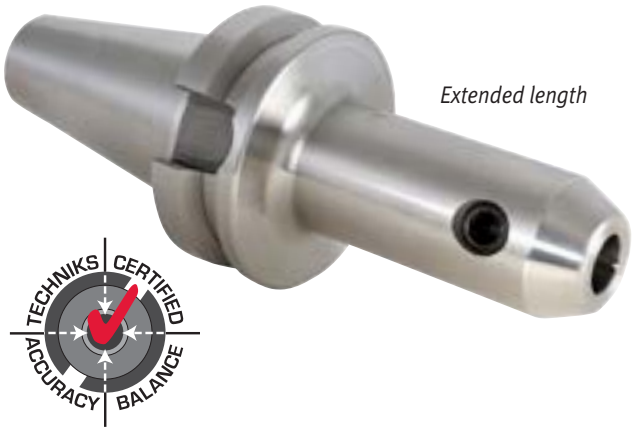
BT40 End Mill Holders Metric Size

Part No.	Description	d1	L1	d2
17131	BT40 x 6mm I.D. - 50mm	6mm	50mm	25mm
17132	BT40 x 8mm I.D. - 50mm	8mm	50mm	28mm
17133	BT40 x 10mm I.D. - 63mm	10mm	63mm	35mm
17134	BT40 x 12mm I.D. - 63mm	12mm	63mm	42mm
17135	BT40 x 16mm I.D. - 63mm	16mm	63mm	48mm
17135-18	BT40 x 18mm I.D. - 63mm	18mm	63mm	50mm
17136	BT40 x 20mm I.D. - 63mm	20mm	63mm	52mm
17137	BT40 x 25mm I.D. - 100mm	25mm	100mm	65mm
17138	BT40 x 32mm I.D. - 100mm	32mm	100mm	72mm

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

BT40 Precision End Mill Holders



Extended length

Techniks Certified for bore and taper tolerances



Retention Knobs pg. 204



Lock Screws pg. 85



Wrenches pg. 208



Tightening Stands pg. 210

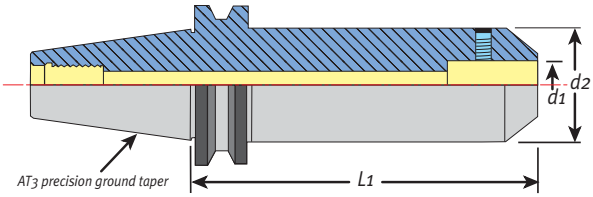
Techniks Certified Tooling Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*

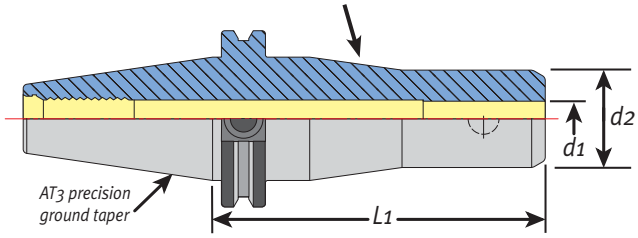


Rigid Reach

Our Rigid Reach End Mill holders are great for machining in tight areas at extended length where tolerance is important. The tapered design improves rigidity and overall cutting performance.



30% more rigidity using taper design.



BT40 Extended Length End Mill Holders

Part No.	Description	d1	L1	d2
17140-1/8-4	BT40 x 1/8" I.D. - 4"	1/8"	4"	.68"
17140-3/16-4	BT40 x 3/16" I.D. - 4"	3/16"	4"	.68"
17140-1/4-4	BT40 x 1/4" I.D. - 4"	1/4"	4"	.78"
17140-3/8-4	BT40 x 3/8" I.D. - 4"	3/8"	4"	1.0"
17140-1/2-4	BT40 x 1/2" I.D. - 4"	1/2"	4"	1.25"
17140-5/8-4	BT40 x 5/8" I.D. - 4"	5/8"	4"	1.5"
17140-3/4-4	BT40 x 3/4" I.D. - 4"	3/4"	4"	1.75"
17140-7/8-5	BT40 x 7/8" I.D. - 5"	7/8"	5"	1.75"
17140-1-5	BT40 x 1.0" I.D. - 5"	1.0"	5"	2"

BT40 Rigid Reach End Mill Holders

Part No.	Description	d1	L1	d2
17140-1/8-5.0-RR	BT40 x 1/8" I.D. - 5"	1/8"	5"	.78"
17140-3/16-4.72-RR	BT40 x 3/16" I.D. - 4.72"	3/16"	4.72"	.78"
17140-1/4-4.72-RR	BT40 x 1/4" I.D. - 4.72"	1/4"	4.72"	.78"
17140-3/8-4.72-RR	BT40 x 3/8" I.D. - 4.72"	3/8"	4.72"	1.0"
17140-1/2-4.72-RR	BT40 x 1/2" I.D. - 4.72"	1/2"	4.72"	1.38"
17140-3/4-6-RR	BT40 x 3/4" I.D. - 6"	3/4"	6"	1.38"

BT40 Precision CoolFLEX End Mill Holders



Techniks Certified for bore and taper tolerances

CoolFLEX Features

- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 15,000 RPM at G6.3*
- *High precision bore (H5) is best in industry*


Retention Knobs pg. 204

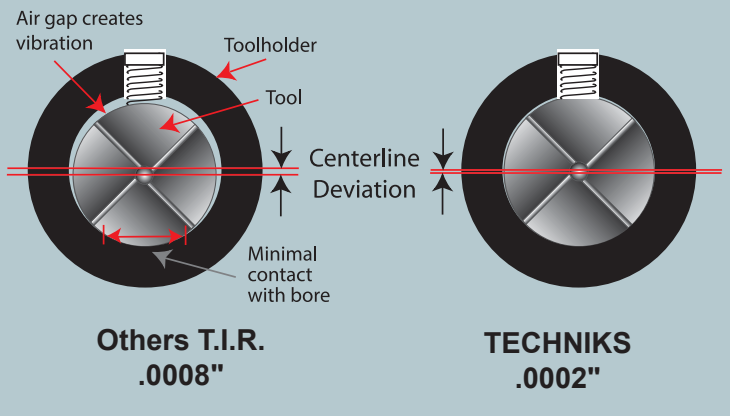

Lock Screws pg. 85


Wrenches pg. 208


Tightening Stands pg. 210

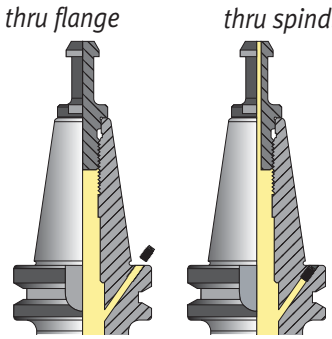
Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life for every .0001" of T.I.R.



CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.

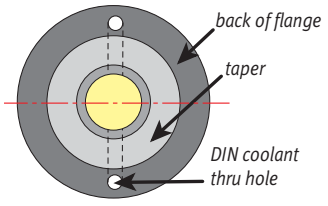


BT40 CoolFLEX End Mill Holders

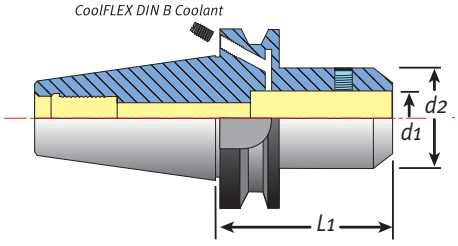
Part No.	Description	d1	L1	d2
17140-1/4F	BT40 x 1/4" I.D. - 2.5"	1/4"	2.5"	.78"
17140-3/8F	BT40 x 3/8" I.D. - 2.5"	3/8"	2.5"	1.0"
17140-1/2F	BT40 x 1/2" I.D. - 2.5"	1/2"	2.5"	1.25"
17140-5/8F	BT40 x 5/8" I.D. - 2.5"	5/8"	2.5"	1.50"
17140-3/4F	BT40 x 3/4" I.D. - 2.5"	3/4"	2.5"	1.75"
17140-1F	BT40 x 1.0" I.D. - 3.56"	1.0"	3.56"	2"
17140-1-1/4F	BT40 x 1-1/4" I.D. - 3.56"	1-1/4"	3.56"	2.5"

Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw



view from back of holder



Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

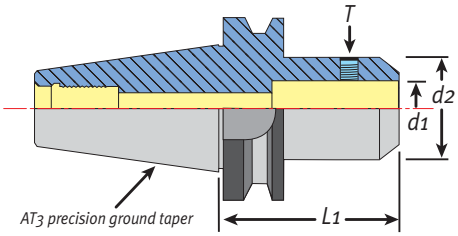
BT50 Precision End Mill Holders – End Mill Lock Screws



Techniks Certified for bore and taper tolerances

Features

- *High precision bore (H5) is best in industry*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*



BT50 End Mill Holders

Part No.	Description	d1	l1	d2
17150-1/4	BT50 x 1/4" I.D. - 3"	1/4"	3"	.78"
17150-3/8	BT50 x 3/8" I.D. - 2.75"	3/8"	2.75"	1.0"
17150-1/2	BT50 x 1/2" I.D. - 3"	1/2"	3"	1.25"
17150-5/8	BT50 x 5/8" I.D. - 3"	5/8"	3"	1.5"
17150-3/4	BT50 x 3/4" I.D. - 3"	3/4"	3"	1.75"
17150-1-4.5	BT50 x 1.0" I.D. - 4.5"	1.0"	4.5"	2"
17150-1-6	BT50 x 1.0" I.D. - 6"	1.0"	6"	2"
17150-1-1/4-4.5	BT50 x 1.25" I.D. -4.5"	1.25"	4.5"	2.5"
18593	BT50 x 1.5" I.D. - 4.13"	1.5"	4.13"	-

End Mill Holder Replacement Lock Screws

Please specify your bore I.D. (shank size) when ordering replacement lock screws to ensure correct replacement.



Part No.	Fits EMH I.D.	Length	Torque	Thread
22954-5/16	1/8"	5/16"(.3125)	10 ft/lbs	6-32
22955-1/4	3/16"	1/4" (.25)	10 ft/lbs	8-32
22956-5/16	1/4"	5/16" (.3125)	10 ft/lbs	1/4-28
22957-5/16	5/16"	5/16" (.3125)	14 ft/lbs	5/16-24
22958-5/16	3/8"	5/16" (.3125)	16 ft/lbs	3/8-24
22959-5/16	7/16"	5/16" (.3125)	16 ft/lbs	7/16-20
22959-3/8	1/2"	3/8" (.375)	24 ft/lbs	7/16-20

Part No.	Fits EMH I.D.	Length	Torque	Thread
22959-7/16	5/8"	7/16" (.4375)	36 ft/lbs	1/2-20
22961-1/2	3/4"	1/2" (.5)	36 ft/lbs	5/8-18
22961-1/2	7/8"	1/2" (.5)	75 ft/lbs	5/8-18
22962-1/2	1.0"	1/2" (.5)	75 ft/lbs	5/8-18
22962-5/8	1-1/4"	5/8" (.625)	150 ft/lbs	3/4-16
22962-1/2	1-1/2"	1/2" (.5)	150 ft/lbs	3/4-16
22962-7/8	2"	7/8" (.875)	270 ft/lbs	1-14

Part No.	Metric	Thread
HSA-18-20	18mm	M18 x 2.0P
HSA-20-20	20mm	M20 x 2.0P

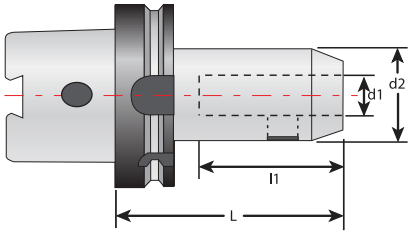
HSK63A, 100A Precision End Mill Holders



Features

- *I.D. bore tolerance is H5 (Best in Industry)*
- *Balanced to 15,000 RPM at G6.3*
- *Taper ground to AT3 for maximum spindle contact*

Techniks Certified for bore and taper tolerances



HSK63A End Mill Holders

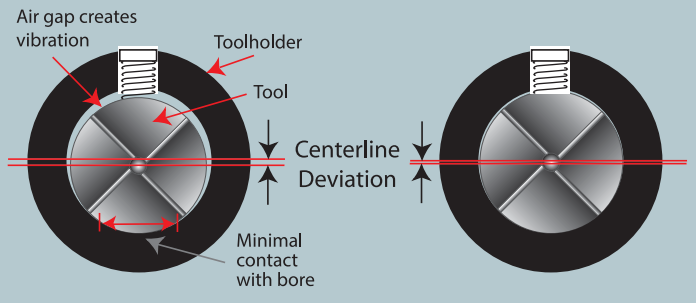
Part No.	Description - I.D.	d1	d2	L	l1
32954	HSK63A x End Mill holder 1/2"	1/2"	1.38"	3.00"	1.97"
32956	HSK63A x End Mill holder 5/8"	5/8"	1.63"	3.75"	2.09"
32958	HSK63A x End Mill holder 3/4"	3/4"	1.75"	3.75"	2.22"
32962	HSK63A x End Mill holder 1"	1"	2.00"	3.75"	2.46"
32964	HSK63A x End Mill holder 1-1/4"	1-1/4"	2.50"	4.25"	2.51"



Techniks Certified for bore and taper tolerances

Techniks H5 Bore Tolerance Extends Tool Life 60%

You lose 10% of cutting tool life for every .0001" of T.I.R.



Others T.I.R. .0008"

TECHNIKS .0002"

HSK100A End Mill Holders

Part No.	Description - I.D.	d1	d2	L	l1
32984	HSK100A x End Mill holder 1/2"	1/2"	1.38"	3.25"	1.97"
32986	HSK100A x End Mill holder 5/8"	5/8"	1.63"	3.75"	2.09"
32988	HSK100A x End Mill holder 3/4"	3/4"	1.75"	3.75"	2.22"
32992	HSK100A x End Mill holder 1"	1"	2.00"	4.25"	2.46"
32994	HSK100A x End Mill holder 1-1/4"	1-1/4"	2.50"	4.25"	2.51"
32996	HSK100A x End Mill holder 1-1/2"	1-1/2"	2.75"	4.50"	2.93"
32998	HSK100A x End Mill holder 2"	2"	3.75"	5.50"	3.53"

Precision ShrinkFIT Holders and Machines

Maximum rigidity and accuracy provide extended cutting tool life.

Full Line of ShrinkFIT

CAT, BT, HSK, ISO – also in extended lengths, inch and metric sizes. See our DualDRIVE ShrinkFIT holders for dual-contact spindles.



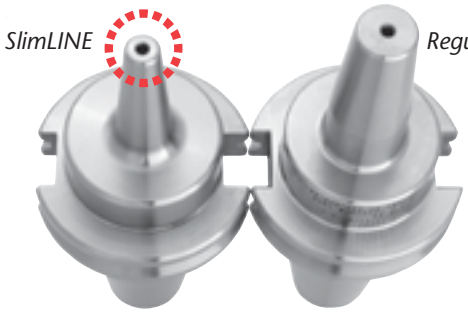
TECHNIKS CERTIFIED ACCURACY BALANCE

CoolBLAST ShrinkFIT

CoolBLAST holders feature coolant ports that put coolant right on the tool.



Small Nose ShrinkFIT



Use SlimLINE when small nose diameter is required.

Use regular ShrinkFIT when clearance is adequate.

Use SlimLINE Holders for machining in tight clearances.

TECHNIKS
BUILT FOR SPEED
www.techniksusa.com
a Quintec Company

You lose 10% of tool life for every .0001" of T.I.R. ShrinkFIT toolholders offer outstanding rigidity to minimizes T.I.R. and extend cutting tool life.

Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!

CAT40 Precision ShrinkFIT Holders – Inch Size



Techniks Certified for accuracy and balance

ShrinkFIT Holder Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

ShrinkFIT toolholders provide concentric clamping force of 10,000 lbs. or more directly on the cutting tool shank to reduce T.I.R. (runout). This is why operators are able to run faster and cutters last longer too. See pg.108 for more info.



ShrinkFIT Machines pg. 105



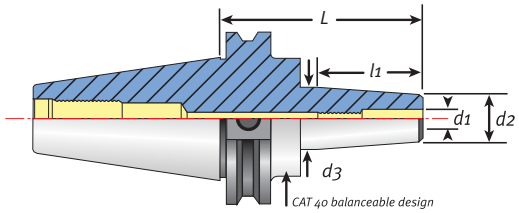
ShrinkFIT Extensions pg. 104



Retention Knobs pg. 204



Wrenches pg. 208



Coolant-thru set screw included. Page 104 for dimensions.



CAT40 ShrinkFIT Holders

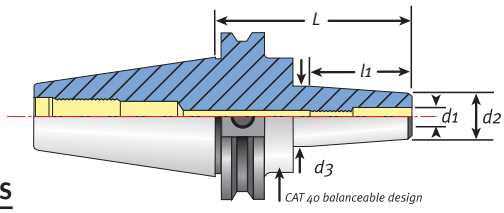
Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29002	CAT40 x 1/8" I.D. - 3.5"	1/8"	.63"	.87"	3.5"	.79"	M6 x 1.0P	16081C-20
29006	CAT40 x 3/16" I.D. - 3.5"	3/16"	.63"	.87"	3.5"	.79"	M6 x 1.0P	16081C-20
29010	CAT40 x 1/4" I.D. - 3"	1/4"	.71"	1.06"	3"	1.42"	M5 x 0.8P	16080C-20
29011	CAT40 x 1/4" I.D. - 3.5"	1/4"	.71"	1.06"	3.5"	1.42"	M5 x 0.8P	16080C-20
29016	CAT40 x 5/16" I.D. - 3.5"	5/16"	.78"	1.06"	3.5"	1.42"	M6 x 1.0P	16081C-20
29020	CAT40 x 3/8" I.D. - 3"	3/8"	.94"	1.26"	3"	1.53"	M8 x 1.25P	16082C-20
29021	CAT40 x 3/8" I.D. - 3.75"	3/8"	.94"	1.26"	3.75"	1.53"	M8 x 1.25P	16082C-20
29025	CAT40 x 7/16" - 3"	7/16"	.94"	1.18"	3"	1.62"	M10 x 1.5P	16083C-20
29026	CAT40 x 1/2" I.D. - 3"	1/2"	1.10"	1.34"	3"	1.85"	M10 x 1.5P	16083C-20
29027	CAT40 x 1/2" I.D. - 3.75"	1/2"	1.10"	1.34"	3.75"	1.85"	M10 x 1.5P	16083C-20
29032	CAT40 x 5/8" I.D. - 3.75"	5/8"	1.26"	1.34"	3.75"	1.97"	M12 x 1.75P	16085C-20
29034	CAT40 x 3/4" I.D. - 3"	3/4"	1.42"	1.65"	3"	2.04"	M16 x 2.0P	16089C-20
29036	CAT40 x 3/4" I.D. - 4"	3/4"	1.42"	1.65"	4"	2.04"	M16 x 2.0P	16089C-20
29040	CAT40 x 1.0" I.D. - 3"	1.0"	1.81"	2.09"	3"	2.28"	M20 x 2.0P	16091C-20
29042	CAT40 x 1.0" I.D. - 4"	1.0"	1.81"	2.09"	4"	2.28"	M20 x 2.0P	16091C-20
29046	CAT40 x 1-1/4" I.D. - 4"	1-1/4"	1.81"	2.09"	4"	2.28"	M20 x 2.0P	16091C-20



Techniks Certified for accuracy and balance

Features

- *Maximum T.I.R. only .0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*



Coolant-thru set screw included. Page 104 for dimensions.



CAT40 Extended Length ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29004	CAT40 x 1/8" I.D. - 5"	1/8"	.63"	.87"	5"	.79"	M6 x 1.0P	16081C-20
29008	CAT40 x 3/16" I.D. - 5"	3/16"	.63"	.87"	5"	.79"	M6 x 1.0P	16081C-20
29013	CAT40 x 1/4" I.D. - 5"	1/4"	.71"	1.06"	5"	1.42"	M5 x 0.8P	16080C-20
29014	CAT40 x 1/4" I.D. - 6"	1/4"	.71"	1.06"	6"	1.42"	M5 x 0.8P	16080C-20
29018	CAT40 x 5/16" I.D. - 5"	5/16"	.78"	1.06"	5"	1.42"	M6 x 1.0P	16081C-20
29023	CAT40 x 3/8" I.D. - 5"	3/8"	.94"	1.26"	5"	1.53"	M8 x 1.25P	16082C-20
29024	CAT40 x 3/8" I.D. - 6"	3/8"	.94"	1.26"	6"	1.53"	M8 x 1.25P	16082C-20
29029	CAT40 x 1/2" I.D. - 5"	1/2"	1.10"	1.34"	5"	1.85"	M10 x 1.5P	16083C-20
29030	CAT40 x 1/2" I.D. - 6"	1/2"	1.10"	1.34"	6"	1.85"	M10 x 1.5P	16083C-20
29037	CAT40 x 3/4" I.D. - 5"	3/4"	1.42"	1.65"	5"	2.04"	M16 x 2.0P	16089C-20
29038	CAT40 x 3/4" I.D. - 6"	3/4"	1.42"	1.65"	6"	2.04"	M16 x 2.0P	16089C-20
29044	CAT40 x 1.0" I.D. - 6"	1.0"	1.81"	2.09"	6"	2.28"	M20 x 2.0P	16091C-20



Features

- *Smaller nose diameter (d2)*
- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*

Use SlimLINE holders for finish passes where small nose diameter (d2) tooling is needed.

CAT40 SlimLINE ShrinkFIT Holders Inch Sizes

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
31528	CAT40 x 1/8" I.D. - 3.15" SlimLINE	1/8"	.35"	.63"	3.15"	.78"	M6 x 1.0P	16081C-20
31538	CAT40 x 3/16" I.D. - 3.15" SlimLINE	3/16"	.43"	.69"	3.15"	.78"	M6 x 1.0P	16081C-20
31548	CAT40 x 1/4" I.D. - 3.15" SlimLINE	1/4"	.47"	.81"	3.15"	1.42"	M5 x 0.8P	16080C-20
31568	CAT40 x 3/8" I.D. - 3.15" SlimLINE	3/8"	.63"	.94"	3.15"	1.93"	M8 x 1.25P	16082C-20
31588	CAT40 x 1/2" I.D. - 3.15" SlimLINE	1/2"	.71"	1.06"	3.15"	1.93"	M10 x 1.5P	16083C-20

CAT40 SlimLINE ShrinkFIT Holders Metric Sizes

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29103	CAT40 x 3mm I.D. - 80mm SlimLINE	3mm	9mm	15.5mm	80mm	45mm	M6 x 1.0P	16081C-20
29104	CAT40 x 4mm I.D. - 80mm SlimLINE	4mm	10mm	16.3mm	80mm	45mm	M6 x 1.0P	16081C-20
29106	CAT40 x 6mm I.D. - 80mm SlimLINE	6mm	12mm	18.3mm	80mm	45mm	M5 x 0.8P	16080C-20

CAT40 Precision ShrinkFIT Toolholders – Metric Size



Techniks Certified for accuracy and balance

ShrinkFIT Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

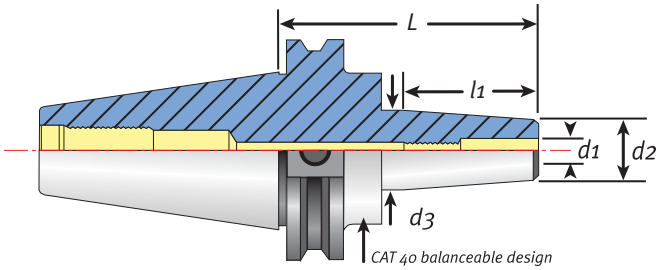
ShrinkFIT toolholders provide concentric clamping force of 10,000 lbs. or more directly on the cutting tool shank to reduce T.I.R. (runout). This is why operators are able to run faster and cutters last longer too. See pg.108 for more info.


ShrinkFIT Machines pg. 105


ShrinkFIT Extensions pg. 104


Retention Knobs pg. 204


Wrenches pg. 208



Coolant-thru set screw included. Page 104 for dimensions.



CAT40 Metric ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29204	CAT40 x 4mm I.D. - 100mm	4mm	10mm	18.7mm	100mm	55mm	M6 x 1.0P	16081C-20
29206	CAT40 x 5mm I.D. - 100mm	5mm	16mm	22mm	100mm	38mm	M6 x 1.0P	16081C-20
29208	CAT40 x 6mm I.D. - 100mm	6mm	21mm	27mm	100mm	36mm	M5 x 0.8P	16080C-20
29210	CAT40 x 6mm I.D. - 150mm	6mm	21mm	27mm	150mm	36mm	M5 x 0.8P	16080C-20
29212	CAT40 x 8mm I.D. - 100mm	8mm	21mm	27mm	100mm	36mm	M6 x 1.0P	16081C-20
29214	CAT40 x 8mm I.D. - 150mm	8mm	21mm	27mm	150mm	36mm	M6 x 1.0P	16081C-20
29216	CAT40 x 10mm I.D. - 100mm	10mm	24mm	32mm	100mm	42mm	M8 x 1.25P	16082C-20
29218	CAT40 x 10mm I.D. - 150mm	10mm	24mm	32mm	150mm	42mm	M8 x 1.25P	16082C-20
29220	CAT40 x 12mm I.D. - 100mm	12mm	24mm	32mm	100mm	47mm	M10 x 1.5P	16083C-20
29222	CAT40 x 12mm I.D. - 150mm	12mm	24mm	32mm	150mm	47mm	M10 x 1.5P	16083C-20
29226	CAT40 x 14mm I.D. - 100mm	14mm	27mm	34mm	100mm	44mm	M10 x 1.5P	16083C-20
29228	CAT40 x 14mm I.D. - 152.4mm	14mm	27mm	34mm	152.4mm	44mm	M10 x 1.5P	16083C-20
29232	CAT40 x 16mm I.D. - 100mm	16mm	27mm	34mm	100mm	44mm	M12 x 1.75P	16085C-20
29234	CAT40 x 16mm I.D. - 160mm	16mm	27mm	34mm	160mm	44mm	M12 x 1.75P	16085C-20
29236	CAT40 x 18mm I.D. - 100mm	18mm	33mm	42mm	100mm	50mm	M16 x 2.0P	16089C-20
29238	CAT40 x 20mm I.D. - 80mm	20mm	33mm	42mm	80mm	52mm	M16 x 2.0P	16089C-20
29240	CAT40 x 25mm I.D. - 101.6mm	25mm	44mm	53mm	101.6mm	57mm	M20 x 2.0P	16091C-20

Distributors - Call to register for our Distributors Webstore for full online access.

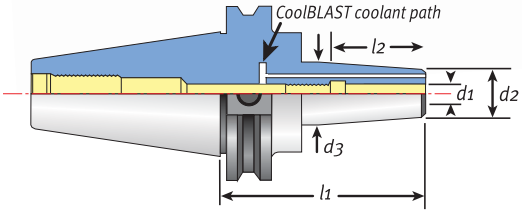
CAT40 CoolBLAST or CoolFLEX Holders



Techniks Certified for accuracy and balance

CoolBLAST Features

- *Maximum chip removal for maximum feed rates*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*



Coolant-thru set screw included. Page 104 for dimensions.





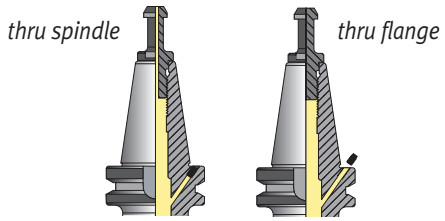
CoolBLAST coolant ports direct coolant on the tool path, even at high RPMs.

CAT40 CoolBLAST ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29004B	CAT40 x 1/8" - 5" with CoolBlast	1/8"	.63"	.87"	5"	.79"	M6 x 1.0P	16081C-20
29008B	CAT40 x 3/16" - 5" with CoolBlast	3/16"	.63"	.87"	5"	.79"	M6 x 1.0P	16081C-20
29014B	CAT40 x 1/4" - 6" with CoolBlast	1/4"	.71"	1.06"	6"	1.42"	M5 x 0.8P	16080C-20
29018B	CAT40 x 5/16" - 5" with CoolBlast	5/16"	.78"	1.06"	5"	1.42"	M6 x 1.0P	16081C-20
29023B	CAT40 x 3/8" I.D. - 5" with CoolBLAST	3/8"	.94"	1.26"	5"	1.53"	M8 x 1.25P	16082C-20
29029B	CAT40 x 1/2" I.D. - 5" with CoolBLAST	1/2"	1.10"	1.34"	5"	1.85"	M10 x 1.5P	16083C-20
29033B	CAT40 x 5/8" I.D. - 5" with CoolBLAST	5/8"	1.26"	1.34"	5"	1.97"	M12 x 1.75P	16085C-20
29036B	CAT40 x 3/4" I.D. - 4" with CoolBLAST	3/4"	1.42"	1.65"	4"	2.04"	M16 x 2.0P	16089C-20
29037B	CAT40 x 3/4" I.D. - 5" with CoolBLAST	3/4"	1.42"	1.65"	5"	2.04"	M16 x 2.0P	16089C-20

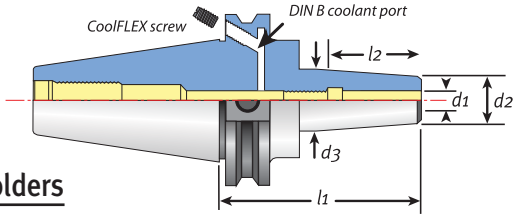
CoolFLEX Features

- *Coolant-thru spindle or thru flange (DIN B)*



CoolFLEX holders are factory set for coolant-thru spindle. Remove 2 set-screws for DIN B coolant-thru flange.

Coolant Set Screws page 104.



Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw

CAT40 CoolFLEX ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29011F	CAT40 x 1/4" I.D. - 3.5" with CoolFLEX	1/4"	.71"	1.06"	3.5"	1.42"	M5 x 0.8P	16080C-20
29021F	CAT40 x 3/8" I.D. - 3.75" with CoolFLEX	3/8"	.94"	1.26"	3.75"	1.53"	M8 x 1.25P	16082C-20
29027F	CAT40 x 1/2" I.D. - 3.75" with CoolFLEX	1/2"	1.10"	1.34"	3.75"	1.85"	M10 x 1.5P	16083C-20
29040F	CAT40 x 1.0" I.D. - 3" with CoolFLEX	1.0"	1.81"	2.09"	3"	2.28"	M20 x 2.0P	16091C-20
29042F	CAT40 x 1.0" I.D. - 4" with CoolFLEX	1.0"	1.81"	2.09"	4"	2.28"	M20 x 2.0P	16091C-20
29046F	CAT40 x 1-1/4" I.D. - 4" with CoolFLEX	1-1/4"	1.81"	2.09"	4"	2.28"	M20 x 2.0P	16091C-20

CAT40 Precision CoolBLAST/CoolFLEX Holders



Techniks Certified for accuracy and balance

Features

- *Get CoolBLAST performance from DIN B spindles*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*



ShrinkFIT Machines pg. 105



ShrinkFIT Extensions pg. 104



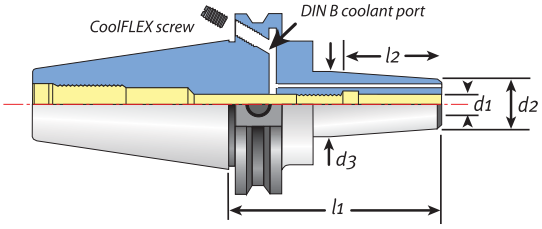
Retention Knobs pg. 204



Wrenches pg. 208

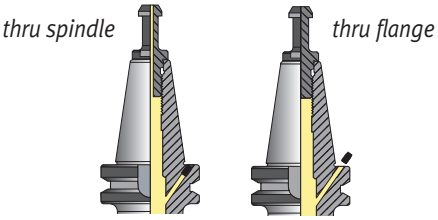
CoolBLAST coolant ports direct coolant on the tool path, even at high RPMs. No need to purchase coolant-thru cutting tools.





Coolant-thru set screw included. Page 104 for dimensions.





CoolFLEX holders are factory set for coolant-thru spindle. Remove 2 setscrews for DIN B coolant-thru flange.

Replacement CoolFLEX Screws

Part No.	Description
HSA-4-6	40 taper DIN B screw

CAT40 CoolBLAST and CoolFLEX DIN B Coolant Capability

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29002FB	CAT40 x 1/8" I.D. - 3.5"	1/8"	.63"	.87"	3.5"	-	M6 x 1.0P	16081C-20
29006FB	CAT40 x 3/16" I.D. - 3.5"	3/16"	.63"	.87"	3.5"	-	M6 x 1.0P	16081C-20
29011FB	CAT40 x 1/4" I.D. - 3.5"	1/4"	.71"	1.06"	3.5"	1.42"	M5 x 0.8P	16080C-20
29016FB	CAT40 x 5/16" I.D. - 3.5"	5/16"	.78"	1.06"	3.5"	1.42"	M6 x 1.0P	16081C-20
29021FB	CAT40 x 3/8" I.D. - 3.75"	3/8"	.94"	1.26"	3.75"	1.53"	M8 x 1.25P	16082C-20
29023FB	CAT40 x 3/8" I.D. - 5"	3/8"	.94"	1.26"	5"	1.53"	M8 x 1.25P	16082C-20
29027FB	CAT40 x 1/2" I.D. - 3.75"	1/2"	1.10"	1.34"	3.75"	1.85"	M10 x 1.5P	16083C-20
29032FB	CAT40 x 5/8" I.D. - 3.75"	5/8"	1.26"	1.34"	3.75"	1.97"	M12 x 1.75P	16085C-20
29036FB	CAT40 x 3/4" I.D. - 4"	3/4"	1.42"	1.65"	4"	2.04"	M16 x 2.0P	16089C-20
29042FB	CAT40 x 1.0" I.D. - 4"	1.0"	1.81"	2.09"	4"	2.28"	M20 x 2.0P	16091C-20

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SYIC

CAT40 DualDRIVE for Dual-Contact Spindles



Techniks Certified for accuracy and balance

Features

- *New one-piece design for dual-contact spindles*
- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*

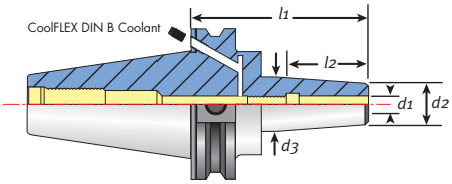
Benefits

- *Better rigidity and reduced vibration (chatter)*
- *Improved performance at high metal removal rates and when machining at extended lengths*

Dual-Contact Spindles

Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.





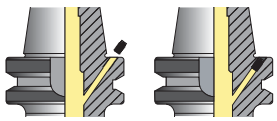
CoolBLAST coolant ports direct coolant on the tool path, even at high RPMs. No need to purchase coolant-thru cutting tools.

CAT50 Dual-Drive holders are available from stock.

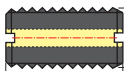
CoolFLEX Feature

CoolFLEX holders are factory set for coolant-thru spindle. Simply remove 2 stop screws for DIN B coolant-thru flange.

thru flange *thru spindle*



Coolant-thru set screw included.
Page 104 for dimensions.



CAT40 DualDRIVE CoolBLAST ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
46.651B.58.315	CAT40 x SF 1/2" - 3.15" DualDRIVE w/BLAST	1/2"	28mm	34mm	3.15"	47mm	M10 x 1.5P	16083C-20
46.651B.64.400	CAT40 x SF 3/4" - 4" DualDRIVE w/BLAST	3/4"	36mm	42mm	4"	52mm	M16 x 2.0P	16089C-20

CAT40 DualDRIVE CoolFLEX ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
46.651.54.350	CAT40 x SF 1/4" - 3.5" DualDRIVE w/FLEX	1/4"	18mm	27mm	3.5"	36mm	M5 x 0.8P	16080C-20
46.651.56.375	CAT40 x SF 3/8" - 3.75" DualDRIVE w/FLEX	3/8"	24mm	32mm	3.75"	42mm	M8 x 1.25P	16082C-20
46.651.58.375	CAT40 x SF 1/2" - 3.75" DualDRIVE w/FLEX	1/2"	28mm	34mm	3.75"	47mm	M10 x 1.5P	16083C-20
46.651.64.400	CAT40 x SF 3/4" - 4" DualDRIVE w/FLEX	3/4"	36mm	42mm	4"	52mm	M16 x 2.0P	16089C-20
46.651.68.400	CAT40 x SF 1.0" - 4" DualDRIVE w/FLEX	1.0"	46mm	53mm	4"	58mm	M20 x 2.0P	16091C-20
46.651.72.400	CAT40 x SF 1-1/4" DualDRIVE w/FLEX	1-1/4"	46mm	53mm	4"	58mm	M20 x 2.0P	16091C-20

CAT50 Precision ShrinkFIT Toolholders – Inch Size



Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

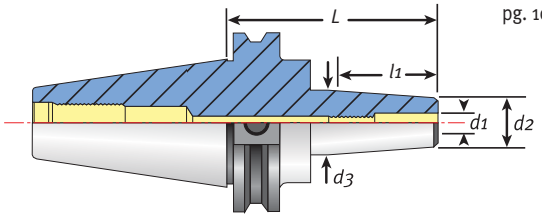
Techniks Certified for accuracy and balance


ShrinkFIT Machines pg. 105


ShrinkFIT Extensions pg. 104


Retention Knobs pg. 204


Wrenches pg. 208



Coolant-thru set screw included. Page 104 for dimensions.



CAT50 ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29051	CAT50 x 1/8" I.D. - 4"	1/8"	.63"	.87"	4"	.79"	M6 x 1.0P	16081C-20
29052	CAT50 x 3/16" I.D. - 3.54"	3/16"	.63"	.87"	3.54"	.79"	M6 x 1.0P	16081C-20
29054	CAT50 x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"	M5 x 0.8P	16080C-20
29056	CAT50 x 5/16" I.D. - 3.54"	5/16"	.71"	1.06"	3.54"	1.42"	M6 x 1.0P	16081C-20
29058	CAT50 x 3/8" I.D. - 3.94"	3/8"	.71"	1.06"	3.94"	1.42"	M8 x 1.25P	16082C-20
29060	CAT50 x 1/2" I.D. - 3.94"	1/2"	1.10"	1.34"	3.94"	1.85"	M10 x 1.5P	16083C-20
29062	CAT50 x 5/8" I.D. - 3.94"	5/8"	1.26"	1.34"	3.94"	1.97"	M12 x 1.75P	16085C-20
29064	CAT50 x 3/4" I.D. - 4.13"	3/4"	1.42"	1.65"	4.13"	2.04"	M16 x 2.0P	16089C-20
29068	CAT50 x 1.0" I.D. - 4.13"	1"	1.81"	2.09"	4.13"	2.28"	M20 x 2.0P	16091C-20
29072	CAT50 x 1-1/4" I.D. - 4.13"	1-1/4"	1.81"	2.09"	4.13"	2.28"	M20 x 2.0P	16091C-20
29074	CAT50 x 1-1/4" I.D. - 4.72"	1-1/4"	1.81"	1.81"	4.72"	2.28"	M20 x 2.0P	16091C-20

CAT50 Extended Length ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29052-6	CAT50 x 3/16"I.D. - 6"	3/16"	.63"	.87"	6"	.79"	M6 x 1.0P	16081C-20
29054-6	CAT50 x 1/4" I.D. - 6"	1/4"	.71"	1.06"	6"	1.42"	M5 x 0.8P	16080C-20
29054-8	CAT50 x 1/4" I.D. - 8"	1/4"	.71"	1.06"	8"	1.42"	M5 x 0.8P	16080C-20
29058-6	CAT50 x 3/8" I.D. - 6"	3/8"	.71"	1.06"	6"	1.42"	M8 x 1.25P	16082C-20
29058-8	CAT50 x 3/8" I.D. - 8"	3/8"	.71"	1.06"	8"	1.42"	M8 x 1.25P	16082C-20
29060-6	CAT50 x 1/2" I.D. - 6"	1/2"	1.10"	1.34"	6"	1.85"	M6 x 1.0P	16081C-20
29060-8	CAT50 x 1/2" I.D. - 8"	1/2"	1.10"	1.34"	8"	1.85"	M10 x 1.5P	16083C-20
29062-6	CAT50 x 5/8" I.D. - 6"	5/8"	1.26"	1.34"	6"	1.97"	M12 x 1.75P	16085C-20
29066-6	CAT50 x 3/4"I.D. - 6"	3/4"	1.42"	1.65"	6"	2.04"	M16 x 2.0P	16089C-20
29070	CAT50 x 1.0"I.D. - 6"	1"	1.81"	2.09"	6"	2.28"	M20 x 2.0P	16091C-20
29076	CAT50 x 1-1/4"I.D. - 6"	1-1/4"	1.81"	2.09"	6"	2.28"	M20 x 2.0P	16091C-20

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

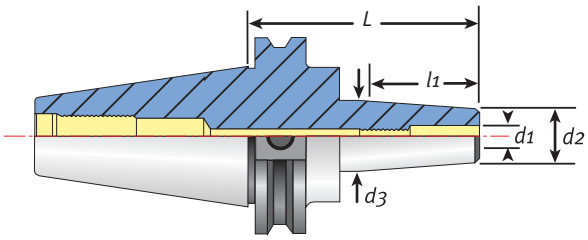
CAT50 Precision ShrinkFIT Toolholders – Metric Size



Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

Techniks Certified for accuracy and balance



Coolant-thru set screw included. Page 104 for dimensions.



CAT50 Metric ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29252	CAT50 x 6mm I.D. - 100mm	6 mm	21 mm	27 mm	100 mm	36 mm	M5 x 0.8P	16080C-20
29256	CAT50 x 8mm I.D. - 100mm	8 mm	21 mm	27 mm	100 mm	36 mm	M6 x 1.0P	16081C-20
29260	CAT50 x 10mm I.D. - 100mm	10 mm	24 mm	32 mm	100 mm	42 mm	M8 x 1.25P	16082C-20
29264	CAT50 x 12mm I.D. - 100mm	12 mm	24 mm	32 mm	100 mm	47 mm	M10 x 1.5P	16083C-20
29268	CAT50 x 14mm I.D. - 100mm	14 mm	27 mm	34 mm	100 mm	47 mm	M10 x 1.5P	16083C-20
29272	CAT50 x 16mm I.D. - 100mm	16 mm	27 mm	34 mm	100 mm	50 mm	M12 x 1.75P	16085C-20
29276	CAT50 x 18mm I.D. - 100mm	18 mm	33 mm	42 mm	100 mm	50 mm	M12 x 1.75P	16085C-20
29278-100	CAT50 x 20mm I.D. - 100mm	20 mm	33 mm	42 mm	100 mm	52 mm	M16 x 2.0P	16089C-20
29280	CAT50 x 25mm I.D. - 100mm	25 mm	44 mm	53 mm	100 mm	58 mm	M20 x 2.0P	16091C-20
29282	CAT50 x 32mm I.D. - 100mm	32 mm	44 mm	53 mm	100 mm	58 mm	M20 x 2.0P	16091C-20

CAT50 Extended Length Metric ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29254	CAT50 x 6mm I.D. - 150mm	6 mm	21 mm	27 mm	150 mm	36 mm	M5 x 0.8P	16080C-20
29254-8	CAT50 x 6mm I.D. - 203mm	6 mm	21 mm	27 mm	203 mm	36mm	M5 x 0.8P	16080C-20
29258	CAT50 x 8mm I.D. - 150mm	8 mm	21 mm	27 mm	150 mm	36 mm	M6 x 1.0P	16081C-20
29258-8	CAT50 x 8mm I.D. - 203mm	8 mm	21 mm	27 mm	203 mm	36 mm	M6 x 1.0P	16081C-20
29262	CAT50 x 10mm I.D. - 150mm	10 mm	24 mm	32 mm	150 mm	42 mm	M8 x 1.25P	16082C-20
29266	CAT50 x 12mm I.D. - 150mm	12 mm	24 mm	32 mm	150 mm	47 mm	M10 x 1.5P	16083C-20
29266-8	CAT50 x 12mm I.D. - 203mm	12 mm	24 mm	32 mm	203 mm	47mm	M10 x 1.5P	16083C-20
29270	CAT50 x 14mm I.D. - 150mm	14 mm	27 mm	34 mm	150 mm	47 mm	M10 x 1.5P	16083C-20
29274	CAT50 x 16mm I.D. - 160mm	16 mm	27 mm	34 mm	160 mm	50 mm	M12 x 1.75P	16085C-20

CAT50 Precision CoolBLAST ShrinkFIT Toolholders



Techniks Certified for accuracy and balance

CoolBLAST Features

- *Maximum chip removal for maximum feed rates*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*



CoolBLAST coolant ports direct coolant on the tool path, even at high RPMs. No need to purchase coolant-thru cutting tools.



ShrinkFIT Machines pg. 105



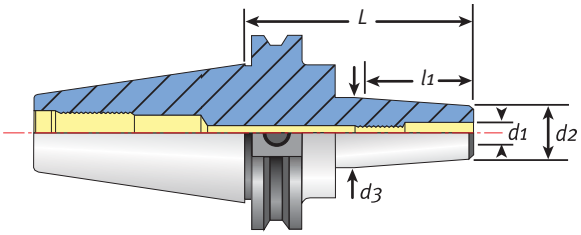
ShrinkFIT Extensions pg. 104



Retention Knobs pg. 204



Wrenches pg. 208



Coolant-thru set screw included. Page 104 for dimensions.



CAT50 CoolBLAST ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29252B	CAT50 x SF 6mm - 100mm CoolBlast	6mm	.71"	1.06"	100mm	1.42"	M5 x 0.8P	16080C-20
29054B	CAT50 x SF 1/4" - 3.54" with CoolBLAST	1/4"	.71"	1.06"	3.54"	1.42"	M5 x 0.8P	16080C-20
29058B	CAT50 x SF 3/8" - 3.94" with CoolBLAST	3/8"	.78"	1.06"	3.94"	1.42"	M8 x 1.25P	16082C-20
29260B	CAT50 x SF 10mm - 100mm w/ CoolBlast	10mm	.78"	1.06"	100mm	1.42"	M8 x 1.25P	16082C-20
29060B	CAT50 x SF 1/2" - 3.94" with CoolBLAST	1/2"	1.10"	1.34"	3.94"	1.85"	M10 x 1.5P	16083C-20
29062B	CAT50 x SF 5/8" - 3.94" with CoolBLAST	5/8"	1.26"	1.34"	3.94"	1.97"	M12 x 1.75P	16085C-20
29064B	CAT50 x SF 3/4" - 4.13" with CoolBLAST	3/4"	1.42"	1.65"	4.13"	2.04"	M16 x 2.0P	16089C-20
29068B	CAT50 x SF 1" - 4.13" with CoolBLAST	1"	1.81"	2.09"	4.13"	2.28"	M20 x 2.0P	16091C-20
29072B	CAT50 x SF 1-1/4" - 4.13" w/ CoolBLAST	1-1/4"	1.81"	2.09"	4.13"	2.28"	M20 x 2.0P	16091C-20

CAT50 Extended Length CoolBLAST ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29054-6B	CAT50 x SF 1/4" - 6" with CoolBLAST	1/4"	.71"	1.06"	6"	1.42"	M5 x 0.8P	16080C-20
29058-6B	CAT50 x SF 3/8" - 6" with CoolBLAST	3/8"	.78"	1.06"	6"	1.42"	M8 x 1.25P	16082C-20
29060-6B	CAT50 x SF 1/2" - 6" with CoolBLAST	1/2"	1.10"	1.34"	6"	1.85"	M10 x 1.5P	16083C-20
29062-6B	CAT50 x SF 5/8" - 6" with CoolBLAST	5/8"	1.26"	1.34"	6"	1.97"	M12 x 1.75P	16085C-20
29066B	CAT50 x SF 3/4" - 6" with CoolBLAST	3/4"	1.42"	1.65"	6"	2.04"	M16 x 2.0P	16089C-20
29070B	CAT50 x SF 1" - 6" with CoolBLAST	1"	1.81"	2.09"	6"	2.28"	M20 x 2.0P	16091C-20

Distributors - Call to register for our Distributors Webstore for full online access.

SYIC

BT 30 ShrinkFIT & DualDRIVE for Dual-Contact Spindles

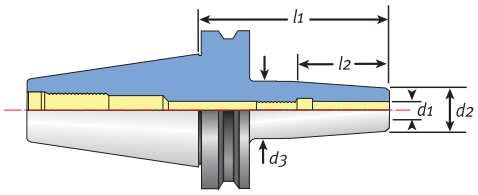


Techniks Certified for accuracy and balance

Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

ShrinkFIT toolholders provide concentric clamping force of 10,000 lbs. or more directly on the cutting tool shank to reduce T.I.R. (runout). This is why operators are able to run faster and cutters last longer too. See pg.108 for more info.



Coolant-thru set screw included. Page 104 for dimensions.



BT30 ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
67250	BT30 x 1/4"I.D. - 3"	1/4"	.71"	1.06"	3"	1.42"	M8 x 1.25P	16082C-20
67375	BT30 x 3/8"I.D. - 3"	3/8"	.78"	1.06"	3"	1.42"	M8 x 1.25P	16082C-20
67500	BT30 x 1/2"I.D. - 3"	1/2"	1.10"	1.34"	3"	1.85"	M10 x 1.5P	16083C-20
67625	BT30 x 5/8"I.D. - 3"	5/8"	1.26"	1.34"	3"	1.97"	M12 x 1.75P	16085C-20
67750	BT30 x 3/4"I.D. - 3"	3/4"	1.42"	1.15"	3"	2.04"	M16 x 2.0P	16089C-20



Techniks Certified for accuracy and balance

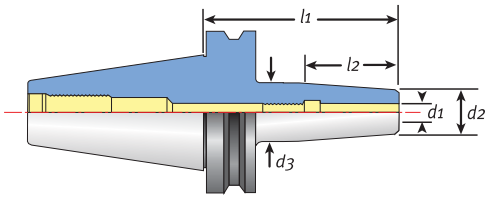
Features

- *New one-piece design for dual-contact spindles*
- *Coolant-thru spindle or thru flange (DIN B)*
- *Balanced to 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

Benefits

- *Better rigidity and reduced vibration (chatter)*
- *Improved performance at high metal removal rates and when machining at extended lengths*

Dual-Contact Spindles: *Dual-Contact is a spindle option that means both the tool-holder taper and the flange make contact with the spindle. Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.*



BT30 DualDRIVE ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
25.651.54.300	BT30 x SF x 1/4"I.D. - 3" DualDRIVE	1/4"	.83"	1.06"	3"	1.42"	M8 x 1.25P	16082C-20
25.651.56.300	BT30 x SF x 3/8"I.D. - 3" DualDRIVE	3/8"	.94"	1.26"	3"	1.42"	M8 x 1.25P	16082C-20
25.651.58.300	BT30 x SF x 1/2"I.D. - 3" DualDRIVE	1/2"	.94"	1.26"	3"	1.85"	M10 x 1.5P	16083C-20
25.651.61.300	BT30 x SF x 5/8"I.D. - 3" DualDRIVE	5/8"	1.06"	1.34"	3"	1.97"	M12 x 1.75P	16085C-20
25.651.64.300	BT30 x SF x 3/4"I.D. - 3" DualDRIVE	3/4"	1.30"	1.62"	3"	2.04"	M16 x 2.0P	16089C-20

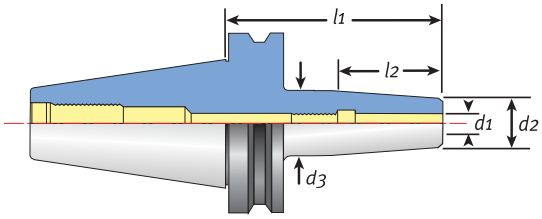
BT 40 Precision ShrinkFIT Toolholders



Techniks Certified for accuracy and balance

Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*



Coolant-thru set screw included. Page 104 for dimensions.



BT40 ShrinkFIT Holders Inch Size

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
39110	BT40 x 3/16" I.D. - 3.54	3/16"	.63"	.87"	3.54"	.79"	M6 x 1.0P	16081C-20
39111	BT40 x 1/4" I.D. - 3.54	1/4"	.71"	1.06"	3.54"	1.42"	M5 x 0.8P	16080C-20
39113	BT40 x 3/8" I.D. - 3.54	3/8"	.78"	1.06"	3.54"	1.42"	M8 x 1.25P	16082C-20
39114	BT40 x 1/2" I.D. - 3.54	1/2"	1.10"	1.34"	3.54"	1.85"	M10 x 1.5P	16083C-20
19029	BT40 x 5/8" I.D. - 3.54	5/8"	1.06"	1.37"	3.54"	1.77"	M16 x 2.0P	16089C-20
39115	BT40 x 3/4"I.D. - 3.54	3/4"	1.42"	1.65"	3.54"	2.04"	M12 x 1.75P	16085C-20
39117	BT40 x 1.0" I.D. - 3.54	1.0"	1.81"	2.09"	3.54"	2.28"	M16 x 2.0P	16089C-20
39119-4.13	BT40 x 1-1/4" I.D. - 4.13	1-1/4"	1.81”	2.09"	4.13"	1.75"	M20 x 2.0P	16091C-20

Extended BT40 ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
19019-6	BT40 x 1/8"I.D. - 6"	1/8"	.36"	-	6"	1.70"	M6 x 1.0P	16081C-20
19020-6	BT40 x 3/16"I.D. - 6"	3/16"	.63"	.87"	6"	0.79"	M6 x 1.0P	16081C-20
19022-6	BT40 x 1/4"I.D. - 6"	1/4"	.71"	1.06"	6"	1.42"	M5 x 0.8P	16080C-20
19026-6	BT40 x 3/8"I.D. - 6"	3/8"	.78"	1.06"	6"	1.42"	M8 x 1.25P	16082C-20
19028-6	BT40 x 1/2"I.D. - 6"	1/2"	1.10"	1.34"	6"	1.85"	M10 x 1.5P	16083C-20
19030-6	BT40 x 5/8"I.D. - 6"	5/8"	1.06"	1.37"	6"	1.77"	M12 x 1.75P	16085C-20
19032-6	BT40 x 3/4"I.D. - 6"	3/4"	1.42"	1.65"	6"	2.04"	M16 x 2.0P	16089C-20
19034-6	BT40 x 1"I.D. - 6"	1"	1.81"	2.09"	6"	2.28"	M20 x 2.0P	16091C-20

BT40 ShrinkFIT Holders Metric Size

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
19136-135	BT40 x 6mm I.D. - 135mm	6mm	9mm	26mm	135mm	36mm	M5 x 0.8P	16080C-20
19138	BT40 x 8mm I.D. - 90mm	8mm	21mm	26mm	90mm	36mm	M6 x 1.0P	16081C-20
19138-135	BT40 x 8mm I.D. - 135mm	8mm	11mm	26mm	135mm	36mm	M6 x 1.0P	16081C-20
19140	BT40 x 10mm I.D. - 90mm	10mm	24mm	29mm	90mm	36mm	M8 x 1.25P	16082C-20
19140-135	BT40 x 10mm - I.D. 135mm	10mm	13mm	29mm	135mm	42mm	M8 x 1.25P	16082C-20
19142	BT40 x 12mm - I.D. 90mm	12mm	24mm	29mm	90mm	47mm	M10 x 1.5P	16083C-20
19142-135	BT40 x 12mm - I.D. 135mm	12mm	15mm	29mm	135mm	47mm	M10 x 1.5P	16083C-20

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

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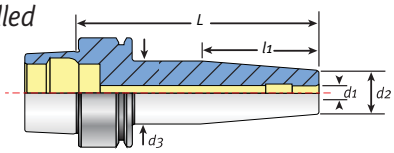
HSK40E, 50E Precision ShrinkFIT Holders



Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

Techniks Certified for accuracy and balance



HSK40E Inch Size ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
39001-E	HSK40E x 1/8" I.D. - 3.54"	1/8"	.63	.87"	3.54"	.79"	M6 x 1.0P	16081C-20
39002-E	HSK40E x 3/16" I.D. - 3.54"	3/16"	.63"	.87"	3.54"	.79"	M6 x 1.0P	16081C-20
39004-E	HSK40E x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"	M5 x 0.8P	16080C-20
39006-E	HSK40E x 5/16" I.D. - 3.54"	5/16"	.79"	1.06"	3.54"	1.42"	M6 x 1.0P	16081C-20
39008-E	HSK40E x 3/8" I.D. - 3.54"	3/8"	.94"	1.26"	3.54"	1.53"	M8 x 1.25P	16082C-20

HSK40E Metric Size ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
39082-E	HSK40E x 3mm I.D. - 80mm	3mm	10mm	18mm	80mm	18mm	M6 x 1.0P	16081C-20
39084-E	HSK40E x 4mm I.D. - 80mm	4mm	14mm	22mm	80mm	20mm	M6 x 1.0P	16081C-20
39088-E	HSK40E x 6mm I.D. - 80mm	6mm	21mm	27mm	80mm	36mm	M5 x 0.8P	16080C-20
39090-E	HSK40E x 8mm I.D. - 80mm	8mm	21mm	27mm	80mm	36mm	M6 x 1.0P	16081C-20
39092-E	HSK40E x 10mm I.D. - 80mm	10mm	24mm	32mm	85mm	42mm	M8 x 1.25P	16082C-20

HSK50E ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
39014-E	HSK50E x 1/8" I.D. - 3.15"	1/8"	.63"	.87"	3.15"	.79"	M6 x 1.0P	16081C-20
39016-E	HSK50E x 3/16" I.D. - 3.54"	3/16"	.63"	.87"	3.54"	.79"	M6 x 1.0P	16081C-20
39018-E	HSK50E x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"	M5 x 0.8P	16080C-20
39020-E	HSK50E x 5/16" I.D. - 3.54"	5/16"	.79"	1.06"	3.54"	1.42"	M6 x 1.0P	16081C-20
39022-E	HSK50E x 3/8" I.D. - 3.54"	3/8"	.94"	1.26"	3.54"	1.53"	M8 x 1.25P	16082C-20
39024-E	HSK50E x 1/2" I.D. - 3.54"	1/2"	1.10"	1.34"	3.54"	1.85"	M10 x 1.5P	16083C-20
39025-E	HSK50E x 5/8" I.D. - 3.54"	5/8"	1.10"	1.34"	3.54"	1.85"	M12 x 1.75P	16085C-20



Use SlimLINE holders for finish passes where small nose diameter (d2) tooling is required.

Features

- *Smaller nose diameter (d2)*
- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*

Coolant-thru set screw included. Page 104 for dimensions.



HSK40E SlimLINE ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
99528	HSK40E x 1/8" I.D. - 2.36" SlimLINE	1/8"	.35"	.63"	2.36"	.78"	M6 x 1.0P	16081C-20
99538	HSK40E x 3/16" I.D. - 2.36" SlimLINE	3/16"	.43"	.69"	2.36"	.78"	M6 x 1.0P	16081C-20
99548	HSK40E x 1/4" I.D. - 2.36" SlimLINE	1/4"	.47"	.81"	2.36"	1.42"	M5 x 0.8P	16080C-20
99568	HSK40E x 3/8" I.D. - 2.36" SlimLINE	3/8"	.63"	.94"	2.36"	1.93"	M8 x 1.25P	16082C-20
99588	HSK40E x 1/2" I.D. - 2.36" SlimLINE	1/2"	.71"	1.06"	2.36"	1.93"	M10 x 1.5P	16083C-20

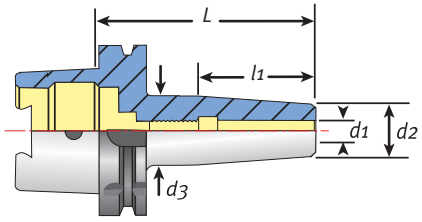
HSK63A Precision ShrinkFIT Holders



Techniks Certified for accuracy and balance

Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*



Coolant-thru set screw included. Page 104 for dimensions.



HSK63A Inch Size ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
93115	HSK63A x 1/4" I.D. - 3.15"	1/4"	.71"	1.06"	3.15"	1.42"	M8 x 1.25P	16082C-20
93116	HSK63A x 5/16" I.D. - 3.15"	5/16"	.79"	1.06"	3.15"	1.42"	M8 x 1.25P	16082C-20
93117	HSK63A x 3/8" I.D. - 3.35"	3/8"	.94"	1.26"	3.35"	1.53"	M8 x 1.25P	16082C-20
93118	HSK63A x 7/16" I.D. - 3.54"	7/16"	1.10"	1.34"	3.54"	1.85"	M8 x 1.25P	16082C-20
93119	HSK63A x 1/2" I.D. - 3.54"	1/2"	1.10"	1.34"	3.54"	1.85"	M10 x 1.5P	16083C-20
93120	HSK63A x 9/16" I.D. - 3.54"	9/16"	1.10"	1.34"	3.54"	1.85"	M10 x 1.5P	16083C-20
93121	HSK63A x 5/8" I.D. - 3.74"	5/8"	1.26"	1.34"	3.74"	1.97"	M12 x 1.75P	16085C-20
93124	HSK63A x 3/4" I.D. - 3.94"	3/4"	1.26"	1.65"	3.94"	1.97"	M16 x 2.0P	16089C-20
93126	HSK63A x 1.0" I.D. - 4.53"	1.0"	1.42"	1.65"	4.53"	2.04"	M20 x 2.0P	16091C-20
93128	HSK63A x 1-1/4" I.D. - 4.72"	1-1/4"	1.81"	2.09"	4.72"	2.28"	M20 x 2.0P	16091C-20

HSK63A Inch Size Extended Length ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
93130	HSK63A x 3/8" I.D. - 6.3"	3/8"	.71"	1.02"	6.3"	1.53"	M8 x 1.25P	16082C-20
93135	HSK63A x 1/2" I.D. - 6.3"	1/2"	.79"	1.10"	6.3"	1.85"	M10 x 1.5P	16083C-20
93140	HSK63A x 3/4" I.D. - 6.3"	3/4"	1.02"	1.42"	6.3"	1.97"	M16 x 2.0P	16089C-20
93145	HSK63A x 1.0" I.D. - 6.3"	1.0"	1.26"	1.65"	6.3"	2.04"	M20 x 2.0P	16091C-20



Use SlimLINE holders for finish passes where small nose diameter (d2) tooling is required.

SlimLINE Features

- *Smaller nose diameter (d2)*
- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*

Coolant-thru set screw included. Page 104 for dimensions.



HSK63A SlimLINE ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
73528	HSK63A x 1/8" I.D. - 3.15" SlimLINE	1/8"	.35"	.63"	3.15"	.78"	M6x1.0P	16081C-20
73538	HSK63A x 3/16" I.D. - 3.15" SlimLINE	3/16"	.43"	.69"	3.15"	.78"	M6x1.0P	16081C-20
73548	HSK63A x 1/4" I.D. - 3.15" SlimLINE	1/4"	.47"	.81"	3.15"	1.42"	M5x0.8P	16080C-20
73568	HSK63A x 3/8" I.D. - 3.15" SlimLINE	3/8"	.63"	.94"	3.15"	1.93"	M8x1.25P	16082C-20
73588	HSK63A x 1/2" I.D. - 3.15" SlimLINE	1/2"	.71"	1.06"	3.15"	1.93"	M10x1.5P	16083C-20

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

HSK63A Precision ShrinkFIT Holders



Techniks Certified for accuracy and balance

Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

Order coolant-thru set screws separately. Page 104 for dimensions.





ShrinkFIT Machines pg. 105



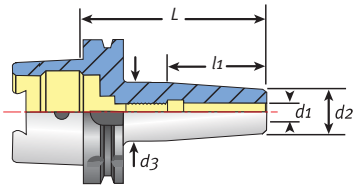
ShrinkFIT Extensions pg. 104



Retention Knobs pg. 204



Wrenches pg. 208



HSK63A Metric Size ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
39132	HSK63A x 4mm I.D. - 80mm	4mm	14mm	22mm	80mm	20mm	M8 x 1.25P	16082C-20
39134	HSK63A x 5mm I.D. - 80mm	5mm	16mm	22mm	80mm	20mm	M8 x 1.25P	16082C-20
39136	HSK63A x 6mm I.D. - 80mm	6mm	21mm	27mm	80mm	36mm	M8 x 1.25P	16082C-20
39138	HSK63A x 8mm I.D. - 80mm	8mm	21mm	27mm	80mm	36mm	M8 x 1.25P	16082C-20
39140	HSK63A x 10mm I.D. - 85mm	10mm	24mm	32mm	85mm	42mm	M8 x 1.25P	16082C-20
39142	HSK63A x 12mm I.D. - 90mm	12mm	24mm	32mm	90mm	47mm	M10 x 1.5P	16083C-20
39144	HSK63A x 14mm I.D. - 90mm	14mm	24mm	32mm	90mm	47mm	M10 x 1.5P	16083C-20
39146	HSK63A x 16mm I.D. - 95mm	16mm	27mm	34mm	95mm	50mm	M12 x 1.75P	16085C-20
39148	HSK63A x 18mm I.D. - 95mm	18mm	33mm	42mm	95mm	50mm	M12 x 1.75P	16085C-20
39150	HSK63A x 20mm I.D. - 100mm	20mm	33mm	42mm	100mm	52mm	M16 x 2.0P	16089C-20
39152	HSK63A x 25mm I.D. - 115mm	25mm	44mm	53mm	115mm	58mm	M20 x 2.0P	16091C-20
39154	HSK63A x 32mm I.D. - 120mm	32mm	44mm	53mm	120mm	58mm	M20 x 2.0P	16091C-20



CoolBLAST Features

- *Maximum chip removal and feed rates*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

CoolBLAST coolant ports direct coolant on the tool path, even at high RPMs. No need to purchase coolant-thru cutting tools.





HSK63A Inch Size CoolBLAST ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
93113B	HSK63A x 1/8" I.D. - 3.15" with CoolBLAST	1/8"	.63"	.87"	3.15"	.79"	M6x1.0P	16081C-20
93114B	HSK63A x 3/16" I.D. - 3.15" with CoolBLAST	3/16"	.63"	.87"	3.15"	.79"	M8 x 1.25P	16082C-20
93115B	HSK63A x 1/4" I.D. - 3.15" with CoolBLAST	1/4"	.71"	1.06"	3.15"	1.42"	M8 x 1.25P	16082C-20
93117B	HSK63A x 3/8" I.D. - 3.35" with CoolBLAST	3/8"	.94"	1.26"	3.35"	1.53"	M8 x 1.25P	16082C-20
93119B	HSK63A x 1/2" I.D. - 3.54" with CoolBLAST	1/2"	1.10"	1.34"	3.54"	1.85"	M10 x 1.5P	16083C-20
93121B	HSK63A x 5/8" I.D. - 3.74" with CoolBLAST	5/8"	1.26"	1.34"	3.74"	1.97"	M12 x 1.75P	16085C-20
93124B	HSK63A x 3/4" I.D. - 3.94" with CoolBLAST	3/4"	1.26"	1.65"	3.94"	1.97"	M16 x 2.0P	16089C-20

HSK100A Precision ShrinkFIT Toolholders



Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

ShrinkFIT toolholders provide concentric clamping force of 10,000 lbs. or more directly on the cutting tool shank to reduce T.I.R. (runout). This is why operators are able to run faster and cutters last longer too. See pg.108 for more info.



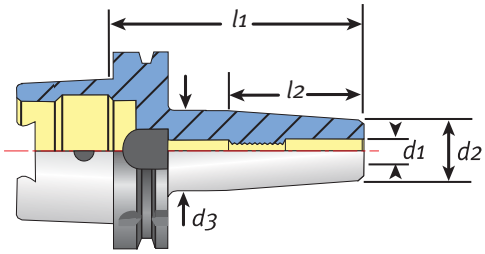
Techniks Certified for accuracy and balance


ShrinkFIT Machines pg. 105


ShrinkFIT Extensions pg. 104


Retention Knobs pg. 204


Wrenches pg. 208



Order coolant-thru set screws separately. Page 104 for dimensions.



HSK100A ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	l1	l2	thread	coolant screw
39304	HSK100A x 1/8" I.D. - 3.54"	1/8"	.63"	.87"	3.54"	.79"	M6 x 1.0P	16081C-20
39306	HSK100A x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"	M5 x 0.8P	16080C-20
39308	HSK100A x 5/16" I.D. - 3.35"	5/16"	.79"	1.06"	3.35"	1.42"	M6 x 1.0P	16081C-20
39310	HSK100A x 3/8" I.D. - 3.54"	3/8"	.94"	1.26"	3.54"	1.53"	M8 x 1.25P	16082C-20
39310-6	HSK100A x 3/8" I.D. - 6"	3/8"	.94"	1.26"	6"	1.53"	M8 x 1.25P	16082C-20
39312	HSK100A x 7/16" I.D. - 3.74"	7/16"	.94"	1.26"	3.74"	1.85"	M10 x 1.5P	16083C-20
39314	HSK100A x 1/2" I.D. - 3.74"	1/2"	1.10"	1.34"	3.74"	1.85"	M10 x 1.5P	16083C-20
39315	HSK100A x 1/2" I.D. - 6"	1/2"	1.10"	1.34"	6"	1.85"	M10 x 1.5P	16083C-20
39318	HSK100A x 5/8" I.D. - 3.94"	5/8"	1.26"	1.34"	3.94"	1.97"	M12 x 1.75P	16085C-20
39319	HSK100A x 5/8" I.D. - 6"	5/8"	1.26"	1.34"	6"	1.97"	M12 x 1.75P	16085C-20
39320	HSK100A x 3/4" I.D. - 4.13"	3/4"	1.42"	1.65"	4.13"	2.04"	M16 x 2.0P	16089C-20
39321	HSK100A x 3/4" I.D. - 6"	3/4"	1.42"	1.65"	6"	2.04"	M16 x 2.0P	16089C-20
39324	HSK100A x 1.0" I.D. - 4.53"	1.0"	1.81"	2.09"	4.53"	2.28"	M20 x 2.0P	16091C-20
39325	HSK100A x 1.0" I.D. - 6.3"	1.0"	1.81"	2.09"	6.3"	2.28	M20 x 2.0P	16091C-20
39326	HSK100A x 1-1/4" I.D. - 4.72"	1-1/4"	1.81"	2.09"	4.72"	2.28	M20 x 2.0P	16091C-20
39327	HSK100A x 1-1/4" I.D. - 6.3"	1-1/4"	1.81"	2.09"	6.3"	2.28	M20 x 2.0P	16091C-20

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

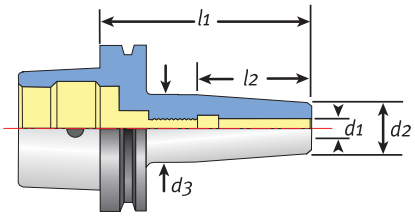
Precision ShrinkFIT Toolholders for CNC Routers

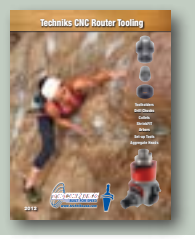


Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced 25,000 RPM at G2.5*
- *Comes with coolant-thru set screw installed*

Techniks Certified for accuracy and balance





Scan the QR code with a smartphone or enter this url: http://ow.ly/rKs6W to request our new 76 page CNC Router Tooling catalog. Or, you can call us at (800) 597-3921 to have it sent to you.

Order coolant-thru set screws separately. Page 104 for dimensions.



HSK63F Inch ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	l1	l2	thread	coolant screw
71250	HSK63F x 1/4" I.D. - 3.15"	1/4"	.71"	1.06"	3.15"	1.42"	M5 x 0.8P	16080C-20
71312	HSK63F x 5/16" I.D. - 3.74"	5/16"	.83"	1.06"	3.74"	1.75"	M6 x 1.0P	16081C-20
71375	HSK63F x 3/8" I.D. - 3.74"	3/8"	.94"	1.26"	3.74"	1.53"	M8 x 1.25P	16082C-20
71500	HSK63F x 1/2" I.D. - 3.74"	1/2"	1.10"	1.34"	3.74"	1.85"	M10 x 1.5P	16083C-20
71625	HSK63F x 5/8" x 3.74"	5/8"	1.06"	1.34"	3.74"	1.77"	M12 x 1.75P	16085C-20
71750	HSK63F x 3/4" I.D. - 3.94"	3/4"	1.26"	1.34"	3.94"	1.97"	M16 x 2.0P	16089C-20
71100	HSK63F x 1.0" I.D. - 4.53"	1"	1.42"	1.65"	4.53"	2.04"	M20 x 2.0P	16091C-20

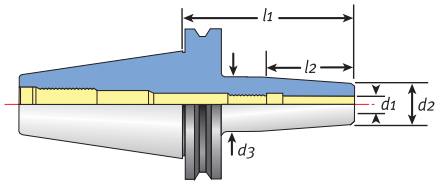
HSK63F Metric ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	l1	l2	thread	coolant screw
71010	HSK63F x 20mm I.D. - 100mm	20mm	33mm	42mm	100mm	47mm	M16 x 2.0P	16089C-20
71011	HSK63F x 25mm I.D. - 115mm	25mm	44mm	53mm	115mm	58mm	M20 x 2.0P	16091C-20



ISO30 ShrinkFIT Toolholders

ShrinkFIT toolholders provide concentric clamping force of 10,000 lbs. or more directly on the cutting tool shank to reduce T.I.R. (runout). This is why operators are able to run faster and cutters last longer too. See pg.108 for more info.



Part No.	Description	d1	d2	d3	l1	l2	thread	coolant screw
64250	ISO30 x 1/4" - 80	1/4"	18	27	80	39	M8 x 1.25P	16082C-20
64375	ISO30 x 3/8" - 80	3/8"	24	32	80	-	M8 x 1.25P	16082C-20
64500	ISO30 x 1/2" - 80	1/2"	28	32	80	25	M10 x 1.5P	16083C-20
64625	ISO30 x 5/8" - 80	5/8"	28	32	80	50	M12 x 1.75P	16085C-20
64750	ISO30 x 3/4" - 80	3/4"	36	41	80	-	M16 x 2.0P	16089C-20
64110	ISO30 x 1.0" - 4"	1.0"			4"		M20 x 2.0P	16091C-20

Universal ShrinkFIT Extensions – Coolant Set Screws



For extended lengths or tight clearances

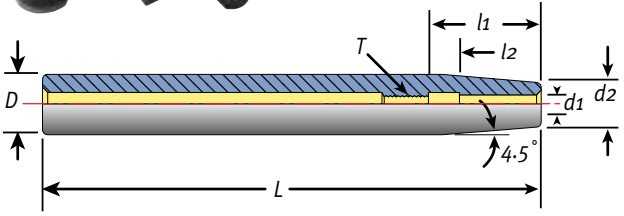
Features

- *Extend the reach of your existing holders*
- *Better rigidity and T.I.R. extends tool life*
- *Works with a variety of toolholders*



ShrinkFIT extensions work great with our 00320 ShrinkSTATION machine.



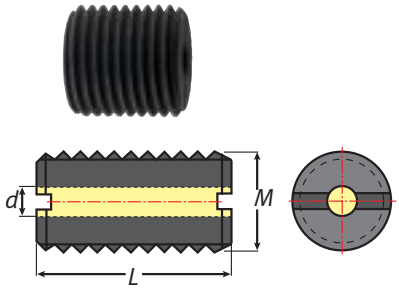


Metric sizes available upon request.

Part No.	Description	D	d1	d2	L	l1	l2	T
86062	5/8" O.D., x 1/8" I.D. - 6.3" length	5/8"	1/8"	.394"	6.3"	-	.394"	-
86064	5/8" O.D., x 3/16" I.D. - 6.3" length	5/8"	3/16"	.394"	6.3"	-	.394"	-
86066	5/8" O.D., x 1/4" I.D. - 6.3" length	5/8"	1/4"	.394"	6.3"	1.42	1.024"	M6x1.0
86076	3/4" O.D., x 1/4" I.D. - 6.3" length	3/4"	1/4"	.551"	6.3"	1.42	1.024"	M6x1.0
86080	3/4" O.D., x 3/8" I.D. - 6.3" length	3/4"	3/8"	.551"	6.3"	1.65	1.26"	M8x1.25
86090	1.0" O.D., x 3/8" I.D. - 6.3" length	1.0"	3/8"	.79"	6.3"	1.65	1.26"	M8x1.25
86092	1.0" O.D., x 1/2" I.D. - 6.3" length	1.0"	1/2"	.79"	6.3"	1.85	1.96"	M10x1.5
86094	1.0" O.D., x 5/8" I.D. - 6.3" length	1.0"	5/8"	.88"	6.3"	1.97	1.57"	M12x1.75

Coolant Set Screws

Part No.	Description	M	L	d
16080C-20	Coolant Set Screw	M5 x 0.8P	20mm	2.5
16081C-20	Coolant Set Screw	M6 x 1.0P	20mm	-
16082C-20	Coolant Set Screw	M8 x 1.25P	20mm	4
16083C-20	Coolant Set Screw	M10 x 1.5P	20mm	4
16085C-20	Coolant Set Screw	M12 x 1.75P	20mm	4
16089C-20	Coolant Set Screw	M16 x 02.0P	20mm	5
16091C-20	Coolant Set Screw	M20 x 2.0P	20mm	5



Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

ShrinkSTATION – ShrinkFIT Machine



Features

- *Changes tools in 30 seconds*
- *Automatic cooling using shop air*
- *For carbide tools from 1/8" to 1-1/4" (works best with h6 shanks)*

The ShrinkSTATION is our small footprint machine. It only requires 17" x 18" of bench space, so it's easy to add to your shop.

All controls are computerized and easy to use – simply align the induction head with your toolholder, enter your shank size, and press START.

small footprint
17" wide x 18" deep x 31" tall

ShrinkSTATION Includes:

Part No.	Description	QTY.
00300-02-1	small induction head (3-16mm)	1
00300-02-2	large induction head (20-32mm)	1
00165	induction stop ring (3-5mm)	1
00166	induction stop ring (6-12mm)	1
00167	induction stop ring (14-20mm)	1
00168	induction stop ring (25-32mm)	1
00151	toolholder adapter - 30 taper	1
00152	toolholder adapter - 40 taper	1
00153	toolholder adapter - 50 taper	1
00157	toolholder adapter - HSK40	1
00158	toolholder adapter - HSK50	1
00159	toolholder adapter - HSK63	1
00170	toolholder sleeve	1
26139-L	thermal insulated glove	1

ShrinkFIT Induction Caps



Part No.	Description	Tool Change	Rating	L x D x H	Wt.
00320	ShrinkSTATION	30 seconds	1 phase, 220V, 20A	17"x 18"x 31"	42 lbs

ShrinkFIT Caps concentrate the induction heat on the cutting tool, to make tool changes faster and easier. Great for stainless steel holders.

Features

- *Make tool extraction faster*
- *For tools 1/8" to 1"*
- *Great for stainless steel holders*

Part No.	Description	Tool Range
00401-06	ShrinkFIT Cap 9mm	1/8", 3mm
00401-07	ShrinkFIT Cap 10mm	3/16", 4mm
00401-75	ShrinkFIT Cap 21mm	1/4", 6mm, 5/16", 8mm
00401-09	ShrinkFIT Cap 24mm	3/8", 10mm, 7/16", 12mm, 1/2", 14mm
00401-10	ShrinkFIT Cap 27mm	5/8", 16mm
00401-11	ShrinkFIT Cap 33mm	3/4", 20mm
00401-13	ShrinkFIT Cap 44mm	1", 25mm

ShrinkPRO – High-Performance ShrinkFIT



20" wide x 20" deep x 37" tall

The ShrinkPRO is a great choice for dedicated tool changing stations or cellular workflows, because it can operate on voltages ranging from 208VAC thru 480VAC.

Features

- *Change 1/8" shanks in 2 seconds. 1" in 6 seconds*
- *Flexible power requirements – Operates on 208V up to 480V*
- *Automatic cooling cycle by compressed air*

Features and Flexibility

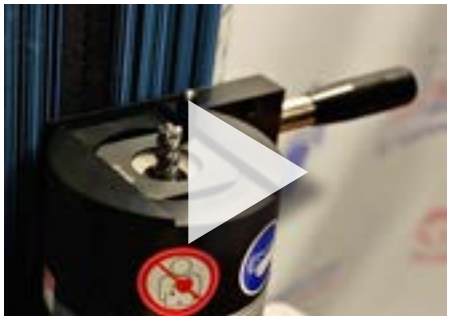
This machine truly has it all; touchscreen simplicity, state-of-the-art induction heating for fast tool changes, and automatic cooling cycle using your shop air.

Easy-to-Use Touchscreen



Select your shank size and ShrinkPRO sets heating duration

View the video.
http://ow.ly/sVv3S



Scan the QR code to view the demo video.

Included With ShrinkPRO Machine

Part No.	Description	QTY.
00151	toolholder adapter - 30 taper	1
00152	toolholder adapter - 40 taper	1
00153	toolholder adapter - 50 taper	1
00157	toolholder adapter - HSK40	1
00158	toolholder adapter - HSK50	1
00159	toolholder adapter - HSK63/100	1
26139-L	thermal insulated glove	1

Part No.	Description	Tool Change	Rating	L x D x H	Ship Wt.
00600	ShrinkPRO machine	2–6 seconds	3 phase, 480V, 20A	20"x 20"x 37"	84 lbs

For HSK32 Adapter order Part No. 00156. For HSK80 Adapter order Part No. 00160.

Need it FAST? We offer Same Day Shipping until 6:00 pm E.S.T.

SYIC

The Quencher Cools Tools in Only 30 Seconds



fast, safe, induction heat

36.75" wide x 24" deep x 71" tall

Features

- *Change tool and back to spindle in under 1 minute!*
- *Auto-Quench means you never touch hot toolholder*
- *Flexible – Operates on 208V up to 480V*

The Quencher ShrinkFIT machine features a liquid cooling cycle that is 250% faster than air-cooled units. Cooling time is to less than 30 seconds!

The hot tool is immersed in the Quench Tank and the cool tool is returned to the shrink position in only 30 seconds and automatically dried using shop air.

The Quencher is a great choice for dedicated tool changing stations or cellular workflows, because it can operate on voltages from 208 - 480VAC.



View the demo video.
http://ow.ly/u3JPk

Touchscreen Simplicity



Select your shank size and the Quencher sets heating duration. Touch the Quench button to start cooling cycle.

The Quencher includes induction rings for 1/8" up to 1-1/4" shank sizes, tool seats for BT30/CAT30, BT40/CAT40, BT50/CAT50, and HSK40, 50, 63 and 100. No plumbing is required and the Quencher comes loaded with coolant.

Description	Tool Change	Recommended Electrical Supply
00500 Quencher	2–5 seconds	3 phase, 480V, 20A

"Never Down" Guarantee

We stand behind our products 100% and expect them to out-perform the competition. Purchase any Techniks ShrinkFIT machine with confidence knowing that we can provide a backup if yours should ever need servicing!

Replacement machine is on loan until original is repaired and back in service. Replacement machines are limited to standard configuration. Power requirements may vary from original machine. Replacements are subject to availability. Extended Warranties are also available.



Tool Life Comparison: ER Chucks vs. ShrinkFIT

Our side-by-side testing shows you the differences.



TEST CONDITIONS

This trial was performed on a CNC Vertical Machining Center with a CT 40 taper. Identical spindle speeds, feed rates, material conditions and endmills were utilized to isolate the performance of these tool holding technologies. The test cuts were in 4140 Prehard (30-32 Rc) using 3 flute uncoated carbide center cutting endmills. The identical tool paths involved a variety of cutting directions.



ER chuck



ShrinkFIT tool

TEST RESULTS

Tool Life

The most significant comparison between these tool holding technologies is in the area of tool life. The endmill in the ShrinkFIT toolholder showed dramatically less wear (photos) compared to the endmill used in the collet chuck (note the fractured surface). Our results back up other reports that ShrinkFIT allows 4 to 7 times the tool life of other tool holding technologies. In our tests there was significant fretting on the taper of the ER collet chuck while there was virtually no fretting on the ShrinkFIT holder (visible in photo above). This was attributed to the superior wear characteristics of H-13 tool steel ovER8620.



ER chuck wear detail



ShrinkFIT wear detail

Shrink-Fit surface finish



ER collet chuck surface finish



Cutting Ability

During our four machining test passes of .125" depth of cut, the ShrinkFIT toolholder required less spindle load than the ER collet chuck toolholder. The increased rigidity of ShrinkFIT created a more balanced chip load during cutting. This was observed in a better machining sound and visual improvement in surface finish (above) and absence of fretting on the ShrinkFIT toolholder (below)



ER chuck fretting *ShrinkFIT*

CONCLUSION

While both technologies have their place, machining using ShrinkFIT is a significant improvement over ER collet chuck technology. ShrinkFIT has advantages in tool life, cutting ability, surface finish, and produces less wear-and tear on the toolholder taper and spindle bearings.

Techniks Certified Face Mill Arbors

Dual-Contact DualDRIVE

View the DualDRIVE video for face mill arbors.

http://ow.ly/sUOqL

NEW!

One-Piece Design



TECHNIKS CERTIFIED ACCURACY BALANCE

Face Mill Arbors

H6 arbor tolerance reduces chatter



CAT, BT, HSK





CoolBLAST Arbor Screw

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Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!

CAT40 Precision Face Mill Arbors



Techniks Certified for accuracy

Features

- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*
- *Taper ground to AT3 tolerance or better*



Arbor Screws pg. 117



Tightening Stands pg. 210



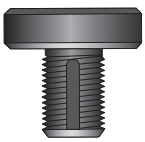
Retention Knobs pg. 204



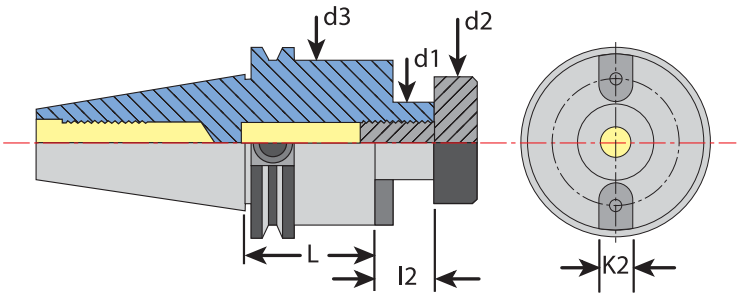
Wrenches pg. 208

CoolBLAST Coolant Option





CoolBLAST arbor screw provides coolant path. Order on page 117.



CAT40 Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
22709	CAT40 x FMA 1/2" - 1.37"	1.37"	.55"	1/2"	.66"	1.45"	.25"
22709-4	CAT40 x FMA 1/2" - 4"	4"	.55"	1/2"	.66"	1.45"	.25"
22711	CAT40 x FMA 3/4" - 1.37"	1.37"	.69"	3/4"	.88"	1.69"	.31"
22711-4	CAT40 x FMA 3/4" - 4.0"	4"	.69"	3/4"	.88"	1.69"	.31"
22711-6	CAT40 x FMA 3/4" - 6.0"	6"	.69"	3/4"	.88"	1.69"	.31"
22713	CAT40 x FMA 1.0" - 2.06"	2.06"	.69"	1.0"	1.19"	2.2"	.38"
22713-4	CAT40 x FMA 1.0" - 4.0"	4"	.69"	1.0"	1.19"	2.2"	.38"
22713-6	CAT40 x FMA 1.0" - 6.0"	6"	.69"	1.0"	1.19"	2.2"	.38"
22715	CAT40 x FMA 1-1/4" - 2.21"	2.21"	.69"	1-1/4"	1.5"	2.75"	.5"
22715-4	CAT40 x FMA 1-1/4" - 4.0"	4"	.69"	1-1/4"	1.5"	2.75"	.5"
22715-6	CAT40 x FMA 1-1/4" - 6.0"	6"	.69"	1-1/4"	1.5"	3."	.5"
22717	CAT40 x FMA 1-1/2" - 2.21"	2.21"	.94"	1-1/2"	1.88"	3.8"	.63"
22717-4	CAT40 x FMA 1-1/2" - 4"	4"	.94"	1-1/2"	1.88"	3.8"	.63"

CAT40 DualDRIVE for Dual-Contact Spindles



Techniks Certified for accuracy

Features

- *New one-piece design for dual-contact spindles*
- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*

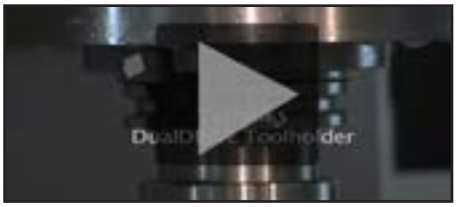
Benefits

- *Better rigidity and reduced vibration*
- *Improved performance at high metal removal rates and when machining at extended lengths*

Dual-Contact Spindles

Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

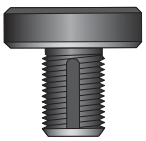
Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.



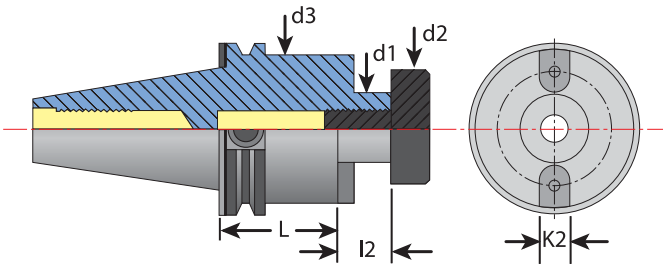
See an on machine demonstration video of DualDRIVE compared to standard toolholders at: http://ow.ly/sUOqL

CoolBLAST Coolant Option





CoolBLAST arbor screw provides coolant path. Order on page 117.



CAT40 DualDRIVE Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
43.151.64.137	CAT40 x FMA 3/4" - 1.37" DualDRIVE	1.37"	.69"	3/4"	.88"	1.69"	.31"
43.151.64.400	CAT40 x FMA 3/4" - 4" DualDRIVE	4"	.69"	3/4"	.88"	1.69"	.31"
43.151.64.600	CAT40 x FMA 3/4" - 6" DualDRIVE	6"	.69"	3/4"	.88"	1.69"	.31"
43.151.68.206	CAT40 x FMA 1.0" - 2.06" DualDRIVE	2.06"	.69"	1.0"	1.19"	2.2"	.38"
43.151.68.400	CAT40 x FMA 1.0" - 4" DualDRIVE	4"	.69"	1.0"	1.19"	2.2"	.38"
43.151.68.600	CAT40 x FMA 1.0" - 6" DualDRIVE	6"	.69"	1.0"	1.19"	2.2"	.38"
43.151.72.221	CAT40 x FMA 1-1/4" - 2.21" DualDRIVE	2.21"	.69"	1-1/4"	1.5"	2.75"	.5"
43.151.72.400	CAT40 x FMA 1-1/4" - 4" DualDRIVE	4"	.69"	1-1/4"	1.5"	2.75"	.5"
43.151.72.600	CAT40 x FMA 1-1/4" - 6" DualDRIVE	6"	.69"	1-1/4"	1.5"	3"	.5"
43.151.77.221	CAT40 x FMA 1-1/2" - 2.21" DualDRIVE	2.21"	.94"	1-1/2"	1.88"	3.8"	.63"
43.151.77.400	CAT40 x FMA 1-1/2" - 4" DualDRIVE	4"	.94"	1-1/2"	1.88"	3.8"	.63"

CAT50 Precision Face Mill Arbors



Techniks Certified for accuracy

Features

- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*
- *Taper ground to AT3 tolerance or better*



Arbor Screws pg. 117



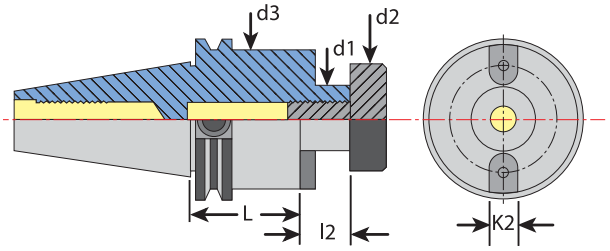
Tightening Stands pg. 210

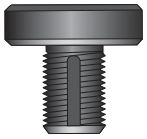


Retention Knobs pg. 204



Wrenches pg. 208





CoolBLAST arbor screw provides coolant path. Order on page 117.

CoolBLAST Coolant Option



CAT50 Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
22719	CAT50 x FMA 1/2" - 1.5"	1.5"	055"	1/2"	.66"	1.45"	.25"
22721	CAT50 x FMA 3/4" - 1.5"	1.5"	.69"	3/4"	.88"	2.75"	.31"
22721-3.5	CAT50 x FMA 3/4" - 3.5"	3.5"	.69"	3/4"	.88"	1.69"	.31"
22721-5.5	CAT50 x FMA 3/4" - 5.5"	5.5"	.69"	3/4"	.88"	1.69"	.31"
22721-8	CAT50 x FMA 3/4" - 8"	8"	.69"	3/4"	.88"	1.69"	.31"
22721-10	CAT50 x FMA 3/4" - 10"	10"	.69"	3/4"	.88"	1.69"	.31"
22723	CAT50 x FMA 1" - 2.0"	2.0"	.69"	1.0"	1.19"	2.2"	.38"
22723-4	CAT50 x FMA 1" - 4.0"	4"	.69"	1.0"	1.19"	2.2"	.38"
22723-6	CAT50 x FMA 1" - 6.0"	6"	.69"	1.0"	1.19"	2.2"	.38"
22723-8	CAT50 x FMA 1" - 8.0"	8"	.69"	1.0"	1.19"	2.2"	.38"
22723-10	CAT50 x FMA 1" - 10.0"	10"	.69"	1.0"	1.19"	2.2"	.38"
22725	CAT50 x FMA 1-1/4" - 1.50"	1.5"	.69"	1-1/4"	1.5"	2.75"	.5"
22725-3.5	CAT50 x FMA 1-1/4" - 3.5"	3.5"	.69"	1-1/4"	1.5"	2.75"	.5"
22725-6	CAT50 x FMA 1-1/4" - 6.0"	6"	.69"	1-1/4"	1.5"	2.75"	.5"
22725-8	CAT50 x FMA 1-1/4" - 8.0"	8"	.69"	1-1/4"	1.5"	2.75"	.5"
22727	CAT50 x FMA 1-1/2" - 2.4"	2.4"	.94"	1-1/2"	1.88"	3.8"	.63"
22727-4	CAT50 x FMA 1-1/2" - 4.0"	4"	.94"	1-1/2"	1.88"	3.8"	.63"
22727-6	CAT50 x FMA 1-1/2" - 6.0"	6"	.94"	1-1/2"	1.88"	3.8"	.63"
22727-8	CAT50 x FMA 1-1/2" - 8.0"	8"	.94"	1-1/2"	1.88"	3.8"	.63"
22729	CAT50 x FMA 2" - 2.4"	2.4"	.94"	2"	2.5"	4.88"	.75"
22729-4	CAT50 x FMA 2" - 4.0"	4"	.94"	2"	2.5"	4.88"	.75"

CAT50 DualDRIVE for Dual-Contact Spindles



Techniks Certified for accuracy

Dual-Contact Spindles: *Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining. Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.*

Features

- *New one-piece design for dual-contact spindles*
- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*

Benefits

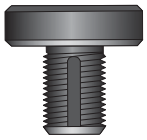
- *Better rigidity and reduced vibration*
- *Improved performance at high metal removal rates and when machining at extended lengths*



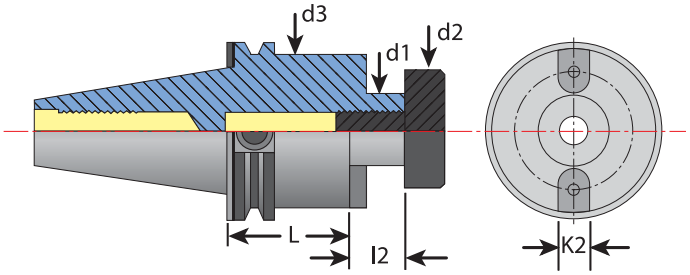
See an on machine demonstration video of DualDRIVE compared to standard toolholders at: http://ow.ly/sUOqL

CoolBLAST Coolant Option





CoolBLAST arbor screw provides coolant path. Order on page 117.



CAT50 DualDRIVE Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
44.151.64.150	CAT50 x FMA 3/4" - 1.5" DualDRIVE	1.5"	.69"	3/4"	.88"	2.75"	.31"
44.151.64.350	CAT50 x FMA 3/4" - 3.5" DualDRIVE	3.5"	.69"	3/4"	.88"	1.69"	.31"
44.151.64.550	CAT50 x FMA 3/4" - 5.5" DualDRIVE	5.5"	.69"	3/4"	.88"	1.69"	.31"
44.151.68.200	CAT50 x FMA 1.0" - 2" DualDRIVE	2"	.69"	1.0"	1.19"	2.2"	.38"
44.151.68.400	CAT50 x FMA 1.0" - 4" DualDRIVE	4"	.69"	1.0"	1.19"	2.2"	.38"
44.151.68.400	CAT50 x FMA 1.0" - 6" DualDRIVE	6"	.69"	1.0"	1.19"	2.2"	.38"
44.151.72.150	CAT50 x FMA 1-1/4" - 1.5" DualDRIVE	1.5"	.69"	1-1/4"	1.5"	2.75"	.5"
44.151.72.350	CAT50 x FMA 1-1/4" - 3.5" DualDRIVE	3.5"	.69"	1-1/4"	1.5"	2.75"	.5"
44.151.72.600	CAT50 x FMA 1-1/4" - 6" DualDRIVE	6"	.69"	1-1/4"	1.5"	2.75"	.5"
44.151.77.240	CAT50 x FMA 1-1/2" - 2.4" DualDRIVE	2.4"	.94"	1-1/2"	1.88"	3.8"	.63"
44.151.77.400	CAT50 x FMA 1-1/2" - 4" DualDRIVE	4"	.94"	1-1/2"	1.88"	3.8"	.63"
44.151.77.600	CAT50 x FMA 1-1/2" - 6" DualDRIVE	6"	.94"	1-1/2"	1.88"	3.8"	.63"
44.151.77.800	CAT50 x FMA 1-1/2" - 8" DualDRIVE	8"	.94"	1-1/2"	1.88"	3.8"	.63"
44.151.86.240	CAT50 x FMA 2" - 2.4" DualDRIVE	2.4"	.94"	2"	2.5"	4.88"	.75"
44.151.86.400	CAT50 x FMA 2" - 4" DualDRIVE	4"	.94"	2"	2.5"	4.88"	.75"

BT30 Arbors & DualDRIVE for Dual-Contact Spindles



Techniks Certified for accuracy

Features

- *New one-piece design for dual-contact spindles*
- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*

Benefits

- *Better rigidity and reduced vibration (chatter)*
- *Improved performance at high metal removal rates and when machining at extended lengths*

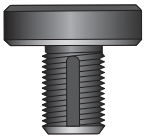
Dual-Contact Spindles: *Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining. Use Techniks DualDRIVE holders if your machine has a dual-contact spindle.*



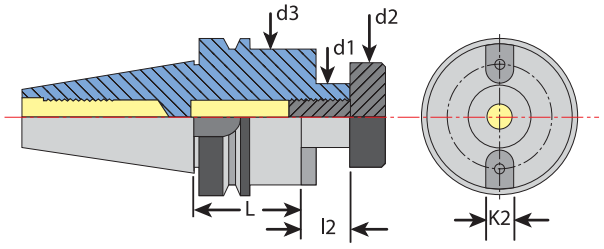
See an on machine demonstration video of DualDRIVE compared to standard toolholders at: http://ow.ly/sUOqL

CoolBLAST Coolant Option





CoolBLAST arbor screw provides coolant path. Order on page 117.



BT30 DualDRIVE Face Mill Arbors

Part No.	Description d1 – l1	L	l2	d1	d2	d3	K2
25.151.64.200	BT30 x DualDRIVE FMA 3/4" - 2"	2"	.69"	3/4"	.88"	1.66"	.313"
25.151.68.200	BT30 x DualDRIVE FMA 1.0" - 2"	2"	.69"	1.0"	1.18"	2.2"	.375"



Features

- *H6 arbor tolerance for less chatter and better tool life*
- *Each arbor lab certified for accuracy*
- *Taper ground to AT3 tolerance for maximum spindle contact*

BT30 Precision Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
16611	BT30 x 3/4"FMA - 1.18"	1.18"	.69"	3/4"	.88"	1.66"	.313"
16612	BT30 x 1" FMA - 1.77"	1.77"	.69"	1.0"	1.18"	2.2"	.375"
16614	BT30 x 1-1/4" FMA - 1.77"	1.77"	.87"	1-1/4"	1.5"	2.37"	.5"

BT40, BT50 Precision Face Mill Arbors



Techniks Certified for accuracy

Features

- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*
- *Taper ground to AT3 tolerance or better*


Arbor Screws pg. 117

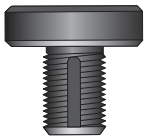

Tightening Stands pg. 210


Retention Knobs pg. 204

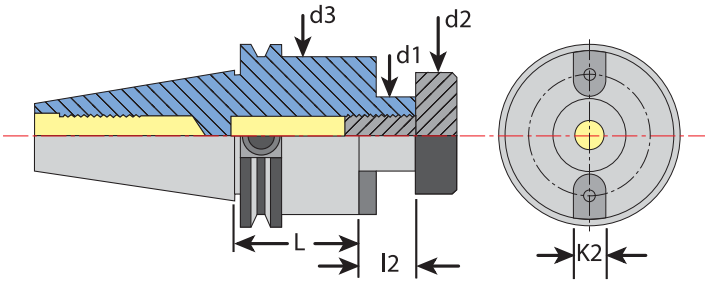

Wrenches pg. 208

CoolBLAST Coolant Option





CoolBLAST arbor screw provides coolant path. Order on page 117.



BT40 Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
16615-3/4	BT40 x 3/4" FMA - 1"	1.0"	.69"	3/4"	.88"	1.69"	.313"
16615-4	BT40 x 3/4" FMA - 4.0"	4"	.69"	3/4"	.88"	1.69"	.313"
16615-6	BT40 x 3/4" FMA - 6.0"	6"	.69"	3/4"	.88"	1.69"	.313"
16615	BT40 x 1.0" FMA - 1.77"	1.77"	.69"	1.0"	1.18"	2.2"	.375"
16617	BT40 x 1.0" FMA - 3.54"	3.54"	.69"	1.0"	1.18"	2.2"	.375"
16620	BT40 x 1-1/4" FMA - 1.77"	1.77"	.69"	1-1/4"	1.5"	2.75"	.5"
16620-4	BT40 x 1-1/4" FMA - 4"	4"	.69"	1-1/4"	1.5"	2.75"	.5"
16626	BT40 x 1-1/2" FMA - 2.36"	2.36"	.94"	1-1/2"	1.88"	3.8"	.625"

BT50 Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
16639	BT50, 1.0" FMA - 1.77"	1.77"	.79"	1.0"	1.19"	1.97	.375"
16639-3	BT50, 1.0" FMA - 3"	3"	.79"	1.0"	1.19"	1.97	.375"
16642	BT50, 1-1/4" FMA - 1.77"	1.77"	.87"	1-1/4"	1.5"	2.34"	.5"
16645	BT50, 1-1/2" FMA - 1.77"	1.77"	.94"	1-1/2"	1.88"	3.8"	.625"
16646	BT50, 1-1/2" FMA - 75mm	75mm	.94"	1-1/2"	1.88"	3.8"	.625"
16646-105	BT50, 1-1/2" FMA - 105mm	105mm	.94"	1-1/2"	1.88"	3.8"	.625"
16646-150	BT50, 1-1/2" FMA - 150mm	150mm	.94"	1-1/2"	1.88"	3.8"	.625"
16648	BT50, 2.0" FMA - 2.95"	2.95"	.94"	2"	3.13"	4.88"	.75"

HSK63A, 100A and R8 Precision Face Mill Arbors



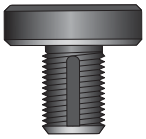
Techniks Certified for accuracy

Features

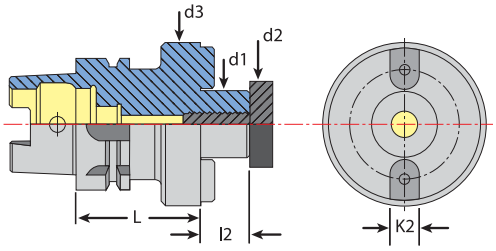
- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*
- *For HSK63A, HSK100A and R8 spindles*

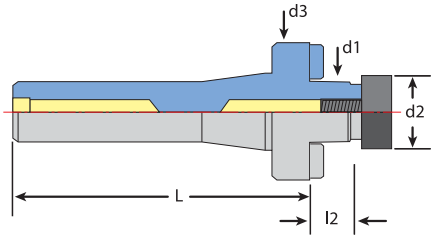


CoolBLAST Coolant Option



CoolBLAST arbor screw provides coolant path. Order on page 117.





HSK63A Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
93500	HSK63A .75" FMA - 2"	2"	.687"	.75"	.875"	1.69"	.313"
93501	HSK63A 1" FMA - 2.37"	2.37"	.687"	1.0"	1.24"	2.2"	.375"
93502	HSK63A 1.25" FMA - 2.75"	2.75"	.687"	1.25"	1.5"	2.75	.5"

HSK63A Extended Length Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
93510	HSK63A .75" FMA - 4"	4"	.687"	.75"	.875"	1.69"	.313"
93520	HSK63A 1.0" FMA - 4"	4"	.687"	1.0"	1.24"	2.2"	.375"
93530	HSK63A 1.25" FMA - 4"	4"	.687"	1.25"	1.5"	2.75	.5"

HSK100A Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
95901	HSK100 A .75" FMA - 2"	2"	.69"	.75"	.88"	1.69"	.31"
95903	HSK100 A 1.0" FMA - 2"	2"	.69"	1.0"	1.19"	2.2"	.38"
95905	HSK100 A 1.25" FMA - 2.5"	2.5"	.69"	1.25"	1.5"	2.75"	.5"
95907	HSK100 A 1.5" FMA - 2.5"	2.5"	.94"	1.5"	1.88"	3.8"	.63"

R8 Face Mill Arbors

Part No.	Description	L	l2	d1	d2	d3	K2
7582401	R8-FMA-0.75	4.7"	.675"	.75"	-	1.93	.37"
7582402	R8-FMA-1.0	4.85"	.85"	1.0"	1.24"	1.81"	.37"
7582403	R8-FMA-1.25	4.90"	.75"	1.25"	1.62"	2.28"	.47"

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

CoolBLAST and Standard Face Mill Arbor Screws

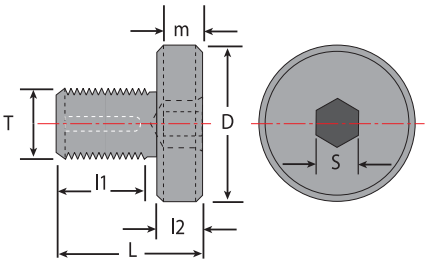


CoolBLAST arbor screw provides coolant path.

Features

- *Compatible with all face mills*
- *Works with all Techniks face mill arbors*
- *For coolant up to 1,500 PSI*





CAT, BT, and HSK CoolBLAST Coolant Arbor Screws

Part No.	Description	Style	Size	D	L	l1	l2	T	S	m
WF.C1-0.5	CoolBLAST arbor screw 1/2"	B	1/2"	5/8"	.84"	.5"	.34"	1/4"-28UNF	3/16"	.157"
WF.C1-0.75	CoolBLAST arbor screw 3/4"	B	3/4"	7/8"	1.8"	1.4"	.37"	3/8"-24UNF	1/4"	.197"
9851125	CAS-A-0.75 smaller "D"	A	3/4"	5/8"	1.375"	1.0"	.36"	3/8-24 UNF	1/4"	.37"
WF.C1-1	CoolBLAST arbor screw 1.0"	B	1.0"	1-3/16"	1.4"	0.81"	.37"	1/2"-20UNF	5/16"	.197"
9851135	CAS-A-1.00 smaller "D"	A	1.0"	3/4"	1.375"	1.0"	.38"	1/2-20UNF	5/16"	.37"
WF.C1-1.25	CoolBLAST arbor screw 1-1/4"	B	1-1/4"	1-1/2"	1.44"	0.94"	.5"	5/8"-18UNF	5/16"	.236"
WF.C1-1.5	CoolBLAST arbor screw 1-1/2"	B	1-1/2"	1-7/8"	1.63"	1.13"	.5"	3/4"-16UNF	3/8"	.276"
WF.C1-2	CoolBLAST arbor screw 2.0"	B	2"	2-1/2"	1.81"	1.31"	.5"	1.0"-14UNF	1/2"	.354"

CAT, BT, and HSK Standard Arbor Screws

Part No.	Description	Arbor Size	D	L	l1	l2	T	S	m
WF0.5	FMA screw 1/2"	1/2"	5/8"	.84"	.5"	.34"	1/4"-28UNF	3/16"	.157"
WF0.75	FMA screw 3/4"	3/4"	7/8"	1.8"	1.4"	.37"	3/8"-24UNF	1/4"	.197"
WF1	FMA screw 1.0"	1.0"	1-3/16"	1.4"	0.81"	.37"	1/2"-20UNF	5/16"	.197"
WF1.25	FMA screw 1-1/4"	1-1/4"	1-1/2"	1.44"	0.94"	.5"	5/8"-18UNF	5/16"	.236"
WF1.5	FMA screw 1-1/2"	1-1/2"	1-7/8"	1.63"	1.13"	.5"	3/4"-16UNF	3/8"	.276"
WF2	FMA screw 2.0"	2"	2-1/2"	1.81"	1.31"	.5"	1.0"-14UNF	1/2"	.354"

Measurement Guide For Special Order Toolholders

V-flange CNC machine make, model and spindle

_____

V-Flange tool #1 dimensions

D = _____

F = _____

W = _____

A = _____

N = _____

V-Flange tool #2 dimensions

D = _____

F = _____

W = _____

A = _____

N = _____

HSK CNC machine make, model and spindle

_____

HSK tool #1 dimensions

D = _____

F = _____

W = _____

A = _____

N = _____

HSK tool #2 dimensions

D = _____

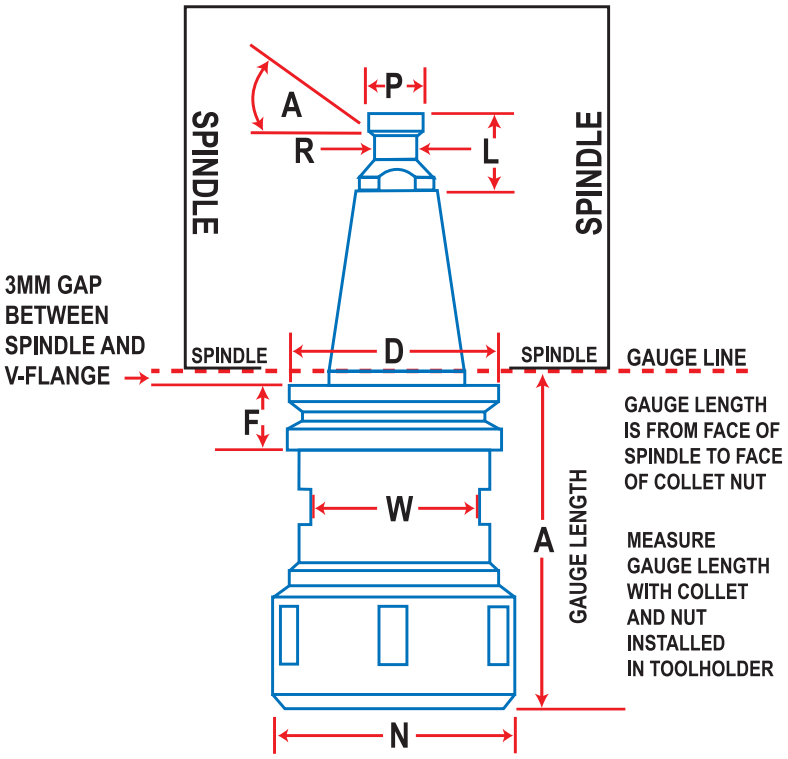
F = _____

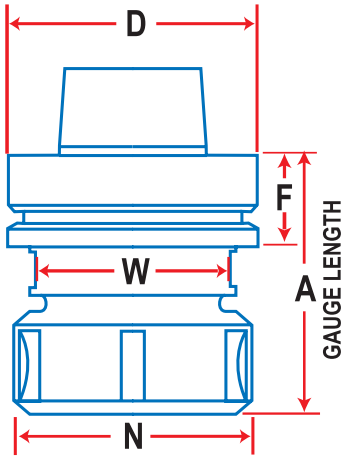
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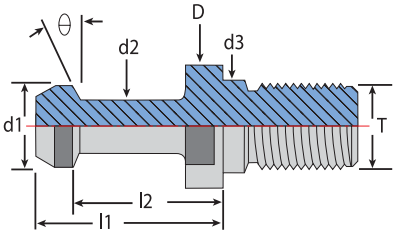
A = _____

N = _____

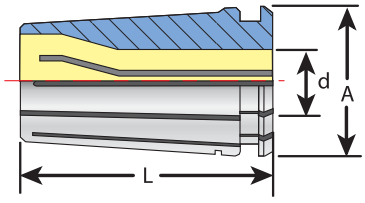
Fill in all the required dimensions (left). Then, fax or phone in your order for a fast quote.







For special order retention knobs see page 207.



For special order collets see page 68.

Milling Chucks – Morse Taper – SIMIS – Drill Chucks

Milling Chucks

New coolant option available for coolant-thru tools. Outstanding rigidity and performance (pg. 120)



http://ow.ly/rKwCZ-
View the video.

Morse Taper Holders

Techniks Certified for accuracy (pg.124)



SIMIS Economy Tooling

ER collet chucks and end mill holders (pg. 128)



High-Precision Drill Chucks

Better accuracy and holding power than Jacobs Chucks (pg. 130)



TECHNIKS
BUILT FOR SPEED
www.techniksusa.com
a Quintec Company

Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!

CAT40, CAT50 High-Performance Milling Chucks

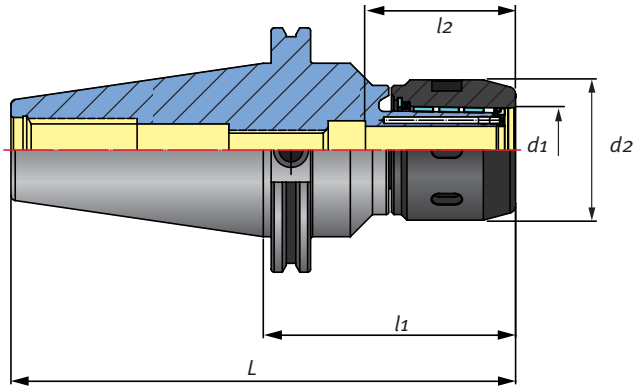


3/4" chuck shown above. Use milling chuck sleeves (page 123) to change tool shank size.

Each Techniks High-Performance Milling Chuck is inspected, tested, and certified for quality, accuracy, and holding power. A full lab report is included with each holder.

Features

- *Grips shank up to 5x tighter than ER 40 holders*
- *Nut seats against the flange when properly tightened (prevents overtightening)*
- *CoolBLAST coolant-thru standard on all milling chucks*



CAT40 Milling Chucks

Part No.	Description	L	l1	l2	d1	d2	Holding Power
23202G	CAT40 x MLD 3/4" - 4"	6.69"	4.0"	2.38"	0.75"	2.24"	350 ft/lbs
23204G	CAT40 x MLD 1" - 4"	6.69"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
23210G	CAT40 x MLD 1-1/4" - 4.2"	6.89"	4.2"	2.38"	1.25"	2.80"	500 ft/lbs

CAT50 Milling Chucks

Part No.	Description	L	l1	l2	d1	d2	Holding Power
23214G	CAT50 x MLD 3/4" - 4"	8.0"	4.0"	2.38"	0.75"	2.24"	350 ft/lbs
23218G	CAT50 x MLD 1" - 4"	8.0"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
23222G	CAT50 x MLD 1-1/4" - 4.13"	8.13"	4.13"	2.38"	1.25"	2.80"	500 ft/lbs

Standard Features for Techniks Milling Chucks

CoolBLAST Coolant-Thru



Coolant is channeled directly onto tool path.

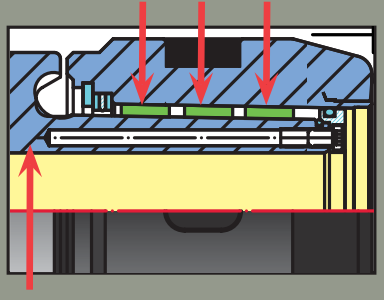
Special Slotted Design



Special slotted design of bore I.D. increases holding power and reduces vibration.

Machined Bearing Cage

High-precision, individually matched needle bearings symmetrically placed for smooth and reliable operation.



Machined bearing cage ensures accuracy and gripping force.

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

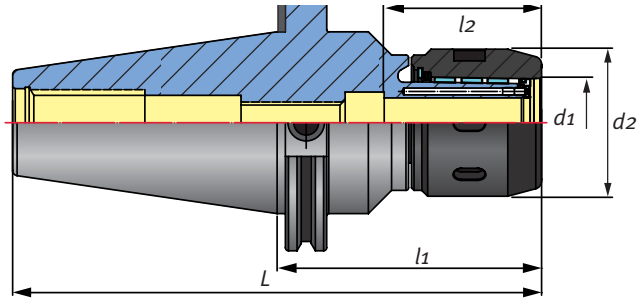
SYIC

CAT40, 50 DualDRIVE for Dual-Contact Spindles

NEW!
One-Piece Design



3/4" chuck shown with optional coolant cap and Black Gold coolant ring.



Features

- *New one-piece design for dual-contact spindles*
- *Grips shank up to 5x tighter than ER 40 holders*
- *Nut seats against the flange when properly tightened (prevents overtightening)*

See an on machine demonstration video of DualDRIVE compared to standard toolholders at: http://ow.ly/sUOqL

Torque Tested to 5x Tighter Grip

Techniks Milling Chucks provide up to 5x tighter grip on the shank than other manufacturer's ER 40 holders with an uncoated nut.

Toolholder Type	Shank Spins At:
Other ER 40 holders	100 ft/lbs
Techniks 3/4" milling chucks	350 ft/lbs
Techniks 1" milling chucks	425 ft/lbs
Techniks 1-1/4" milling chucks	500 ft/lbs

CAT40, CAT50 Milling Chucks with DualDRIVE

Part No.	Description	L	l1	l2	d1	d2	Holding Power
43.463G.64.400	CAT40 x MLD 3/4" - 4" DualDRIVE	6.69"	4.00"	2.38"	0.75"	2.24"	350 ft/lbs
43.463G.68.400	CAT40 x MLD 1" - 4" DualDRIVE	6.69"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
43.463G.72.420	CAT40 x MLD 1-1/4" - 4.2" DualDRIVE	6.89"	4.20"	2.38"	1.25"	2.80"	500 ft/lbs
44.463G.64.400	CAT50 x MLD 3/4" - 4" DualDRIVE	8.00"	4.00"	2.38"	0.75"	2.24"	350 ft/lbs
44.463G.68.400	CAT50 x MLD 1" - 4" DualDrive	8.0"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
44.463G.72.413	CAT50 x MLD 1-1/4" - 4.13" DualDRIVE	8.13"	4.13"	2.38"	1.25"	2.80"	500 ft/lbs

Coolant Cap option for all spindle types

Use coolant cap and Black Gold ring for coolant-thru tools.

- *Maximum chip removal, increase feed rates, extend tool life*



Insert Black Gold coolant ring into cap



Cap screws onto end of milling chuck



Coolant-thru tool installed



Use coolant cap with Black Gold ER25 or ER40 coolant rings. Select the coolant ring to fit your shank size. *See page 60*

Part No.	Description	Ring
19496G	For 3/4" chuck	ER25
19489G	For 1-1/4" chuck	ER40

BT40, HSK63A, and HSK100A Milling Chucks

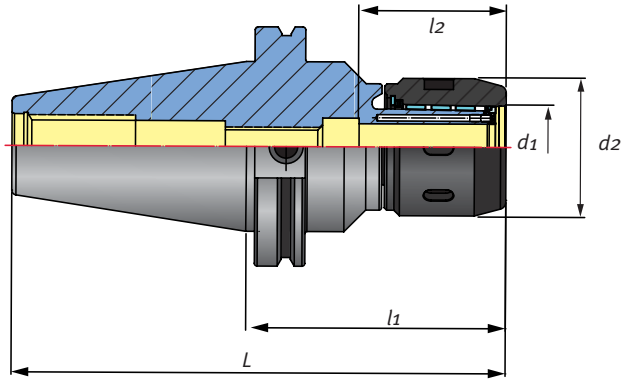


1-1/4" chuck shown above. Use milling chuck sleeves (page 123) to change tool shank size.

Each Techniks High-Performance Milling Chuck is inspected, tested, and certified for quality, accuracy, and holding power. A full lab report is included with each holder.

Features

- *Grips shank up to 5x tighter than ER 40 holders*
- *Nut seats against the flange when properly tightened (prevents overtightening)*
- *CoolBLAST coolant-thru standard on all milling chucks*



BT40 Milling Chucks

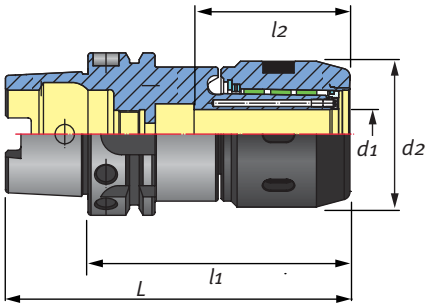
Part No.	Description	L	l1	l2	d1	d2	Holding Power
15994G	BT40 X MLD 3/4" - 3.15	5.75"	3.15"	1.97"	0.75"	2.22"	350 ft/lbs
15995G	BT40 X MLD 1" - 3.15	5.75"	3.15"	2.07"	1.0"	2.36"	425 ft/lbs
15996G	BT40 x MLD 1-1/4" - 4"	6.57"	4"	2.62"	1.25"	2.80"	500 ft/lbs



3/4" chuck shown above. Use milling chuck sleeves (page 123) to change tool shank size.



Tightening Stands pg. 210 | Retention Knobs pg. 209 | Wrenches pg. 208



For coolant-thru tools order the coolant ring that fits your shank size (pg. 121)



HSK63A and HSK100A Milling Chucks

Part No.	Description	L	l1	l2	d1	d2	Holding Power
33232G	HKS63A X MLD 3/4" - 4"	5.30"	4"	2.01"	.75"	2.22"	350 ft/lbs
33236G	HSK63A x MLD 1-1/4" - 4.72"	5.98"	4.72"	2.65"	1.25"	2.80"	500 ft/lbs
33252G	HSK100A X MLD 3/4" - 4.72"	6.70"	4.72"	2.01"	.75"	2.22"	350 ft/lbs
33256G	HSK100A x MLD 1-1/4" - 4.72"	6.70"	4.72"	2.65"	1.25"	2.79"	500 ft/lbs

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

Precision Reduction Sleeves for Milling Chucks

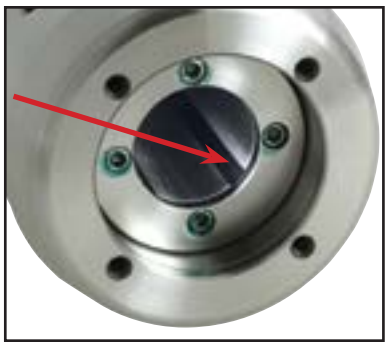


Use sleeves to change tool shank sizes just like you would collets.

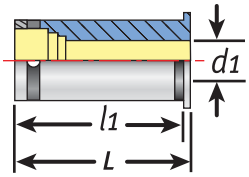
Milling Chuck Reduction Sleeves

- *For inch and metric shanks*
- *T.I.R only .0001"*
- *All surfaces precision ground for maximum accuracy*
- *Maximize your milling chuck capability*

Special slotted design (right) of bore I.D. increases holding power and reduces vibration.



Insert sleeve into chuck, then insert cutting tool, and tighten chuck last.



3/4" O.D. Reduction Sleeves for 3/4" Chucks

Part No.	Description	d1	l1	L
84126-1/8	3/4" O.D., x 1/8" I.D.	1/8"	1.93"	2.09"
84126-3/16	3/4" O.D., x 3/16" I.D.	3/16"	1.93"	2.09"
84126-1/4	3/4" O.D., x 1/4" I.D.	1/4"	1.93"	2.09"
84126-5/16	3/4" O.D., x 5/16" I.D.	5/16"	1.93"	2.09"
84126-3/8	3/4" O.D., x 3/8" I.D.	3/8"	1.93"	2.09"
84126-7/16	3/4" O.D., x 7/16" I.D.	7/16"	1.93"	2.09"
84126-1/2	3/4" O.D., x 1/2" I.D.	1/2"	1.93"	2.09"
84126-9/16	3/4" O.D., x 9/16" I.D.	9/16"	1.93"	2.09"
84126-5/8	3/4" O.D., x 5/8" I.D.	5/8"	1.93"	2.09"
84126-06	3/4" O.D., x 6mm I.D.	6mm	1.93"	2.09"
84126-08	3/4" O.D., x 8mm I.D.	8mm	1.93"	2.09"
84126-10	3/4" O.D., x 10mm I.D.	10mm	1.93"	2.09"
84126-12	3/4" O.D., x 12mm I.D.	12mm	1.93"	2.09"

1-1/4" O.D. Reduction Sleeves for 1-1/4" Chucks

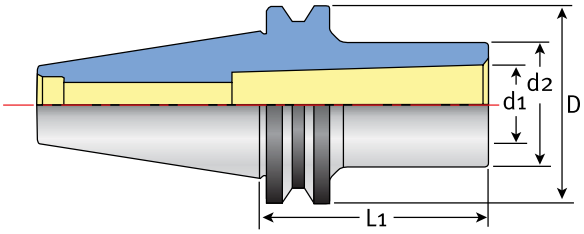
Part No.	Description	d1	l1	L
84127-1/8	1-1/4" O.D., x 1/8" I.D.	1/8"	2.56"	2.75"
84127-3/16	1-1/4" O.D., x 3/16" I.D.	3/16"	2.56"	2.75"
84127-1/4	1-1/4" O.D., x 1/4" I.D.	1/4"	2.56"	2.75"
84127-5/16	1-1/4" O.D., x 5/16 I.D.	5/16"	2.56"	2.75"
84127-3/8	1-1/4" O.D., x 3/8" I.D.	3/8"	2.56"	2.75"
84127-7/16	1-1/4" O.D., x 7/16" I.D.	7/16"	2.56"	2.75"
84127-1/2	1-1/4" O.D., x 1/2" I.D.	1/2"	2.56"	2.75"
84127-9/16	1-1/4" O.D., x 9/16 I.D.	9/16"	2.56"	2.75"
84127-5/8	1-1/4" O.D., x 5/8" I.D.	5/8"	2.56"	2.75"
84127-3/4	1-1/4" O.D., x 3/4" I.D.	3/4"	2.56"	2.75"
84127-7/8	1-1/4" O.D., x 7/8 " I.D.	7/8"	2.56"	2.75"
84127-1	1-1/4" O.D., x 1.0" I.D.	1.0"	2.56"	2.75"
84127-08	1-1/4" O.D., x 8mm I.D.	8mm	2.56"	2.75"
84127-10	1-1/4" O.D., x 10mm I.D.	10mm	2.56"	2.75"
84127-12	1-1/4" O.D., x 12mm I.D.	12mm	2.56"	2.75"
84127-14	1-1/4" O.D., x 14mm I.D.	14mm	2.56"	2.75"
84127-16	1-1/4" O.D., x 16mm I.D.	16mm	2.56"	2.75"
84127-20	1-1/4" O.D., x 20mm I.D.	20mm	2.56"	2.75"
84127-25	1-1/4" O.D., x 25mm I.D.	25mm	2.56"	2.75"

Precision CAT40, CAT50 Morse Taper Toolholders



Techniks Certified Tooling Features

- *Taper ground to AT3 accuracy or better*
- *.0002" runout from taper to tool pocket*
- *Each holder lab certified for accuracy*





Tightening Stands pg. 210



Retention Knobs pg. 209



Wrenches pg. 208

CAT40 Morse Taper Toolholders

Part No.	Taper	Size	L1	d1	d2	D
22611	CAT40 Morse Taper	MT#1	1.75"	.475"	.984"	2.5"
22613	CAT40 Morse Taper	MT#2	2.00"	.7"	1.26"	2.5"
22615	CAT40 Morse Taper	MT#3	2.75"	.937"	1.575"	2.5"
22617	CAT40 Morse Taper	MT#4	3.75"	1.231"	1.889"	2.5"

CAT50 Morse Taper Toolholders

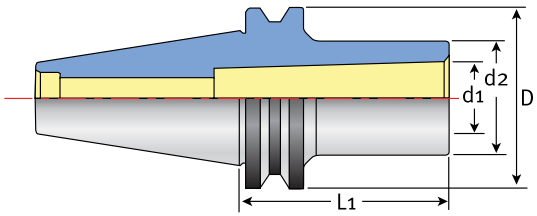
Part No.	Taper	Size	L1	d1	d2	D
22623	CAT50 Morse Taper	MT#2	2.36"	.7"	1.26"	3.875"
22625	CAT50 Morse Taper	MT#3	2.56"	.937"	1.575"	3.875"
22627	CAT50 Morse Taper	MT#4	3.75"	1.231"	1.889"	3.875"
22629	CAT50 Morse Taper	MT#5	4.13"	1.75"	2.48"	3.875"

Precision BT30, BT40, BT50 Morse Taper Toolholders



Techniks Certified Tooling Features

- *Taper ground to AT3 accuracy or better*
- *.0002" runout from taper to tool pocket*
- *Each holder lab certified for accuracy*



BT30 Morse Taper Toolholders

Part No.	Taper	Size	L1	d1	d2	D
17001	BT30 Morse Taper	MT#1	1.77"	.475"	.984"	1.811"
17006	BT30 Morse Taper	MT#2	2.36"	.7"	1.26"	1.811"
17010	BT30 Morse Taper	MT#3	3.14"	.937"	1.575"	1.811"

BT40 Morse Taper Toolholders

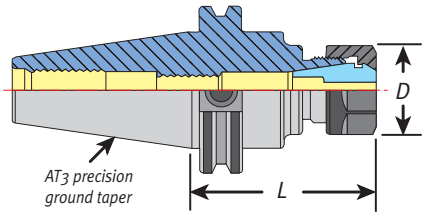
Part No.	Taper	Size	L1	d1	d2	D
17011	BT40 Morse Taper	MT#1	1.77"	.475"	.984"	2.48"
17014	BT40 Morse Taper	MT#2	1.96"	.7"	1.26"	2.48"
17018	BT40 Morse Taper	MT#3	2.75"	.937"	1.575"	2.48"
17023	BT40 Morse Taper	MT#4	3.75"	1.231"	1.889"	2.48"

BT50 Morse Taper Toolholders

Part No.	Taper	Size	L1	d1	d2	D
17036	BT50 Morse Taper	MT#2	2.36"	.7"	1.26"	3.937"
17039	BT50 Morse Taper	MT#2-135	5.31"	.7"	1.26"	3.937"
17042	BT50 Morse Taper	MT#3	2.56"	.937"	1.575"	3.937"
17046	BT50 Morse Taper	MT3-150	5.9"	.937"	1.575"	3.937"
17048	BT50 Morse Taper	MT#4	3.74"	1.231"	1.889"	3.937"
17051	BT50 Morse Taper	MT4-180	7.08"	1.231"	1.889"	3.937"
17053	BT50 Morse Taper	MT#5	4.13"	1.75"	2.48"	3.937"

CAT40 and CAT50 SIMIS ER Collet Chucks





Comparison of SIMIS Economy Collet Chucks and Techniks

	SIMIS	Techniks Certified
Lab Certified for Accuracy & Balance	NO	YES
Collet Nut Included	YES - uncoated	YES - PowerCOAT
Balance Specification	18,000 RPMs	25,000 RPMs
DIN B Coolant Available	NO	YES
Available Sizes	most common	wide selection

ER Nut Included



Part No.	Description
11116	ER16 uncoated hex nut
11120	ER20 uncoated hex nut
11125	ER25 uncoated slotted nut
11132	ER32 uncoated slotted nut
11140	ER40 uncoated slotted nut

CAT40 ER Toolholders

Part No.	Description	L	D	Collet	Max. Shank	Stop Screw	Wrench
CAT40ER11-3	CAT40 x ER11-3"	3	.748"	ER11	.275"	06081	04608
CAT40ER11-4	CAT40 x ER11-4"	4	.748	ER11	.275"	06081	04608
CAT40ER11-6	CAT40 x ER11-6"	6	.748	ER11	.275"	06081	04608
CAT40ER16-2.76	CAT40 x ER16-2.76"	2.76"	1.08"	ER16	.406"	06083	04609 hex
CAT40ER16-4	CAT40 x ER16-4"	4"	1.08"	ER16	.406"	06083	04609 hex
CAT40ER20-2.76	CAT40 x ER20-2.76"	2.76"	1.34"	ER20	.512"	06087	04610 hex
CAT40ER20-4	CAT40 x ER20-4"	4"	1.34"	ER20	.512"	06087	04610 hex
CAT40ER20-6	CAT40 x ER20-6"	6"	1.34"	ER20	.512"	06087	04610 hex
CAT40ER25-2.76	CAT40 x ER25-2.76"	2.76"	1.65"	ER25	.63"	06089	04615
CAT40ER25-4	CAT40 x ER25-4"	4"	1.65"	ER25	.63"	06089	04615
CAT40ER32-2.76	CAT40 x ER32-2.76"	2.76"	1.97"	ER32	.788"	06089	04616
CAT40ER32-4	CAT40 x ER32-4"	4"	1.97"	ER32	.788"	06089	04616
CAT40ER40-3.15	CAT40 x ER40-3.15"	3.15"	2.48"	ER40	1.023"	06091	04617

CAT50 ER Toolholders

Part No.	Description	L	D	Collet	Max. Shank	Stop Screw	Wrench
CAT50ER16-4	CAT50 x ER16-4	4"	1.08"	ER16	.406"	06083	04609 hex
CAT50ER16-6	CAT50 x ER16-6	6"	1.08"	ER16	.406"	06083	04609 hex
CAT50ER20-4	CAT50 x ER20-4	4"	1.34"	ER20	.512"	06087	04610 hex
CAT50ER20-6	CAT50 x ER20-6	6"	1.34"	ER20	.512"	06087	04610 hex
CAT50ER32-4	CAT50 x ER32-4	4"	1.97"	ER32	.788"	06089	04616
CAT50ER32-6	CAT50 x ER32-6	6"	1.97"	ER32	.788"	06089	04616
CAT50ER40-4	CAT50 x ER40-4	4"	2.48"	ER40	1.023"	06091	04617

Sign up to receive special offers at: www.techniksusa.com/contact.htm

CAT40 and CAT50 SIMIS End Mill Holders



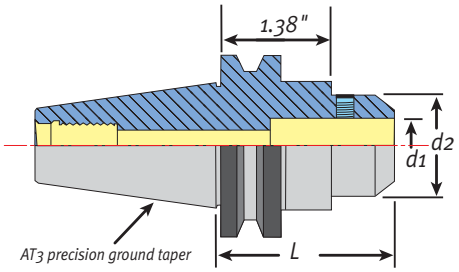

Tightening Stands pg. 210


Retention Knobs pg. 209


Wrenches pg. 208

Comparison of SIMIS Economy End Mill Holders and Techniks

	SIMIS	Techniks Certified
Lab Certified for Accuracy & Balance	NO	YES
Balance Specification	8,000 RPMs	10,000 RPMs
DIN B Coolant Available	NO	YES
End Mill Bore Tolerance	H7	H5
Available Sizes	most common	wide selection



CAT40 End Mill Holders

Part No.	Description – d1	L	d2
CAT40SLN1/8	CAT40 x SLN - 1/8"	2.375"	.69"
CAT40SLN3/16	CAT40 x SLN - 3/16"	2.5"	.69"
CAT40SLN1/4	CAT40 x SLN - 1/4"	3"	.78"
CAT40SLN1/4-1.75	CAT40 x SLN - 1/4"	1.75"	.795"
CAT40SLN3/8	CAT40 x SLN - 3/8"	3"	.88"
CAT40SLN3/8-1.75	CAT40 x SLN - 3/8"	1.75"	.88"
CAT40SLN1/2	CAT40 x SLN - 1/2"	3"	1.25"
CAT40SLN1/2-1.75	CAT40 x SLN - 1/2"	1.75"	1.5"
CAT40SLN5/8	CAT40 x SLN - 5/8"	3"	1.5"
CAT40SLN3/4	CAT40 x SLN - 3/4"	3.5"	1.75"
CAT40SLN3/4-1.75	CAT40 x SLN - 3/4"	1.75"	1.75"
CAT40SLN1	CAT40 x SLN - 1.0"	4"	2"
CAT40SLN1-1.75	CAT40 x SLN - 1.0"	1.75"	1.75"
CAT40SLN1 1/4-2	CAT40 x SLN - 1-1/4"	2"	1.75"

CAT50 Endmill Holders

Part No.	Description – d1	d2	L
CAT50SLN1/4	CAT50 x SLN - 1/4"	.78	4"
CAT50SLN3/8	CAT50 x SLN - 3/8"	1.0"	4"
CAT50SLN1/2	CAT50 x SLN - 1/2"	1.25"	4"
CAT50SLN5/8	CAT50 x SLN - 5/8"	1.5"	4"
CAT50SLN3/4	CAT50 x SLN - 3/4"	1.75"	4"
CAT50SLN1	CAT50 x SLN - 1.0"	2"	4"
CAT50SLN11/4	CAT50 x SLN - 1-1/4"	2.5"	4.6"

HP3 High Precision and Keyless Jacobs Drill Chucks

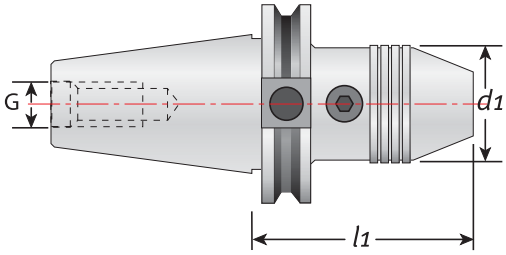


Features

- *Capacity from 1/16" to 1/2"*
- *4 times greater holding power*
- *Balanced to 10,000 RPM*

Our HP3 High-Precision Drill Chucks have the flexibility to hold a wide range of shank sizes and deliver superior performance too. Maximum runout (T.I.R.) is only .0008".

They also feature a one-piece design that provides greater rigidty and safety because the chuck cannot break free during operation.



HP3 Precision Drill Toolholders (ISO, BT, HSK)

Part No.	Description	d1	l1	G
24.05.046.005	CAT40 HP3 drill chuck 1/2"	50	103	-
17.05.046.005	CAT50 HP3 drill chuck 1/2"	50	87.5	-
64.05.046.051	ISO30 HP3 drill chuck 1/2"	50	103	M12
67.05.046.001	BT30 HP3 drill chuck 1/2"	50	92.5	M12
39.05.046.001	BT40 HP3 drill chuck 1/2"	50	95.5	M16
93.05.046.003	HSK 63A HP3 drill chuck 1/2"	50	123.5	-
171.05.046.003	HSK63F HP3 drill chuck 1/2"	50	123.5	-



Features

- *For milling machines & drilling machines*
- *All hardened parts for long life and safety*
- *Use with CAT or BT holders (pg. 130)*

Keyless Jacobs Taper Drill Chucks

Part No.	Description	Length Closed	Outer Diameter	Range
82150	08S x JT1	76mm	38mm	0 - 5/16"
82153	13S x JT6	102mm	49mm	0 - 1/2"
82151-JT33	10S x JT33	92mm	43mm	0 - 3/8"
82153-JT33	13S x JT33	102mm	49mm	0 - 1/2"

See our product application videos at: www.techniksusa.com

SYIC

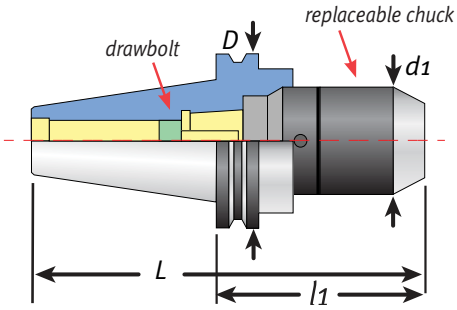
CAT, BT, HSK Replaceable Keyless Drill Chucks



Features

- *3 times more holding power than other chucks*
- *Holds non-standard shank sizes up to 1/2"*
- *Replaceable chuck is held by a drawbolt*

Order Part No. 82164 replaceable chuck



CAT Replaceable Drill Chucks

Part No.	Description	l1	L	D	d1
22403	CAT40 SPU x 1/2"- 4"	101.6mm	169.9mm	63.5mm	50mm
22405	CAT50 SPU x 1/2"- 4"	101.6mm	203.2mm	98.4mm	50mm
82164	SPU drill chuck (replacement)				
82172	SPU drill chuck wrench (replacement)				

BT Replaceable Drill Chucks

Part No.	Description	l1	L	D	d1
16456-W	BT30 x SPU 13mm - 110mm (no slots)	110mm	170.4mm	46mm	50mm
16456	BT30 x SPU 13mm - 110mm	110mm	170.4mm	46mm	50mm
16466	BT40 x SPU 13mm - 100mm	100mm	177.4mm	63mm	50mm
16476	BT50 x SPU 13mm - 100mm	100mm	213.8mm	100mm	50mm
82164	SPU drill chuck (replacement)				
82172	SPU drill chuck wrench (replacement)				

HSK Replaceable Drill Chucks

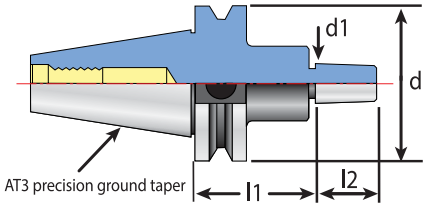
Part No.	Description	l1	L	D	d1
34905	HSK 63A x SPU 13mm - 150mm	150mm	182.5mm	63mm	50mm
34905-F	HSK 63F x SPU 13mm - 150mm	150mm	175mm	63mm	50mm
82164	SPU drill chuck (replacement)				
82172	SPU drill chuck wrench (replacement)				

CAT and BT Toolholders For Jacobs Taper Drill Chucks



Features

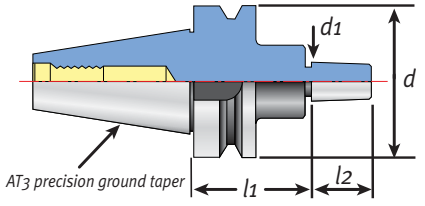
- *Better T.I.R. and rigidity than standard drill chucks*
- *Taper ground to AT3 accuracy*
- *Use with keyless Jacobs chucks*



CAT Toolholders For Jacobs Taper Drill Chucks

Part No.	Description	l1	l2	d1	Jacobs Taper
22511	CAT40 x JT2 - 1.57"	1.57"	.875"	.559"	2
22512	CAT40 x JT3 - 1.57"	1.57"	1.2"	.811"	3
22513	CAT40 x JT6 - 1.57"	1.57"	.945"	.676"	6
22515	CAT40 x JT33 - 1.57"	1.57"	.945"	.624"	33
22521	CAT50 x JT2 - 1.57"	1.57"	.875"	.559"	2
22527	CAT50 x JT3 - 1.57"	1.57"	1.2"	.811	3
22529	CAT50 x JT4 - 1.57"	1.57"	1.656"	1.124"	4
22531	CAT50 x JT5 - 1.57"	1.57"	1.875"	1.413"	5
22523	CAT50 x JT6 - 1.57"	1.57"	.945"	.676"	6
22525	CAT50 x JT33 - 1.57"	1.57"	.945"	.624"	33





BT Toolholders For Jacobs Taper Drill Chucks

Part No.	Description	l1	l2	d1
16502	BT30 x JT2 - 45mm	45mm	20mm	14.199
16504	BT30 x JT33 - 45mm	45mm	24mm	15.850
16506	BT30 x JT6 - 45mm	45mm	24mm	17.170
16522	BT40 x JT2 - 45mm	45mm	20mm	14.199
16523	BT40 x JT33 - 45mm	45mm	24mm	15.850
16524	BT40 x JT6 - 45mm	45mm	24mm	17.170
16542	BT50 x JT2 - 45mm	45mm	20mm	14.199
16543	BT50 x JT33 - 45mm	45mm	24mm	15.850
16544	BT50 x JT6 - 45mm	45mm	24mm	17.170

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

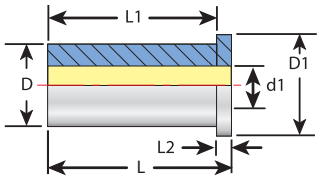
SYIC

Precision Reduction Sleeves for Hydraulic Toolholders



Features

- *Use sleeves with your hydraulic toolholders to run a variety of shank sizes*
- *T.I.R. of only .00012"*
- *Sealed to 1,000 P.S.I. for coolant applications*



Inch O.D. / Inch I.D. Reduction Sleeves for Hydraulic Toolholders

Part No.	Description	d1	D	D1	L	L1	L2
19474-1/8	3/4" OD - 1/8" ID	.125"	.75"	.945"	2.083"	2.003"	.079"
19474-3/16	3/4" OD - 3/16" ID	.1875"	.75"	.945"	2.083"	2.003"	.079"
19474-1/4	3/4" OD - 1/4" ID	.25"	.75"	.945"	2.083"	2.003"	.079"
19474-5/16	3/4" OD - 5/16" ID	.3125"	.75"	.945"	2.083"	2.003"	.079"
19474-3/8	3/4" OD - 3/8" ID	.375"	.75"	.945"	2.083"	2.003"	.079"
19474-7/16	3/4" OD - 7/16" ID	.4375"	.75"	.945"	2.083"	2.003"	.079"
19474-1/2	3/4" OD - 1/2" ID	.5"	.75"	.945"	2.083"	2.003"	.079"
19474-5/8	3/4" OD - 5/8" ID	.625"	.75"	.945"	2.083"	2.003"	.079"
19478-1/4	1-1/4" OD - 1/4" ID	.25"	1.25"	1.575"	2.598"	2.441"	.157"
19478-5/16	1-1/4" OD - 5/16" ID	.3125"	1.25"	1.575"	2.598"	2.441"	.157"
19478-3/8	1-1/4" OD - 3/8" ID	.375"	1.25"	1.575"	2.598"	2.441"	.157"
19478-1/2	1-1/4" OD - 1/2" ID	.5"	1.25"	1.575"	2.598"	2.441"	.157"
19478-5/8	1-1/4" OD - 5/8" ID	.625"	1.25"	1.575"	2.598"	2.441"	.157"
19478-3/4	1-1/4" OD - 3/4" ID	.75"	1.25"	1.575"	2.598"	2.441"	.157"
19478-7/8	1-1/4" OD - 7/8" ID	.875"	1.25"	1.575"	2.598"	2.441"	.157"
19478-01	1-1/4"OD - 1" ID	1.0"	1.25"	1.575"	2.598"	2.441"	.157"

Metric O.D. / Inch I.D. Reduction Sleeves for Hydraulic Toolholders

Part No.	Description	d1	D	D1	L	L1	L2
19462-1/4	20mm OD - 1/4" ID	.25"	20mm	24mm	52.9mm	50.9mm	2mm
19462-5/16	20mm OD - 5/16" ID	.3125"	20mm	24mm	52.9mm	50.9mm	2mm
19462-3/8	20mm OD - 3/8" ID	.375"	20mm	24mm	52.9mm	50.9mm	2mm
19462-7/16	20mm OD - 7/16" ID	.4375"	20mm	24mm	52.9mm	50.9mm	2mm
19462-1/2	20mm OD - 1/2" ID	.5"	20mm	24mm	52.9mm	50.9mm	2mm
19462-5/8	20mm OD - 5/8" ID	.625"	20mm	24mm	52.9mm	50.9mm	2mm

Metric O.D. / Metric I.D. Reduction Sleeves for Hydraulic Toolholders

Part No.	Description	d1	D	D1	L	L1	L2
19462-06	20mm OD - 6mm ID	6mm	20mm	24mm	52.90mm	50.9mm	2mm
19462-08	20mm OD - 8mm ID	8mm	20mm	24mm	52.90mm	50.9mm	2mm
19462-10	20mm OD - 10mm ID	10mm	20mm	24mm	52.90mm	50.9mm	2mm
19462-12	20mm OD - 12mm ID	12mm	20mm	24mm	52.90mm	50.9mm	2mm
19462-14	20mm OD - 14mm ID	14mm	20mm	24mm	52.90mm	50.9mm	2mm
19462-16	20mm OD - 16mm ID	16mm	20mm	24mm	52.90mm	50.9mm	2mm

Measurement Guide For Special Order Toolholders

V-flange CNC machine make, model and spindle

_____

V-Flange tool #1 dimensions

D = _____

F = _____

W = _____

A = _____

N = _____

V-Flange tool #2 dimensions

D = _____

F = _____

W = _____

A = _____

N = _____

HSK CNC machine make, model and spindle

_____

HSK tool #1 dimensions

D = _____

F = _____

W = _____

A = _____

N = _____

HSK tool #2 dimensions

D = _____

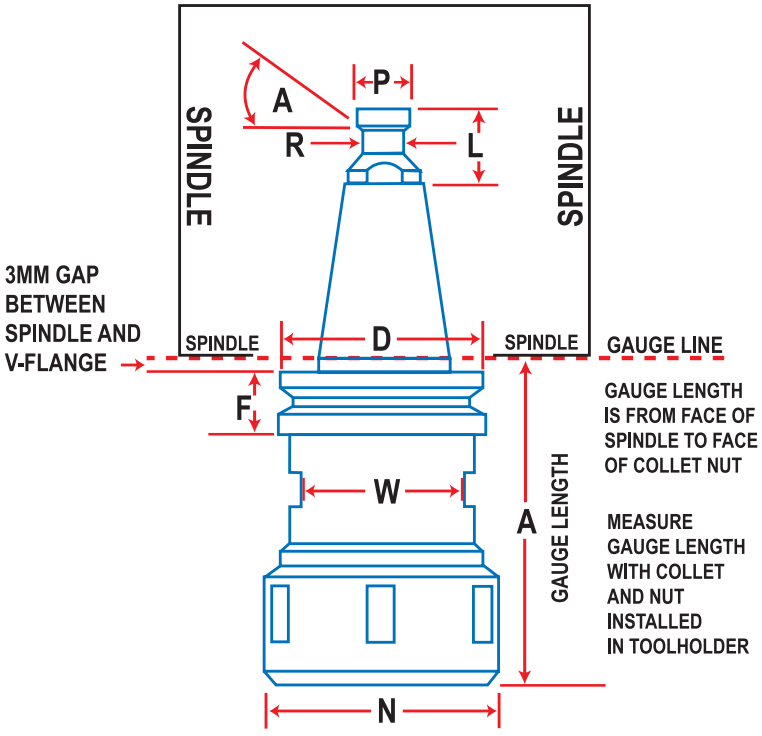
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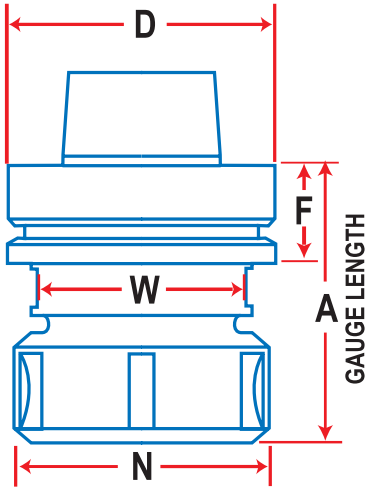
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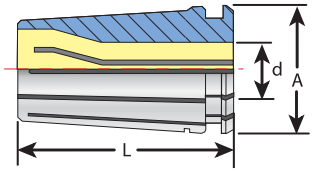
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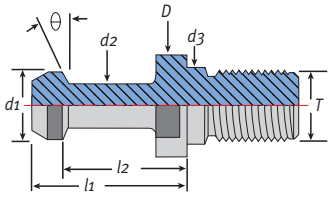
Fill in all the required dimensions (left). Then, fax or phone in your order for a fast quote.







For special order collets see page 68.



For special order retention knobs see page 207.

Capto-Compatible* Turn/Mill Toolholders

The C4, C5, C6, holders you need, Techniks Certified.

TECHNIKS CERTIFIED ACCURACY BALANCE

NEW!



ER Collet Chucks

NEW!



End Mill Holders

NEW!



ShrinkFIT

NEW!



Face Mill Arbors

NEW!



Turning Tools & Inserts

NEW!



SlimFIT Holders

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BUILT FOR SPEED
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Built for Speed.

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

Capto-Compatible* C4, C5, C6, ER Collet Chucks





For turn/mill machines that accept "C" style toolholders.

Coolant-thru is standard feature.

Each toolholder is individually lab tested, inspected, and certified for quality.

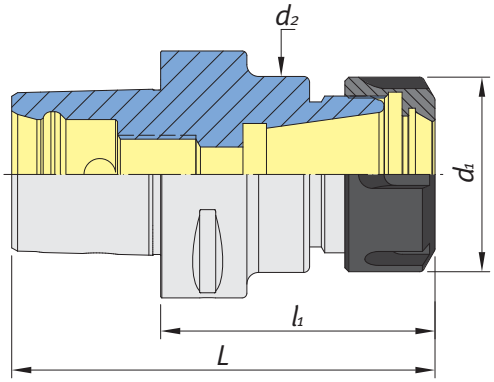
An individual inspection report comes with each holder documenting accuracy and balance.

Techniks Certified toolholders are backed by our 100% Performance Guarantee.

Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" or better*
- *PowerCOAT Nut included!*

Friction-reducing PowerCOAT nut provides 75% greater clamping power than standard nuts for improved rigidity, accuracy, and extended tool life.



C4 ER Collet Chucks

Part No.	Description	L	l1	d1	d2	Size Range
141.122.16.070	C4 x ER16–70mm	94mm	70mm	28mm	28mm	1.0–10.0mm
141.122.25.052	C4 x ER25–52mm	76mm	52mm	42mm	42mm	1.0–16.0mm
141.122.32.054	C4 x ER32–54mm	78mm	54mm	50mm	50mm	2.0–20.0mm

C5 ER Collet Chucks

Part No.	Description	L	l1	d1	d2	Size Range
142.122.16.100	C5 x ER16–100mm	130mm	100mm	28mm	28mm	1.0–10.0mm
142.122.25.055	C5 x ER25–55mm	82mm	55mm	42mm	42mm	1.0–16.0mm
142.122.32.057	C5 x ER 32–57mm	84mm	57mm	50mm	50mm	2.0–20mm

C6 ER Collet Chucks

Part No.	Description	L	l1	d1	d2	Size Range
143.122.16.100	C6 x ER16–100mm	138mm	100mm	28mm	28mm	1.0–10.0mm
143.122.25.060	C6 x ER25–60mm	98mm	60mm	42mm	42mm	1.0–160mm
143.122.32.070	C6 x ER32–70mm	108mm	70mm	50mm	50mm	2.0–20.0mm
143.122.40.065	C6 x ER40–65mm	103mm	65mm	63mm	63mm	3.0–26.0mm
143.123.08.600	C6 x ER8M–6"	190mm	6"	12mm	16mm	0.5–5.0mm
143.123.11.600	C6 x ER11M–6"	190mm	6"	19mm	20mm	0.5–7.0mm
143.123.16.600	C6 x ER16M–6"	190mm	6"	22mm	25mm	1.0–10.0mm
143.123.20.600	C6 x ER20M–6"	190mm	6"	28mm	32mm	2.0–16.0mm

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

Capto-Compatible* C4, C6, SlimFIT Collet Chucks



Use SlimFIT for tight clearance situations.



For turn/mill machines that accept "C" style toolholders.

Coolant-thru is standard feature.

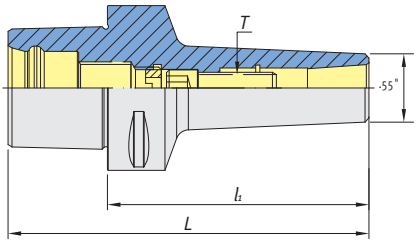
Each toolholder is individually lab tested, inspected, and certified for quality.

An individual inspection report comes with each holder documenting accuracy and balance.

Techniks Certified toolholders are backed by our 100% Performance Guarantee.

Features

- *Powerful drawbar clamping and 4˚ collet maximizes holding power on tool shank*
- *Maximum T.I.R. 0.0001"*
- *Balanced to 25,000 RPM at G2.5*



SlimFIT Collet Set



Part No.	Description
18851-12IMS	SlimFIT 6 - 12 pc. set

1/8" – 1/4" by 64ths (except no 5/32 or 7/32) 3mm – 6mm by 1mm



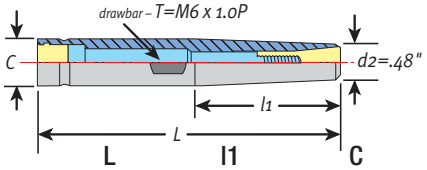
C4 & C6 SlimFIT Collet Chucks

Part No.	Description	L	l1	Drawbar
141.648.06.075	C4 x SBL 6–75mm	94mm	75mm	SBL-M6CT-20
143.648.06.080	C6 x SBL 6–80mm	118mm	80mm	SBL-M6CT-20

SlimFIT Extensions



- *Use with any toolholder*
- *Extremely accurate drawbar collet*
- *Use with SlimFIT 6 collets*



SlimFIT Extensions

Part No.	Description	L	l1	C
06032-3	1/2" x OLP6-3" extension	3"	1.89"	.50"
06032	1/2" x OLP6-5" extension	5"	1.89"	.50"
06034	1/2" x OLP6-6" extension	6"	1.89"	.50"
06038	5/8" x OLP6-5" extension	5"	1.89"	.625"
06040	5/8" x OLP6-6" extension	6"	1.89"	.625"
06042	5/8" x OLP6-8" extension	8"	1.89"	.625"

SlimFIT Inch Size Collets

Part No.	Description
18851-3/32	SlimFIT 6 - 3/32" collet
18851-7/64	SlimFIT 6 - 7/64" collet
18851-1/8	SlimFIT 6 - 1/8" collet
18851-9/64	SlimFIT 6 - 9/64" collet
18851-5/32	SlimFIT 6 - 5/32" collet
18851-11/64	SlimFIT 6 - 11/64" collet
18851-3/16	SlimFIT 6 - 3/16" collet
18851-13/64	SlimFIT 6 - 13/64" collet
18851-7/32	SlimFIT 6 - 7/32" collet
18851-15/64	SlimFIT 6 - 15/64" collet
18851-1/4	SlimFIT 6 - 1/4" collet

SlimFIT Metric Size Collets

Part No.	Description
18851-03	SlimFIT 6 - 3mm collet
18851-04	SlimFIT 6 - 4mm collet
18851-05	SlimFIT 6 - 5mm collet
18851-05.5	SlimFIT 6 - 5.5mm collet
18851-06	SlimFIT 6 - 6mm collet

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

Capto-Compatible* C4, C6, Endmill Holders





For turn/mill machines that accept "C" style toolholders.

Coolant-thru is standard feature.

Features

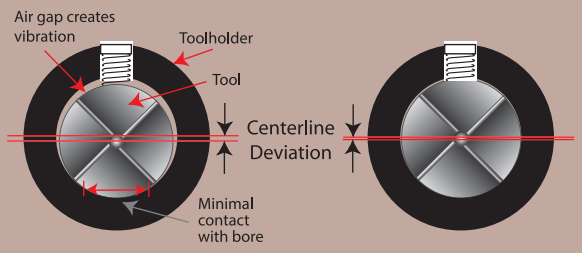
- *High precision bore (H5) is best in the industry*
- *Extends cutting tool life 60%*
- *Balanced to 15,000 RPM at G6.3*

Each toolholder is individually lab tested, inspected, and certified for quality.

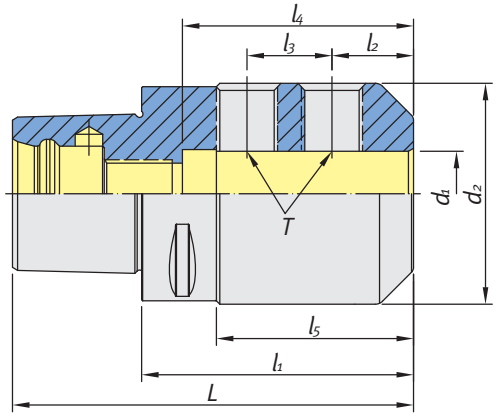
An individual inspection report comes with each holder documenting accuracy and balance.

Techniks Certified toolholders are backed by our 100% Performance Guarantee.

Techniks H5 Bore Tolerance Extends Tool Life 60%



You lose 10% tool life for every .0001" T.I.R.



C4 Endmill Holders

Part No.	Description	L	l1	l2	l4	l5	d1	d2	T
141.653.54.197	C4 x SLN 1/4"–1.97"	2.91"	1.97"	0.63"	1.38"	1"	0.25"	0.78"	1/4-28"
141.653.55.197	C4 x SLN 5/16"–1.97"	2.91"	1.97"	0.63"	1.38"	1.02"	0.3125"	0.88"	5/16-24"
141.653.56.197	C4 x SLN 3/8"–1.97"	2.91"	1.97"	0.75"	1.535"	1.08"	0.375"	1"	3/8-24"
141.653.58.217	C4 x SLN 1/2"–2.17"	3.11"	2.17"	0.875"	1.732"	1.42"	0.5"	1.25"	7/16-20"
141.653.61.217	C4 x SLN 5/8"–2.17"	3.11"	2.17"	0.875"	1.732"	1.54"	0.625"	1.5"	7/16-20"

C6 Endmill Holders

Part No.	Description	L	l1	l2	l3	l4	l5	d1	d2	T
143.653.54.217	C6 x SLN 1/4"–2.17"	3.66"	2.17"	0.63"	-	1.38"	0.984"	0.25"	0.78"	1/4-28"
143.653.55.217	C6 x SLN 5/16"–2.17"	3.66"	2.17"	0.63"	-	1.38"	1.024"	0.3125"	0.88"	5/16-24"
143.653.56.236	C6 x SLN 3/8"–2.36"	3.86"	2.36"	0.75"	-	1.535"	1.181"	0.375"	1"	3/8-24"
143.653.58.236	C6 x SLN 1/2"–2.36"	3.86"	2.36"	0.875"	-	1.732"	1.299"	0.5"	1.25"	7/16-20"
143.653.61.256	C6 x SLN 5/8"–2.56"	4.06"	2.56"	0.937"	-	1.732"	1.398"	0.625"	1.5"	1/2-20"
143.653.64.256	C6 x SLN 3/4"–2.56"	4.06"	2.56"	1"	-	1.929"	1.476"	0.75"	1.75"	5/8-18"
143.653.68.315	C6 x SLN 1" -3.15"	4.65	3.15"	1.125"	1"	2.559"	2.283"	1"	2"	3/4-16"

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

Capto-Compatible* C4, C5, C6, ShrinkFIT Holders

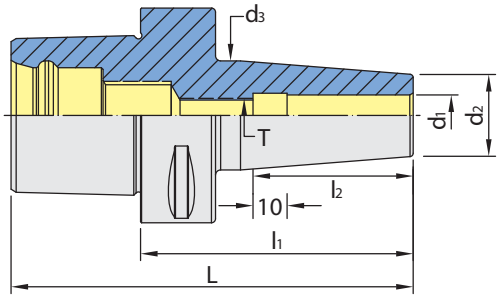


For turn/mill machines that accept "C" style toolholders.

Coolant-thru is standard feature.

Features

- *Maximum T.I.R. only 0.0001"*
- *Balanced to 25,000 RPM at G2.5*
- *Superior rigidity and holding power*



C4 ShrinkFIT Chucks

Part No.	Description	L	l1	l2	d1	d2	d3	T
141.651.54.295	C4 x SF 1/4"–2.95"	3.9"	2.95"	1.41"	0.3125"	0.83"	1.06"	M5 x 0.8P
141.651.55.295	C4 x SF 5/16"–2.95"	3.9"	2.95"	1.41"	0.3125"	0.83"	1.06"	M6 x 1.0P
141.651.56.295	C4 x SF 3/8"–2.95"	3.9"	2.95"	1.61"	0.375"	0.95"	1.26"	M8 x 1.25P
141.651.58.295	C4 x SF 1/2"–2.95"	3.9"	2.95"	1.81"	0.5"	1.10"	1.34"	M10 x 1.5P
141.651.61.315	C4 x SF 5/8"–3.15"	4.09"	3.15"	1.93"	0.625"	1.06"	1.34"	M12 x 1.75P

C5 ShrinkFIT Chucks

Part No.	Description	L	l1	l2	d1	d2	d3	T
142.651.52.315	C5 x SF 1/8–80mm	110mm	80mm	38mm	1/8"	16mm	22mm	M6 x 1.0P
142.651.53.315	C5 x SF 3/16–80mm	110mm	80mm	38mm	3/16"	16mm	22mm	M6 x 1.0P
142.651.54.315	C5 x SF 1/4–80mm	110mm	80mm	38mm	1/4"	21mm	27mm	M5 x 0.8P
142.651.56.315	C5 x SF 3/8–80mm	110mm	80mm	51mm	3/8"	24mm	32mm	M8 x 1.25P
142.651.58.315	C5 x SF 1/2–80mm	110mm	80mm	38mm	1/2"	28mm	34mm	M10 x 1.5P
142.651.61.315	C5 x SF 5/8–80mm	110mm	80mm	44.5mm	5/8"	27mm	34mm	M12 x 1.75P
142.651.64.315	C5 x SF 3/4–80mm	110mm	80mm	38mm	3/4"	36mm	42mm	M16 x 2.0P

C6 ShrinkFIT Chucks

Part No.	Description	L	l1	l2	d1	d2	d3	T
143.651.52.300	C6 x SF 1/8"–3"	4.50"	3"	1.77"	0.125"	0.36"	0.64"	M6 x 1.0P
143.651.53.300	C6 x SF 3/16"–3"	4.50"	3"	1.77"	0.137"	0.43"	0.70"	M6 x 1.0P
143.651.54.315	C6 x SF 1/4"–3.15"	4.65"	3.15"	1.41"	0.3125"	0.83"	1.06"	M5 x 0.8P
143.651.55.315	C6 x SF 5/16"–3.15"	4.65"	3.15"	1.41"	0.3125"	0.83"	1.06"	M6 x 1.0P
143.651.56.315	C6 x SF 3/8"–3.15"	4.65"	3.15"	1.61"	0.375"	0.95"	1.26"	M8 x 1.25P
143.651.58.315	C6 x SF 1/2"–3.15"	4.65"	3.15"	1.81"	0.5"	1.10"	1.34"	M10 x 1.5P
143.651.61.335	C6 x SF 5/8"–3.35"	4.84"	3.35"	1.93"	0.625"	1.06"	1.34"	M12 x 1.75P
143.651.64.335	C6 x SF 3/4"–3.35"	4.84"	3.35"	2"	0.75"	1.26"	1.65"	M16 x 2.0P
143.651.68.354	C6 x SF 1"–3.54"	5.04"	3.54"	2.24"	1"	1.73"	2.08"	M16 x 2.0P
143.651.72.374	C6 x SF 1-1/4"–3.74"	5.24"	3.74"	2.4"	1.25"	1.73"	2.08"	M16 x 2.0P

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

Capto-Compatible* C4, C5, C6, Face Mill Arbors



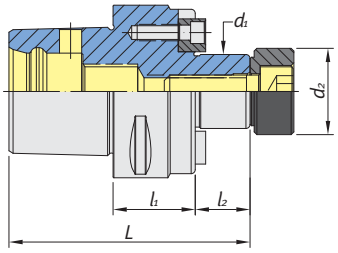


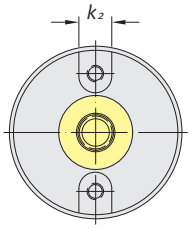
For turn/mill machines that accept "C" style toolholders.

Coolant-thru is standard feature.

Features

- *Compatible with all face mills*
- *H6 arbor tolerance for less chatter and better tool life*
- *Techniks Certified for accuracy and balance and backed by our 100% Performance guarantee*





C4, C5, C6 Face Mill Arbors

Part No.	Description	L	l1	l2	d1	d2	k2
141.151.64.100	C4 x FMA 3/4"–1"	3.13"	1"	0.687"	3/4"	0.88"	0.314"
142.151.68.157	C5 x FMA 1"–1.57"	3.43"	1.57"	0.687"	1"	1.24"	0.375"
143.151.64.100	C6 x FMA 3/4"–1"	3.18"	1"	0.687"	3/4"	0.88"	0.314"
143.151.68.200	C6 x FMA 1"–2"	4.18"	2"	0.687"	1"	1.24"	0.375"
143.151.72.200	C6 x FMA 1-1/4"–2"	4.18"	2"	0.687"	1.25"	1.614"	0.5"

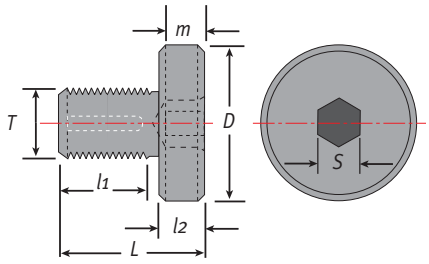
CoolBLAST Coolant Arbor Screws



- *Use with Techniks face mill arbors*
- *Works with coolant thru face mills*
- *For coolant up to 1,500 PSI*



CoolBLAST arbor screw provides coolant path.



Part No.	Description	Style	Size	D	L	l1	l2	T	S	m
WF.C1-0.75	CoolBLAST arbor screw 3/4"	B	3/4"	7/8"	1.8"	1.4"	.37"	3/8"-24UNF	1/4"	.197"
9851125	CAS-A-0.75 Smaller "D"	A	3/4"	5/8"	1.375"	1.0"	.36"	3/8-24 UNF	1/4"	.37"
WF.C1-1	CoolBLAST arbor screw 1.0"	B	1.0"	1-3/16"	1.4"	0.81"	.37"	1/2"-20UNF	5/16"	.197"
9851135	CAS-A-1.00 Smaller "D"	A	1.0"	3/4"	1.375"	1.0"	.38"	1/2-20UNF	5/16"	.37"
WF.C1-1.25	CoolBLAST arbor screw 1-1/4"	B	1-1/4"	1-1/2"	1.44"	0.94"	.5"	5/8"-18UNF	5/16"	.236"

Standard Arbor Screws

Part No.	Description	Arbor Size	D	L	l1	l2	T	S	m
WF0.75	FMA arbor screw 3/4"	3/4"	7/8"	1.8"	1.4"	.37"	3/8"-24UNF	1/4"	.197"
WF1	FMA arbor screw 1.0"	1.0"	1-3/16"	1.4"	0.81"	.37"	1/2"-20UNF	5/16"	.197"
WF1.25	FMA arbor screw 1-1/4"	1-1/4"	1-1/2"	1.44"	0.94"	.5"	5/8"-18UNF	5/16"	.236"

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

Capto-Compatible* C6 External Turning Tools

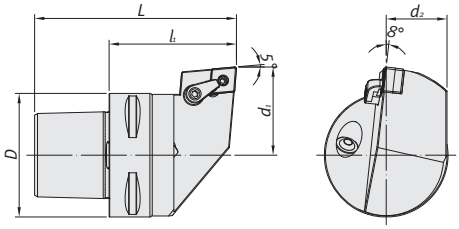




For turn/mill machines that accept "C" style toolholders.

Features

- *High accuracy for best repeatability*
- *Turning, boring, threading and grooving*



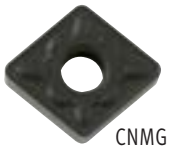
C6 MCLN

Part No.	Description	L	l1	D	d1	d2	Insert	Clamp	Shim	Screw	Lock Pin
143.475.12L.065	C6–MCLNL-DX12	103	65	63	45	31	CN_ _43_	MC620	CMS432	MS630	MLP46-A
143.475.12R.065	C6–MCLNR-DX12	103	65	63	45	31	CN_ _43_	MC620	CMS432	MS630	MLP46-A

CNMG Inserts for Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
6607029	CNMG431-NN	LT10	0.016	finishing	P-M-K-S-H
6608011	CNMG431-NN	LT1000	0.016	finishing	P-M-K-S-H
6607033	CNMG432-NN	LT10	0.031	general	P-M-K-S-H
6608016	CNMG432-NN	LT1000	0.031	general	P-M-K-S-H
6601436	CNMG432-NM	LT10	0.031	roughing	P-M-K-S-H
6601446	CNMG432-NR	LT10	0.031	roughing	P-M-K-S-H
6608026	CNMG432-NX	LT1000	0.031	general	P-M-K-S-H
6607037	CNMG433-NN	LT10	0.047	roughing	P-M-K-S-H
6608021	CNMG433-NN	LT1000	0.047	roughing	P-M-K-S-H

We recommend LT1000 grade inserts for maximum insert performance. LT1000 grade features an advanced PVD coating that is 14 microns thick and lasts 250% longer than other inserts.


CNMG

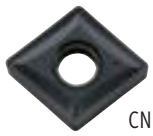
CNMM Inserts for Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
6602011	CNMM432-NR	LT10	0.031	finish-medium	P-M-K-S-H
6602022	CNMM433-NR	LT10	0.047	medium-rough	P-M-K-S-H


CNMM

CNMP Inserts for Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
6607045	CNMP432-NN	LT10	0.031	finish-medium	P-M-K-S-H
6608031	CNMP432-NN	LT1000	0.031	finish-medium	P-M-K-S-H
3665525	CNMP433-NN	LT10	0.047	medium-rough	P-M-K-S-H
6608036	CNMP433-NN	LT1000	0.047	medium-rough	P-M-K-S-H


CNMP

CNGG Inserts for Aluminum Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
6607901	CNGG431-ALU	LT05	0.016	finishing	N
6607905	CNGG432-ALU	LT05	0.031	general	N


CNGG

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

P = steel, M = stainless, K = cast iron, S = high temp alloys, H = hardened material, N = aluminum & alloys

Capto-Compatible* C6 External Turning Tools

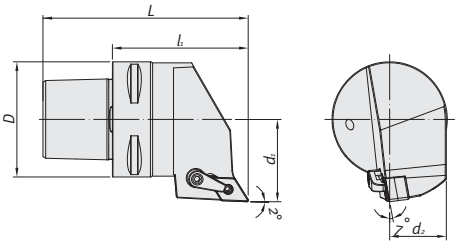




For turn/mill machines that accept "C" style toolholders.

Features

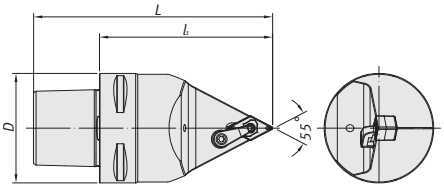
- *High accuracy for best repeatability*
- *Turning, boring, threading and grooving*



C6 MDJN

Part No.	Description	L	l1	D	d1	d2	Insert	Clamp	Shim	Screw	Lock Pin
143.476.15L.075	C6–MDJNL-EX15	113	75	63	45	31	DN_ _43_	MC622	DMS442	MS630	MLP46L-A
143.476.15R.075	C6–MDJNR-EX15	113	75	63	45	31	DN_ _43_	MC622	DMS442	MS630	MLP46L-A





C6 MDNN

Part No.	Description	L	l1	D	Insert	Clamp	Shim	Screw	Screw
143.481.15N.100	C6–MDNNN-H15	138	100	63	DN_ _43_	MC622	DMS442	MS625	MLP46L-A

DNMG and DNGG Inserts for Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
7607061	DNMG331-NN	LT10	0.016	finishing	P-M-K-S-H
7608011	DNMG331-NN	LT1000	0.016	finishing	P-M-K-S-H
7607065	DNMG332-NN	LT10	0.031	general	P-M-K-S-H
7608016	DNMG332-NN	LT1000	0.031	general	P-M-K-S-H
7607069	DNMG431-NN	LT10	0.016	finishing	P-M-K-S-H
7608021	DNMG431-NN	LT1000	0.016	finishing	P-M-K-S-H
7607073	DNMG432-NN	LT10	0.031	finish-medium	P-M-K-S-H
7608026	DNMG432-NN	LT1000	0.031	finish-medium	P-M-K-S-H
7608029	DNMG432-NX	LT1000	0.031	general	P-M-K-S-H
7607077	DNMG433-NN	LT10	0.047	medium-rough	P-M-K-S-H
7608031	DNMG433-NN	LT1000	0.047	medium-rough	P-M-K-S-H
7608036	DNMG441-NN	LT10	0.016	finishing	P-M-K-S-H
7608041	DNMG442-NN	LT10	0.031	finish-medium	P-M-K-S-H
7608046	DNMG443-NN	LT10	0.047	medium-rough	P-M-K-S-H
7607909	DNGG331-ALU	LT05	0.016	finishing	N
7607913	DNGG332-ALU	LT05	0.031	finish-medium	N

We recommend LT1000 grade inserts for maximum insert performance. LT1000 grade features an advanced PVD coating that is 14 microns thick and lasts 250% longer than other inserts.



DNMG



DNGG

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P = steel, M = stainless, K = cast iron, S = high temp alloys, H = hardened material, N = aluminum & alloys

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SYIC

Capto-Compatible* C6 External Turning Tools

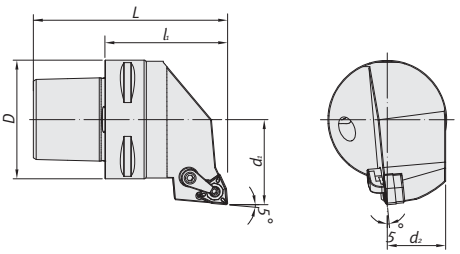


Features

- *High accuracy for best repeatability*
- *Turning, boring, threading and grooving*



For turn/mill machines that accept "C" style toolholders.



C6 MWLN

Part No.	Description	L	l1	D	d1	d2	Insert	Clamp	Shim	Screw	Lock Pin
143.478.08L.065	C6–MWLNL-DX08	103	65	63	45	31	WN_ _43_	MC620	TMS432	MS630	MLP46L-A
143.478.08R.065	C6–MWLNR-DX08	103	65	63	45	31	WN_ _43_	MC620	TMS432	MS630	MLP46L-A

WNMG Inserts for Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
3463311	WNMG331-NN	LT10	0.016	finishing	P-M-K-S-H
3463315	WNMG332-NN	LT10	0.031	finish-medium	P-M-K-S-H
4607257	WNMG431-NN	LT10	0.016	finishing	P-M-K-S-H
4608011	WNMG431-NN	LT1000	0.016	finishing	P-M-K-S-H
4607261	WNMG432-NN	LT10	0.031	finish-medium	P-M-K-S-H
4608016	WNMG432-NN	LT1000	0.031	finish-medium	P-M-K-S-H
4608023	WNMG432-NM	LT1000	0.031	roughing	P-M-K-S-H
4601437	WNMG332-NR	LT10	0.031	roughing	P-M-K-S-H
4608021	WNMG432-NX	LT1000	0.031	general	P-M-K-S-H
4600076	WNMG432-WM	LT10	0.031	finish-medium	P-M-K-S-H
4607265	WNMG433-NN	LT10	0.047	medium-rough	P-M-K-S-H
4608026	WNMG433-NN	LT1000	0.047	medium-rough	P-M-K-S-H

We recommend LT1000 grade inserts for maximum insert performance. LT1000 grade features an advanced PVD coating that is 14 microns thick and lasts 250% longer than other inserts.



WNMG

WNMP Inserts for Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
4608029	WNMP331-NN	LT10	0.016	finishing	P-M-K-S-H
4608030	WNMP332-NN	LT10	0.031	finish-medium	P-M-K-S-H
4607277	WNMP432-NN	LT10	0.031	finish-medium	P-M-K-S-H
4608031	WNMP432-NN	LT1000	0.031	finish-medium	P-M-K-S-H



WNMP

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

P = *steel*, M = *stainless*, K = *cast iron*, S = *high temp alloys*, H = *hardened material*, N = *aluminum & alloys*

Capto-Compatible* C6 External Turning Tools

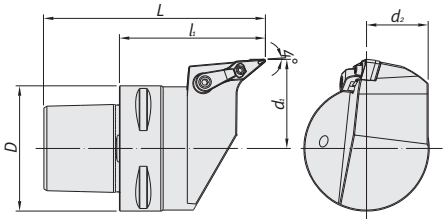


Features

- *High accuracy for best repeatability*
- *Turning, boring, threading and grooving*



For turn/mill machines that accept "C" style toolholders.



C6 MVLN

Part No.	Description	L	l1	D	d1	d2	Insert	Clamp	Shim	Screw	Screw
143.479.16L.075	C6–MVLNL-EX16	113	75	63	45	31	VN_ _33_	MC622	VMS322	MS630	MLP34L-A
143.479.16R.075	C6–MVLNR-EX16	113	75	63	45	31	VN_ _33_	MC622	VMS322	MS630	MLP34L-A

VNMG Inserts for Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
8607241	VNMG331-NN	LT10	0.016	finishing	P-M-K-S-H
8608011	VNMG331-NN	LT1000	0.016	finishing	P-M-K-S-H
8607245	VNMG332-NN	LT10	0.031	finish-medium	P-M-K-S-H
8608016	VNMG332-NN	LT1000	0.031	finish-medium	P-M-K-S-H

We recommend LT1000 grade inserts for maximum insert performance. LT1000 grade features an advanced PVD coating that is 14 microns thick and lasts 250% longer than other inserts.



VNMG



VNGG

VNGG Inserts for Aluminum Negative Turning and Boring

Part No.	Description	Grade	Radius	Operation	Material
8607921	VNGG331-ALU	LT 05	0.016	finishing	N
8607925	VNGG332-ALU	LT 05	0.031	finish-medium	N

**Compatible with the Capto tool system. Techniks products are not affiliated with or endorsed by Sandvik AB.*

P = steel, M = stainless, K = cast iron, S = high temp alloys, H = hardened material, N = aluminum & alloys

Tapping Systems – ANSI Tap Collets



NEW!

MicroFLOAT

Rigid Tapping Holders

Increase Tap Life 295%

Tension-Compression Tap Holders

Automatically compensate for machine feed rates to improve results.



Rigid Tap Chucks

Easy to use and reliable tap holders for general tapping applications.



ANSI Clutch Drive & Rigid Tap Collets

Clutch drive automatically stops spinning if tap reaches bottom of hole preventing broken taps.



TECHNIKS
BUILT FOR SPEED
www.techniksusa.com
a Quintec Company

http://ow.ly/rIi2o
View the MicroFLOAT Tapping video.

Built for Speed.

All Techniks products are backed by our 100% satisfaction guarantee!

MicroFLOAT – Compensated Holders for Rigid Tapping

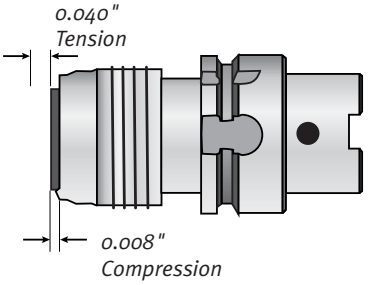


MicroFLOAT holders make rigid tapping easier and much more productive.

Advantages

- *Increase tap life 295%*
- *Improve thread quality*
- *Reduces scrap rates*
- *Great for high pressure coolant applications*

MicroFLOAT Tension / Compression



MicroFLOAT Extensible System

Teckniks' MicroFLOAT quick-change tap holders feature tension/compression technology optimized specifically for rigid tapping. MicroFLOAT holders provide 0.008" of compression for hard to start or sensitive taps, and 0.040" of tension (extension) to compensate for any inaccuracy in the machine, taps, or associated tooling and fixturing.

In actual production testing customers report a great improvement in overall tap performance, and thread quality.

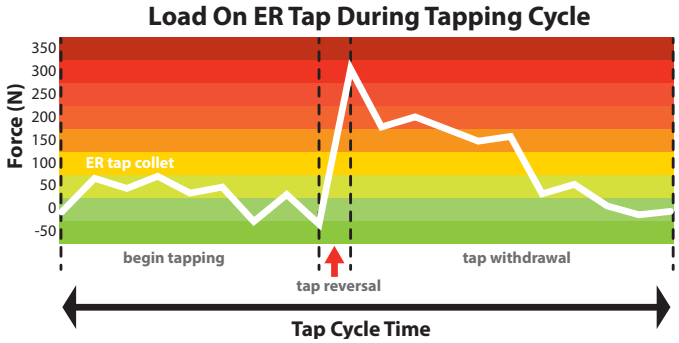
MicroFLOAT compensation prevents premature wear on the tap and tool life went up an average of 295%

The MicroFLOAT modular tapping system provides a quick change tapping platform that is extensible for deep hole tapping up to 9 inches.

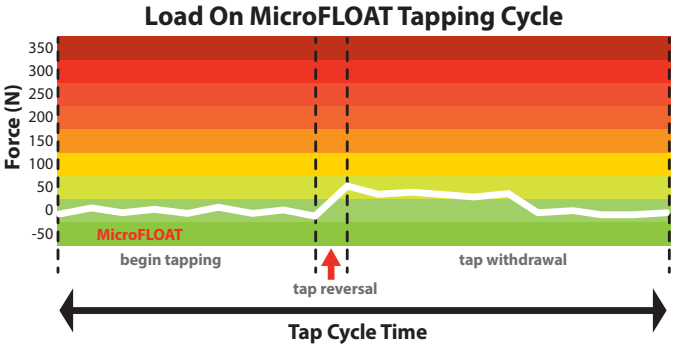


Extensible up to 9"

Optimized Compensation Designed For Rigid Tapping



Optimal thread quality is achieved when the tap follows the exact same path out as it did when it cut the threads. This graph shows that the load on the tap peaks when the spindle reverses direction, causing tap wear, thread damage, or tap breakage.



As this graph shows, MicroFLOAT compensation greatly reduces this load, stabilizing the tap throughout its cycle, increasing tap life up to 295%.

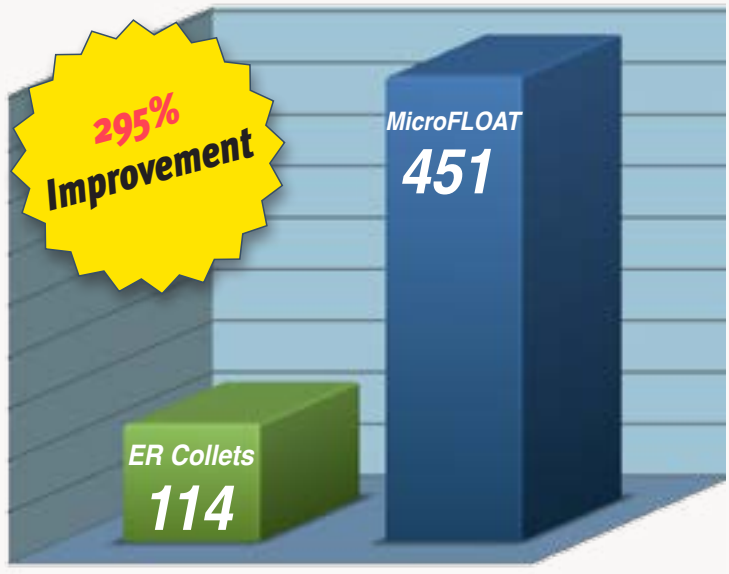
MicroFLOAT Case-Study – 295% Productivity Increase



Case-Study Shows MicroFLOAT System Increases Tap Life by 295%

Techniks recently conducted a case-study comparing tapping using a rigid tap system and the new MicroFLOAT Tapping System.

MicroFLOAT vs. ER Chucks



Case-Study Parameters

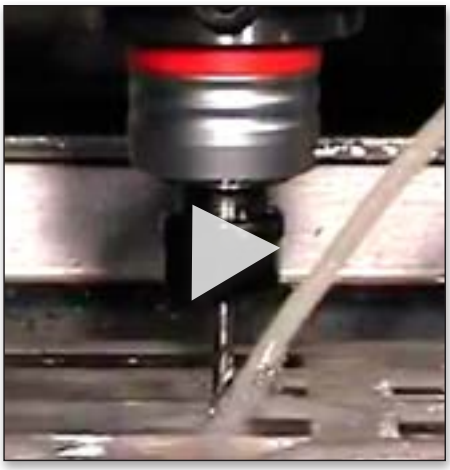
Material: *AISI 304*

Speeds and Feeds:
(Vt=12m/min
Av=1 mm/rev
prof=12 mm)

Test Results

Number of tapped holes before breakage

- *MicroFLOAT tapping system: 451*
- *Standard rigid tapping system: 114*



View our informative video at http://ow.ly/u8vK2

Directions for Use

1. *Select the MicroFLOAT chuck required for your machine spindle (see page 146)*
2. *Select the ER adapter size and number of extensions needed for your tapping application. (see page 147)*
3. *To change taps, pull the outside sleeve away from the v-flange to release the tap adapter in the toolholder so it can be changed or extensions added.*
4. *Start tapping at 100% of pitch feed. If issues occur, program 3–5% below the pitch feed. This will engage more tension to ensure the tap does not "drag" coming out.*

CAT, BT, HSK, MicroFLOAT Tap Chucks and ER Adapters



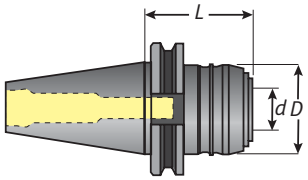
Use MicroFLOAT chucks with ER Tap Adapters

Features & Benefits

- *Compensates for sensitive and hard to start taps*
- *Great for high pressure coolant applications*
- *Decreases cost by increasing tap life, decreasing scrap, and reducing tap breakage*



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CAT40 & 50 MicroFLOAT Tap Chucks

Part No.	Description	L	D	d
23400-40CAT	CAT40 MicroFLOAT #1	2.75"	1.7"	0.79"
23600-40CAT	CAT40 MicroFLOAT #2	3.54"	2.36"	1.26"
23400-50CAT	CAT50 MicroFLOAT #1	2.75"	1.7"	0.79"
23600-50CAT	CAT50 MicroFLOAT #2	3.54"	2.36"	1.26"

BT30 & 40 MicroFLOAT Tap Chucks

Part No.	Description	L	D	d
23400-30BT	BT30 MicroFLOAT #1	2.09"	1.7"	0.79"
23400-40BT	BT40 MicroFLOAT #1	2.40"	1.7"	1.26"
23600-40BT	BT40 MicroFLOAT #2	3.22"	2.36"	1.26"

HSK63A MicroFLOAT Tap Chucks

Part No.	Description	L	D	d
23400-H63A	HSK63A MicroFLOAT #1	2.52"	1.7"	.79"

Straight Shank MicroFLOAT Chucks

Part No.	Description	L	D	d
23400-INC1	1" SS MicroFLOAT # 1	1.3"	1.7"	0.79"
23600-INC1	1" SS MicroFLOAT # 2	2.13"	2.36"	1.26"

ER Tap Adapter – Required

Part No.	Description	L	D	d
23410-ER16	ER16 MicroFLOAT 1 Adapter	2.16"	1.10"	.79"
23610-ER25	ER25 MicroFLOAT 2 Adapter	3.39"	1.65"	1.27"

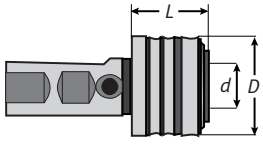
High-Pressure Coolant Enabled

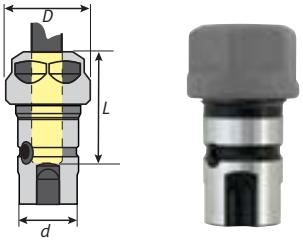


Coolant-thru tool is a standard feature on MicroFLOAT tap chucks



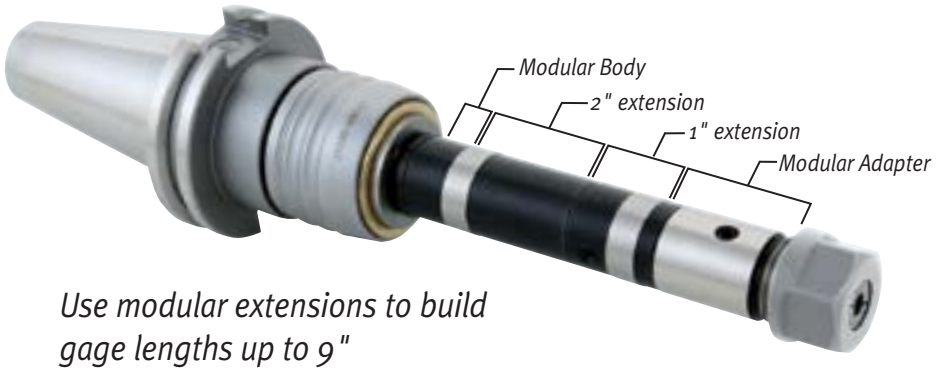
MicroFLOAT straight shank chuck



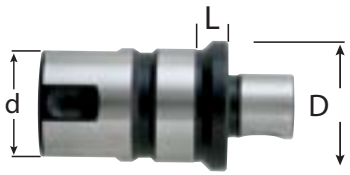


ER16 adapter takes up to 3/8" tap
ER25 takes up to 3/4" tap

MicroFLOAT Modular Tap Extensions



Use modular extensions to build gage lengths up to 9"



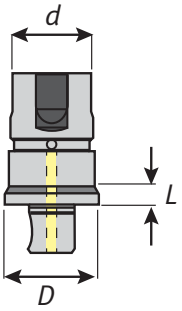
Use modular bodies when you use extensions.

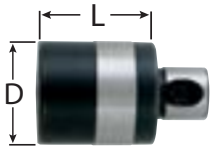
Directions for Use

1. *Select the MicroFLOAT chuck required for your machine spindle (see previous page)*
2. *Select the modular adapter size and number of extensions needed for your tapping application.*
3. *Start tapping at 100% of pitch feed. If issues occur, program 3–5% below the pitch feed. This will engage more tension to ensure the tap does not "drag" coming out.*

Modular Body

Part No.	Description	L	D	d
23411-MOD	Modular Body MicroFLOAT #1	.20"	.91"	.79"
23611-MOD	Modular Body MicroFLOAT #2	.28"	1.38"	1.26"





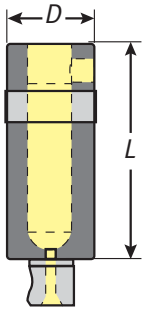
1" extension



2" extension

Modular Extensions

Part No.	Description	L	D	Chuck
42150-25	1" Modular Extension MicroFLOAT #1	.98"	.91"	23400-..
42150-50	1" Modular Extension MicroFLOAT #1	1.97"	.91"	23400-..
42250-50	2" Modular Extension MicroFLOAT #2	1.97"	1.38"	23600-..
42250-100	2" Modular Extension MicroFLOAT #2	3.94"	1.38"	23600-..



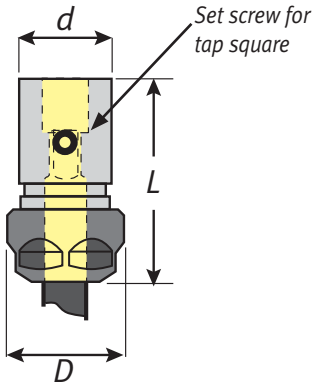


ER16 Modular Adapter

ER16 adapter takes up to 3/8" tap
ER25 takes up to 3/4" tap

ER Modular Adapter

Part No.	Description	L	D	d
42147-ER16	ER16 Modular Adapter MicroFLOAT #1	1.97"	1.10"	.91"
42247-ER25	ER25 Modular Adapter MicroFLOAT #2	3.11"	1.65"	1.38"



CAT, BT Tension / Compression Tap Holders

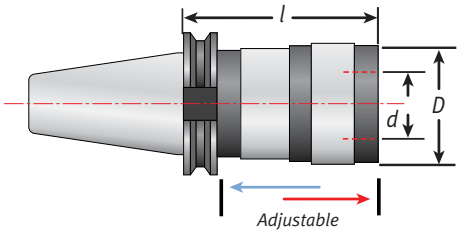


Techniks Quality Features

- *Adjustible compression helps start difficult taps*
- *Taper ground to AT3 accuracy or better*
- *Quick-Change Style*



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CAT Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap Capacity	Compensation Tension	Compensation Compression
32400/40CAT	CAT40 T/C Holder, Size 1	0.748"	1.5"	2.36"	1	0 – 9/16"	0.35"	0.35"
32400/50CAT	CAT50 T/C Holder, Size 1	0.748"	1.5"	2.44"	1	0 – 9/16"	0.35"	0.35"
32600/40CAT	CAT40 T/C Holder, Size 2	1.220"	2.17"	3.94"	2	5/16 – 7/8"	0.59"	0.59"
32600/50CAT	CAT50 T/C Holder, Size 2	1.220"	2.17"	3.27"	2	5/16 – 7/8"	0.59"	0.59"
32800/40CAT	CAT40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50CAT	CAT50 T/C Holder, Size 3	1.890"	3.11"	5.24"	3	1/2 – 1 3/8"	0.94"	0.94"
32900/40CAT	CAT40 T/C Holder, Size 4	2.362"	3.86"	6.06"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50CAT	CAT50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

BT Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap Capacity	Compensation Tension	Compensation Compression
32400/30BT	BT30 T/C Holder, Size 1	0.748"	1.5"	2.48"	1	0 – 9/16"	0.35"	0.35"
32400/40BT	BT40 T/C Holder, Size 1	0.748"	1.5"	2.68"	1	0 – 9/16"	0.35"	0.35"
32400/50BT	BT50 T/C Holder, Size 1	0.748"	1.5"	3.15"	1	0 – 9/16"	0.35"	0.35"
32600/30BT	BT30 T/C Holder, Size 2	1.220"	2.17"	3.78"	2	5/16 – 7/8"	0.59"	0.59"
32600/40BT	BT40 T/C Holder, Size 2	1.220"	2.17"	3.66"	2	5/16 – 7/8"	0.59"	0.59"
32600/50BT	BT50 T/C Holder, Size 2	1.220"	2.17"	4.02"	2	5/16 – 7/8"	0.59"	0.59"
32800/40BT	BT40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50BT	BT50 T/C Holder, Size 3	1.890"	3.11"	5.31"	3	1/2 – 1-3/8"	0.94"	0.94"
32900/40BT	BT40 T/C Holder, Size 4	2.362"	3.86"	6.18"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50BT	BT50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

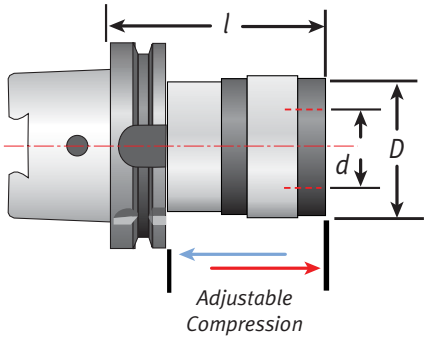
Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

HSK & Straight Shank Tension / Compression Tap Holders



Techniks Quality Features

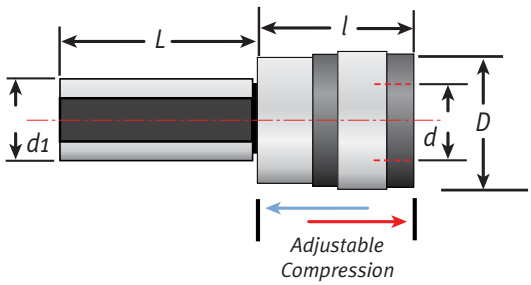
- *Adjustible compression helps start difficult taps*
- *Quick-Change Style*



HSK A Tension / Compression Tap Holders

						Tap	Compensation	
Part No.	Description	d	D	l	Size	Capacity	Tension	Compression
34400/H40A	HSK40A T/C Holder, Size 1	0.748"	1.5"	3.14"	1	0 – 9/16"	0.295"	0.295"
34400/H50A	HSK50A T/C Holder, Size 1	0.748"	1.5"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H63A	HSK63A T/C Holder, Size 1	0.748"	1.5"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H100A	HSK100A T/C Holder, Size 1	0.748"	1.5"	3.14"	1	0 – 9/16"	0.295"	0.295"
34600/H50A	HSK50A T/C Holder, Size 2	1.22"	2.17"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H63A	HSK63A T/C Holder, Size 2	1.22"	2.17"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H100A	HSK100A T/C Holder, Size 2	1.22"	2.17"	3.94"	2	5/16 – 7/8"	0.393"	0.393"





Straight Shank Tapping Chucks

						Tap	Compensation	
Part No.	Description	D1	D	l	L	Capacity	Tension	Compression
32400/INC1	1" shank T/C Holder, Size 1	1.00"	1.5"	1.76"	1.95"	0 – 9/16"	0.35"	0.35"
32600/INC1	1" shank T/C Holder, Size 2	1.00"	2.17"	2.52"	2.00"	5/16 – 7/8"	0.59"	0.59"
32600/INC1-1/2	1 1/2" shank T/C Holder, Size 2	1.50"	2.17"	2.52"	3.50"	5/16 – 7/8"	0.59"	0.59"
32800/INC1-1/2	1 1/2" shank T/C Holder, Size 3	1.50"	3.38"	3.85"	3.50"	1/2 – 1 3/8"	0.94"	0.94"

CAT, BT Rigid Tap Holders



Techniks Quality Features

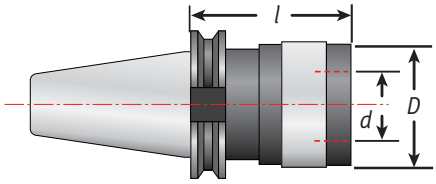
- *Taper ground to AT3 accuracy or better*
- *Quick-Change Style*


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Retention Knobs pg. 204


Wrenches pg. 208



CAT Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/40CAT	CAT40 Rigid Tap Holder, Size 1	2.32"	1.31"	0.748"	1	0 – 9/16"
21480/50CAT	CAT50 Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 – 9/16"
21680/40CAT	CAT40 Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 – 7/8"
21680/50CAT	CAT50 Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 – 7/8"
21880/40CAT	CAT40 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1 3/8"
21880/50CAT	CAT50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1-3/8"

BT Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/30BT	BT30 Rigid Tap Holder, Size 1	2.80"	1.31"	0.748"	1	0 - 9/16"
21480/40BT	BT40 Rigid Tap Holder, Size 1	2.63"	1.31"	0.748"	1	0 - 9/16"
21480/50BT	BT50 Rigid Tap Holder, Size 1	3.07"	1.31"	0.748"	1	0 - 9/16"
21680/30BT	BT30 Rigid Tap Holder, Size 2	3.70"	1.97"	1.22"	2	5/16 - 7/8"
21680/40BT	BT40 Rigid Tap Holder, Size 2	3.54"	1.97"	1.22"	2	5/16 - 7/8"
21680/50BT	BT50 Rigid Tap Holder, Size 2	3.97"	1.97"	1.22"	2	5/16 - 7/8"
21880/40BT	BT40 Rigid Tap Holder, Size 3	4.61"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/50BT	BT50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"

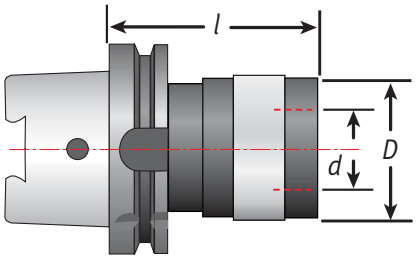
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HSK and Straight Shank Rigid Tap Holders



Techniks Quality Features

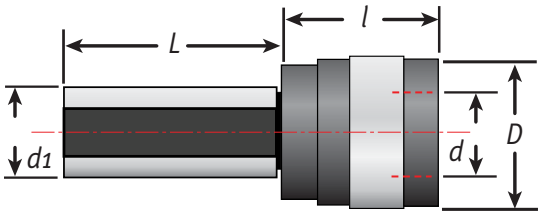
- *Quick-Change Style*



HSK Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/H50A	HSK50A Rigid Tap Holder, Size 1	2.30"	1.31"	0.748"	1	0 - 9/16"
21480/H63A	HSK63A Rigid Tap Holder, Size 1	2.32"	1.31"	0.748"	1	0 - 9/16"
21480/H100A	HSK100A Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 - 9/16"
21680/H50A	HSK50A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H63A	HSK63A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H100A	HSK100A Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 - 7/8"
21880/H63A	HSK63A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/H100A	HSK100A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"





Straight Shank Rigid Tap Holders

Part No.	Description	d1	L	l	D	d	Tap Capacity
21480/INC1	1" shank, Rigid Tap Holder, Size 1	1.00"	1.95"	1.60"	1.31"	.748"	0 – 9/16"
21680/INC1	1" shank, Rigid Tap Holder, Size 2	1.00"	2.00"	2.50"	1.97"	1.22"	3/8 – 7/8"
21880/INC1-1/2	1 1/2" shank, Rigid Tap Holder, Size 3	1.50"	3.50"	3.44"	2.83"	1.89"	1/2 – 1 3/8"

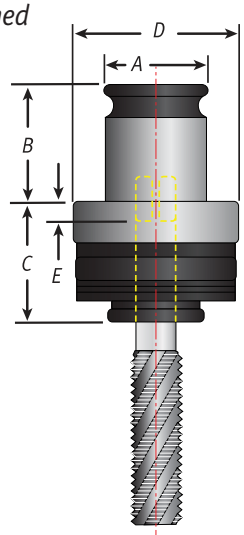
ANSI Clutch Drive Tap Collets



Note: Metric tap collets available on request. Please verify shank diameter when ordering metric tap collets.

ANSI Clutch Drive Tap Collet Features

- *Prevents broken taps*
- *Automatically stops spinning when bottom is reached*
- *Change worn taps in seconds*



Dimensions	A	B	C	D	E
Size 0	.51"	.77"	.83"	.91"	.24"
Size 1	.75"	.85"	.98"	1.26"	.31"
Size 2	1.22"	1.38"	1.34"	1.97"	.16"
Size 3	1.89"	2.19"	1.77"	2.83"	.04"

Collet Set

Part No.	Description
48/3-SET	Size 3, 16 piece set – 1/2" thru 1" NPT

ANSI Clutch Drive Tap Collets

ANSI	Metric Tap / ANSI Shank	Shank	SQ	Size 0	Size 1	Size 2	Size 3
0-6"	M1.6-M3.5	0.141"	0.110"	13/0-4036	19/1-4036		
8, 5/32"	M4	0.168"	0.131"	13/0-4041	19/1-4041		
10, 3/16"	M4.5, M5	0.194"	0.152"	13/0-4048	19/1-4048		
12, 7/32"		0.220"	0.165"	13/0-4054	19/1-4054		
1/4"	M6, M6.3	0.255"	0.191"	13/0-4063	19/1-4063		
5/16"	M7, M8	0.318"	0.238"		19/1-4079	31/2-4079	
3/8"	M10	0.381"	0.286"		19/1-4095	31/2-4095	
7/16"	M11	0.323"	0.242"		19/1-4111	31/2-4111	
1/2"	M12, M12.5	0.367"	0.275"		19/1-4127	31/2-4127	48/3-4127
9/16"	M14	0.429"	0.322"		19/1-4142	31/2-4142	48/3-4142
5/8"	M16	0.480"	0.360"			31/2-4158	48/3-4158
11/16"	M18	0.542"	0.406"			31/2-4174	48/3-4174
3/4"		0.590"	0.442"			31/2-4190	48/3-4190
13/16"	M20	0.652"	0.489"			31/2-4206	48/3-4206
7/8"	M22	0.697"	0.523"			31/2-4222	48/3-4222
15/16"	M24	0.760"	0.570"				48/3-4238
1"	M25	0.800"	0.600"				48/3-4254
1 1/8, 1 1/16"	M27	0.896"	0.672"				48/3-4286
1 1/4, 1 3/16"	M30	1.021"	0.766"				48/3-4317
1 3/8, 1 5/16"	M33	1.108"	0.831"				48/3-4349
1/8" NPT		0.437"	0.328"		19/1 - 4097		
1/4" NPT		0.562"	0.421"			31/2-4131C	
3/8" NPT		0.700"	0.531"			31/2-4166C	48/3-4166C
1/2" NPT		0.687"	0.515"			31/2-4209C	48/3-4209C
3/4" NPT		0.906"	0.678"				48/3-4264C
1" NPT		1.125"	0.843"				48/3-4332C

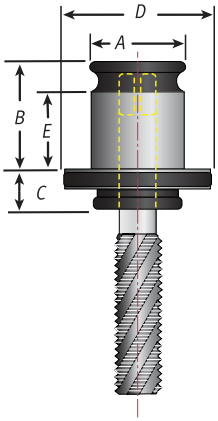
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ANSI Rigid Tap Collets



- *Change worn taps in seconds*
- *Quick-Change Style*

Dimensions	A	B	C	D	E
Size 1	.75"	.85"	.28"	1.18"	.39"
Size 2	1.22"	1.38"	.43"	1.81"	.75"
Size 3	1.89"	2.19"	.55"	2.68"	1.18"
Size 4	2.36"	2.48"	1.65"	3.27"	1.14"



Collet Sets

Part No.	Description
19/11-SET	Size 1, 11 piece set – 0-6" thru 9/16" & 1/8" NPT
31/12-SET	Size 2, 13 piece set – 5/16" thru 1/2" NPT
48/13-SET	Size 3, 16 piece set – 1/2" thru 1" NPT

ANSI Rigid Tap Collets

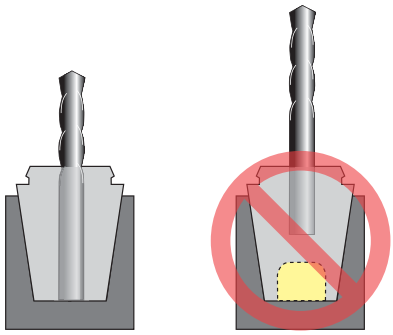
ANSI	Metric Tap / ANSI Shank	Shank	SQ	Size 1	Size 2	Size 3	Size 4
0-6"	M1.6-M3.5	0.141"	0.110"	19/11-4036			
8, 5/32"	M4	0.168"	0.131"	19/11-4041			
10, 3/16"	M4.5, M5	0.194"	0.152"	19/11-4048			
12, 7/32"		0.220"	0.165"	19/11-4054			
1/4"	M6, M6.3	0.255"	0.191"	19/11-4063			
5/16"	M7, M8	0.318"	0.238"	19/11-4079	31/12-4079		
3/8"	M10	0.381"	0.286"	19/11-4095	31/12-4095		
7/16"	M11	0.323"	0.242"	19/11-4111	31/12-4111		
1/2"	M12, M12.5	0.367"	0.275"	19/11-4127	31/12-4127	48/13-4127	
9/16"	M14	0.429"	0.322"	19/11-4142	31/12-4142	48/13-4142	
5/8"	M16	0.480"	0.360"		31/12-4158	48/13-4158	
11/16"	M18	0.542"	0.406"		31/12-4174	48/13-4174	
3/4"		0.590"	0.442"		31/12-4190C	48/13-4190	
13/16"	M20	0.652"	0.489"		31/12-4206C	48/13-4206	
7/8"	M22	0.697"	0.523"		31/12-4222C	48/13-4222	
15/16"	M24	0.760"	0.570"			48/13-4238	
1"	M25	0.800"	0.600"			48/13-4254	
1 1/8, 1 1/16"	M27	0.896"	0.672"			48/13-4286	
1 1/4, 1 3/16"	M30	1.021"	0.766"			48/13-4317	
1 3/8, 1 5/16"	M33	1.108"	0.831"			48/13-4349	
1 1/2, 1 7/16"	M36	1.233"	0.925"				60/14-4381C
1 5/8"	M39	1.305"	0.925"				60/14-4412C
1 3/4"	M42	1.430"	1.072"				60/14-4444C
1 7/8"		1.520"	1.139"				60/14-4476C
1/8" NPT		0.437"	0.328"	19/11-4097			
1/4" NPT		0.562"	0.421"		31/12-4131C		
3/8" NPT		0.700"	0.531"		31/12-4166C	48/13-4166C	
1/2" NPT		0.687"	0.515"		31/12-4209C	48/13-4209C	
3/4" NPT		0.906"	0.678"			48/13-4264C	
1" NPT		1.125"	0.843"			48/13-4332C	

Tightening Torque Specifications Chart

Recommended Collet & Retention Knob Tightening Torque

Collet	Nut Type	Collets I.D. OVER 1/16" (2mm)	Collets I.D. UNDER 1/16" (2mm)	Order Torque Wrench Adapter
ER16	slotted	42 ft/lbs	30 ft/lbs	04580-16
ER16	hex	42 ft/lbs	30 ft/lbs	04601-16
ER20	slotted	59 ft/lbs	24 ft/lbs	04580-20
ER20	hex	59 ft/lbs	24 ft/lbs	04602-20
ER25	slotted	77 ft/lbs	77 ft/lbs	04503-25
ER25	mini nut	25 ft/lbs	25 ft/lbs	04587
ER32	slotted	100 ft/lbs	100 ft/lbs	04604-32
ER40	slotted	130 ft/lbs	130 ft/lbs	04605-40
SYOZ 25	hook	90 ft/lbs	90 ft/lbs	03690-25
TG 75	slotted	90 ft/lbs	90 ft/lbs	04604-32
TG 100	hook	90 ft/lbs	90 ft/lbs	03690-25

Retention Knobs	Wrench Flats	Drive	Torque	Order Socket
BT30 Taper	0.535"	1/4"	36 ft/lbs	PSS-30BT
ISO 30 Taper	0.535"	3/8"	36 ft/lbs	PSS-30ISO
Any 40 Taper	0.750"	3/8"	76 ft/lbs	PSS-40
BT50 Taper	1.187"	1/2"	99 ft/lbs	PSC-50
CAT50 Taper	1.250"	1/2"	99 ft/lbs	PSC-50



For maximum holding power fill the collet all the way with the tool shank (left) and use a PowerCOAT nut.

DIRECTIONS

1. *Snap collet into nut.*
2. *Insert cutting tool into collet. Make sure shank extends to the bottom of the collet.*
3. *Hand tighten collet nut assembly into toolholder.*
4. *Insert toolholder assembly into tightening fixture and secure it.*
5. *Tighten collet nut to recommended torque using a torque wrench and adapter.*

PinzBOHR High Precision Boring Tools



Modular Boring Tools

- *Range .314" to 40.157"*

see page 162

http://ow.ly/rImTv
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MacroBOHR

NEW!

Range 8.661" up to 40.157"

see page 194



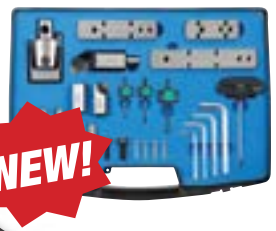
UltraFINE finish heads

see page 172

NEW!



Eight Kits Now Available



NEW!

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see page 156

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BohrSTAR High-Performance Boring Kits

"Right-Sized" boring kits meet your exact needs.

range 0.314" up to 8.27"



All kits available for either rhombic or triangular inserts.

Machinists rely on BohrSTAR kits for performance and ease-of-use (no spacers or complicated set-ups) without the expense of dedicated boring tools.

BohrSTAR components are manufactured from nickle-chrome alloy steel hardened to 58–60 HRC. All moving parts are precision ground for accuracy, wear resistance, and smooth adjustment.

BohrSTAR Kit Setup Examples – Range from .314" to 8.27"

AccuSET dial adjustable heads





0.314" to 1.692"



1.496" to 2.322"



2.204" to 3.897"



3.267" to 5.118"



4.841" to 8.27"

These kits are so new we couldn't get them into this catalog!

NEW!

http://ow.ly/tBzx4
for more details on all our kits

Now all our BohrSTAR kits are available in either rhombic or triangular insert pockets. These include our new, very affordable BohrSTAR 43 kits for making holes from 0.314" to 1.692".

See the rest of our kits on pages 157 thru 160. Kit toolholders are on page 161.

NEW! BohrSTAR 43 Kits



No. 6991215, Triangular, range: 0.314" - 1.692"
No. 6991210, Rhombic, range: 0.314" - 1.692"

NEW! BohrSTAR 170 Kit



No. 6991250, Triangular, range: 0.314" - 6.692"

NEW! BohrSTAR 210 Kit



No. 6991245, Rhombic, range: 0.314" - 8.267"

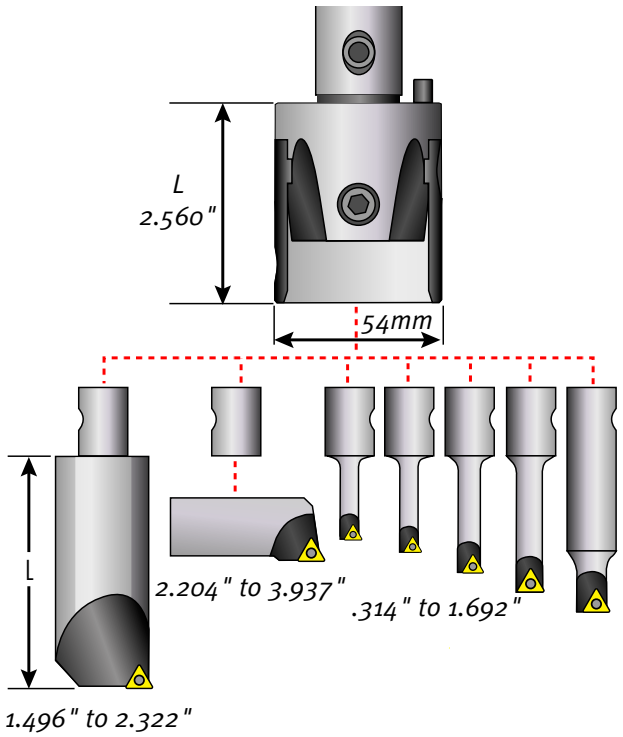
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PINZBOHR

BohrSTAR 100 Triangular Kit – Range: 0.314" to 3.94"



Kit Part No.	Description	Range
6991235	BS-54-KIT-TC-8-100	0.314" – 3.94"



Kit Includes Triangular Inserts:

- *2 Pcs. TCMT 1.2_*
- *3 Pcs. TCMT 1.8_*
- *2 Pcs. TCMT 32.5_*



TCMT

BohrSTAR kits are designed for maximum performance and ease-of-use (no spacers or complicated set-ups). Our boring tools out perform all others when it comes to accuracy, rigidity, and repeatability.

Our exclusive, modular coupling system features two, tapered locking screws that provide maximum rigidity between the boring head and the toolholder to increase accuracy.
All connections are easily made using the tools provided.

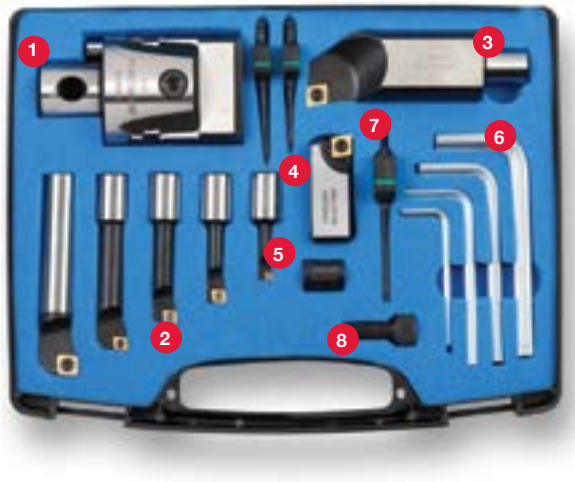
BohrSTAR 100 Kit Includes These Components

	Part No.	Description	Length
1	6951234	BS-54-16-W head	.2560"
2	6943333	BS-06-16-T01 6mm bar	.984"
	6943334	BS-08-16-T01 8mm bar	1.378"
	6943335	BS-10-16-T02 10mm bar	1.772"
	6943336	BS-12-16-T02 12mm bar	2.244"
	6943337	BS-16-16-T02 16mm bar	2.874"
3	6943338	BS-34-16-T04 34mm bar	3.228"
4	6922243	BS-2CT-T04 cartridge	.787"
5	6921239	BS-16-M10 location sleeve	
6	6962233	H3 hex	
	6962235	H5 hex	
	6962236	H6 hex	
	6962238	H8 hex	
7	6972236	T6 torx	
	6972237	T7 torx	
	6972215	T15 torx	
8	6921241	CS-10-25 cartridge screw	

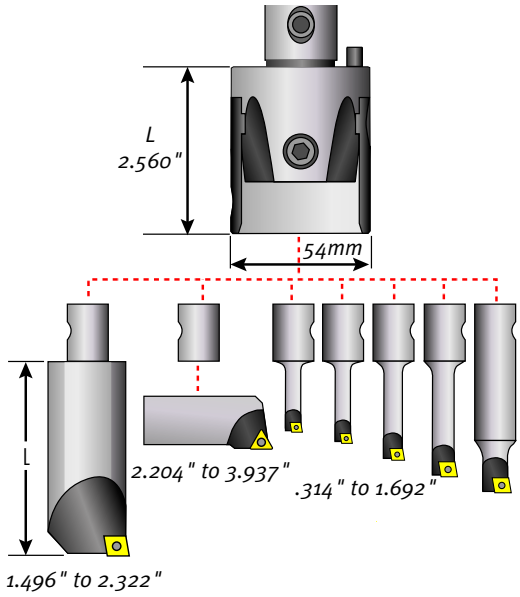
Kit Boring Bar and Insert Specifications

		Bore Range					
Part No.	Boring Bar Description	Min	Max	L	Insert	Insert Screw	Wrench
6943333	BS-06-16-T01	.314"	1.181"	.984"	TCMT 1.21._	6811220	9355111
6943334	BS-08-16-T01	.394"	1.260"	1.378"	TCMT 1.21._	6811235	9355111
6943335	BS-10-16-T02	.512"	1.378"	1.772"	TCMT 1.81.5_	6811250	9355222
6943336	BS-12-16-T02	.630"	1.496"	2.244"	TCMT 1.81.5_	6811250	9355222
6943337	BS-16-16-T02	.787"	1.692"	2.874"	TCMT 1.81.5_	6811250	9355222
6943338	BS-34-16-T04	1.496"	2.322"	3.228"	TCMT 32.5_	6811260	9355555
6922243	BS-2CT-T04 cartridge	2.204"	3.937"	.787"	TCMT 32.5_	6811260	9355555

BohrSTAR 100 Rhombic Kit – Range: 0.314" to 3.94"

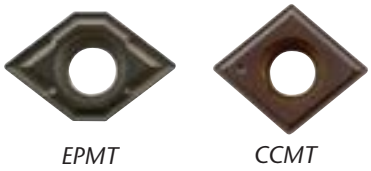


Kit Part No.	Description	Range
6991220	BS-54-KIT-RC-8-100	0.314" – 3.94"



Kit Includes Rhombic Inserts:

- 1 Pc. EPMT 1.5_
- 3 Pcs. CCMT 21.5_
- 3 Pcs. CCMT 32.5_



EPMT *CCMT*

BohrSTAR kits are designed for maximum performance and ease-of-use (no spacers or complicated set-ups). Our boring tools out perform all others when it comes to accuracy, rigidity, and repeatability.

Our exclusive, modular coupling system features two, tapered locking screws that provide maximum rigidity between the boring head and the toolholder to increase accuracy. All connections are easily made using the tools provided.

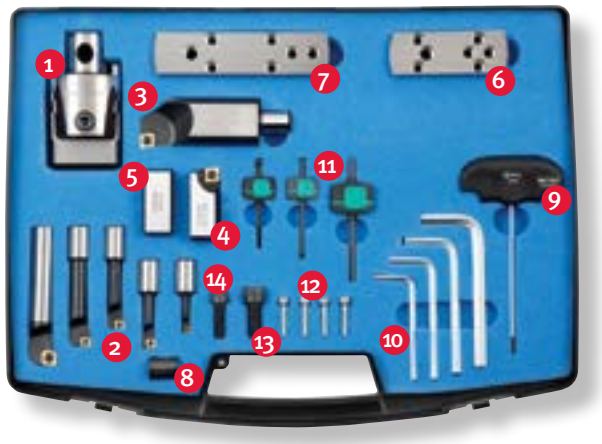
BohrSTAR 100 Kit Includes These Components

	Part No.	Description	Length
1	6951234	BS-54-16-W Head	.2560"
2	6942234	BS-06-16-R02 6mm bar	.984"
	6942235	BS-08-16-R03 8mm bar	1.378"
	6942236	BS-10-16-R03 10mm bar	1.772"
	6942237	BS-12-16-R03 12mm bar	2.244"
	6942238	BS-16-16-R04 16mm bar	2.874"
3	6942239	BS-34-16-R04 34mm bar	3.228"
4	6922243	BS-2CT-R04 Cartridge	.787"
5	6921239	BS-16-M10 Location sleeve	
6	6962233	H3 Hex	
	6962235	H5 Hex	
	6962236	H6 Hex	
	6962238	H8 Hex	
7	6972238	T8 Torx	
	6972237	T7 Torx	
	6972215	T15 Torx	
8	6921241	CS-10-25 Cartridge screw	

Kit Boring Bar and Insert Specifications

		Bore Range					
Part No.	Description	Min	Max	L	Insert	Insert Screw	Wrench
6942234	BS-06-16-R02	.314"	1.181"	.984"	EPMT 1.53._	6811220	9355222
6942235	BS-08-16-R03	.394"	1.260"	1.378"	CCMT 21.5_	6811235	9355333
6942236	BS-10-16-R03	.512"	1.378"	1.772"	CCMT 21.5_	6811250	9355333
6942237	BS-12-16-R03	.630"	1.496"	2.244"	CCMT 21.5_	6811250	9355333
6942238	BS-16-16-R04	.787"	1.692"	2.874"	CCMT 32.5_	6811260	9355555
6942239	BS-34-16-R04	1.496"	2.322"	3.228"	CCMT 32.5_	6811260	9355555
6922243	BS-2CT-R04 Cartridge	2.204"	3.937"	.787"	CCMT 32.5_	6811260	9355555

BohrSTAR 170 Rhombic Kit – Range: 0.314" to 6.69"



Kit Includes Rhombic Inserts:

- *1 Pc. EPMT 1.5_*
- *3 Pcs. CCMT 21.5_*
- *3 Pcs. CCMT 32.5_*



EPMT



CCMT

Kit Part No.	Description	Range
6991230	BS-54-KIT-RC-8-170	0.314" – 6.69"

NOTE: For a triangular insert version of this kit, range: 0.314" - 6.692" order: Part No. 6991250.

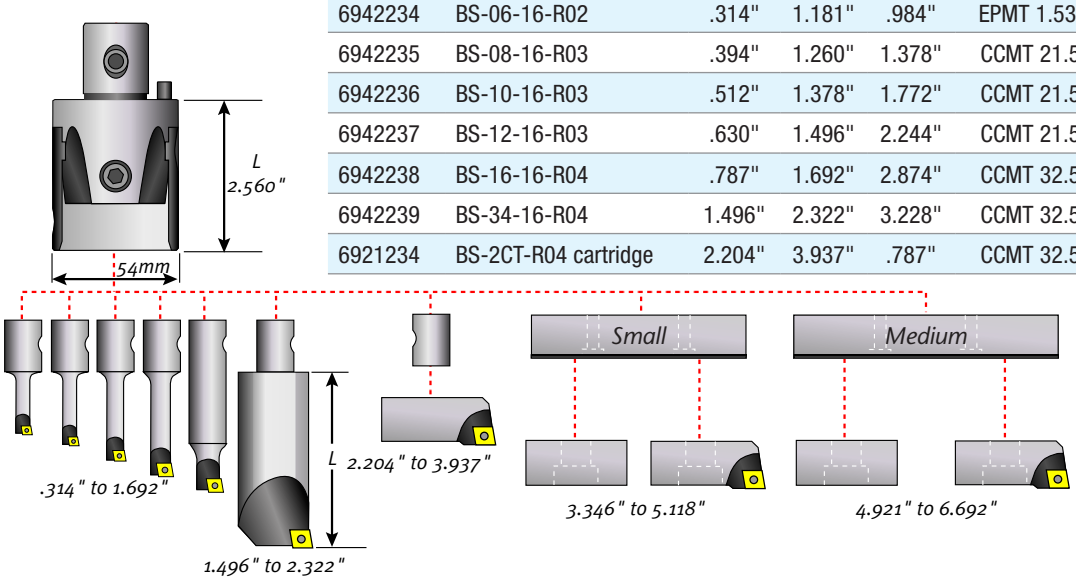
BohrSTAR 170 Kit Includes These Components

	Part No.	Description	Length
1	6951234	BS-54-16-W head	2.560"
2	6942234	BS-06-16-R02 6mm bar	.984"
	6942235	BS-08-16-R03 8mm bar	1.378"
	6942236	BS-10-16-R03 10mm bar	1.772"
	6942237	BS-12-16-R03 12mm bar	2.244"
	6942238	BS-16-16-R04 16mm bar	2.874"
3	6942239	BS-34-16-R04 34mm bar	3.228"
4	6921234	BS-2CT-R04 cartridge	.787"
5	6921235	BS-2CW counterweight	.728"
6	6921236	BS-SP-83-130 small plate	.787"
7	6921237	BS-SP-123-170 medium plate	.787"
8	6921239	BS-16-M10 location sleeve	-

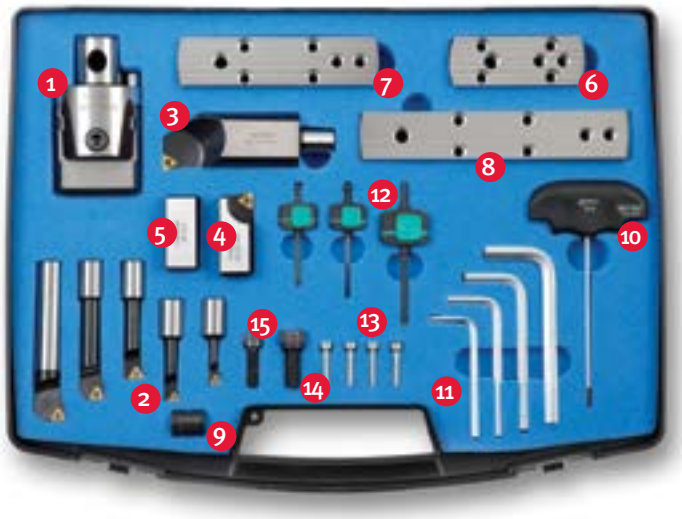
	Part No.	Description
9	6921243	A3 adjusting key
10	6962234	H4 hex
	6962235	H5 hex
	6962236	H6 hex
	6962238	H8 hex
11	6972237	T7 torx
	6972238	T8 torx
	6972215	T15 torx
12	6921240	D-27-21 plate fixing screws
13	6921241	CS-10-25 cartridge screw
14	6921242	CS-08-25 counterweight screw

Kit Boring Bar and Insert Specifications

		Bore Range					
Part No.	Description	Min	Max	L	Insert	Insert Screw	Wrench
6942234	BS-06-16-R02	.314"	1.181"	.984"	EPMT 1.53._	6811220	9355222
6942235	BS-08-16-R03	.394"	1.260"	1.378"	CCMT 21.5_	6811235	9355333
6942236	BS-10-16-R03	.512"	1.378"	1.772"	CCMT 21.5_	6811250	9355333
6942237	BS-12-16-R03	.630"	1.496"	2.244"	CCMT 21.5_	6811250	9355333
6942238	BS-16-16-R04	.787"	1.692"	2.874"	CCMT 32.5_	6811260	9355555
6942239	BS-34-16-R04	1.496"	2.322"	3.228"	CCMT 32.5_	6811260	9355555
6921234	BS-2CT-R04 cartridge	2.204"	3.937"	.787"	CCMT 32.5_	6811260	9355555



BohrSTAR 210 Triangular Kit – Range: 0.314" to 8.27"



Kit Includes Triangular Inserts:

- *2 Pcs. TCMT 1.21._*
- *3 Pcs. TCMT 1.81._*
- *2 Pcs. TCMT 32.5_*



TCMT

BohrSTAR kits are designed for maximum performance and ease-of-use (no spacers or complicated set-ups). Our boring tools out perform all others when it comes to accuracy, rigidity, and repeatability.

Kit Part No.	Description	Range
6991240	BS-54-KIT-TC-8-210	0.314" – 8.27"

NOTE: For a rhombic insert version of this kit, order: Part No. 6991245.

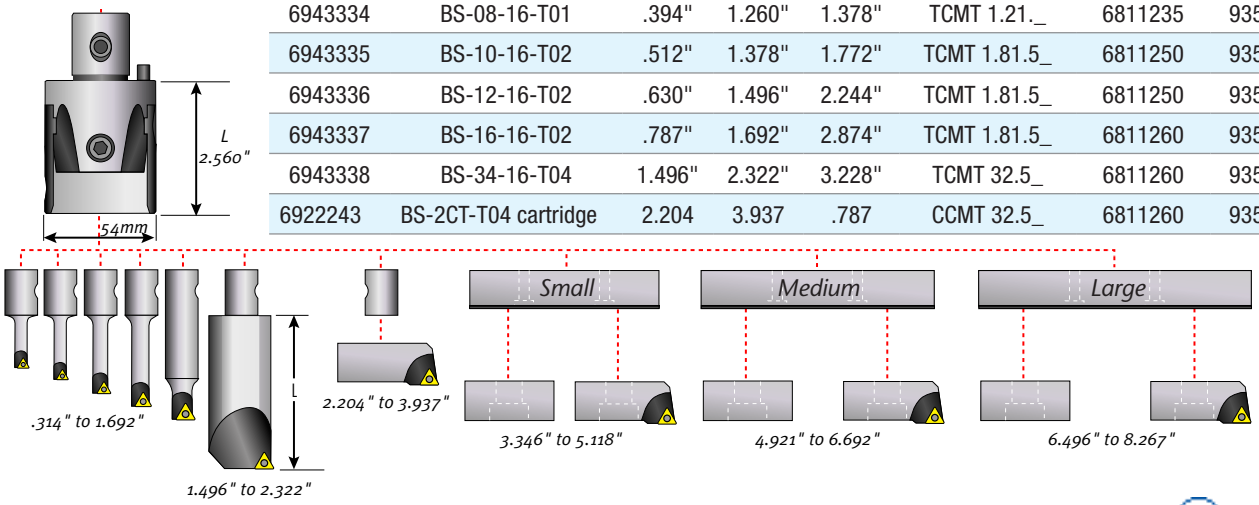
BohrSTAR 210 Kit Includes These Components

	Part No.	Description	Length
1	6951234	BS-54-16-W head	2.560"
2	6943333	BS-06-16-T01 6mm bar	.984"
	6943334	BS-08-16-T01 8mm bar	1.378"
	6943335	BS-10-16-T02 10mm bar	1.772"
	6943336	BS-12-16-T02 12mm bar	2.244"
	6943337	BS-16-16-T02 16mm bar	2.874"
3	6943338	BS-34-16-T04 34mm bar	3.228"
4	6922243	BS-2CT-T04 cartridge	.787"
5	6921235	BS-2CW counterweight	.728"
6	6921236	BS-SP-83-130 small plate	.787"
7	6921237	BS-SP-123-170 medium plate	.787"
8	6921238	BS-SP-165-210 large plate	.787"

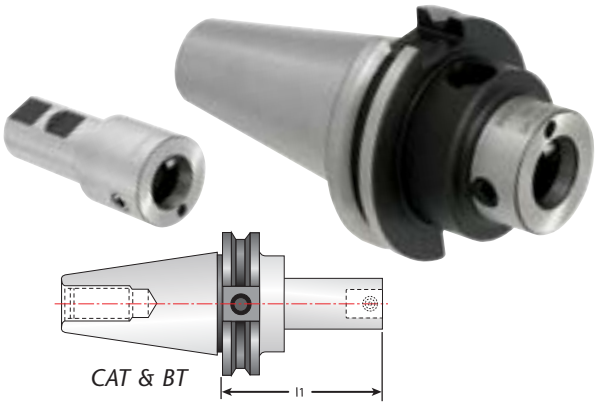
	Part No.	Description
9	6921239	BS-16-M10 location sleeve
10	6921243	A3 adjusting key
11	6962234	H4 hex
	6962235	H5 hex
	6962236	H6 hex
	6962238	H8 hex
12	6972236	T6 torx
	6972237	T7 torx
	6972215	T15 torx
13	6921240	D-27-21 plate fixing screws
14	6921241	CS-10-25 cartridge screw
15	6921242	CS-08-25 counterweight screw

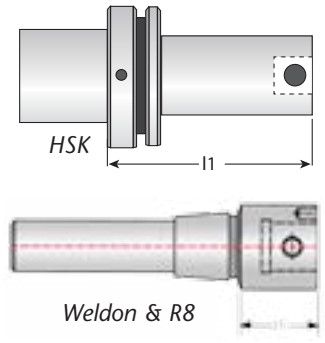
Kit Boring Bar and Insert Specifications

Part No.	Description	Bore Range Min	Bore Range Max	L	Insert	Insert Screw	Wrench
6943333	BS-06-16-T01	.314"	1.181"	.984"	TCMT 1.21._	6811220	9355111
6943334	BS-08-16-T01	.394"	1.260"	1.378"	TCMT 1.21._	6811235	9355111
6943335	BS-10-16-T02	.512"	1.378"	1.772"	TCMT 1.81.5_	6811250	9355222
6943336	BS-12-16-T02	.630"	1.496"	2.244"	TCMT 1.81.5_	6811250	9355222
6943337	BS-16-16-T02	.787"	1.692"	2.874"	TCMT 1.81.5_	6811260	9355222
6943338	BS-34-16-T04	1.496"	2.322"	3.228"	TCMT 32.5_	6811260	9355555
6922243	BS-2CT-T04 cartridge	2.204	3.937	.787	CCMT 32.5_	6811260	9355555



Toolholders and Inserts for BohrSTAR Kits





Features

- *Exceeds industry standards for taper accuracy and concentricity*
- *Use with BohrSTAR kits and 54mm extensions (below)*

CAT40, CAT50 BT40 Toolholders

Part No.	Spindle	Description	l1
6134310	CAT 40	CT-340-54-120	3.00"
6134315	CAT 40	CT-340-54-160	4.57"
6134320	CAT 40	CT-340-54-200	6.14"
6141305	CAT 50	CT-350-54-90	2.44"
6141310	CAT 50	CT-350-54-160	5.20"
6141315	CAT 50	CT-350-54-200	6.77"
6140400	BT 40	BT-340-54-90	2.13"
6140425	BT 40	BT-340-54-160	4.88"
6140450	BT 40	BT-340-54-200	6.46"

Toolholders come with coupling screw installed. Order 6811550 for replacements.

BT50, HSK, Weldon, R8 Toolholders

Part No.	Spindle	Description	l1
6150375	BT 50	BT-350-54-90	2.56"
6150400	BT 50	BT-350-54-160	5.31"
6150425	BT 50	BT-350-54-200	6.90"
6155635	HSK 63	HSK-63A-54-110	2.76"
6155105	HSK 100	HSK-100A-54-110	2.76"
6165343	Weldon	B-20-54-110-3/4	0.75"
6165103	Weldon	B-25-54-110-1.0	1.00"
6165144	Weldon	B-32-54-110-1-1/4	1.25"
6165123	Weldon	B-40-54-110-1-1/2	1.50"
6165805	R8	R8-54-110	1.50"



Extensions

Part No.	Desc.	L
6555450	P-54-50	1.97"
6555475	P-54-75	2.95"

The coolant-thru spindle extension directs coolant to the cutting zone for optimal stock removal rates.

Coolant Extension

Part No.	Desc.	L
6565450	P-54-50R	1.97"

Stock up on high-performance LT1000 PVD Inserts for BohrSTAR Kits!

Features

- *LT1000 PVD is 14 microns thick! (3.5x thicker)*
- *250% longer insert life*
- *Great for exotics and stainless*

We recommend LT1000 or LT10 grade inserts for best performance and extended insert life.



Triangular Inserts for Kits

Part No.	Description	Grade
3533010	TCMT 1.2(1).50	5615
3533020	TCMT 1.2(1)1	5625
3563311	TCMT 1.8(1.5)0 HF	251
3533033	TCMT 1.8(1.5)1 HM	251
3563388	TCMT 1.8(1.5)2 HM	251
3563399	TCMT 1.8(1.5)1 HF	251
3533030	TCMT 1.8(1.5)1 PF4	5625
3564438	TCMT 3(2.5)1 NN	LT 10
3568851	TCMT 3(2.5)1 NN	LT 1000
3564441	TCMT 3(2.5)2 NN	LT 10
3568861	TCMT 3(2.5)2 NN	LT 1000
3533090	TCMT 3(2.5)2 PM4	5625
3561774	TCMT 3(2.5)3 NN	LT 10
3561929	TCMT 3(2.5)3 NN	LT 1000

Rhombic Inserts for Kits

Part No.	Description	Grade
3663311	CCMT 2(1.5)0 HF	251
3664411	CCMT 2(1.5)1 NN	LT 10
3668011	CCMT 2(1.5)1 NN	LT 1000
3663399	CCMT 2(1.5)2 HM	251
3663344	CCMT 3(2.5)0 HF	251
3664413	CCMT 3(2.5)1 NN	LT 10
3668021	CCMT 3(2.5)1 NN	LT 1000
3664416	CCMT 3(2.5)2 NN	LT 10
3668026	CCMT 3(2.5)2 NN	LT 1000
3664419	CCMT 3(2.5)2 WM	LT 10
3934030	EPMT 1.5(3).5 PM5	5625

PinzBOHR High Precision Modular Boring Tools

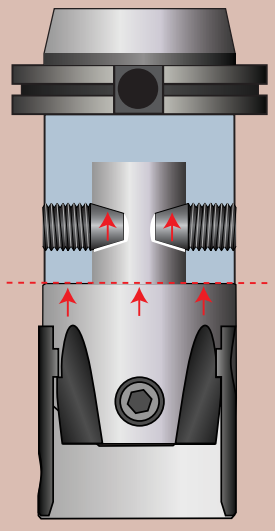
PinzBOHR Modular System

PinzBOHR is a flexible boring system for holes ranging from 0.315" up to 40.157". The system includes all necessary extensions and reducers, rough heads, finish heads and even includes face mill arbors and end mill holder options.



Coupling System

Allows heads to be changed quickly without removing tools from the spindle. Two offset center lock screws apply maximum tightening force between the boring head and the toolholder. This increases rigidity and enhances vibration dampening characteristics.







Carbide & HSS Boring Bars



Boring Heads .945" 19.685"



pg. 194

MacroBOHR range: 8.661" - 40.157"



NEW! UltraFINE finish heads

UltraFINE finish heads are so new we couldn't get them into this catalog!

UltraFINE finish heads feature an 11˚ relief angle that provides an ultra-smooth finish, reducing the need for extra operations.

Scan the QR code or visit the link below for more information about UltraFINE heads.

http://ow.ly/tKQyH

Toolholders for CAT, BT, HSK and more!



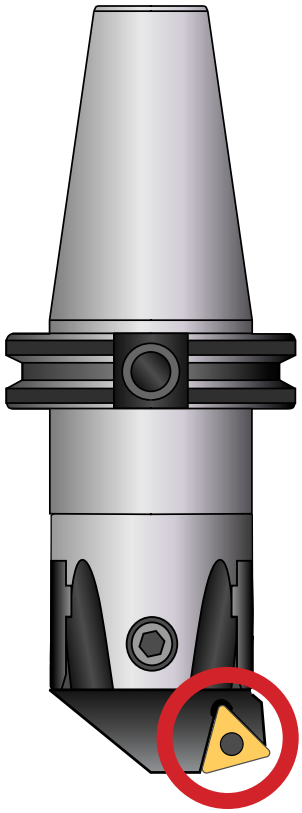
Extensions & Reducers

modular toolholders

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

PinzBOHR Design Provides Best Rigidity and Accuracy

PinzBOHR is more rigid and accurate than other designs



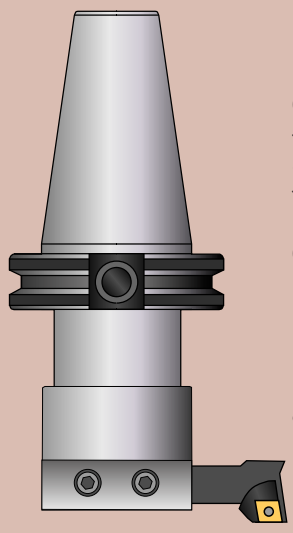
- *Simple and extremely strong design for best reliability, rigidity, and repeatability.*
- *Flexible, modular system reduces tooling inventory.*
- *Top quality steel alloy hardened to 58-60 HRc.*
- *Heads are heat treated to minimize wear.*
- *Precision ground components for highest accuracy.*

PinzBOHR designs the insert pocket integral with the head for maximum strength, rigidity, and insert life.

We put more metal behind the insert for maximum rigidity!

All PinzBOHR heads feature insert pockets that are either integral with the body of the head, or feature integral cartridges to provide maximum rigidity and accuracy.

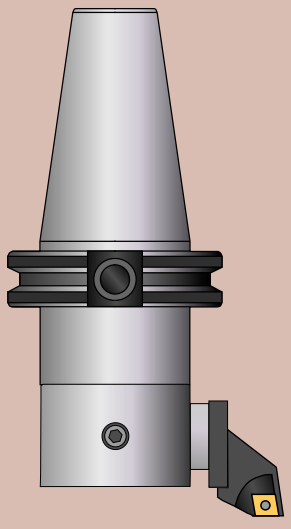
Other Brands



Other Design #1

Bar extension design is an unbalanced, weak solution, extending from the side of the head. Extension is subject to runout during cutting, reducing accuracy and shortening insert life.

PinzBOHR design puts the pocket and insert in the head. This maximizes rigidity and accuracy.



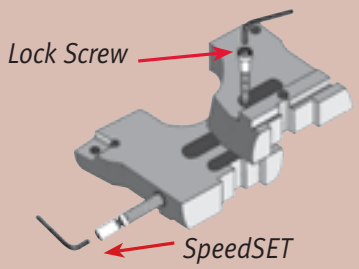
Other Design #2

Dogleg variation is better than above, but also extends beyond the body of the boring head, causing runout.



Ease-of-Use Features

- *SafetySET feature prevents damage to the adjustment screw.*



- *SpeedSET synchronized adjustment for setting of roughing heads.*

Adjustment is This Easy

- *AccuSET graduated dial for fast and easy cutting adjustments in .0001" increments.*

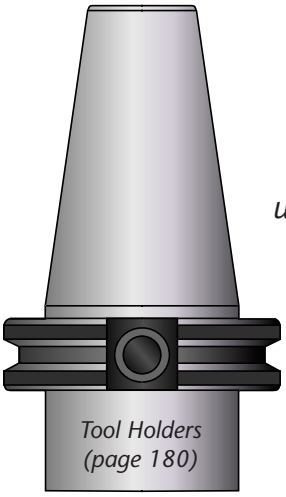


- *.0001" graduated dial allows operators to quickly set the head to any cutting diameter.*

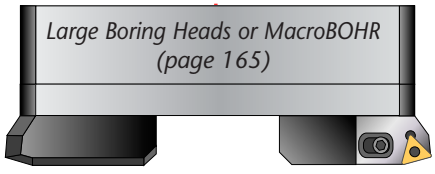
PinzBOHR Modular Boring Tools – Range .315" – 40.157"

Pinzbohr Modular Borring tools feature range from .315 " up to 19.685 '.

For boring holes from 8.661 up to 40.157 " see our MacroBOHR boring tools on page 194



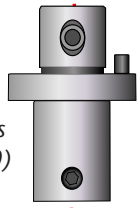
Tool Holders (page 180)



Large Boring Heads or MacroBOHR (page 165)



Extensions (page 190)



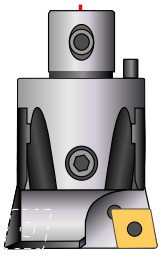
Reducers (page 191)



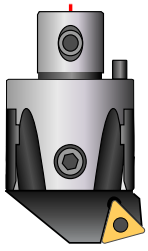
Chamfer Head (page 191)



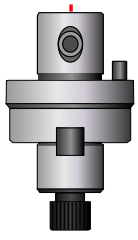
Micro Heads (page 167)



Rough Heads (page 168)

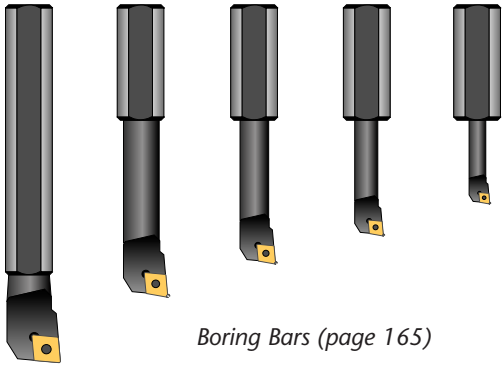


Finish Heads (page 172)





Shell mill and End mill holders (page 192



Boring Bars (page 165)

MacroBOHR Modular Boring System

For large diameter boring, MacroBOHR features a boring range up to 40". (pg. 194)



Boring Bars – Use With Micro Head A-42-016



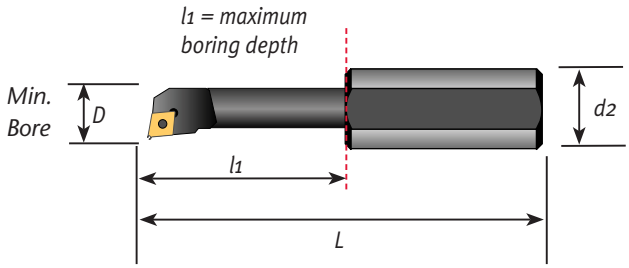
Features

- *16mm shanks for A-42-016 micro head*
- *Manufactured from HSS or Carbide*
- *Precision ground shank*

Inserts and Cartridges pg. 176 | Toolholders pg. 180 | Extensions & Reducers pg. 190 | Retention Knobs pg. 204

5:1 length-to-diameter ratios can be achieved when roughing with steel bars. 3:1 length-to-diameter ratios can be achieved when finishing with steel bars.

The shortest bar overhang possible should be used to maximize results.



HSS Boring Bars for Micro Head A-42-016

Part No.	Description	Min. Bore	d2 (mm)	L	(l1)	Insert	Screw	Wrench
6711225	S06-16SELPR-04	.315"	16	2.598"	.984"	EPGT 1.21._L	6811210	9355111
6711235	S06-16SELPR-05	.315"	16	2.598"	.984"	EPMT 1.53._	6811220	9355111
6722225	S06-16STFCR-06	.315"	16	2.598"	.984"	TCMT 1.21._	6811215	9355111
6711245	S08-16SCLCR-06	.394"	16	2.992"	1.377"	CCMT 21.5_	6811235	9355222
6722235	S08-16STFCR-06	.394"	16	2.992"	1.377"	TCMT 1.21._	6811215	9355111
6711255	S10-16SCLCR-06	.512"	16	3.386"	1.771"	CCMT 21.5_	6811250	9355222
6722245	S10-16STFCR-09	.512"	16	3.386"	1.771"	TCMT 1.81.5_	6811230	9355222
6711265	S12-16SCLCR-06	.630"	16	3.858"	2.244"	CCMT 21.5_	6811255	9355222
6722255	S12-16STFCR-09	.630"	16	3.858"	2.244"	TCMT 1.81.5_	6811230	9355222
6711275	S16-16SCLCR-09	.787"	16	4.488"	2.874"	CCMT 32.5_	6811260	9355555
6722265	S16-16STFCR-09	.787"	16	4.488"	2.874"	TCMT 1.81.5_	6811230	9355222
6722275	S16-16STFCR-16	.787"	16	4.488"	2.874"	TCMT 32.5_	6811260	9355555

Carbide Boring Bar for Micro Head A-42-016

Part No.	Description	Min. Bore	d2 (mm)	L	(l1)	Insert	Screw	Wrench
6733265	C16L-SCLCR-09	.787"	16	5.512"	4.409"	CCMT 32.5_	6811260	T15

Boring Bars – Carbide or HSS Shank



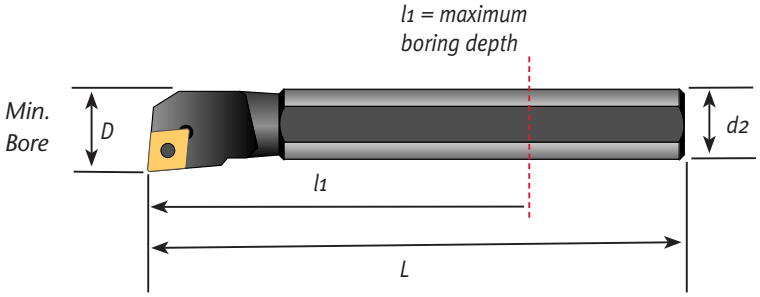
Features

- *Minimum bore .315"*
- *Maximum bore 1.496"*
- *Carbide or HSS*

Usage

- *7:1 length-to-diameter ratios can be achieved with carbide bars*
- *5:1 for roughing with steel bars*
- *3:1 for finishing with steel bars*

Select a boring bar with a "d2" dimension that matches the "d2" of the head.



Carbide Shank Boring Bars

Part No.	Description	Micro Head	Min. Bore	d2	L	(l1)	Insert	Screw	Wrench
6733225	C06F-SELPR-04	A-27-006	.315"	6mm	3.150"	2.204"	EPGT1.21._L	6811210	T6
6733230	C06-08H-SELPR-05	A-27-008 or A-32-008	.315"	8mm	3.150"	2.204"	EMPT1.53._	6811210	T6
6733235	C08G-SCLCR-06	A-27-008 or A-32-008	.394"	8mm	3.543"	2.362"	CCMT21.5_	6811235	T7
6733245	C10J-SCLCR-06	A-32-010 or A-42-010	.512"	10mm	4.331"	2.913"	CCMT21.5_	6811250	T7
6733255	C12K-SCLCR-06	A-42-012	.630"	12mm	4.921"	3.503"	CCMT21.5_	6811255	T7
6733265	C16L-SCLCR-09	A-42-016	.787"	16mm	5.512"	4.094"	CCMT32.5_	6811260	T15

HSS Shank Boring Bars

Part No.	Description	Micro Head	Min. Bore	d2	L	(l1)	Insert	Screw	Wrench
6733227	S06E-SELPR-04	A-27-006	.315"	6mm	2.756"	1.811"	EPGT1.21._L	6811210	T6
6733232	S06E-SELPR-05	A-27-006	.315"	6mm	2.756"	1.811"	EMPT1.53._	6811210	T6
6733237	S08F-SCLCR-06	A-27-008 & A32-008	.394"	8mm	3.150"	1.968"	CCMT21.5_	6811235	T7
6733247	S10G-SCLCR-06	A-32-010 & A42-010	.512"	10mm	3.543"	2.125"	CCMT21.5_	6811250	T7
6733257	S12H-SCLCR-06	A-42-012	.630"	12mm	3.937"	2.519"	CCMT21.5_	6811255	T7
6733267	S16J-SCLCR-09	A-42-016	.787"	16mm	4.331"	2.913"	CCMT32.5_	6811260	T15

Micro Heads for Carbide or HSS Boring Bars



Features

- *AccuSET .0001" graduated dial allows fast and easy adjustments*
- *Tapered nose improves clearance*
- *Two offset center lock screws maximize rigidity while still permitting fast tool changes*

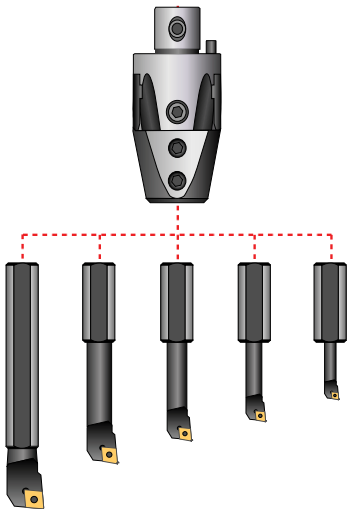

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Toolholders pg. 180


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Retention Knobs pg. 204

Micro Heads available in 5 shank sizes for carbide and HSS boring bars.



Adjustment Is This Easy

AccuSET graduated adjustment dial



Adjustable in 0.0001" increments

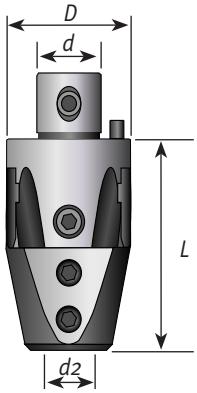
Metric dials available

.0001" dial allows operators to quickly set the finish head to any diameter.

Procedure:

1. Loosen locking screw
2. Remove any backlash
3. Rotate scale to desired setting
4. Tighten locking screw

Select a micro head with a "d2" dimension that matches the "d2" of the boring bar. (see page 166)



AccuSET Micro Heads

Part No.	Description	Range Min	Range Max	D (mm)	d (mm)	d2 (mm)	L
6011000	A-27-006	.315"	.787"	27	15	6	1.97"
6011050	A-27-008	.394"	.827"	27	15	8	1.97"
6011100	A-32-008	.394"	.827"	32	18	8	2.28"
6011150	A-32-010	.512"	.984"	32	18	10	2.28"
6011200	A-42-010	.512"	1.142"	42	24	10	2.76"
6011250	A-42-012	.63"	1.339"	42	24	12	2.76"
6011300	A-42-016	.787"	1.496"	42	24	16	2.76"

Note: All wrenches are included with each boring head. No special tools are needed.

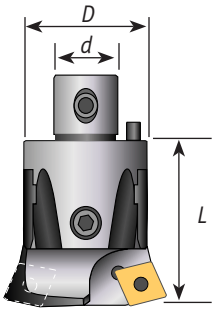
75° Lead Angle Rough Heads – Range .945" up to 8.661"



Integral pocket type

Features

- *SpeedSET feature adjusts both slides at once and slides won't lose position during adjustment*
- *SafetySET feature prevents accidental damage to adjustment screw. See page 163*
- *Two insert pockets for faster cutting and better accuracy*





Cartridge type rough head

75° Integral Pocket Rough Heads

Part No.	Description	Range Min	Range Max	D (mm)	d (mm)	L	Insert	Screw
6275100	D-22-75-400	.945"	1.181"	22	12	1.39"	CCMT 21.5_	6811250
6275105	D-27-75-409	1.142"	1.575"	27	15	1.65"	CCMT 32.5_	6811260
6275115	D-32-75-409	1.535"	1.969"	32	18	1.77"	CCMT 32.5_	6811260
6275120	D-42-75-300	1.929"	2.559"	42	24	2.20"	TCMT 1.81._	6811262
6275125	D-42-75-402	1.929"	2.559"	42	24	2.20"	CCMT 43_	6811266
6275130	D-42-75-402N	2.087"	2.559"	42	24	2.20"	CNMG 43_	6811270
6275135	D-54-75-300	2.48"	3.228"	54	28	2.60"	TCMT 1.81._	6811262
6275140	D-54-75-402	2.48"	3.228"	54	28	2.60"	CCMT 43_	6811 266
6275145	D-54-75-402N	2.48"	3.228"	54	28	2.60"	CNMG 43_	6811270

75° Cartridge Type Rough Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6275150	D-68-75-2CT-300	3.15"	4.016"	2CT-75-300	68	36	3.39"	TCMT 1.81.5_	6811262
6275155	D-68-75-2CT-402	3.15"	4.016"	2CT-75-402	68	36	3.39"	CCMT 43_	6811266
6275160	D-68-75-2CT-402N	3.15"	4.016"	2CT-75-402N	68	36	3.39"	CNMG 43_	6811270
6275165	D-85-75-3CT-300	3.937"	4.921"	3CT-75-300	85	50	3.94"	TCMT 32.5_	6811262
6275170	D-85-75-3CT-402	3.937"	4.921"	3CT-75-402	85	50	3.94"	CCMT 43_	6811266
6275175	D-85-75-3CT-402N	3.937"	4.921"	3CT-75-402N	85	50	3.94"	CNMG 43_	6811270
6275180	D-100-75-3CT-300	4.921"	6.299"	3CT-75-300	110	60	3.94"	TCMT 32.5_	6811262
6275185	D-100-75-3CT-402	4.921"	6.299"	3CT-75-402	110	60	3.94"	CCMT 43_	6811266
6275190	D-100-75-3CT-402N	4.921"	6.299"	3CT-75-402N	110	60	3.94"	CNMG 43_	6811270
6275195	D-200-75-3CT-300	6.299"	8.661"	2CT-75-300	145	60	3.94"	TCMT 32.5_	6811262
6275200	D-200-75-3CT-402	6.299"	8.661"	3CT-75-402	145	60	3.94"	CCMT 43_	6811266
6275205	D-200-75-3CT-402N	6.299"	8.661"	3CT-75-402N	145	60	3.94"	CNMG 432_	6811270

AccuSET dial not available on small rough heads due to their design differences.

75° Lead Angle Rough Heads – Range 8.661" up to 19.685"



SafetySET feature not available on large boring heads due to their design differences.

Features

- *Two AccuSET .0001" graduated dials allow setting both inserts simultaneously*
- *Top quality steel alloy hardened to 58-60 HRc*
- *Precision ground components for accuracy*

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75° lead angle heads tend to self center in the pilot hole, stabilizing the cut and maximizing stock removal rates.



Use large boring heads with direct mount toolholders or ADT 100-50 adapter and a toolholder with a 100mm connection.

See page 188.

Adjustment Is This Easy

AccuSET graduated adjustment dial



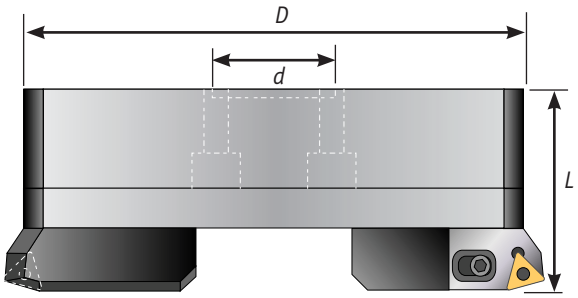
Adjustable in 0.0001" increments

Metric dials available

Two .0001" AccuSET dials allows operators to quickly set both inserts to any diameter simultaneously.

Procedure:

1. Loosen locking screw
2. Remove any backlash
3. Rotate scale to desired setting
4. Tighten locking screw



75° Large Rough Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6275210	D-300-75-3CT-300	8.661"	12.598"	3CT-75-300	202	60	3.54"	TCMT 32.5_	6811262
6275215	D-300-75-3CT-402	8.661"	12.598"	3CT-75-402	202	60	3.54"	CCMT 43_	6811266
6275220	D-300-75-3CT-402N	8.661"	12.598"	3CT-75-402N	202	60	3.54"	CNMG 43_	6811270
6275225	D-400-75-3CT-300	11.417"	15.748"	3CT-75-300	272	60	3.54"	TCMT 32.5_	6811262
6275230	D-400-75-3CT-402	11.417"	15.748"	3CT-75-402	272	60	3.54"	CCMT 43_	6811266
6275235	D-400-75-3CT-402N	11.417"	15.748"	3CT-75-402N	272	60	3.54"	CNMG 43_	6811270
6275240	D-500-75-3CT-300	14.567"	19.685"	3CT-75-300	352	60	3.54"	TCMT 32.5_	6811262
6275245	D-500-75-3CT-402	14.567"	19.685"	3CT-75-402	352	60	3.54"	CCMT 43_	6811266
6275250	D-500-75-3CT-402N	14.567"	19.685"	3CT-75-402N	352	60	3.54"	CNMG 43_	6811270

SafetySET feature not available on large boring heads due to their design differences.

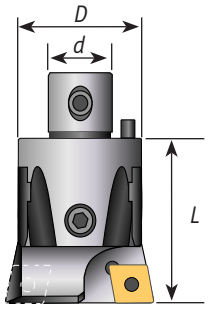
90° Lead Angle Rough Heads – Range .945" up to 8.661"



Integral pocket type

Features

- *SpeedSET feature adjusts both slides at once and slides won't lose position during adjustment*
- *SafetySET feature prevents accidental damage to the adjustment screw. See page 163*
- *Two insert pockets for faster metal removal*





Cartridge type rough head

90° Integral Pocket Type Rough Heads

Part No.	Description	Range Min	Range Max	D (mm)	d (mm)	L	Insert	Screw
6390100	D-22-90-400	.945"	1.181"	22	12	1.39"	CCMT 21.5_	6811250
6390105	D-27-90-409	1.142"	1.575"	27	15	1.65"	CCMT 32.5_	6811260
6390110	D-32-90-409	1.535"	1.969"	32	18	1.77"	CCMT 32.5_	6811260
6390115	D-42-90-300	1.929"	2.559"	42	24	2.20"	TCMT 32.5_	6811262
6390120	D-42-90-402	1.929"	2.559"	42	24	2.20"	CCMT 43_	6811266
6390125	D-42-90-402N	2.087"	2.559"	42	24	2.20"	CNMG 43_	6811270
6390130	D-54-90-300	2.48"	3.228"	54	28	2.60"	TCMT 32.5_	6811262
6390135	D-54-90-402	2.48"	3.228"	54	28	2.60"	CCMT 43_	6811266
6390140	D-54-90-402N	2.48"	3.228"	54	28	2.60"	CNMG 43_	6811270

90° Cartridge Type Rough Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6390145	D-68-90-2CT-300	3.15"	4.016"	2CT-90-300	68	36	3.39"	TCMT 32.5_	6811262
6390150	D-68-90-2CT-402	3.15"	4.016"	2CT-90-402	68	36	3.39"	CCMT 43_	6811266
6390155	D-68-90-2CT-402N	3.15"	4.016"	2CT-90-402N	68	36	3.39"	CNMG 43_	6811270
6390160	D-85-90-3CT-300	3.937"	4.921"	3CT-90-300	85	50	3.94"	TCMT 32.5_	6811262
6390165	D-85-90-3CT-402	3.937"	4.921"	3CT-90-402	85	50	3.94"	CCMT 43_	6811266
6390170	D-85-90-3CT-402N	3.937"	4.921"	3CT-90-402N	85	50	3.94"	CNMG 43_	6811270
6390175	D-100-90-3CT-300	4.921"	6.299"	3CT-90-300	110	60	3.94"	TCMT 32.5_	6811262
6390180	D-100-90-3CT-402	4.921"	6.299"	3CT-90-402	110	60	3.94"	CCMT 43_	6811266
6390185	D-100-90-3CT-402N	4.921"	6.299"	3CT-90-402N	110	60	3.94"	CNMG 43_	6811270
6390190	D-200-90-3CT-300	6.299"	8.661"	2CT-90-300	145	60	3.94"	TCMT 32.5_	6811262
6390200	D-200-90-3CT-402	6.299"	8.661"	3CT-90-402	145	60	3.94"	CCMT 43_	6811266
6390205	D-200-90-3CT-402N	6.299"	8.661"	3CT-90-402N	145	60	3.94"	CNMG 43_	6811270

AccuSET, feature not available on large boring heads due to their design differences.

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

90° Lead Angle Rough Heads – Range 8.661" up to 19.685"



SafetySET feature not available on large boring heads due to their design differences.

Features

- *Two AccuSET .0001" graduated dials allow setting both inserts simultaneously*
- *Top quality steel alloy hardened to 58-60 HRc*
- *Precision ground components for accuracy*

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Use 90° lead angle heads when performing blind boring, or if the desired hole is not exactly on center with your pilot hole. The 90° lead will have less tendency to follow the pilot hole.

Adjustment Is This Easy

AccuSET graduated adjustment dial



Adjustable in 0.0001" increments

Metric dials available

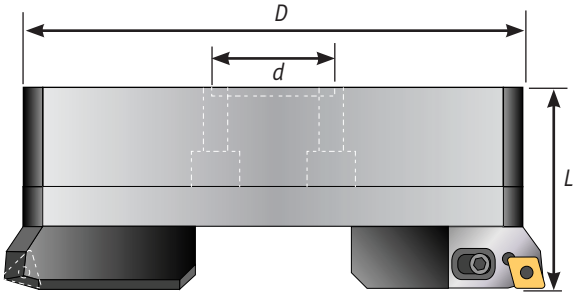
Two .0001" AccuSET dials allows operators to quickly set both inserts to any diameter simultaneously.

Procedure:

1. Loosen locking screw
2. Remove any backlash
3. Rotate scale to desired setting
4. Tighten locking screw



Use large boring heads with direct mount toolholders or ADT 100-50 adapter and a toolholder with a 100mm connection. See "Toolholders for Large Boring Heads" on page 188.



90° Large Rough Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6390210	D-300-90-3CT-300	8.661"	12.598"	3CT-90-300	202	60	3.54"	TCMT 32.5_	6811262
6390215	D-300-90-3CT-402	8.661"	12.598"	3CT-90-402	202	60	3.54"	CCMT 43_	6811266
6390220	D-300-90-3CT-402N	8.661"	12.598"	3CT-90-402N	202	60	3.54"	CNMG 43_	6811270
6390225	D-400-90-3CT-300	11.417"	15.748"	3CT-90-300	272	60	3.54"	TCMT 32.5_	6811262
6390230	D-400-90-3CT-402	11.417"	15.748"	3CT-90-402	272	60	3.54"	CCMT 43_	6811266
6390235	D-400-90-3CT-402N	11.417"	15.748"	3CT-90-402N	272	60	3.54"	CNMG 43_	6811270
6390240	D-500-90-3CT-300	14.567"	19.685"	3CT-90-300	352	60	3.54"	TCMT 32.5_	6811262
6390245	D-500-90-3CT-402	14.567"	19.685"	3CT-90-402	352	60	3.54"	CCMT 43_	6811266
6390250	D-500-90-3CT-402N	14.567"	19.685"	3CT-90-402N	352	60	3.54"	CNMG 43_	6811270

SafetySET feature not available on large boring heads due to their design differences.

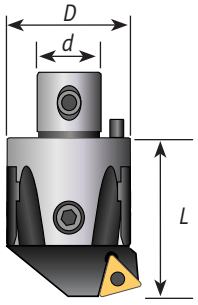
75° Lead Angle Finish Heads – Range .945" up to 8.661"



Integral pocket type

Features

- *Spring-loaded slide won't lose position during adjustment*
- *AccuSET .0001" graduated dial allows fast and easy adjustments*
- *Designed for maximum rigidity and accuracy*





Cartridge type



UltraFINE finish heads are so new we couldn't get them into this catalog!

UltraFINE finish heads feature an 11° relief angle that provides an ultra-smooth finish, reducing the need for extra operations.

Scan the QR code or visit the link below for more information about UltraFINE heads.

http://ow.ly/tKQyH

75° Integral Pocket Type Finish Heads

Part No.	Description	Range Min	Range Max	D (mm)	d (mm)	L	Insert	Screw
6275255	A-22-75-400	.945"	1.181"	22	12	1.39"	CCMT 21.5_	6811250
6275260	A-27-75-409	1.142"	1.575"	27	15	1.65"	CCMT 32.5_	6811260
6275265	A-32-75-409	1.535"	1.969"	32	18	1.77"	CCMT 32.5_	6811260
6275270	A-42-75-300	1.929"	2.559"	42	24	2.20"	TCMT 32.5_	6811262
6275275	A-54-75-300	2.48"	3.228"	54	28	2.60"	TCMT 32.5_	6811262

75° Cartridge Type Finish Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6275280	A-68-75-2CT-300	3.15"	4.016"	2CT-75-300	68	36	3.39"	TCMT 32.5_	6811262
6275285	A-68-75-2CT-402	3.15"	4.016"	2CT-75-402	68	36	3.39"	CCMT 43_	6811266
6275290	A-68-75-2CT-402N	3.15"	4.016"	2CT-75-402N	68	36	3.39"	CNMG 43_	6811270
6275295	A-85-75-3CT-300	3.937"	4.921"	3CT-75-300	85	50	3.94"	TCMT 32.5_	6811262
6275300	A-85-75-3CT-402	3.937"	4.921"	3CT-75-402	85	50	3.94"	CCMT 43_	6811266
6275305	A-85-75-3CT-402N	3.937"	4.921"	3CT-75-402N	85	50	3.94"	CNMG 43_	6811270
6275310	A-100-75-3CT-300	4.921"	6.299"	3CT-75-300	110	60	3.94"	TCMT 32.5_	6811262
6275315	A-100-75-3CT-402	4.921"	6.299"	3CT-75-402	110	60	3.94"	CCMT 43_	6811266
6275320	A-100-75-3CT-402N	4.921"	6.299"	3CT-75-402N	110	60	3.94"	CNMG 43_	6811270
6275325	A-200-75-3CT-300	6.299"	8.661"	2CT-75-300	145	60	3.94"	TCMT 32.5_	6811262
6275330	A-200-75-3CT-402	6.299"	8.661"	3CT-75-402	145	60	3.94"	CCMT 43_	6811266
6275335	A-200-75-3CT-402N	6.299"	8.661"	3CT-75-402N	145	60	3.94"	CNMG 43_	6811270

75° Lead Angle Finish Heads – Range 8.661" up to 19.685"



Features

- *AccuSET .0001" graduated dial for easy adjustments*
- *Designed for maximum rigidity and accuracy*
- *Top quality steel alloy hardened to 58-60 HRc*

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75° lead angle head tends to self-center in the pilot hole, stabilizing the cut and maximizing stock removal rates.



Use large boring heads with direct mount toolholders or ADT 100-50 adapter and a toolholder with a 100mm connection. See page 188.

Adjustment Is This Easy

AccuSET graduated adjustment dial



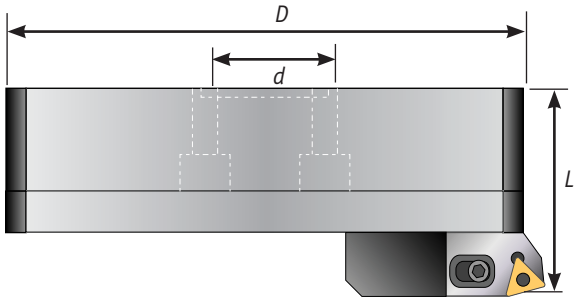
Adjustable in 0.0001" increments

Metric dials available

.0001" dial allows operators to quickly set the finish head to any diameter.

Procedure:

1. Loosen locking screw
2. Remove any backlash
3. Rotate scale to desired setting
4. Tighten locking screw



75° Large Finish Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6275340	A-300-75-3CT-300	8.661"	12.598"	3CT.75.300	202	60	3.54"	TCMT 32.5_	6811262
6275345	A-300-75-3CT-402	8.661"	12.598"	3CT.75.402	202	60	3.54"	CCMT 43_	6811266
6275350	A-300-75-3CT-402N	8.661"	12.598"	3CT.75.402N	202	60	3.54"	CNMG 43_	6811270
6275355	A-400-75-3CT-300	11.417"	15.748"	3CT.75.300	272	60	3.54"	TCMT 32.5_	6811262
6275360	A-400-75-3CT-402	11.417"	15.748"	3CT.75.402	272	60	3.54"	CCMT 43_	6811266
6275365	A-400-75-3CT-402N	11.417"	15.748"	3CT.75.402N	272	60	3.54"	CNMG 43_	6811270
6275370	A-500-75-3CT-300	14.567"	19.685"	3CT.75.300	352	60	3.54"	TCMT 32.5_	6811262
6275375	A-500-75-3CT-402	14.567"	19.685"	3CT.75.402	352	60	3.54"	CCMT 43_	6811266
6275380	A-500-75-3CT-402N	14.567"	19.685"	3CT.75.402N	352	60	3.54"	CNMG 43_	6811270

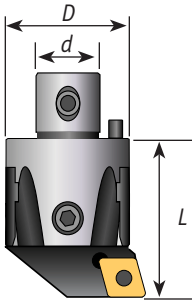
90° Lead Angle Finish Heads – Range .945" up to 8.661"



Features

- *Spring-loaded slide won't lose position during adjustment*
- *AccuSET .0001" graduated dial for fast & easy adjustments*
- *Designed for maximum rigidity and accuracy*

Integral pocket type



Cartridge type





UltraFINE finish heads are so new we couldn't get them into this catalog!

UltraFINE finish heads feature an 11° relief angle that provides an ultra-smooth finish, reducing the need for extra operations.

Scan the QR code or visit the link below for more information about UltraFINE heads.

http://ow.ly/tKQyH

90° Integral Pocket Type Finish Heads

Part No.	Description	Range Min	Range Max	D (mm)	d (mm)	L	Insert	Screw
6390255	A-22-90-400	.945"	1.181"	22	12	1.39"	CCMT 21.5_	6811250
6390260	A-27-90-409	1.142"	1.575"	27	15	1.65"	CCMT 32.5_	6811260
6390265	A-32-90-300	1.535"	1.969"	32	18	1.77"	TCMT 32.5_	6811262
6390270	A-32-90-409	1.535"	1.969"	32	18	1.77"	CCMT 32.5_	6811260
6390275	A-42-90-300	1.929"	2.559"	42	24	2.20"	TCMT 32.5_	6811262
6390280	A-42-90-402	1.929"	2.559"	42	24	2.20"	CCMT 43_	6811266
6390285	A-42-90-402N	2.087"	2.559"	42	24	2.20"	CNMG 43_	6811270
6390290	A-54-90-300	2.48"	3.228"	54	28	2.60"	TCMT 32.5_	6811262
6390295	A-54-90-402	2.48"	3.228"	54	28	2.60"	CCMT 43_	6811266
6390300	A-54-90-402N	2.48"	3.228"	54	28	2.60"	CNMG 43_	6811270

90° Cartridge Type Finish Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6390305	A-68-90-2CT-300	3.15"	4.016"	2CT-90-300	68	36	3.39"	TCMT 32.5_	6811262
6390310	A-68-90-2CT-402	3.15"	4.016"	2CT-90-402	68	36	3.39"	CCMT 43_	6811266
6390315	A-68-90-2CT-402N	3.15"	4.016"	2CT-90-402N	68	36	3.39"	CNMG 43_	6811270
6390320	A-85-90-3CT-300	3.937"	4.921"	3CT-90-300	85	50	3.94"	TCMT 32.5_	6811262
6390325	A-85-90-3CT-402	3.937"	4.921"	3CT-90-402	85	50	3.94"	CCMT 43_	6811266
6390330	A-85-90-3CT-402N	3.937"	4.921"	3CT-90-402N	85	50	3.94"	CNMG 43_	6811270
6390335	A-100-90-3CT-300	4.921"	6.299"	3CT-90-300	110	60	3.94"	TCMT 32._	6811262
6390340	A-100-90-3CT-402	4.921"	6.299"	3CT-90-402	110	60	3.94"	CCMT 43_	6811266
6390345	A-100-90-3CT-402N	4.921"	6.299"	3CT-90-402N	110	60	3.94"	CNMG 43_	6811270
6390350	A-200-90-3CT-300	6.299"	8.661"	2CT-90-300	145	60	3.94"	TCMT 32.5_	6811262
6390355	A-200-90-3CT-402	6.299"	8.661"	3CT-90-402	145	60	3.94"	CCMT 43_	6811266
6390360	A-200-90-3CT-402N	6.299"	8.661"	3CT-90-402N	145	60	3.94"	CNMG 43_	6811270

90˚ Lead Angle Finish Heads – Range 8.661" up to 19.685"



Features

- *AccuSET .0001" graduated dial for easy adjustments*
- *Designed for maximum rigidity and accuracy*
- *Top quality steel alloy hardened to 58-60 HRc*

Inserts and Cartridges pg. 176 | Toolholders pg. 180 | Extensions & Reducers pg. 190 | Retention Knobs pg. 204

Use 90˚ lead angle heads when performing blind boring, or if the desired hole is not exactly on center with your pilot hole. The 90˚ lead will have less tendency to follow the pilot hole.



Use large boring heads with direct mount toolholders or ADT 100-50 adapter and a toolholder with a 100mm connection. See page 188.

Adjustment Is This Easy

AccuSET graduated adjustment dial



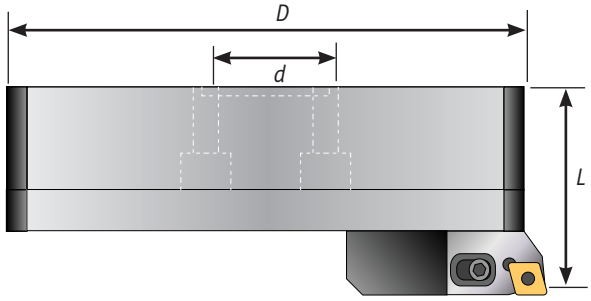
Adjustable in 0.0001" increments

Metric dials available

.0001" dial allows operators to quickly set the finish head to any diameter.

Procedure:

1. Loosen locking screw
2. Remove any backlash
3. Rotate scale to desired setting
4. Tighten locking screw



90˚ Large Finish Heads

Part No.	Description	Range Min	Range Max	Cartridge	D (mm)	d (mm)	L	Insert	Screw
6390365	A-300-90-3CT-300	8.661"	12.598"	3CT-90-300	202	60	3.54"	TCMT 32.5_	6811262
6390370	A-300-90-3CT-402	8.661"	12.598"	3CT-90-402	202	60	3.54"	CCMT 43_	6811266
6390375	A-300-90-3CT-402N	8.661"	12.598"	3CT-90-402N	202	60	3.54"	CNMG 43_	6811270
6390380	A-400-90-3CT-300	11.417"	15.748"	3CT-90-300	272	60	3.54"	TCMT 32.5_	6811262
6390385	A-400-90-3CT-402	11.417"	15.748"	3CT-90-402	272	60	3.54"	CCMT 43_	6811266
6390390	A-400-90-3CT-402N	11.417"	15.748"	3CT-90-402N	272	60	3.54"	CNMG 43_	6811270
6390395	A-500-90-3CT-300	14.567"	19.685"	3CT-90-300	352	60	3.54"	TCMT 32.5_	6811262
6390400	A-500-90-3CT-402	14.567"	19.685"	3CT-90-402	352	60	3.54"	CCMT 43_	6811266
6390405	A-500-90-3CT-402N	14.567"	19.685"	3CT-90-402N	352	60	3.54"	CNMG 43_	6811270

Indexable Cartridges 75° & 90° Lead Angle




75° type 300


75° type 402

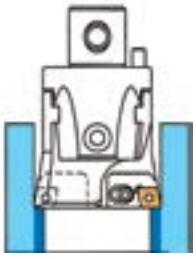

90° type 300

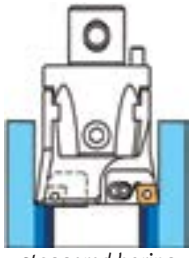

90° type 402

Features

- *Change lead angle or insert style by simply changing cartridges*
- *Precision ground accuracy*
- *Symmetrical or staggered boring*




symmetrical boring


staggered boring

Staggered boring is possible by substituting a staggered cartridge in place of the regular cartridge. This .020" of axial stagger will accommodate most staggered, or "stepped" boring processes. Order staggered cartridges from the table at bottom of page.

75° Lead Angle Cartridges for Symmetrical Boring

Part No.	Description	Insert	1	2	3	4	5	6	7
6675125	2CT-75-300	TCMT 32.5_	D-68-29	A-68-26	D-68-28	H5	H2	6811260	9355555
6675130	2CT-75-402	CCMT 43_	D-68-29	A-68-26	D-68-28	H5	H2	6811266	9355666
6675135	2CT-75-402N	CNMG 43_	D-68-29	A-68-26	D-68-28	H5	H2	6811270	9322116
6675140	3CT-75-300	TCMT 32.5_	D-85-29	D-85-27	D-68-28	H5	H3	6811262	9355555
6675145	3CT-75-402	CCMT 43_	D-85-29	D-85-27	D-68-28	H5	H3	6811266	9355666
6675150	3CT-75-402N	CNMG 43_	D-85-29	D-85-27	D-68-28	H5	H3	6811270	9322116

90° Lead Angle Cartridges for Symmetrical Boring

Part No.	Description	Insert	1	2	3	4	5	6	7
6690125	2CT-90-300	TCMT 32.5_	D-68-29	A-68-26	D-68-28	H5	H2	6811260	9355555
6690130	2CT-90-402	CCMT 43_	D-68-29	A-68-26	D-68-28	H5	H2	6811266	9355666
6690135	2CT-90-402N	CNMG 43_	D-68-29	A-68-26	D-68-28	H5	H2	6811270	9322116
6690140	3CT-90-300	TCMT 32.5_	D-85-29	D-85-27	D-68-28	H5	H3	6811262	9355555
6690145	3CT-90-402	CCMT 43_	D-85-29	D-85-27	D-68-28	H5	H3	6811266	9355666
6690150	3CT-90-402N	CNMG 43_	D-85-29	D-85-27	D-68-28	H5	H3	6811270	9322116

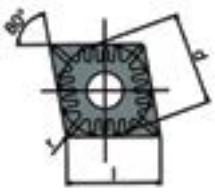
90° Lead Angle Cartridges for Staggered Boring

Part No.	Description	Insert	1	2	3	4	5	6	7
6690155	2CT-90-300S	TCMT 32.5_	D-68-29	A-68-26	D-68-28	H5	H2	6811260	9355555
6690160	2CT-90-402S	CCMT 43_	D-68-29	A-68-26	D-68-28	H5	H2	6811266	9355666
6690165	2CT-90-402NS	CNMG 43_	D-68-29	A-68-26	D-68-28	H5	H2	6811270	9322116
6690170	3CT-90-300S	TCMT 32.5_	D-85-29	D-85-27	D-68-28	H5	H3	6811262	9355555
6690175	3CT-90-402S	CCMT 43_	D-85-29	D-85-27	D-68-28	H5	H3	6811266	9355666
6690180	3CT-90-402NS	CNMG 43_	D-85-29	D-85-27	D-68-28	H5	H3	6811270	9322116

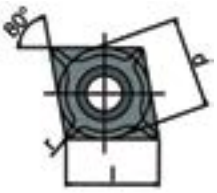
High-Performance Boring Inserts



magia



CNMG insert



CCMT insert



TCMT insert



DCMT insert

Features

- *ISO standard inserts*
- *TCMT, CCMT, CNMG, EPMT, and DCMT*
- *Use Magia LT-1000 grade inserts for extended insert life in all types of materials*

Tech Tips

Roughing:
Use the largest available corner radius unless otherwise specified.

Finish boring:
Use the smallest available corner radius to minimize tool deflection.

Best finish:
Generally start with your feed at 25% of insert nose radius. Optimal speeds and feeds depend upon material, tool overhang, and setup conditions.

We recommend LT1000 grade inserts for maximum insert performance. LT1000 grade features an advanced PVD coating that is 14 microns thick and lasts 250% longer than other inserts.

*Inserts marked in green are for **aluminum & alloys***

Part No.	Description (ANSI)	Description (ISO)	Grade	l	s	r	Operation	magia
3663336	CCGX 2(1.5)1 LH HP	CCGX 060204 LH	101	0.252	0.094	0.016	General	
3663337	CCGX 3(2.5)1 LH HP	CCGX 09T304 LH	101	0.382	0.156	0.016	General	
3663338	CCGX 3(2.5)2 LH HP	CCGX 09T308 LH	101	0.382	0.156	0.031	General	
3663339	CCGX 432 LH HP	CCGX 120408 LH	101	0.508	0.187	0.031	General	
3663311	CCMT 2(1.5)0 HF	CCMT 060202 HF	251	0.252	0.094	0.008	General	
3664411	CCMT 2(1.5)1 NN	CCMT 060204 NN	LT 10	0.254	0.094	0.016	General	
3668011	CCMT 2(1.5)1 NN	CCMT 060204 NN	LT 1000	0.254	0.094	0.016	General	m
3663399	CCMT 2(1.5)2 HM	CCMT 060208 HM	251	0.252	0.094	0.031	General	
3663344	CCMT 3(2.5)0 HF	CCMT 09T302 HF	251	0.382	0.156	0.008	Finishing	
3664413	CCMT 3(2.5)1 NN	CCMT 09T304 NN	LT 10	0.381	0.156	0.016	General	
3668021	CCMT 3(2.5)1 NN	CCMT 09T304 NN	LT 1000	0.381	0.156	0.016	General	m
3664416	CCMT 3(2.5)2 NN	CCMT 09T308 NN	LT 10	0.381	0.156	0.036	General	
3668026	CCMT 3(2.5)2 NN	CCMT 09T308 NN	LT 1000	0.381	0.156	0.036	General	m
3664419	CCMT 3(2.5)2 WM	CCMT 09T308 WM	LT 10	0.381	0.156	0.036	General	
3664422	CCMT 431 NN	CCMT 120404 NN	LT 1000	0.508	0.187	0.016	General	m
3664421	CCMT 431 NN	CCMT 120404 NN	LT 10	0.508	0.187	0.016	General	
3664427	CCMT 432 NN	CCMT 120408 NN	LT 1000	0.508	0.187	0.036	General	m
3664425	CCMT 432 NN	CCMT 120408 NN	LT 10	0.508	0.187	0.036	General	
3664429	CCMT 433 NN	CCMT 120412 NN	LT 1000	0.508	0.187	0.047	General	m
3631083	CCMT 433 NN	CCMT 120412 NN	LT 10	0.508	0.187	0.047	General	
6607901	CNGG 431 ALU	CNGG 120404 ALU	LT 05	0.508	0.187	0.016	General	m
6607905	CNGG 432 ALU	CNGG 120408 ALU	LT 05	0.508	0.187	0.031	General	



CC_ _



CCMT



CN_ _

High-Performance Boring Inserts

*Inserts marked in green are for **aluminum & alloys***
For extended insert life we recommend Magia LT-1000 grade.

Part No.	Description (ANSI)	Description (ISO)	Grade	l	s	r	Operation	magia
6607029	CNMG 431 NN	CNMG 120404 NN	LT 10	0.508	0.187	0.016	General	
6608011	CNMG 431 NN	CNMG 120404 NN	LT 1000	0.508	0.187	0.016	General	m
6601436	CNMG 432 NM	CNMG 120408 NM	LT 10	0.508	0.187	0.031	Roughing	
6601437	CNMG 432 NM	CNMG 120408 NM	LT 1000	0.508	0.187	0.031	Roughing	m
6607033	CNMG 432 NN	CNM G120408 NN	LT 10	0.508	0.187	0.031	General	
6608016	CNMG 432 NN	CNMG 120408 NN	LT 1000	0.508	0.187	0.031	General	m
6601446	CNMG 432 NR	CNMG 120408 NR	LT 10	0.508	0.187	0.031	Roughing	
6608026	CNMG 432 NX	CNMG 120408 NX	LT 1000	0.508	0.187	0.031	General	m
6607037	CNMG 433 NN	CNMG 120412 NN	LT 10	0.508	0.187	0.047	Roughing	
6608021	CNMG 433 NN	CNMG 120412 NN	LT 1000	0.508	0.187	0.047	Roughing	m
3764421	DCMT 2(1.5)1 NN	DCMT 070304 NN	LT 10	0.305	0.094	0.016	Finishing	
3768811	DCMT 2(1.5)1 NN	DCMT 070304 NN	LT 1000	0.305	0.094	0.016	Finishing	m
3764424	DCMT 3(2.5)1 NN	DCMT 11T304 NN	LT 10	0.458	0.156	0.016	General	
3768821	DCMT 3(2.5)1 NN	DCMT 11T304 NN	LT 1000	0.458	0.156	0.016	General	m
3764427	DCMT 3(2.5)2 NN	DCMT 11T308 NN	LT 10	0.458	0.156	0.031	General	
3768826	DCMT 3(2.5)2 NN	DCMT 11T308 NN	LT 1000	0.458	0.156	0.031	General	m
3732040	DCMT 432 PM4	DCMT 150408 PM4	5615	0.591	0.187	0.031	General	
3563336	TCGX21.51 LH HP	TCGX110204 LH HP	101	0.433	0.94	0.016	Finishing	
3563337	TCGX32.52 LH HP	TCGX16T308 LH HP	101	0.65	0.156	0.031	General	
3533010	TCMT 1.2(1).50 PF4	TCMT 06T102 PF4	5615	0.378	0.094	0.004	Finishing	
3533020	TCMT 1.2(1)1 PF4	TCMT 06T104 PF4	5625	0.378	0.094	0.008	Finishing	
3563311	TCMT 1.8(1.5)0 HF	TCMT 090202 HF	251	0.378	0.094	0.008	Finishing	
3563399	TCMT 1.8(1.5)2 HF	TCMT 090208 HF	251	0.378	0.094	0.016	General	
3533033	TCMT 1.8(1.5)1 HM	TCMT 090204 HM	251	0.378	0.094	0.016	General	
3533030	TCMT 1.8(1.5)1 PF4	TCMT 090204 PF4	5625	0.378	0.094	0.016	Finishing	
3563388	TCMT 1.8(1.5)2 HM	TCMT090208 HM	251	0.378	0.094	0.031	General	
3564431	TCMT 2(1.5)1 NN	TCMT 110204 NN	LT 10	0.433	0.094	0.016	Finishing	
3568831	TCMT 2(1.5)1 NN	TCMT 110204 NN	LT 1000	0.433	0.094	0.016	Finishing	m
3564435	TCMT 2(1.5)2 NN	TCMT 110208 NN	LT 10	0.433	0.094	0.031	General	
3568841	TCMT 2(1.5)2 NN	TCMT 110208 NN	LT 1000	0.433	0.094	0.031	General	m
3564438	TCMT 3(2.5)1 NN	TCMT 16T304 NN	LT 10	0.65	0.156	0.016	General	
3568851	TCMT 3(2.5)1 NN	TCMT 16T304 NN	LT 1000	0.65	0.156	0.016	General	m
3564441	TCMT 3(2.5)2 NN	TCMT 16T308 NN	LT 10	0.65	0.156	0.031	General	
3568861	TCMT 3(2.5)2 NN	TCMT 16T308 NN	LT 1000	0.65	0.156	0.031	General	m
3533090	TCMT 3(2.5)2 PM4	TCMT 16T308PM4	5625	0.65	0.156	0.031	General	
3561774	TCMT 3(2.5)3 NN	TCMT 16T312 NN	LT 10	0.65	0.156	0.047	Rough	
3561929	TCMT 3(2.5)3 NN	TCMT 16T312 NN	LT 1000	0.65	0.156	0.047	Rough	m


CNMG


DCMT


TC_ _

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

Choosing and Using PinzBOHR Boring Heads

Using 75° Boring Heads

Use a 75-degree head for thru holes when the hole position is accurate. A 75-degree head will tend to follow a pre-existing hole. A 75-degree head can also be used when there is a lot of stock to be removed. The lead angle will allow higher feed rates.

Using 90° Boring Heads

Use a 90-degree boring head when a hole is off-center, shifted, or off-angle. The 90-degree lead angle will have fewer tendencies to follow the existing hole.

It is also used for blind or stepped holes and is the most versatile of our heads.

Using Boring Bars

The diameter of the boring bar should always be less than the diameter of the pre-existing hole to allow proper chip evacuation.

5:1 length-to-diameter ratios can be achieved when roughing with steel bars.

3:1 length-to-diameter ratios can be achieved when finishing with steel bars.

7:1 length-to-diameter ratios can be achieved with carbide bars.

Three Major Influences on Boring

1. **Depth of Cut (D.O.C.)**

   To determine the depth of a cut, take the finish diameter, minus the starting diameter and divide by two (2). The D.O.C. should always be greater than or equal to the nose radius of the insert. This will produce a stable cut with axial cutting forces. When D.O.C. is less than the radius, the forces are radial, and can cause chatter and deflection.

2. **Feed Rate (IPR)**

   Feeds and speeds are always dependent upon material, machine, setup conditions (fixturing) and tool over-hang. The feed rate (IPR) should always be larger than the hone of the insert and at least 25% of the nose radius. This creates full use of the chip breaker. An IPR less than the hone will produce vibration, which will affect the tool life and finish.

3. **Speed (SFPM)**

   Speed is the function of coating, nose radius, and over-hang. Higher speeds typically produce a better finish, shorter cycling times and better chip evacuation. Lower speed reduces the possibility of chatter, but also has higher cycle times and poorer quality finishes. This can also cause a built-up edge and reduce insert life. Sometimes coatings can be used to run higher surface footage, create better finish, and limit built-up edges.



75° Lead Angle Rough Head



90° Lead Angle Rough Head



Carbide or HSS Boring Bars



Use Micro Heads with Boring Bars

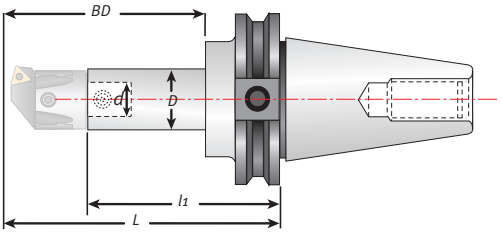
PinzBOHR High Precision CAT40 Toolholders



Match the "d" dimension on toolholder and boring head for proper selection.

Features

- *Exceed industry standards for taper accuracy and concentricity*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*
- *Reducers allow different size boring heads to be used with the same toolholder*
- *Use extensions to increase boring depth*




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Extensions & Reducers pg. 190


Retention Knobs pg. 204

CAT40 Boring Toolholders

Boring depth (BD) is tool length plus boring head.

Part No.	Description	D (mm)	d (mm)	BD	L	l1	Coupling Screw
6133250	CT-340-22-80	22	12	3.150"	4.65"	3.31"	6811510
6133255	CT-340-22-100	22	12	3.937"	5.43"	4.09"	6811510
6133260	CT-340-27-55	27	15	2.165"	3.54"	1.89"	6811520
6133265	CT-340-27-100	27	15	3.937"	5.43"	3.78"	6811520
6133270	CT-340-27-130	27	15	5.118"	6.61"	4.96"	6811520
6133275	CT-340-32-60	32	18	2.362"	3.78"	2.01"	6811530
6133280	CT-340-32-100	32	18	3.937"	5.43"	3.66"	6811530
6133285	CT-340-32-130	32	18	5.118"	6.61"	4.84"	6811530
6133290	CT-340-42-75	42	24	2.953"	4.41"	2.20"	6811540
6133295	CT-340-42-120	42	24	4.724"	5.59"	3.86"	6811540
6134300	CT-340-42-160	42	24	6.300"	7.17"	4.96"	6811540
6134305	CT-340-42-200	42	24	7.874"	8.74"	6.54"	6811540
6134310	CT-340-54-120	54	28	4.724"	5.59"	2.99"	6811550
6134315	CT-340-54-160	54	28	6.300"	7.17"	4.57"	6811550
6134320	CT-340-54-200	54	28	7.874"	8.74"	6.14"	6811550
6134325	CT-340-68-160	68	36	6.300"	7.20"	3.82"	6811560
6134330	CT-340-68-200	68	36	7.874"	8.78"	5.39"	6811560
6134335	CT-340-85-200	85	50	7.874"	8.819"	4.88"	6811570
6134338	CT-340-100-200	100	60	7.874"	8.819"	4.88"	6811580

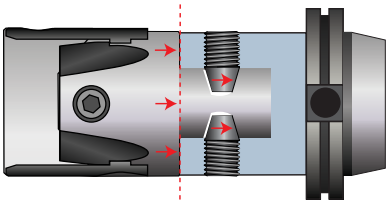
For large head toolholders, see page 188.

PinzBOHR High Precision CAT40 Coolant-Thru Toolholders



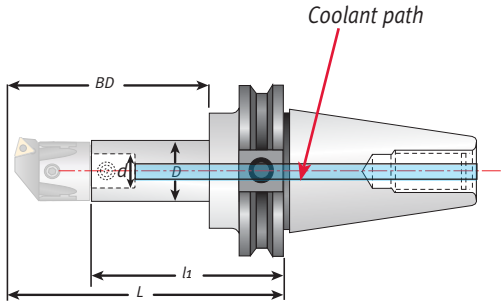
Features

- *Exceed industry standards for taper accuracy and concentricity*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*
- *Reducers allow different size boring heads to be used with the same toolholder*
- *Use extensions to increase boring depth*



Offset Center Lock Screws

Our **modular coupling system** allows heads to be changed without removing tools from the spindle. Two offset center lock screws apply maximum tightening force between the boring head and the toolholder. This increases rigidity and enhances vibration dampening characteristics.



Match the "d" dimension on toolholder and boring head for proper selection.

Boring depth (BD) is tool length plus boring head.

CAT40 Coolant-thru

Part No.	Description	D (mm)	d (mm)	BD	L	l1	Coupling Screw
6133257	CT-340-22-100-R	22	12	3.937"	5.43"	4.09"	6811510
6133252	CT-340-22-80-R	22	12	3.150"	4.65"	3.31"	6811510
6133267	CT-340-27-100-R	27	15	3.937"	5.43"	3.78"	6811520
6133272	CT-340-27-130-R	27	15	5.118"	6.61"	4.96"	6811520
6133262	CT-340-27-55-R	27	15	2.165"	3.54"	1.89"	6811520
6133282	CT-340-32-100-R	32	18	3.937"	5.34"	3.66"	6811530
6133287	CT-340-32-130-R	32	18	5.118"	6.61"	4.84"	6811520
6133277	CT-340-32-60-R	32	18	2.362"	3.78"	2.01"	6811530
6133297	CT-340-42-120-R	42	24	4.724"	5.59"	3.39"	6811540
6134302	CT-340-42-160-R	42	24	6.300"	7.17"	4.96"	6811540
6134307	CT-340-42-200-R	42	24	7.874"	8.74"	6.54"	6811540
6133292	CT-340-42-75-R	42	24	2.953"	4.41"	2.20"	6811540
6134312	CT-340-54-120-R	54	28	4.724"	5.59"	2.99"	6811550
6134317	CT-340-54-160-R	54	28	6.300"	7.17"	4.57"	6811550
6134322	CT-340-54-200-R	54	28	7.874"	8.74"	6.14"	6811550
6134327	CT-340-68-160-R	68	36	6.300"	7.20"	3.82"	6811560
6134332	CT-340-68-200-R	68	36	7.874"	8.78"	5.39"	6811560
6134337	CT-340-85-200-R	85	50	7.874"	8.819"	4.88"	6811570
6134340	CT-340-100-200-R	100	60	7.874"	8.819"	4.88"	6811580

For large head toolholders, see page 188.

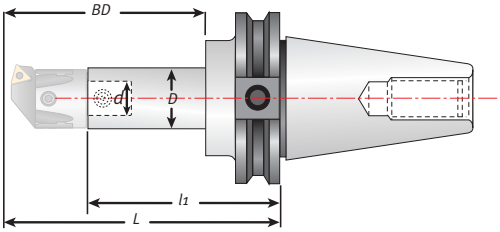
PinzBOHR High Precision CAT50 Toolholders



Match the "d" dimension on toolholder and boring head for proper selection.

Features

- *Exceed industry standards for taper accuracy and concentricity*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*
- *Reducers allow different size boring heads to be used with the same toolholder*
- *Use extensions to increase boring depth*



Boring depth (BD) is tool length plus boring head.

CAT50 Boring Toolholders

Part No.	Description	D (mm)	d (mm)	BD	L	l1	Coupling Screw
6141250	CT-350-22-80	22	12	3.150"	4.65"	3.31"	6811510
6141255	CT-350-22-100	22	12	3.937"	5.43"	4.09"	6811510
6141260	CT-350-27-55	27	15	2.165"	3.54"	1.89"	6811520
6141265	CT-350-27-100	27	15	3.937"	5.43"	3.78"	6811520
6141270	CT-350-27-130	27	15	5.118"	6.61"	4.96"	6811520
6141275	CT-350-32-60	32	18	2.362"	3.78"	2.01"	6811530
6141280	CT-350-32-130	32	18	5.118"	6.61"	4.84"	6811530
6141285	CT-350-32-160	32	18	6.299"	7.80"	6.02"	6811530
6141290	CT-350-42-75	42	24	2.953"	4.41"	2.20"	6811540
6141295	CT-350-42-160	42	24	6.299"	7.80"	5.59"	6811540
6141300	CT-350-42-200	42	24	7.874"	9.37"	7.17"	6811540
6141305	CT-350-54-90	54	28	3.543"	5.04"	2.44"	6811550
6141310	CT-350-54-160	54	28	6.299"	7.80"	5.20"	6811550
6141315	CT-350-54-200	54	28	7.874"	9.37"	6.77"	6811550
6141320	CT-350-68-115	68	36	4.528"	5.94"	2.56"	6811560
6141325	CT-350-68-200	68	36	7.874"	8.78"	5.39"	6811560
6141330	CT-350-68-260	68	36	10.236"	11.14"	7.76"	6811560
6141335	CT-350-85-200	85	50	7.874"	8.82"	4.88"	6811570
6141340	CT-350-85-260	85	50	10.236"	11.18"	7.24"	6811570
6141345	CT-350-85-320	85	50	12.598"	13.54"	9.61"	6811570
6141350	CT-350-100-190	100	60	7.480"	8.43"	4.49"	6811580
6141355	CT-350-100-260	100	60	10.236"	11.18"	7.24"	6811580
6141360	CT-350-100-320	100	60	12.598"	13.54"	9.61"	6811580
6166124	CT-550-160*	100	60	4.921"	6.30"	2.76"	6811590

For large head toolholders, see page 188.

PinzBOHR High Precision CAT50 Coolant-Thru Toolholders



Match the "d" dimension on toolholder and boring head for proper selection.

Boring Heads pg. 167

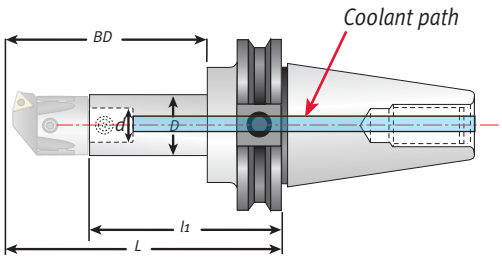
Inserts and Cartridges pg. 176

Extensions & Reducers pg. 190

Retention Knobs pg. 204

Features

- *Exceed industry standards for taper accuracy and concentricity*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*
- *Reducers allow different size boring heads to be used with the same toolholder*
- *Use extensions to increase boring depth*



Boring depth (BD) is tool length plus boring head.

CAT50 Coolant-thru

Part No.	Description	D (mm)	d (mm)	BD	L	l1	Coupling Screw
6141252	CT-350-22-80-R	22	12	3.150"	4.65"	3.31"	6811510
6141257	CT-350-22-100-R	22	12	3.937"	5.43"	4.09"	6811510
6141262	CT-350-27-55-R	27	15	2.165"	3.54"	1.89"	6811520
6141267	CT-350-27-100-R	27	15	3.937"	5.43"	3.78"	6811520
6141272	CT-350-27-130-R	27	15	5.118"	6.61"	4.96"	6811520
6141277	CT-350-32-60-R	32	18	2.362"	3.78"	2.01"	6811530
6141282	CT-350-32-130-R	32	18	5.118"	6.61"	4.84"	6811530
6141287	CT-350-32-160-R	32	18	6.299"	7.80"	6.02"	6811530
6141292	CT-350-42-75-R	42	24	2.953"	4.41"	2.20"	6811540
6141297	CT-350-42-160-R	42	24	6.299"	7.80"	5.59"	6811540
6141302	CT-350-42-200-R	42	24	7.874"	9.37"	7.17"	6811540
6141307	CT-350-54-90-R	54	28	3.543"	5.04"	2.44"	6811550
6141312	CT-350-54-160-R	54	28	6.299"	7.80"	5.20"	6811550
6141317	CT-350-54-200-R	54	28	7.874"	9.37"	6.77"	6811550
6141322	CT-350-68-115-R	68	36	4.528"	5.94"	2.56"	6811560
6141327	CT-350-68-200-R	68	36	7.874"	8.78"	5.39"	6811560
6141332	CT-350-68-260-R	68	36	10.236"	11.14"	7.76"	6811560
6141337	CT-350-85-200-R	85	50	7.874"	8.82"	4.88"	6811570
6141342	CT-350-85-260-R	85	50	10.236"	11.18"	7.24"	6811570
6141347	CT-350-85-320-R	85	50	12.598"	13.54"	9.61"	6811570
6141352	CT-350-100-190-R	100	60	7.480"	8.43"	4.49"	6811580
6141362	CT-350-100-320-R	100	60	12.598"	13.54"	9.61"	6811580
6141357	CT-350-100-260-R	100	60	10.236"	11.18"	7.24"	6811580

For large head toolholders, see page 188.

PinzBOHR High Precision BT30, BT40 Toolholders

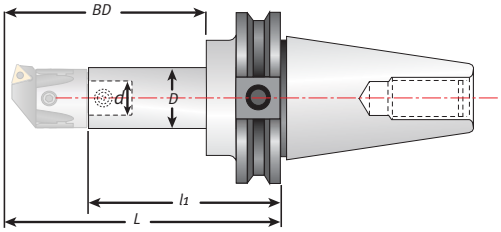


Match the "d" dimension on toolholder and boring head for proper selection.

Boring depth (BD) is tool length plus boring head.

Features

- *Exceed industry standards for taper accuracy and concentricity*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*
- *Reducers allow different size boring heads to be used with the same toolholder*



BT30 Boring Toolholders

Part-No.	Description	D (mm)	d (mm)	BD	L	l1	Coupling-Screw
6130100	BT-330-22-100	22	12	3.937"	4.92"	3.58"	6811510
6130150	BT-330-27-55	27	15	2.165"	3.03"	1.38"	6811520
6130200	BT-330-27-100	27	15	3.937"	4.92"	3.27"	6811520
6130250	BT-330-32-60	32	18	2.362"	3.27"	1.50"	6811530
6130300	BT-330-32-100	32	18	3.937"	4.92"	3.15"	6811530

BT40 Boring Toolholders

Part-No.	Description	D (mm)	d (mm)	BD	L	l1	Coupling-Screw
6140100	BT-340-22-50	22	12	1.969"	3.15"	1.81"	6811510
6140125	BT-340-22-80	22	12	3.150"	4.33"	2.99"	6811510
6140150	BT-340-22-100	22	12	3.937"	5.12"	3.78"	6811510
6140175	BT-340-27-55	27	15	2.165"	3.23"	1.57"	6811520
6140200	BT-340-27-100	27	15	3.937"	5.12"	3.46"	6811520
6140225	BT-340-27-130	27	15	5.118"	6.30"	4.65"	6811520
6140250	BT-340-32-60	32	18	2.362"	3.46"	1.69"	6811530
6140275	BT-340-32-100	32	18	3.937"	5.12"	3.35"	6811530
6140300	BT-340-32-130	32	18	5.118"	6.30"	4.53"	6811530
6140325	BT-340-42-75	42	24	2.953"	4.09"	1.89"	6811540
6140350	BT-340-42-160	42	24	6.299"	7.48"	5.28"	6811540
6140375	BT-340-42-200	42	24	7.874"	9.06"	6.85"	6811540
6140400	BT-340-54-90	54	28	3.543"	4.72"	2.13"	6811550
6140425	BT-340-54-160	54	28	6.299"	7.48"	4.88"	6811550
6140450	BT-340-54-200	54	28	7.874"	9.06"	6.46"	6811550
6140475	BT-340-68-160	68	36	6.299"	7.13"	3.74"	6811560
6140500	BT-340-68-200	68	36	7.874"	8.70"	5.31"	6811560
6140525	BT-340-85-200	85	50	7.874"	8.66"	4.72"	6811570
6140550	BT-340-100-200	100	60	7.874"	8.66"	4.72"	6811580

For large head toolholders, see page 188.

PinzBOHR High Precision BT50 Toolholders



Features

- *Exceed industry standards for taper accuracy and concentricity*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*
- *Reducers allow different size boring heads to be used with the same toolholder*
- *Use extensions to increase boring depth*

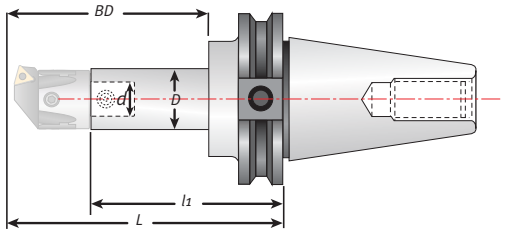

Boring Heads pg. 167


Inserts and Cartridges pg. 176


Extensions & Reducers pg. 190


Retention Knobs pg. 204

Match the "d" dimension on toolholder and boring head for proper selection.



Boring depth (BD) is tool length plus boring head.

BT50 Boring Toolholders

Part No.	Description	D (mm)	d (mm)	BD	L	l1	Coupling Screw
6150100	BT-350-22-80	22	12	3.150"	4.76"	3.43"	6811510
6150125	BT-350-22-100	22	12	3.937"	5.55"	4.21"	6811510
6150150	BT-350-27-55	27	15	2.165"	3.66"	2.01"	6811520
6150175	BT-350-27-100	27	15	3.937"	5.55"	3.90"	6811520
6150200	BT-350-27-130	27	15	5.118"	6.73"	5.08"	6811520
6150225	BT-350-32-60	32	18	2.362"	3.90"	2.13"	6811530
6150250	BT-350-32-130	32	18	5.118"	6.73"	4.96"	6811530
6150275	BT-350-32-160	32	18	6.299"	7.91"	6.14"	6811530
6150300	BT-350-42-75	42	24	2.953"	4.53"	2.32"	6811540
6150325	BT-350-42-160	42	24	6.299"	7.91"	5.71"	6811540
6150350	BT-350-42-200	42	24	7.874"	9.49"	7.28"	6811540
6150375	BT-350-54-90	54	28	3.543"	5.16"	2.56"	6811550
6150400	BT-350-54-160	54	28	6.299"	7.91"	5.31"	6811550
6150425	BT-350-54-200	54	28	7.874"	9.49"	6.89"	6811550
6150450	BT-350-68-115	68	36	4.528"	6.06"	2.68"	6811560
6150475	BT-350-68-200	68	36	7.874"	9.53"	6.14"	6811560
6150500	BT-350-68-260	68	36	10.236"	11.89"	8.50"	6811560
6150525	BT-350-85-200	85	50	7.874"	9.53"	5.59"	6811570
6150550	BT-350-85-260	85	50	10.236"	11.89"	7.95"	6811570
6150575	BT-350-85-320	85	50	12.598"	14.25"	10.31"	6811570
6150600	BT-350-100-170	100	60	6.693"	7.68"	3.74"	6811580
6150625	BT-350-100-260	100	60	10.236"	11.89"	7.95"	6811580
6150650	BT-350-100-320	100	60	12.598"	14.25"	10.31"	6811580
6166123	BT-550-160*	100	60	4.921"	6.30"	2.76"	6811590

*BT-550-160 is for direct mounting of large heads. For large head toolholders, see page 188.

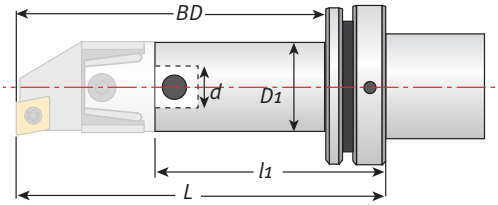
PinzBOHR High Precision HSK50A, 63A, 100A Toolholders



Match the d dimension on toolholder and boring head for proper selection.

Features

- *Exceed industry standards for taper accuracy and concentricity*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*
- *Reducers allow different size boring heads to be used with the same toolholder*
- *Use extensions to increase boring depth*



HSK50A Boring Toolholders

Boring depth (BD) is tool length plus boring head.

Part No.	Description	D1 (mm)	d (mm)	BD	L	l1	Coupling Screw
6155501	HSK-50A-22-55	22	12	2.165"	3.19"	1.85"	6811510
6155502	HSK-50A-27-65	27	15	2.559"	3.58"	1.93"	6811520
6155503	HSK-50A-32-75	32	18	2.953"	3.98"	2.20"	6811530
6155504	HSK-50A-42-90	42	24	3.543"	4.57"	2.36"	6811540

HSK63A Boring Toolholders

Part No.	Description	D1 (mm)	d (mm)	BD	L	l1	Coupling Screw
6155631	HSK-63A-22-55	22	12	2.165"	3.19"	1.85"	6811510
6155632	HSK-63A-27-65	27	15	2.559"	3.58"	1.93"	6811520
6155633	HSK-63A-32-75	32	18	2.953"	3.98"	2.20"	6811530
6155634	HSK-63A-42-90	42	24	3.543"	4.57"	2.36"	6811540
6155635	HSK-63A-54-110	54	28	4.331"	5.35"	2.76"	6811550
6155636	HSK-63A-68-145	68	36	5.709"	6.73"	3.35"	6811560

HSK100A Boring Toolholders

Part No.	Description	D1 (mm)	d (mm)	BD	L	l1	Coupling Screw
6155101	HSK-100A-22-55	22	12	2.165"	3.50"	2.165"	6811510
6155102	HSK-100A-27-65	27	15	2.559"	3.90"	2.244"	6811520
6155103	HSK-100A-32-75	32	18	2.953"	4.09"	2.322"	6811530
6155104	HSK-100A-42-90	42	24	3.543"	4.69"	2.480"	6811540
6155105	HSK-100A-54-110	54	28	4.331"	5.47"	2.847"	6811550
6155106	HSK-100A-68-145	68	36	5.709"	6.85"	3.46"	6811560
6155107	HSK-100A-85-165	85	50	6.496"	7.64"	3.70"	6811570
6155108	HSK-100A-100-185	100	60	7.283"	8.43"	4.49"	6811580
6166125	HSK-550-160*	100	60	5.511"	6.692"	3.149"	6811590

*HSK-550-160 is for direct mounting of large heads. For large head toolholders, see page 188.

PinzBOHR High Precision Weldon & R8 Toolholders

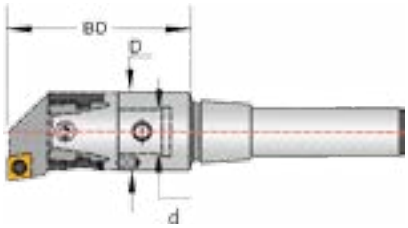


Weldon toolholder

Match the d dimension on toolholder and boring head for proper selection.

Features

- *Use with any Techniks End Mill Holders with H5 bore tolerance for boring applications from .315" up to 3.228"*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*



Boring depth (BD) is tool length plus boring head.

Weldon 3/4" Shank

Part No.	Description	D (mm)	d (mm)	BD	Coupling Screws
6165341	B-20-22-50-3/4-SS-WELDON	22	12	1.969"	6811510
6165342	B-20-22-100-3/4-SS-WELDON	22	12	3.937"	6811510
6165343	B-20-54-110-3/4-SS-WELDON	54	28	4.331"	6811550

Weldon 1" Shank

Part No.	Description	D (mm)	d (mm)	BD	Coupling Screws
6165101	B-25-27-55-1.0-SS-WELDON	27	15	2.165"	6811520
6165102	B-25-27-100-1.0-SS-WELDON	27	15	3.937"	6811520
6165103	B-25-54-110-1.0-SS-WELDON	54	28	4.331"	6811550

Weldon 1-1/4" Shank

Part No.	Description	D (mm)	d (mm)	BD	Coupling Screws
6165141	B-32-32-60-1-1/4-SS-WELDON	32	18	2.362"	6811530
6165142	B-32-32-100-1-1/4-SS-WELDON	32	18	3.937"	6811530
6165143	B-32-42-90-1-1/4-SS-WELDON	42	24	3.543"	6811540
6165144	B-32-54-110-1-1/4-SS-WELDON	54	28	4.331"	6811550

Weldon 1-1/2" Shank

Part No.	Description	D (mm)	d (mm)	BD	Coupling Screws
6165121	B-40-42-90-1-1/2-SS-WELDON	42	24	3.543"	6811540
6165122	B-40-42-160-1-1/2-SS-WELDON	42	24	6.299"	6811540
6165123	B-40-54-110-1-1/2-SS-WELDON	54	28	4.331"	6811550

R8 Toolholders

Part No.	Description	D (mm)	d (mm)	BD	Coupling Screws
6165801	R8-22-50-R8	22	12	1.969"	6811510
6165802	R8-27-60-R8	27	15	2.362"	6811520
6165803	R8-32-75-R8	32	18	2.953"	6811530
6165804	R8-42-90-R8	42	24	3.543"	6811540
6165805	R8-54-110-R8	54	28	4.331"	6811550



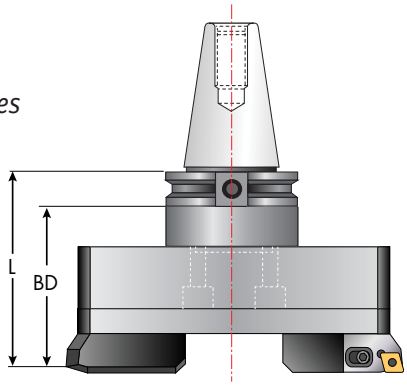
R8 Tool holder

Large Head Holders, Adapters and Extensions



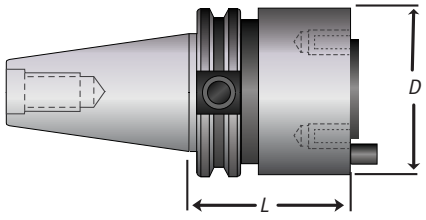
Features

- *Maximum rigidity and accuracy*
- *CAT, BT, HSK100A spindles*
- *Nickel-chrome alloy steel ensures best reliablity and repeatability*



CAT, BT, HSK Direct Mount Toolholders

Part No.	Description	D	L	lbs
6166124	CAT-550-160-W	3.93"	2.75"	12.45
6166123	BT-550-160	3.93"	2.75"	13.24
6166125	HSK-550-160	3.93"	3.14"	11.55



direct mount toolholder



adapter mount holders require 6022510 adapter



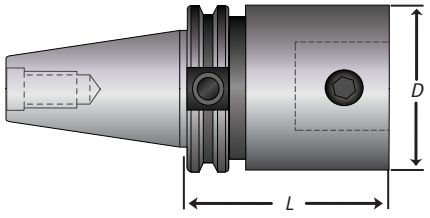
optional extension



required adapter

CAT, BT, HSK100A Adapter Mount Toolholders

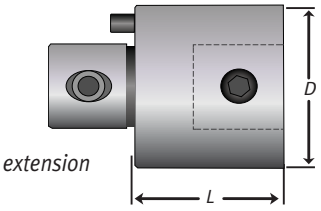
Part No.	Description	D	L	lbs
6141350	CAT-350-100-190-W	3.93"	4.48"	14.50
6141355	CAT-350-100-260-W	3.93"	7.24"	24.25
6141360	CAT-350-100-320-W	3.93"	9.60"	32.32
6150600	BT-350-100-170	3.93"	3.74"	12.74
6150625	BT-350-100-260	3.93"	7.95"	27.47
6150650	BT-350-100-320	3.93"	10.31"	35.45
6155108	HSK-100A-100-185	3.93"	4.48"	12.50



adapter mount toolholder

Optional Extensions (require adapter for large head mounting)

Part No.	Description	D	L	lbs
6551080	P-100-80	3.93"	3.14"	10.10
6551012	P-100-120	3.93"	4.72"	15.56

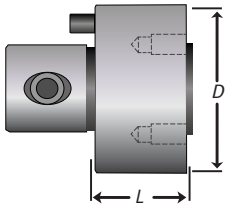


extension

Extensions can be used with adaptor mount toolholders but do require a adaptor for large head mounting.

Large Head Adapter (use with adapter mount holders)

Part No.	Description	D	L	lbs
6022510	ADT-100-50	3.93"	1.96"	9.61

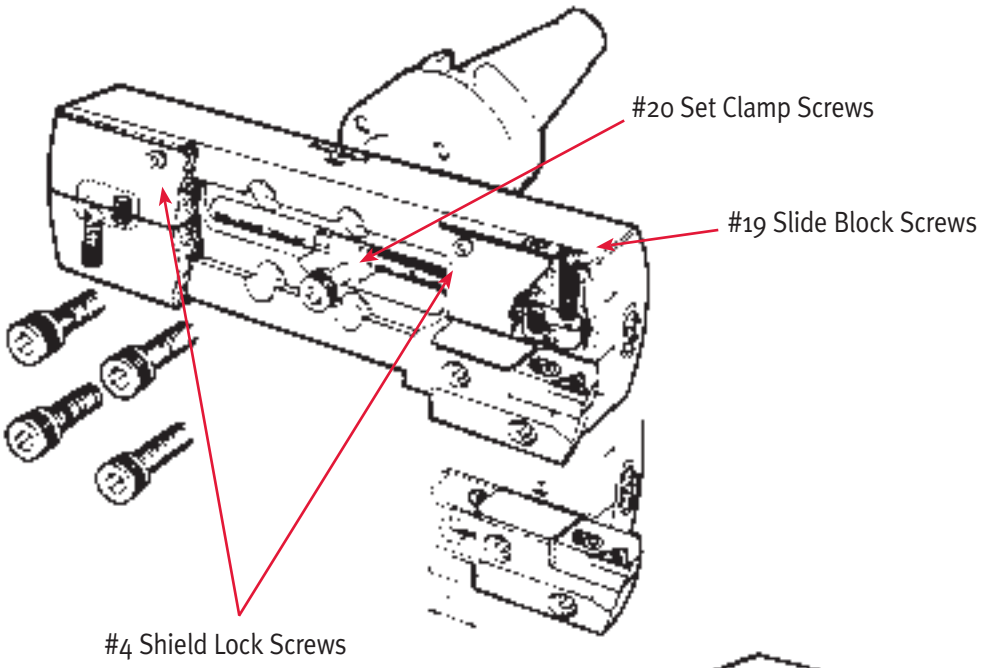


large head adapter

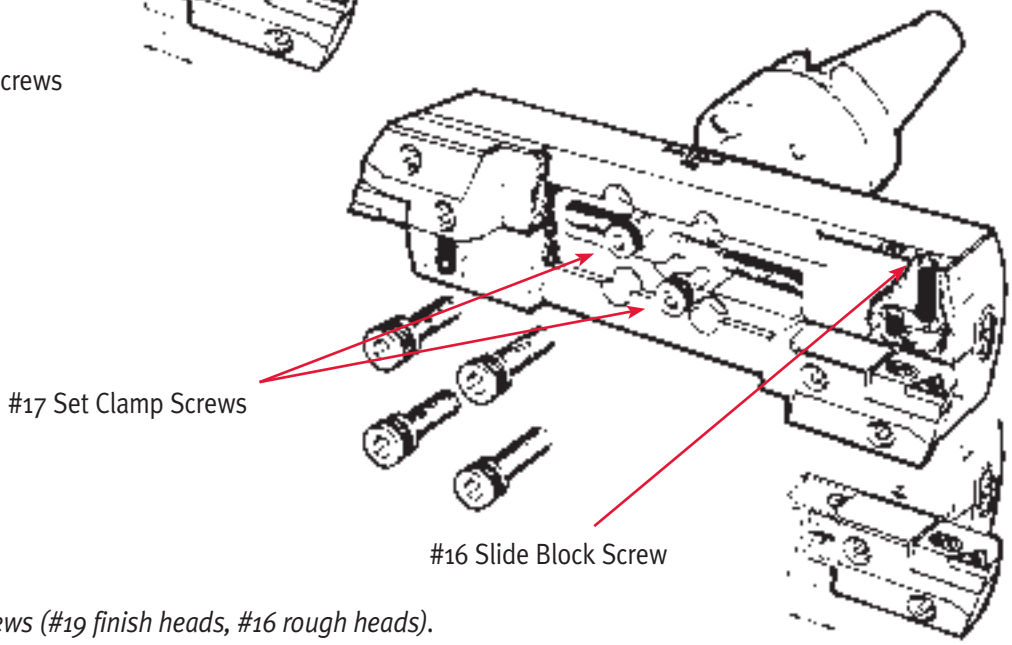
Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

Large Head Mounting Instructions

Finish Heads



Rough Heads



1. *Loosen slide block screws (#19 finish heads, #16 rough heads).*
2. *Remove set clamp screws (#20 finish heads, #17 rough heads).*
3. *On finish boring heads only, remove shield lock screws #4.*
4. *Move slide blocks /shield off-center until the four counter bored bolt holes located in the body below the slide blocks are completely exposed.*
5. *Place taper shank holder or adapter on back side of boring head with pilot completely engaged in pilot cavity.*
6. *Insert 4 socket head cap screws into counter bored holes and tighten to 90 ft-lbs torque.*
7. *Push slide blocks back into position to line up with threaded holes below.*
8. *Insert nut /close shield lock screws and tighten.*
9. *Adjust boring head to desired diameter and tighten slide block lock screws.*

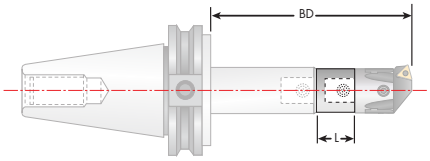
PinzBOHR High Precision Extensions



Match the "d" dimensions on toolholder, extension, and boring head for proper selection.

Features

- *Extend boring depth*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*



Calculate needed extension length (L) to achieve your boring depth (BD)



Boring Heads pg. 160



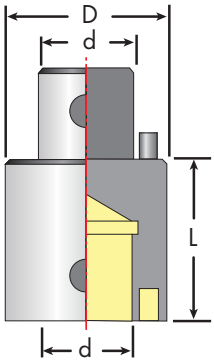
Inserts and Cartridges pg. 168



Retention Knobs pg. 200

Standard Extensions

Part No.	Description	D (mm)	d (mm)	L	Coupling Screw
6552220	P-22-20	22	12	0.79"	6811510
6552230	P-22-30	22	12	1.18"	6811510
6552730	P-27-30	27	15	1.18"	6811520
6552745	P-27-45	27	15	1.77"	6811520
6553235	P-32-35	32	18	1.38"	6811530
6553252	P-32-52	32	18	2.05"	6811530
6554240	P-42-40	42	24	1.57"	6811540
6554260	P-42-60	42	24	2.36"	6811540
6555450	P-54-50	54	28	1.97"	6811550
6555475	P-54-75	54	28	2.95"	6811550
6556860	P-68-60	68	36	2.36"	6811560
6556890	P-68-90	68	36	3.54"	6811560
6558570	P-85-70	85	50	2.76"	6811570
6558510	P-85-105	85	50	4.13"	6811570
6551080	P-100-80	100	60	3.15"	6811580
6551012	P-100-120	100	60	4.72"	6811580



Coolant-thru Spindle Extension

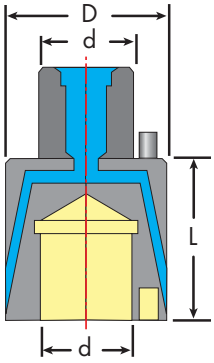
The coolant-thru spindle extension provides coolant to the cutting zone for optimal stock removal rates.

Minimum recommend coolant pressure is 70 psi. Coolant is directed onto cutting edge by adapter.

Coolant-thru Spindle Extension

Part No.	Description	D (mm)	d (mm)	L	Coupling Screw
6562230	P-22-30R	22	12	1.18"	6811510
6562730	P-27-30R	27	15	1.18"	6811520
6563235	P-32-35R	32	18	1.38"	6811530
6564240	P-42-40R	42	24	1.57"	6811540
6565450	P-54-50R	54	28	1.97"	6811550
6566860	P-68-60R	68	36	2.36"	6811560
6568570	P-85-70R	85	50	2.76"	6811570
6561080	P-100-80R	100	60	3.15"	6811580

Use with coolant-thru toolholders available upon request.



Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

PinzBOHR High Precision Reducers & Chamfering Heads



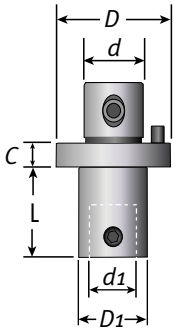
Features

- *Reducers allow different boring heads to be used with the same toolholder / extension combination*
- *Two offset axial tapered locking screws maximize rigidity and allow fast tool changes*

Match the "d" dimensions on toolholder, reducer, and boring head for proper selection.

Reducers

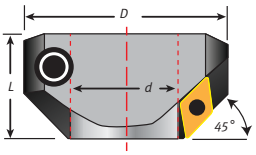
Part No.	Description	D (mm)	d (mm)	D1 (mm)	d1 (mm)	L	c	Coupling Screw
6442236	R-27-22-36	27	15	22	12	1.02"	.39"	6811510
6442240	R-32-22-40	32	18	22	12	1.18"	.39"	6811510
6442258	R-42-22-58	42	24	22	12	1.89"	.39"	6811510
6442286	R-54-22-86	54	28	22	12	2.99"	.39"	6811510
6442210	R-68-22-102	68	36	22	12	3.54"	.47"	6811510
6442734	R-32-27-34	32	18	27	15	0.94"	.39"	6811520
6442750	R-42-27-50	42	24	27	15	1.57"	.39"	6811520
6442780	R-54-27-80	54	28	27	15	2.76"	.39"	6811520
6442795	R-68-27-95	68	36	27	15	3.27"	.47"	6811520
6443246	R-42-32-46	42	24	32	18	1.42"	.39"	6811530
6443276	R-54-32-76	54	28	32	18	2.60"	.39"	6811530
6443290	R-68-32-90	68	36	32	18	3.07"	.47"	6811530
6444270	R-54-42-70	54	28	42	24	2.36"	.39"	6811540
6444282	R-68-42-82	68	36	42	24	2.76"	.47"	6811540
6444295	R-85-42-95	85	50	42	24	3.27"	.47"	6811540
6445472	R-68-54-72	68	36	54	28	2.36"	.47"	6811550
6445490	R-85-54-90	85	50	54	28	3.07"	.47"	6811550
6446810	R-85-68-100	85	50	68	36	3.46"	.47"	6811560
6448510	R-100-85-100	100	60	85	50	3.46"	.47"	6811570

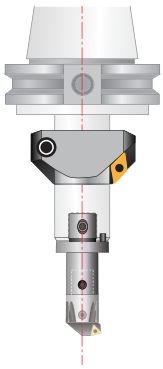


45° Chamfering Heads

Part No.	Desc.	D (mm)	d (mm)	L	Insert	Insert Screw	Wrench	Hex Wrench
6033311	CH-22	43	22	0.94"	DCMT 32.5_	6811260	9355555	4 hex
6033322	CH-27	48	27	0.94"	DCMT 32.5_	6811260	9355555	4 hex
6033333	CH-32	62	32	1.18"	DCMT 32.5_	6811260	9355555	5 hex
6033344	CH-42	72	42	1.18"	DCMT 32.5_	6811260	9355555	5 hex
6033355	CH-54	94	54	1.57"	DCMT 43_	6811266	9355666	6 hex
6033366	CH-68	110	68	1.57"	DCMT 43_	6811266	9355666	8 hex
6033377	CH-85	145	85	2.17"	DCMT 43_	6811266	9355666	10 hex
6033388	CH-100	170	100	2.36"	DCMT 43_	6811266	9355666	14 hex
6033399	CH-200	200	100	2.36"	DCMT 43_	6811266	9355666	14 hex

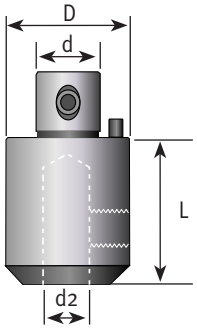






High Precision End Mill Holders & Face Mill Arbors





Features

- *For 1/4" up to 3/4" end mills*
- *Use with extra-long toolholders and extensions for extended length applications*
- *Two offset center lock screws maximize rigidity while still permitting fast tool changes*

Boring Heads pg. 167 | Inserts and Cartridges pg. 176 | Extensions & Reducers pg. 190 | Retention Knobs pg. 204

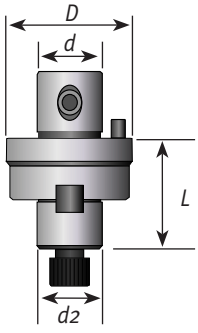
End Mill Holders

Part No.	Description	D (mm)	d (mm)	L	d2
6123300	ADM-42-W1/4	42	24	1.38"	1/4"
6123305	ADM-42-W3/8	42	24	1.50"	3/8"
6123310	ADM-42-W1/2	42	24	2.17"	1/2"
6123315	ADM-42-W3/4	42	28	2.83"	3/4"
6123320	ADM-54-W3/4	54	28	2.85"	3/4"



Features

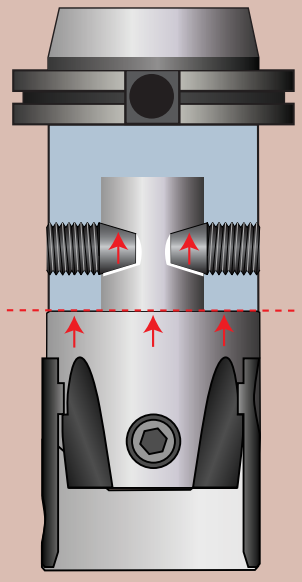
- *For 3/4" up to 1-1/4" face mills*
- *Two offset center lock screws maximize rigidity while still permitting fast tool changes*
- *Use with extra-long toolholders and extensions for extended length applications*



Face Mill Arbor

Part No.	Description	D (mm)	d (mm)	L	d2
6133300	ADM-54-3/4	54	28	1.97"	3/4"
6133305	ADM-54-1.0	54	28	1.97"	1.0"
6133310	ADM-68-1.0	68	36	1.97"	1.0"
6133315	ADM-68-1-1/4	68	36	1.97"	1-1/4"

Modular Coupling System



Offset Center Lock Screws

Pin and taper coupling system allows tools to be changed without removing from the spindle. Two offset center lock screws apply maximum tightening force between the tool and the toolholder. This increases rigidity and enhances vibration damping characteristics.

PinzBOHR Speeds & Feeds Guidelines

Optimal speeds & feeds depend upon material, machine, tool overhang, and setup. These guidelines may not be correct for your application, but can serve as a useful starting point.

Rough Boring with Dual Inserts

Material: Plain Carbon Steel

Dia. Range (inch)	Head Size	Max. Stock Removal on Dia.	Suggested Speeds & Feeds Speed SFM	Feed IPR
.944 - 1.181	22	0.38	320 - 420	.006 - .010
1.141 - 1.574	27	0.47	350 - 450	.006 - .012
1.535 - 1.968	32	0.56	350 - 500	.008 - .012
1.929 - 4.015	42, 54, 68	0.75	350 - 500	.010 - .014
3.935 - 20.00	85, 100, 200	0.84	350 - 500	.012 - .016
	300, 400, 500		350 - 500	.012 - .016

Material: Alloy Steels

.944 - 1.181	22	0.38	300 - 390	.006 - .010
1.141 - 1.574	27	0.47	320 - 420	.006 - .012
1.535 - 1.968	32	0.56	320 - 420	.008 - .012
1.929 - 4.015	42, 54, 68	0.75	320 - 420	.010 - .014
3.935 - 20.00	85, 100, 200	0.84	320 - 420	.012 - .016
	300, 400, 500		320 - 420	.012 - .016

Material: Stainless Steels

.944 - 1.181	22	0.38	200 - 300	.005 - .008
1.141 - 1.574	27	0.47	220 - 320	.006 - .010
1.535 - 1.968	32	0.56	220 - 320	.006 - .010
1.929 - 4.015	42, 54, 68	0.75	220 - 320	.008 - .012
3.935 - 20.00	85, 100, 200	0.84	220 - 320	.010 - .014
	300, 400, 500		220 - 320	.010 - .014

Material: Cast Iron

.944 - 1.181	22	0.38	200 - 350	.008 - .012
1.141 - 1.574	27	0.47	220 - 350	.010 - .014
1.535 - 1.968	32	0.56	220 - 350	.010 - .014
1.929 - 4.015	42, 54, 68	0.75	220 - 350	.012 - .016
3.935 - 20.00	85, 100, 200	0.84	220 - 350	.012 - .018
	300, 400, 500		220 - 350	.012 - .018

Material: Aluminum and Aluminum Alloys

.944 - 1.181	22	0.38	400 - 1000	.008 - .012
1.141 - 1.574	27	0.47	500 - 1200	.010 - .014
1.535 - 1.968	32	0.56	500 - 1200	.010 - .014
1.929 - 4.015	42, 54, 68	0.75	500 - 1200	.012 - .016
3.935 - 20.00	85, 100, 200	0.84	500 - 1200	.012 - .018
	300, 400, 500		500 - 1200	.012 - .018

Material: Titanium and High Temperature Alloys

.944 - 1.181	22	0.25	90 - 120	.005 - .008
1.141 - 1.574	27	0.32	100 - 130	.006 - .010
1.535 - 1.968	32	0.38	100 - 130	.006 - .010
1.929 - 4.015	42, 54, 68	0.50	100 - 130	.008 - .012
3.935 - 20.00	85, 100, 200	0.56	100 - 130	.008 - .014
	300, 400, 500		100 - 130	.008 - .014

Finish Boring with Single Inserts

Material: Plain Carbon Steel

Dia. Range (inch)	Max. Stock Head Size	Suggested Speeds & Feeds Removal on Dia.	Speed SFM	Feed IPR
.944 - 1.181	22	.004 - .024	350 - 450	.002 - .006
1.141 - 1.574	27	.004 - .024	380 - 500	.002 - .006
1.535 - 1.968	32	.005 - .030	380 - 500	.002 - .006
1.929 - 4.015	42, 54, 68	.005 - .030	380 - 500	.004. - .008
3.935 - 20.00	85, 100, 200	.006 - .040	380 - 500	.004. - .008
	300, 400, 500	.006 - .040	380 - 500	.004. - .008

Material: Alloy Steels

.944 - 1.181	22	.004 - .024	320 - 420	.002 - .006
1.141 - 1.574	27	.004 - .024	350 - 450	.002 - .006
1.535 - 1.968	32	.005 - .030	350 - 480	.002 - .006
1.929 - 4.015	42, 54, 68	.005 - .030	350 - 480	.004. - .008
3.935 - 20.00	85, 100, 200	.006 - .040	350 - 480	.004. - .008
	300, 400, 500	.006 - .040	350 - 480	.004. - .008

Material: Stainless Steels

.944 - 1.181	22	.010 - .030	220 - 320	.003 - .006
1.141 - 1.574	27	.010 - .030	250 - 350	.003 - .006
1.535 - 1.968	32	.015 - .040	250 - 350	.003 - .006
1.929 - 4.015	42, 54, 68	.015 - .040	250 - 350	.004 - .008
3.935 - 20.00	85, 100, 200	.020 - .050	250 - 350	.005 - .008
	300, 400, 500	.020 - .050	250 - 350	.005 - .008

Material: Cast Iron

.944 - 1.181	22	.010 - .030	220 - 350	.003 - .006
1.141 - 1.574	27	.010 - .030	250 - 380	.003 - .006
1.535 - 1.968	32	.015 - .040	250 - 380	.003 - .006
1.929 - 4.015	42, 54, 68	.015 - .040	250 - 380	.005 - .008
3.935 - 20.00	85, 100, 200	.020 - .050	250 - 380	.005 - .008
	300, 400, 500	.020 - .050	250 - 380	.005 - .008

Material: Aluminum and Aluminum Alloys

.944 - 1.181	22	.010 - .030	500 - 1000	.002 - .006
1.141 - 1.574	27	.010 - .030	500 - 1200	.004 - .008
1.535 - 1.968	32	.015 - .040	500 - 1200	.004 - .008
1.929 - 4.015	42, 54, 68	.015 - .040	500 - 1200	.004 - .008
3.935 - 20.00	85, 100, 200	.020 - .050	500 - 1200	.004 - .010
	300, 400, 500	.020 - .050	500 - 1200	.004 - .010

Material: Titanium and High Temperature Alloys

.944 - 1.181	22	.010 - .030	100 - 130	.003 - .006
1.141 - 1.574	27	.010 - .030	100 - 150	.003 - .006
1.535 - 1.968	32	.015 - .040	100 - 150	.003 - .006
1.929 - 4.015	42, 54, 68	.015 - .040	100 - 150	.004 - .008
3.935 - 20.00	85, 100, 200	.020 - .050	100 - 150	.004 - .008
	300, 400, 500	.020 - .050	100 - 150	.004 - .008

Range: 8.661" up to 40.157"

MacroBOHR



- *For finish, rough, and external boring*
- *Easy-to-use, no complicated setups*
- *Hard coated aluminum and nickel-chrome alloy steel for maximum accuracy and rigidty*

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Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

PINZBOHR

MacroBOHR Boring Tools – Range: 8.661" to 40.157"

MacroBOHR Modular System



The MacroBOHR boring system is a lightweight line of tools optimized for large diameter boring.

MacroBOHR tools are capabable of boring holes ranging from 8.661" up to 40.157".

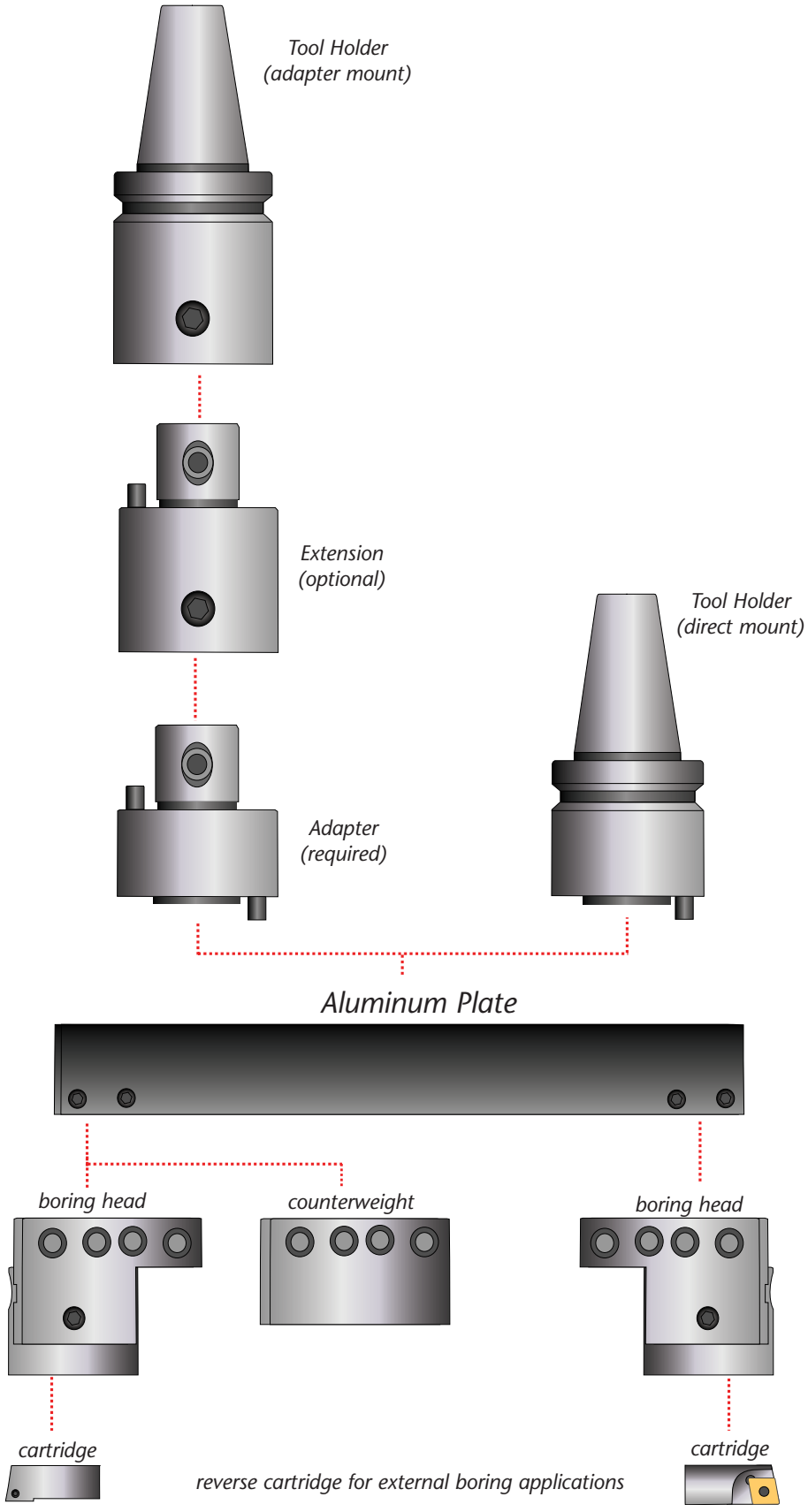
All tool holders, boring heads, & counterweights are made from high-strength aluminum or nickle-chrome alloy steel. The boring heads are fully indexable on the plates and very easy to setup.

MacroBOHR Boring Range

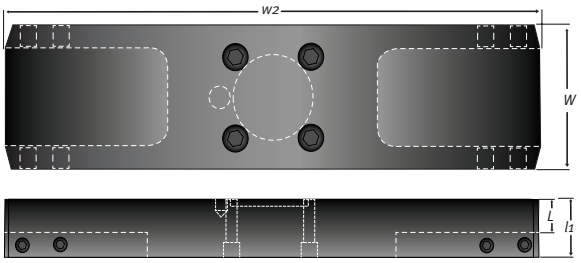


Boring holes from 8.661" up to 40.157" can be achieved by simply changing the plate size. Each plate has 2 radial positions to locate the boring head and counter-weight to achieve minimum or maximum bore size.

Use MacroBOHR for finish, rough, and external boring applications. External boring is achieved by reversing the cartridge position.







Aluminum Plates

Part No.	Description	Min	Max	w2	W	l1	L	lbs	Coupling screw	Qty.	Fixing Screw	Qty.
6921255	MB-SP-0320	8.66"	12.59"	7.87"	3.93"	2.28"	1.22"	4.76	TF 100	4	TC-068-1624	8
6921256	MB-SP-0420	12.59"	16.53"	11.81"	3.93"	2.28"	1.22"	7.21	TF 100	4	TC-068-1624	8
6921257	MB-SP-0520	16.53"	20.47"	15.74"	3.93"	2.28"	1.22"	11.46	TF 101	4	TC-068-1624	8
6921258	MB-SP-0620	20.47"	24.40"	19.68"	3.93"	2.67"	1.61"	18.08	TF 102	4	TC-068-1624	8
6921259	MB-SP-0720	24.40"	28.34"	23.62"	3.93"	2.67"	1.61"	22.27	TF 102	4	TC-068-1624	8
6921260	MB-SP-0820	28.34"	32.28"	27.55"	3.93"	2.67"	1.61"	26.24	TF 102	4	TC-068-1624	8
6921261	MB-SP-0920	32.28"	36.22"	31.49"	3.93"	3.07"	2.00"	35.27	TF 103	4	TC-068-1624	8
6921262	MB-SP-1020	36.22"	40.15"	35.43"	3.93"	3.07"	2.00"	39.90	TF 103	4	TC-068-1624	8

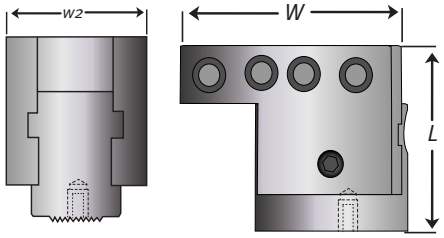




AccuSET graduated dial in .0001" increments for fast and easy cutting adjustments.

Boring Head

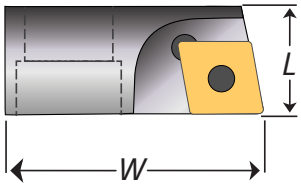
Part No.	Description	W	L	w2	lbs	Cartridge Screw	Adjusting Key	Locking Key
6390410	MB-068-W	4.07"	3.42"	2.67"	6.77	CS 10 25	HK 050	HK 080





Cartridges

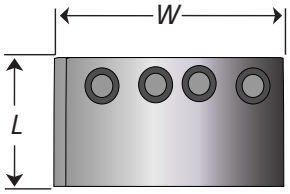
Part No.	Description	Insert	W	L	lbs	Torx Screw	Torx Key
6690190	TP_22_	TP-1102	2.00"	.78"	0.22	TT 400	TK 08
6922243	TC_32.5_	TC-16T3	2.00"	.78"	0.22	TT 409	TK 15
6921234	CC_32.5_	CC-09T3	2.00"	.78"	0.22	TT 409	TK 15





Counterweight

Part No.	Description	W	L	lbs
6921245	MB-CW	4.07"	2.36"	6.99



MacroBOHR Holders, Adapters and Extensions

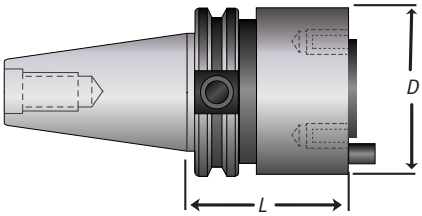


Features

- *Maximum rigidity and accuracy*
- *CAT, BT, HSK100A spindles*
- *Nickel-chrome alloy steel ensures best reliablity and repeatability*

CAT, BT, HSK Direct Mount Toolholders

Part No.	Description	D	L	lbs
6166124	CAT-550-160-W	3.93"	2.75"	12.45
6166123	BT-550-160	3.93"	2.75"	13.24
6166125	HSK-550-160	3.93"	3.14"	11.55



direct mount toolholders do not accept extensions.



adapter mount holders require 6022510 adapter



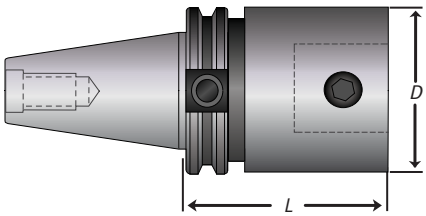
optional extension



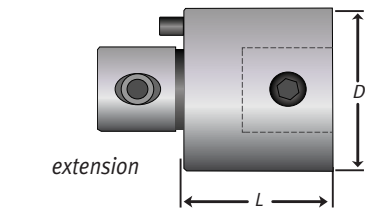
required adapter

CAT, BT, HSK100A Adapter Mount Toolholders

Part No.	Description	D	L	lbs
6141350	CAT-350-100-190-W	3.93"	4.48"	14.50
6141355	CAT-350-100-260-W	3.93"	7.24"	24.25
6141360	CAT-350-100-320-W	3.93"	9.60"	32.32
6150600	BT-350-100-170	3.93"	3.74"	12.74
6150625	BT-350-100-260	3.93"	7.95"	27.47
6150650	BT-350-100-320	3.93"	10.31"	35.45
6155108	HSK-100A-100-185	3.93"	4.48"	12.50



adapter mount toolholder

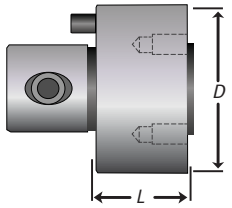


extension

Extensions can be used with adaptor mount toolholders but do require a adaptor for large head mounting.

Optional Extensions (require adapter for large head mounting)

Part No.	Description	D	L	lbs
6551080	P-100-80	3.93"	3.14"	10.10
6551012	P-100-120	3.93"	4.72"	15.56



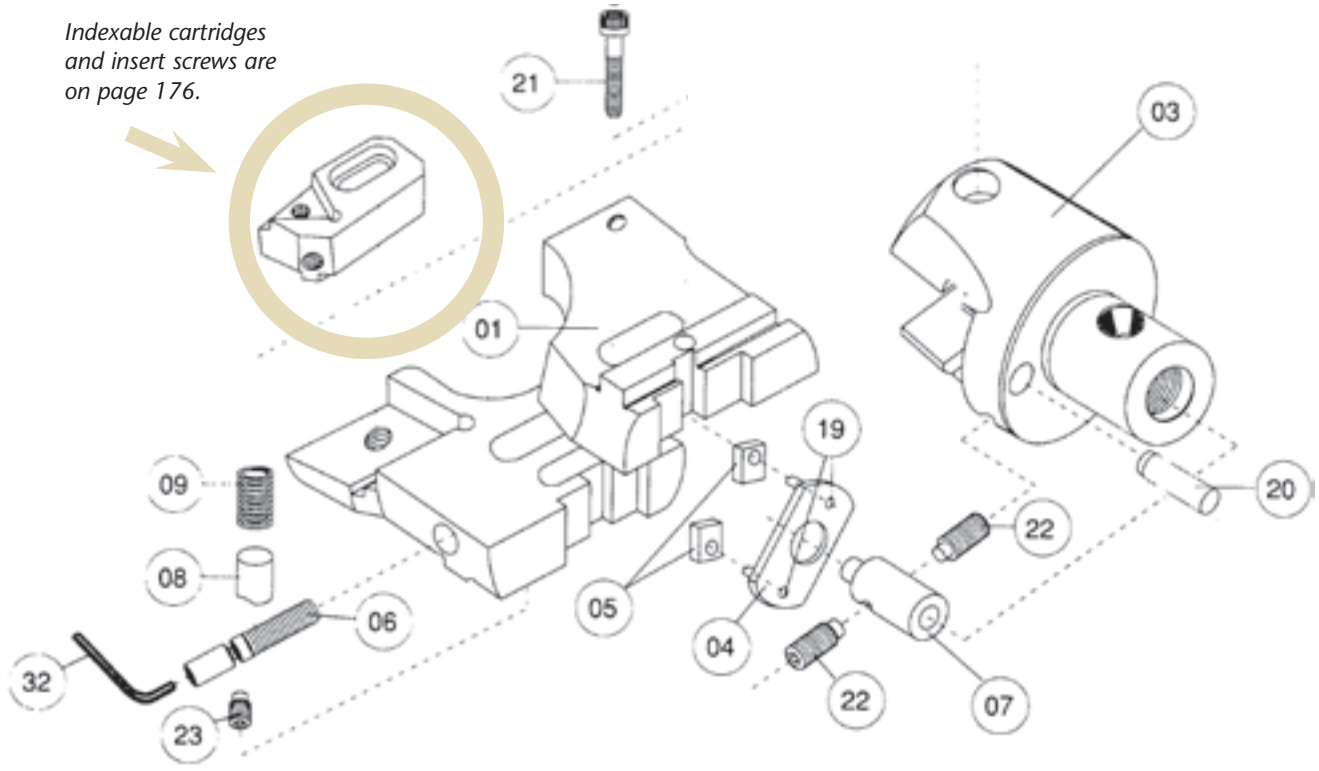
large head adapter

Large Head Adapter (use with adapter mount holders)

Part No.	Description	D	L	lbs
6022510	ADT-100-50	3.93"	1.96"	9.61

Parts for Rough Heads

Indexable cartridges and insert screws are on page 176.



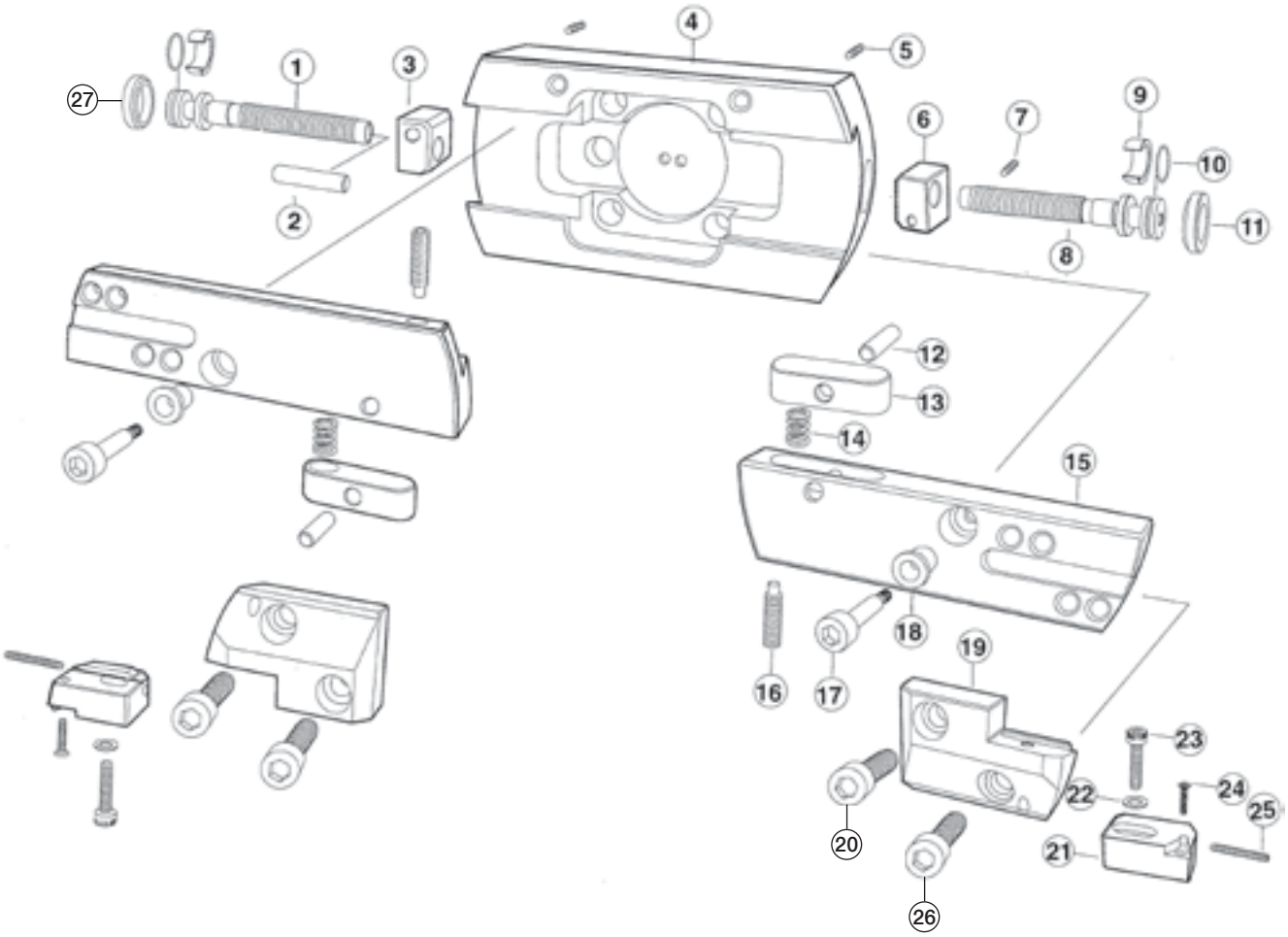
Rough Boring Heads - Integral Pocket

Boring Heads	01	03	04	05	06	07	08	09	19	20	21	22	23
D 22.75_ _ _	D22.75.01._ _ _	D22 03	D22 04		D22 06	D22 07	D22 08	D22 09	D22 19	D22 20	D22 21	D22 22	D22 23
D 22.90_ _ _	D22.90.01._ _ _	D22 03	D22 04		D22 06	D22 07	D22 08	D22 09	D22 19	D22 20	D22 21	D22 22	D22 23
D 27.75_ _ _	D27.75.01._ _ _	D27 03	D27 04		D27 06	D22 07	D22 08	D27 09	D22 19	D27 20	D27 21	D27 22	D27 23
D 27.90_ _ _	D27.90.01._ _ _	D27 03	D27 04		D27 06	D22 07	D22 08	D27 09	D22 19	D27 20	D27 21	D27 22	D27 23
D 32.75_ _ _W	D32.75.01._ _ _	D32 03W	D32 04		D32 06	D32 07	D32 08	D32 09	D32 19	D32 20	D32 21	D32 22	D32 23
D 32.90_ _ _W	D32.90.01._ _ _	D32 03W	D32 04		D32 06	D32 07	D32 08	D32 09	D32 19	D32 20	D32 21	D32 22	D32 23
D 42.75_ _ _	D42.75.01._ _ _	D42 03	D42 04	D42 05	D42 06	D42 07	D42 08	D42 09	D22 20	D42 20	D42 21	D42 22	D42 23
D 42.90_ _ _	D42.90.01._ _ _	D42 03	D42 04	D42 05	D42 06	D42 07	D42 08	D42 09	D22 20	D42 20	D42 21	D42 22	D42 23
D 54.75_ _ _	D54.75.01._ _ _	D54 03	D54 04	D42 05	D54 06	D54 07	D54 08	D42 09	D22 20	D54 20	D54 21	D54 22	D42 23
D 54.90_ _ _	D54.90.01._ _ _	D54 03	D54 04	D42 05	D54 06	D54 07	D54 08	D42 09	D22 20	D54 20	D54 21	D54 22	D42 23

Rough Boring Heads - Cartridge Type

Boring Heads	01	03	04	05	06	07	08	09	19	20	21	22	23
D 68.2CT_ _ _	D68 01 2CT	D68 03	D68 04	D68 05	D68 06	D68 07	D68 08	D68 09	D68 19	D68 20	D68 21	D68 22	D68 23
D 85.3CT_ _ _	D85 01 3CT	D85 03	D85 04	D85 05	D85 06	D85 07	D85 08	D85 09	D85 19	D85 20	D85 21	D85 22	D85 23
D 100.3CT_ _ _	D100 01 3CT	D100 03	D100 04	D85 05	D100 06	D100 07	D100 08	D85 09	D85 19	D100 20	D100 21	D85 22	D85 23
D 200.3CT_ _ _	D200 01 3CT	D200 03	D100 04	D85 05	D200 06	D100 07	D100 08	D85 09	D85 19	D100 20	D100 21	D85 22	D85 23

Parts for Large Rough Heads

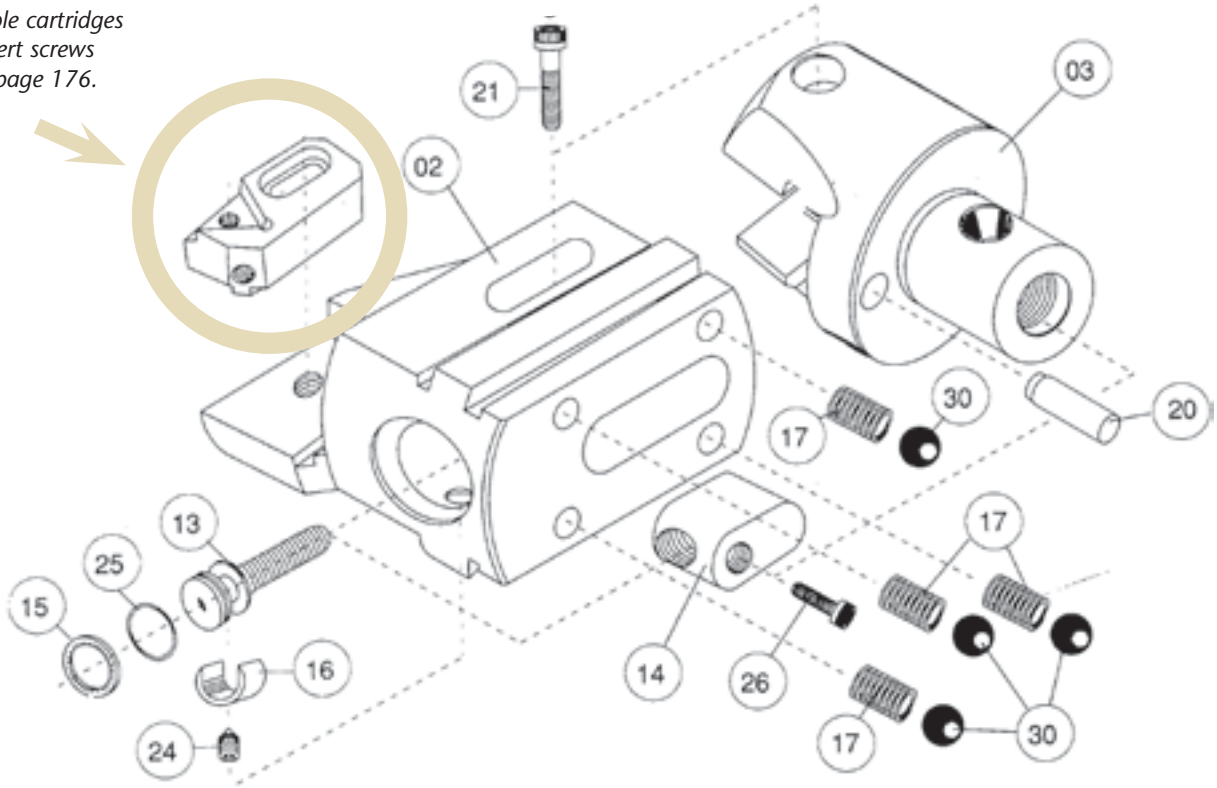


Large Rough Boring Heads

Spare Part	Rough Head Reference Number		
	D 300W	D 400W	D 500W
1	D300.51W	D400.51W	D500.51W
2	D300.66	D300.66	D300.66
3	D300.55W	D300.55W	D300.55W
4	D300.03	D400.03	D500.03
5	D68.23	D68.23	D68.23
6	D300.54W	D300.54W	D300.54W
7	D300.65	D300.65	D300.65
8	D300.50W	D400.50W	D500.50W
9	A68.16	A68.16	A68.16
10	A68.25	A68.25	A68.25
11	D300.15	D300.15	D300.15
12	D300.60	D300.60	D300.60
13	D300.56	D300.56	D300.56

Spare Part	Rough Head Reference Number		
	D 300W	D 400W	D 500W
14	D300.59	D300.59	D300.59
15	D300.01	D400.01	D500.01
16	D300.58	D300.58	D300.58
17	D300.57	D300.57	D300.57
18	D300.62	D300.62	D300.62
19	D300.49	D300.49	D300.49
20	D300.61	D300.61	D300.61
21	3CT._ _._ _ _	3CT._ _._ _ _	3CT._ _._ _ _
22	D68.28	D68.28	D68.28
23	D85.27	D85.27	D85.27
24	TT_ _ _ _ _	TT_ _ _ _ _	TT_ _ _ _ _
25	D85.29	D85.29	D85.29
26	D300.67	D300.67	D300.67
27	A68.15	A68.15	A68.15

Indexable cartridges and insert screws are on page 176.



Finish boring heads - Integral Pocket

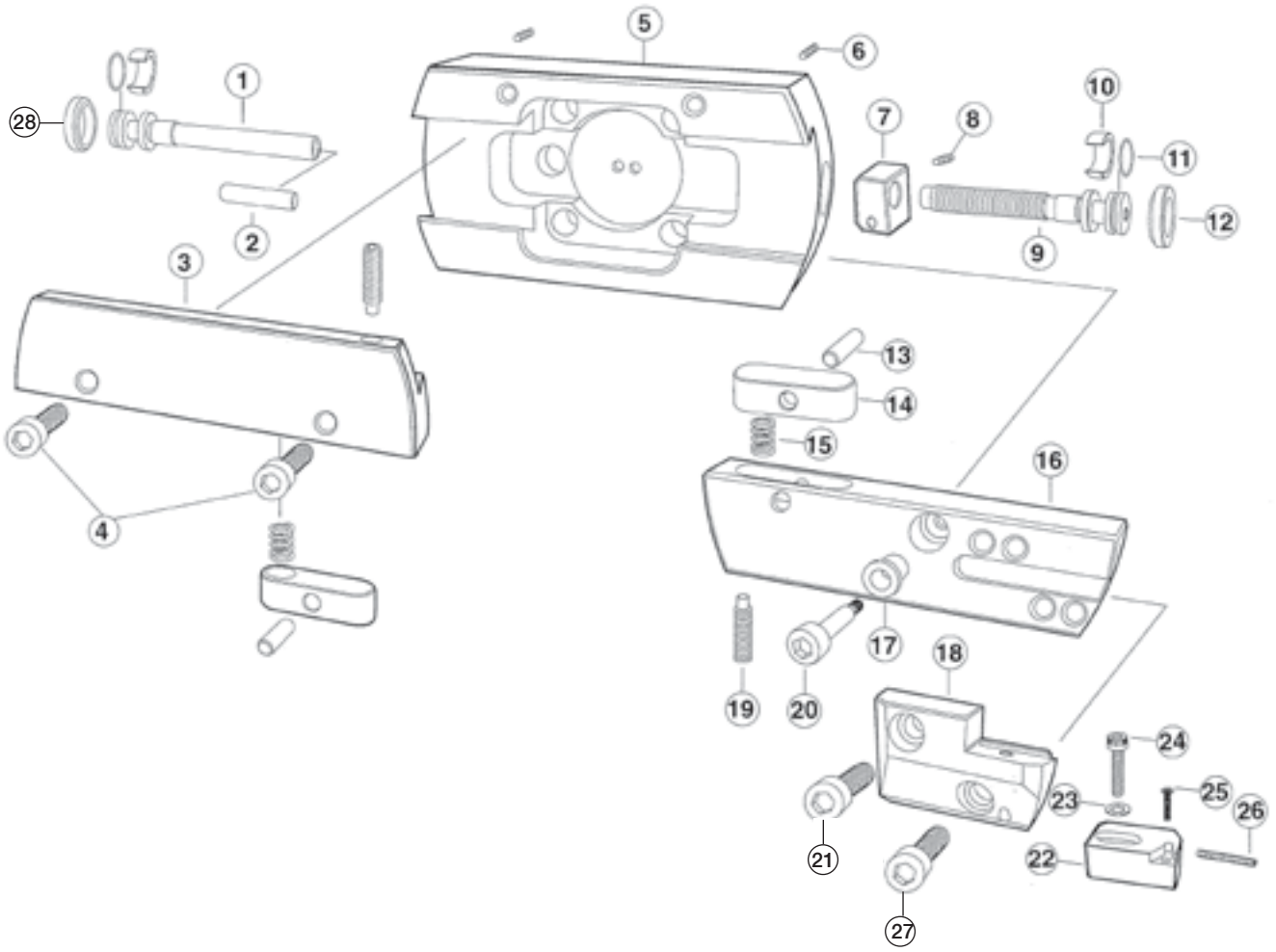
Boring Head	02	03	13	14	15	16	17	20	21	24	25	26	30
A 22.75_ _ _W	A22.75.02._ _ _	A22 03	A22 13W	A22 14W	A22 15	A22 16	A22 17	D22 20	D22 21	D22 23	A22 25	A22 26	A22 30
A 22.90_ _ _W	A22.90.02._ _ _	A22 03	A22 13W	A22 14W	A22 15	A22 16	A22 17	D22 20	D22 21	D22 23	A22 25	A22 26	A22 30
A 27.75_ _ _W	A27.75.02._ _ _	A27 03	A27 13W	A22 14W	A22 15	A22 16	A27 17	D27 20	D27 21	D27 23	A22 25	A27 26	A27 30
A 27.90_ _ _W	A27.90.02._ _ _	A27 03	A27 13W	A22 14W	A22 15	A22 16	A27 17	D27 20	D27 21	D27 23	A22 25	A27 26	A27 30
A 32.75_ _ _W	A32.75.02._ _ _	A32 03W	A32 13W	A32 14W	A32 15	A32 16	A27 17	D32 20	D32 21	D32 23	A22 25	A32 26	A27 30
A 32.90_ _ _W	A32.90.02._ _ _	A32 03W	A32 13W	A32 14W	A32 15	A32 16	A27 17	D32 20	D32 21	D32 23	A22 25	A32 26	A27 30
A 42.75_ _ _W	A42.75.02._ _ _	A42 03	A42 13W	A42 14W	A42 15	A42 16	A42 17	D42 20	D42 21	D42 23	A42 25	A42 26	A42 30
A 42.90_ _ _W	A42.90.02._ _ _	A42 03	A42 13W	A42 14W	A42 15	A42 16	A42 17	D42 20	D42 21	D42 23	A42 25	A42 26	A42 30
A 54.75_ _ _W	A54.75.02._ _ _	A54 03	A54 13W	A54 14W	A42 15	A42 16	D42 09	D54 20	D54 21	D42 23	A42 25	A42 26	A54 30
A 54.90_ _ _W	A54.90.02._ _ _	A54 03	A54 13W	A54 14W	A42 15	A42 16	D42 09	D54 20	D54 21	D42 23	A42 25	A42 26	A54 30

Finish boring heads - Cartridge Type

Boring Head	02	03	13	14	15	16	17	20	21	24	25	26	30
A 68.2CT_ _ _W	A68 02 2CT	A68 03	A68 13W	A68 14W	A68 15	A68 16	A68 17	D68 20	D68 21	D68 23	A68 25	A68 26	A68 30
A 85.3CT_ _ _W	A85 02 3CT	A85 03	A85 13W	A85 14W	A85 15	A85 16	D85 09	D85 20	D85 21	D85 23	A85 25	A85 26	A85 30
A 100.3CT_ _ _W	A100 02 3CT	A100 03	A85 13W	A85 14W	A85 15	A85 16	D85 09	D100 20	D100 21	D85 23	A85 25	A85 26	A85 30
A 200.3CT_ _ _W	A200 02 3CT	A200 03	A200 13W	A85 14W	A85 15	A85 16	D85 09	D100 20	D100 21	D85 23	A85 25	A85 26	A85 30

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

Parts for Large Finish Heads



Large Finish Boring Heads

Spare Part	Finish Head Reference Number		
	A 300W	A 400W	A 500W
1	A300.52W	A300.52W	A300.52W
2	D 300.66	D 300.66	D 300.66
3	A 300.02	A400.02	A500.02
4	A300.63	A300.63	A300.63
5	D300.03	D400.03	D500.03
6	D68.23	D68.23	D68.23
7	D300.54W	D300.54W	D300.54W
8	D300.65	D300.65	D300.65
9	D300.50W	D300.50W	D300.50W
10	A68.16	A68.16	A68.16
11	A68.25	A68.25	A68.25
12	D300.15	D300.15	D300.15
13	D300.60	D300.60	D300.60
14	D300.56	D300.56	D300.56

Spare Part	Finish Head Reference Number		
	A 300W	A 400W	A 500W
15	D300.59	D300.59	D300.59
16	D300.001	D400.001	D500.001
17	D300.62	D300.62	D300.62
18	D300.49	D300.49	D300.49
19	D300.58	D300.58	D300.58
20	D300.57	D300.57	D300.57
21	D300.61	D300.61	D300.61
22	3CT._ _._ _ _	3CT._ _._ _ _	3CT._ _._ _ _
23	D68.28	D68.28	D68.28
24	D85.27	D85.27	D85.27
25	TT_ _ _ _ _	TT_ _ _ _ _	TT_ _ _ _ _
26	D85.29	D85.29	D85.29
27	D300.67	D300.67	D300.67
28	A68.15	A68.15	A68.15

PinzBOHR Boring Tool Selection Guide

Use the questions below to determine your tooling requirements. You can also fill out and fax this information to us if you need assistance with your tooling selection. Fax it to: (317) 803-8001.

Name _____

Company _____

Address _____

City _____ St _____ Zip _____

E-mail _____ Ph _____ Fax _____

1. What is the finish size of the hole? _____
   (Determines size of boring head.)
2. What is the tolerance of the finished hole? _____
   (Determines if you need rough or finish boring head.)
3. Is the starting hole forged, cast, drilled, or reamed? _____
   (Determines whether you need 75 or 90 degree boring head.)
4. What is the design of the bored hole? _____
   (Also determines degree of boring head.)
   a. Stepped bore _____
   b. Thru bore _____
5. What material are you machining? _____
   (Determines insert grade and chip breaker selection.)
6. What spindle type is on the machine? _____
   (Determines holder selection.)
7. How deep is the bore? _____
   (Determines length of holder and extensions.)
8. Do you require any extra reach for fixturing or other reasons? _____
9. Does your machine have coolant-thru capability? _____

Misc: Select coolant option based on connection diameter and bore depth requirements (question #6 above).



Key to boring head descriptions

A 22 75 400 A = finish heads, D = rough heads
(see question #2 above)
22 = connection diameter (see question #1 above)
75 = approach angle (see question #3 above)
400 = insert style or CT cartridge (see question #5 above)



Key to boring toolholder descriptions

CT 330 or 350 22 100
CT = type of spindle (see question #6 above)
330 = taper size (see question #6 above)
22 = connection diameter (match head connection)
100 = boring depth (BD) (see question #7 above)

Precision Retention Knobs and Setup Equipment



Retention Knobs

- *All mating surfaces are precision ground*
- *Manufactured to the highest standards for maximum safety and long life*

Tightening Fixtures

- *Preset tools offline to save machine time*
- *For CAT, BT, HSK, ISO tapers*
- *Change retention knobs from below*



NEW!



Torque Wrenches and Adapters

http://ow.ly/rloi1
View the video on testing runout.

TECHNIKS
BUILT FOR SPEED
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a Quintec Company

You lose 10% of tool life for every .0001" of T.I.R. Always torque your retention knobs and collets to proper torque for best performance and tool life.

Built for Speed.

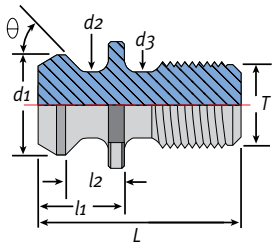
All Techniks products are backed by our 100% satisfaction guarantee!

CAT40, 50 Precision Retention Knobs

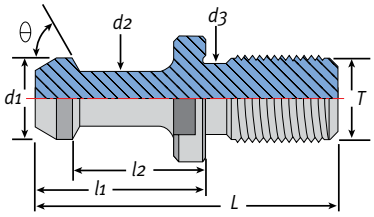


Techniks Retention Knobs

- *All mating surfaces precision ground*
- *Manufactured to the highest standards for maximum safety and long life*
- *Hardened for maximum longevity*



ANSI Style



MAS Style

Please make sure that the Retention Knob you order is the correct one for your machine. Using the wrong Retention Knob can cause damage to your machine spindle, the toolholder, and may create a safety hazard.

CAT Retention Knobs

Part No.	Type	θ	d1	d2	d3	L	l1	l2	T
21006-15	CAT40-DIN	15°	.75"	0.55"	0.640"	1.88"	1.024"	.787"	5/8 - 11
21007-15	CAT40-DIN	15°	.75"	0.55"	-	1.89"	1.028"	.792"	5/8 - 11
21003	CAT40-ANSI	45°	0.740"	0.490"	0.490"	1.50"	0.640"	.440"	5/8 - 11
21003-45	CAT40-MAS-I	45°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21003-60	CAT40-MAS-II	60°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21003-90	CAT40-MAS-III	90°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21005-45	CAT50-MAS-I	45°	0.906"	0.669"	0.827"	3.346"	1.772"	1.378"	1 - 8
21005-60	CAT50-MAS-II	60°	0.906"	0.669"	0.827"	3.346"	1.772"	1.378"	1 - 8
21005-90	CAT50-MAS-III	90°	0.906"	0.669"	0.827"	3.346"	1.772"	1.378"	1 - 8
21008-15	CAT50-DIN	15°	1.101"	0.825"	-	2.640"	1.338"	.984 "	1 - 8
21005	CAT50-ANSI	45°	1.140"	0.820"	0.820"	2.30"	1.00"	.700"	1 - 8

CAT Coolant Style Retention Knobs

Part No.	Type	θ	d1	d2	d3	L	l1	l2	T
21006-15C	CAT40-DIN Coolant	15°	.75"	0.55"	0.640"	1.88"	1.024"	.787"	5/8 - 11
21007-15C	CAT40-DIN Coolant	15°	.75"	0.55"	-	1.89"	1.028"	.792"	5/8 - 11
21148-C	CAT40-Coolant Mori-Seiki	15°	0.747"	0.548"	0.641"	2.004"	1.024"	.787"	5/8 - 11
21003-C	CAT40-ANSI-C	45°	0.740"	0.490"	0.490"	1.50"	0.640"	.440"	5/8 - 11
21003-45C	CAT40-Coolant-I	45°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21003-60C	CAT40-Coolant-II	60°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21003-90C	CAT40-Coolant-III	90°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21003-45CSF	CAT40-Coolant-I SlimFIT	45°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21003-60CSF	CAT40-Coolant-II SlimFIT	60°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21003-90CSF	CAT40-Coolant-III SlimFIT	90°	0.590"	0.394"	0.512"	2.25"	1.266"	.990"	5/8 - 11
21005-45C	CAT50-Coolant-I	45°	0.906"	0.669"	0.827"	3.346"	1.772"	1.378"	1 - 8
21005-60C	CAT50-Coolant-II	60°	0.906"	0.669"	0.827"	3.346"	1.772"	1.378"	1 - 8
21005-90C	CAT50-Coolant-III	90°	0.906"	0.669"	0.827"	3.346"	1.772"	1.378"	1 - 8
21008-15C	CAT50-DIN Coolant	15°	1.101"	0.825"	-	2.640"	1.338"	.984"	1 - 8
21005-C	CAT50-ANSI-C	45°	1.140"	0.820"	0.820"	2.30"	1.00"	.700"	1 - 8

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

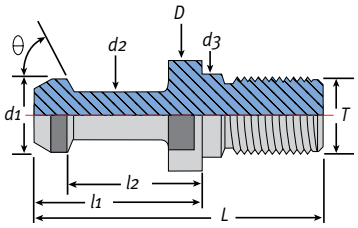
BT Retention Knobs



Techniks Retention Knobs

- *All mating surfaces precision ground*
- *Manufactured to the highest standards for maximum safety and long life*
- *Hardened for maximum longevity*

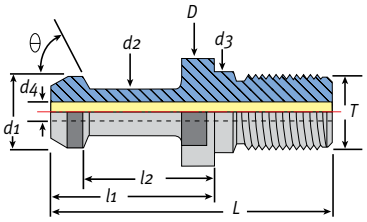
Please make sure that the Retention Knob you order is the correct one for your machine. Using the wrong Retention Knob can cause damage to your machine spindle, the toolholder, and may create a safety hazard.



BT Retention Knobs

Dimensions in millimeters.

Part No.	Description	θ	D	d1	d2	d3	L	l1	l2	T
17801	BT30 - 45°	45°	16.5	11	7	12.5	43	23	18	M12
17803	BT40 - 45°	45°	23	15	10	17	60	35	28	M16
17834	BT40, ANSI, metric thread	45°	23	18.8	12.5	12.4	38	16	11	M16
17805	BT50 - 45°	45°	38	23	17	25	85	45	35	M24
17806	BT30 - 60°	60°	16.5	11	7	12.5	43	23	18	M12
17808	BT40 - 60°	60°	23	15	10	17	60	35	28	M16
17810	BT50 - 60°	60°	38	23	17	25	85	45	35	M24
17812	BT30 - 90°	60°	16.5	11	7	12.5	43	23	8	M12
17814	BT40 - 90°	60°	23	15	10	17	60	35	28	M16
17816	BT50 - 90°	60°	38	23	17	25	85	45	35	M24



BT Coolant Style Retention Knobs

Dimensions in millimeters.

Part No.	Description	θ	D	d1	d2	d3	d4	L	l1	l2	T
17817	BT30 - 45° coolant	45°	16.5	11	7	12.5	4	43	23	18	M12
17836	BT40, ANSI, metric, coolant	45°	-	18.8	12.5	12.5	6.8	38	16	11	M16
17818	BT40 - 45° coolant	45°	23	15	10	17	4	60	35	28	M16
17820	BT40 - 60° coolant	60°	23	15	10	17	4	60	35	28	M16
17822	BT40 - 90° coolant	90°	23	15	10	17	4	60	35	28	M16
17824	BT50 - 45° coolant	45°	38	23	17	25	5	85	45	35	M24
17826	BT50 - 60° coolant	60°	38	23	17	25	5	85	45	35	M24
17828	BT50 - 90° coolant	90°	38	23	17	25	5	85	45	35	M24

Retention Knobs for CNC Routers

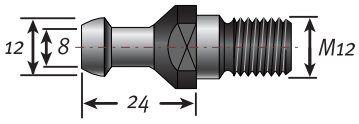


- *All mating surfaces precision ground*
- *Manufactured to the highest standards for maximum safety and long life*
- *Hardened for maximum longevity*

Match the dimensions and appearance of your retention knob to the drawings below. Use the manufacturer's print that came with your machine to verify your selection.

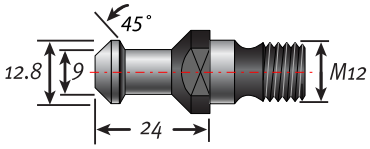
For safe operation, make sure that the pull stud you order is the exact pull stud your machine uses. Using the wrong pull stud can cause damage to the spindle and/or toolholder, and is a safety hazard.

HSD Spindles

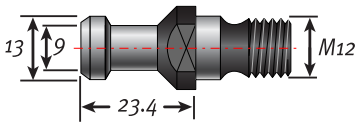


Part No. 49019
(for HSD spindles) Includes: Biesse, Bermag, Bussellato, CNT, DMS, CR Onsrud, Masterwood, Thermwood, and Holz-her

ISO30 Spindles

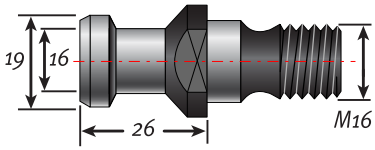


Part No. 49001-45
(Colombo ISO30 ball style for RS spindles) Includes: Motion Master (verify on manufacturer's print)



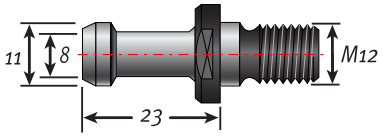
Part No. 49001
(for Colombo ISO30 billet spindle) Includes: Motion Master, Anderson (for newer machines, verify on manufacturer's print)

DAT Spindles

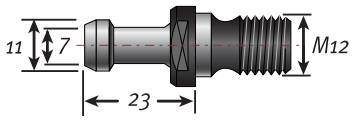


Part No. 49003
(DAT 40) (verify on manufacturer's print)

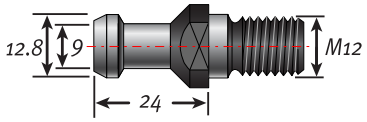
BT Spindles



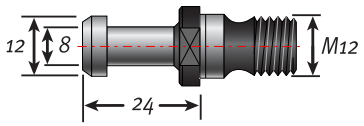
Part No. 07801
(BT30 – 45°) Includes: Heian, Shinx



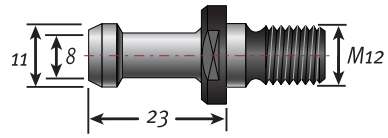
Part No. 07806
(BT30 – 60°) Includes: Shoda, Anderson (1997 and earlier, verify on manufacturer's print)



Part No. 750-19
(BT30 KOMO) Only for BT30 KOMO routers



Part No. 07812
(BT30 – 90°) (verify on manufacturer's print)



Part No. 4403502
(BT35 – 60°) (Heian, verify on manufacturer's print)

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

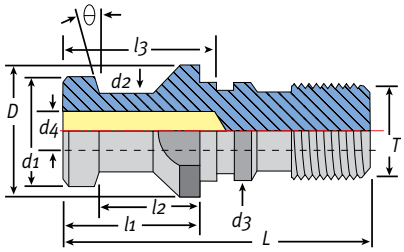
DIN 69871 A & B Retention Knobs & Calibration Tools



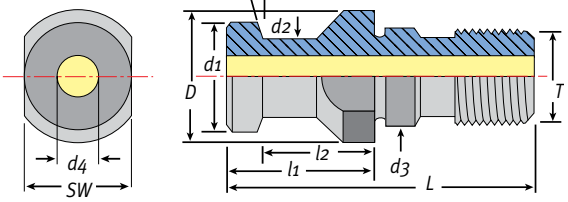
Techniks Retention Knobs

- *All mating surfaces precision ground*
- *Manufactured to the highest standards for maximum safety and long life*
- *Hardened for maximum longevity*

Please make sure that the Retention Knob you order is the correct one for your machine. Using the wrong Retention Knob can cause damage to your machine spindle, the toolholder, and may create a safety hazard.



DIN 69871B

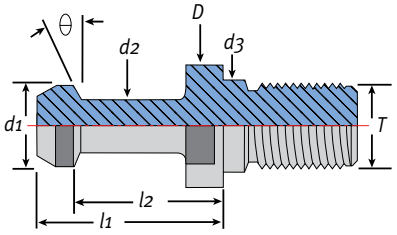


DIN 69871A

DIN 69871 A and B Style Retention Knobs

Dimensions in millimeters.

Part No.	Description	θ	D	d1	d2	d3	d4	L	l1	l2	l3	SW	T
49001	DAT30-A	15°	17	13	9	13	-	44	24	19	-	14	M12
49003	DAT40-A	15°	23	19	14	17	7	54	26	20	-	19	M16
49005	DAT50-A	15°	36	28	21	25	11.5	74	34	25	-	30	M24
49011	DAT30-B	15°	17	13	9	13	-	44	24	19	2.3	14	M12
49013	DAT40-B	15°	23	19	14	17	7	54	26	20	3.0	19	M16
49015	DAT50-B	15°	36	28	21	25	11.5	74	34	25	4.5	30	M24



Hard-To-Find- Retention Knobs

We can get the Retention Knobs you need. Just fill in your dimensions on the chart below before you call.

Keep your information in this catalog for easy re-orders.



CAT & BT Alignment Tools, HSK Calibration Tools

Part No.	Description
2100-CAT40-3	CAT 40 Alignment Tool - 3 pcs
2100-CAT50-3	CAT 50 Alignment Tool - 3 pcs
1600-BT30-3	BT 30 Alignment Tool - 3 pcs.
171.02.002.000	HSK 63F Calibration Tool - 4.975"

Stud	Machine	d1	d2	l1	l2	θ	T

Hand Wrenches for Collet Nuts



DNA slotted wrench



ER hex wrench



ER or TG slotted wrench

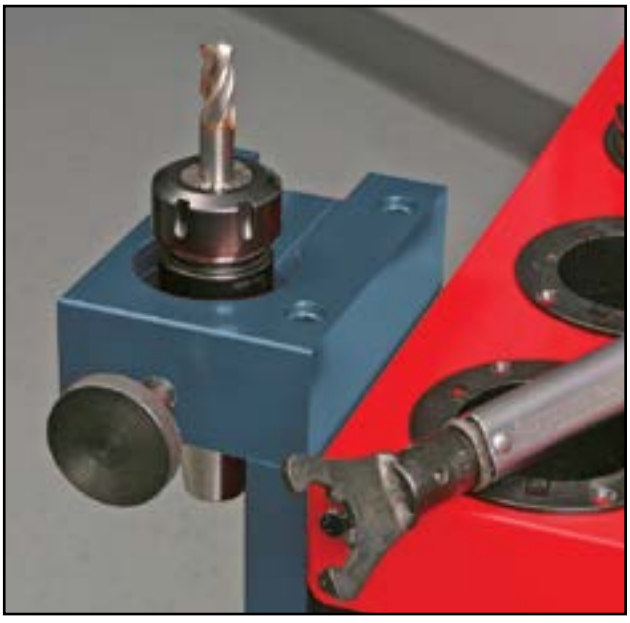


ER mini wrench



TG hook wrench

Note: *Correct torque on the collet nut reduces collet wear and improves safety by properly securing cutting tool in the holder. Use the torque chart on page 72 for tightening collet nuts. Do not over-tighten nuts or you may damage the collet and/or toolholder.*



Use a tightening fixture to secure the toolholder. (pg. 206)

DNA Hand Wrenches

Part No.	Description	Nut Type
DNA11W	DNA 11 wrench	DNA-11
DNA16W	DNA 16 wrench	DNA-16
DNA20W	DNA 20 wrench	DNA-20
DNA32W	DNA 32 wrench	DNA-32
894-22	DNA 16 mini nut wrench	DNA-16 Mini

ER Hex Hand Wrenches

Part No.	Description	Nut Type
894-36	TE-Short wrench	TE Short
04608	ER11-A wrench	A (Hex)
04609	ER16-A wrench	A (Hex)
04610	ER20-A wrench	A (Hex)

ER Slotted Hand Wrenches

Part No.	Description	Nut Type
04613	ER16-E wrench	Slotted
04614	ER20-E wrench	Slotted
04615	ER25-E wrench	Slotted
04616	ER32-E wrench	Slotted
04617	ER40-E wrench	Slotted
04618	ER50-E wrench	Slotted

ER Mini Hand Wrenches

Part No.	Description	Nut Type
04620	ER8-M wrench	ER Mini
04621	ER11-M wrench	ER Mini
04622	ER16-M wrench	ER Mini
04623	ER20-M wrench	ER Mini
04624	ER25-M wrench	ER Mini

TG, SYOZ and Drill Chuck Hand Wrenches

Part No.	Description	Nut Type
04616	TG 75 slotted wrench	TG 75
03691	TG 100 hook wrench	TG 100
22220	SYOZ 20 wrench	SYOZ 20
82172	Drill Chuck wrench	Chuck

Adjustable Torque Wrenches and Collet Key Adapters



Torque Wrench Features

- *Provides proper tightening for cutting tool life*
- *Easy read dial for fast adjustments to torque value*
- *Prevent tool accidents*



Set adjustable dial to specified torque and tighten nut until wrench "clicks".

Torque values given in tables on this page.

Adjustable Torque Wrench

Part No.	Range	Length	Weight	Spigot
60TH	5-45 ft/lbs	12"	1 lb.	16mm round
200TH	30-150 ft/lbs	16.5"	1.75 lbs	16mm round
300TH	45-228 ft/lbs	21.5"	2.5 lbs	16mm round



ER25 Mini



TG Hook



DNA 16 Slotted



ER Hex



ER Slotted

ER Mini Collet Key Adapters

Part No.	Size	Type	Torque
04576	ER11 mini	mini	12 ft/lbs
04577	ER16 mini	mini	20 ft/lbs
04578	ER20 mini	mini	22 ft/lbs
04587	ER25 mini	mini	28 ft/lbs

ER Hex Collet Key Adapters

Part No.	Size	Type	Torque
04601-16	ER16 hex	hex	42 ft/lbs
04602-20	ER20 hex	hex	59 ft/lbs

TG and SYOZ Collet Key Adapters

Part No.	Size	Type	Torque
04604-32	TG 75	slotted	90 ft/lbs
03690-25	TG 100/SYOZ 25	hook	90 ft/lbs
SYOZ20-TWA	SYOZ-20	hook	40 ft/lbs

ER Slotted Collet Key Adapters

Part No.	Size	Type	Torque
DNA11TWA	DNA 11	slotted	12 ft/lbs
DNA16TWA	DNA 16	slotted	42 ft/lbs
DNA20TWA	DNA 20	slotted	59 ft/lbs
DNA32TWA	DNA 32	slotted	100 ft/lbs
04580-16	ER16 slotted	slotted	42 ft/lbs
04580-20	ER20 slotted	slotted	59 ft/lbs
04603-25	ER25 slotted	slotted	77 ft/lbs
04604-32	ER32 slotted	slotted	100 ft/lbs
04605-40	ER40 slotted	slotted	130 ft/lbs



Retention Knob Sockets – Square Drive

Part No.	Size	Flats	Drive	Torque
PSS-30BT	BT30	0.535"	3/8"	36 ft/lbs
PSS-30ISO	ISO 30	0.535"	3/8"	36 ft/lbs
PSS-40	All 40 taper	0.750"	3/8"	76 ft/lbs
PSC-50	CAT50, BT50	1.187"	1/2"	100 ft/lbs

Fixed Head Square Drives

Part No.	Description	Drive
29828	3/8" square drive	3/8"
29827	1/2" square drive	1/2"



Tightening Fixtures For CAT, BT, HSK, and ISO Spindles



A sliding collar engages the wrench flats on HSK and toolholders without drive slots.

NTS Side Mount Fixtures

- *For CAT, BT, HSK, ISO spindles*
- *Change knobs from bottom*
- *Bolts right to workbench*





A large set-screw engages the drive slot in BT and CAT holders.

40 Taper and BT30 NTS Fixtures

Part No.	Description
NTS-40-TAPER	Any CAT40 or BT40 taper
NTS-BT30-38	BT30 taper - 38mm flats
NTS-BT30-41	BT30 taper - 41mm flats
NTS-BT30-SLOT	BT30 for drive slots

HSK63 NTS Fixtures

Part No.	Description
NTS-HSK63A	HSK63A - no flats
NTS-HSK63F-36	HSK63F - 36mm flats
NTS-HSK63F-38	HSK63F - 38mm flats
NTS-HSK63F-41	HSK63F - 41mm flats
NTS-HSK63F-46	HSK63F - 46mm flats

ISO NTS Fixtures

Part No.	Description
NTS-ISO20-17	ISO 20 - 17mm flats
NTS-ISO20-22	ISO 20 - 22mm flats
NTS-ISO25-27	ISO 25 - 27mm flats
NTS-ISO30-36	ISO 30 - 36mm flats
NTS-ISO30-38	ISO 30 - 38mm flats
NTS-ISO30-47	ISO 30 - 47mm flats

Top or Side Mount Fixtures

- *For CAT, BT, HSK, spindles*
- *Change knobs from bottom*
- *Bolts right to workbench*



BT, CAT style *HSK style*

Top or Side Mount Fixtures

Part No.	Description
17883	BT30, CAT 30
07884	BT40, CAT40
07885	BT50, CAT50
17893	HSK63A, 63B, 63D

Benchtop Mount Fixtures

- *For CAT, BT spindles*
- *Bolts right to workbench*



Benchtop Mount for CAT & BT

Part No.	Description
07852	BT30
07854	BT40
07856	BT50
07870	CAT40
07872	CAT50

NEW! – Auto-Locking Stands

- *For HSK & C5, C6 spindles*
- *NEW! Roller-Bearing design*
- *Fastest tool changes possible, simply drop holder into stand and tighten or loosen*



Benchtop Stand for HSK & C5,C6

Part No.	Description
17844B	HSK50A, 50E, 50F, C5
17846B	HSK63A, 63E, 63F, C6

See our product application videos at: www.techniksusa.com

SYIC

Spindle Wipers – Analog and Touch Lamp Preset Gauges



Real lambskin provides the best cleaning. Use with any type of machine with a taper of 7/24 CAT, BT or DIN 69871.

Spindle Wipers

- *For CAT, BT, ISO, HSK spindles*
- *Keep spindle and tapers clean*

Part No.	Taper
17706	30
17707	40
17708	50
38036	HSK63A
38032	HSK63F

Magnetic V-Blocks & V-Block Sets

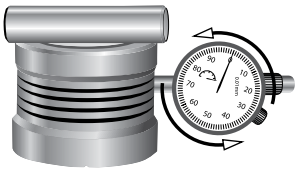
- *See page 237*
- *Fast and powerful workholding*

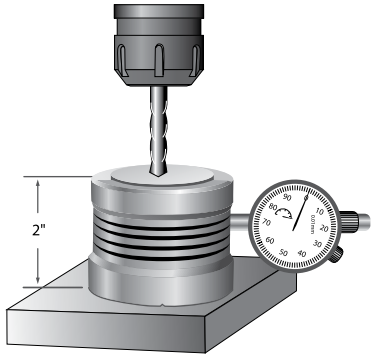




Analog Axial Preset Gauge Features

- *Accuracy 0.0002"*
- *Easy to measure tool depth*
- *Height 50mm*





Analog Axial Preset Gauge

Part No.	Description
17906-2	ZSI-50 preset gauge
17906-04	replacement dial

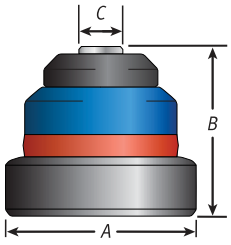
1. Use the gauge pin included to press down on the spring-loaded center piece as illustrated. Please be sure the gauge pin is placed on the shiny surface.
2. Turn the indicator to read "0", then remove the gauge pin.

3. Put the unit on the workpiece and carefully jog the tool down to make contact with the gauge face. When the gauge reads "0" the tool is 2" above the workpiece.



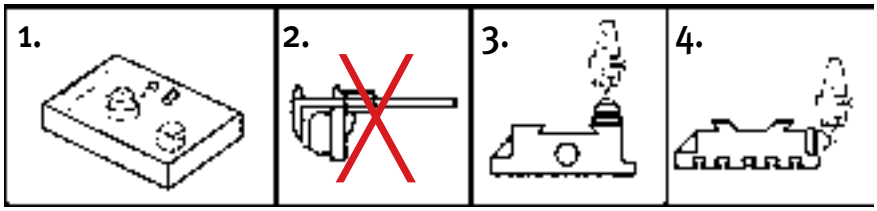
Touch Lamp Axial Preset Gauge Features

- *Accuracy .0002"*
- *360° red lamp lights up when touched*
- *Height 2" (50mm)*
- *Magnetic base (use vertically or horizontally)*



Instructions

1. *Check height of unit with a gauge block and dial indicator. Turn allen screw on the side of the unit if adjustment is needed.*
2. *Do not use calipers for presetting unit, only use gauge block.*
3. *Move the cutting tool tip towards the sensor button until the unit lights up, then reverse direction until the light goes off.*
4. *When presetting diameter, rotate tool slowly for higher precision.*

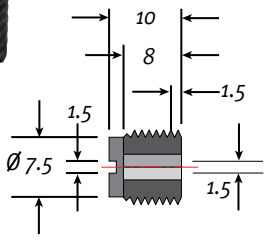


Touch Lamp Axial Preset Gauge

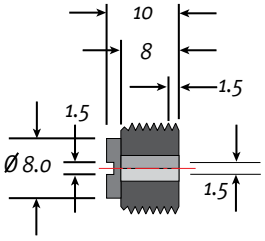
Part No.	Description	A	B	C
07905-2	ZOP-50 Gauge	56mm	50mm or 2"	13.5mm

Coolant-Thru Pre-Set Screws

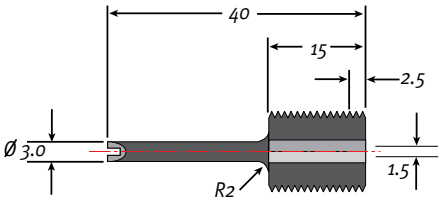




BD-TH-1031



BD-TH-1062



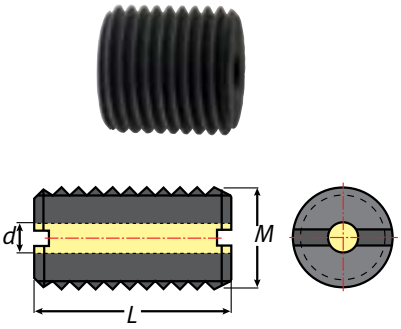
BD-TH-1063

Coolant Set Screws

Part No.	Description
BD-TH-1031	For M10 x 1.5 straight shank chuck with coolant – for small diameter tools
BD-TH-1062	For M12 x 1.75 straight shank chuck w/ coolant – for small diameter tools
BD-TH-1063	Long stop for M12 x 1.75 straight shank chuck w/coolant – for small diameter tools

Coolant Set Screws

Part No.	Description	M	L	d
16080C-20	Coolant Set Screw	M5 x 0.8P	20mm	2.5
16082C-20	Coolant Set Screw	M8 x 1.25P	20mm	4
16083C-20	Coolant Set Screw	M10 x 1.5P	20mm	4
16085C-20	Coolant Set Screw	M12 x 1.75P	20mm	4
16089C-20	Coolant Set Screw	M16 x 02.0P	20mm	5
16091C-20	Coolant Set Screw	M20 x 2.0P	20mm	5



Solid Pre-set Screws for ER and TG Collet Chucks

Part No.	Description	Figure	Collet Series
16081	M 6 x 1.0 P - 15	1	ER11
16083	M 10 x 1.5 P - 15	1	ER16
16085	M 12 x 1.75 P - 15	1	ER20
16087	M 12 x 1.75 P - 25 (extended)	2	ER20
16088	M 8 x 1.25 P -16	1	-
16089	M 16 x 2.0 P - 15	1	ER25 & 32, TG 75
16096	M 16 x 2.0 P - 50		-
16091	M 20 x 2.0 P - 15	1	ER40
16094	M 20 x 2.0 P - 50		-
16092	M20 x 2.0P - 100		-
16093	M 24 x 2.0 P - 15	1	ER50 & TG 100

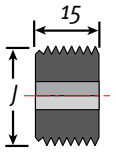


Figure 1

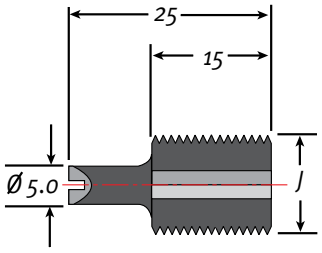


Figure 2

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

MagVISE Workholding Systems

We Provide Turn-Key Magnetic Workholding Solutions

Contact us for solutions to your workholding bottlenecks.

MagVISE WORKHOLDING

Magnetic Chucks



Modular Chucks

NEW!



Horizontal Chucks



Indexing Chucks



Round Chucks

NEW!

For lathe and vertical turning or grinding



Injection Mold Clamping

NEW!



Magnetic Vises



Surface Grinding



EARTH-CHAIN
Power that works.

View Magnetic Workholding videos at: http://ow.ly/tL1Yo

MagVISE WORKHOLDING

Depend On Us

We're large enough to have the talent and resources you need, but small enough to respond quickly and get to know your business on a personal level.



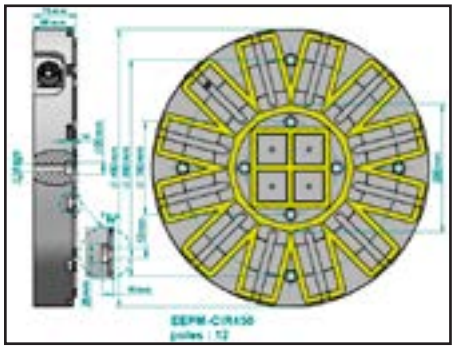


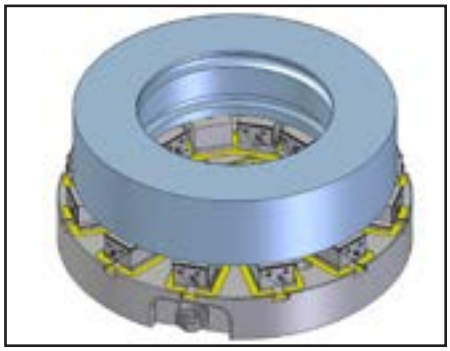
Our entire team is committed to providing the information and solutions you are looking for.

Engineered Turn-Key Solutions

Our team has been doing magnetic workholding installations for over 10 years. Tap into our experience solving tough manufacturing process problems. We can help you become more competitive and improve your bottom line.

Our engineered solutions are proved-out at our Tech Center and are guaranteed to perform as advertised.





Design – Build – Install – We work closely with your team to ensure your complete satisfaction.

We Go The Extra Mile

Our "Roadshow" program brings the benefits of attending one of our trade show events right to your facility. We will provide live product demonstrations and answer your questions about magnetic workholding, material transport and CNC tooling. While we are there we can verify the holding power of your magnetic chucks (see below).

Call (800) 597-3921 to schedule a visit.





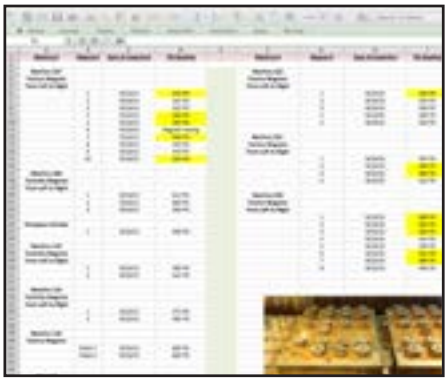
We'll bring a van chock-full of magnetic workholding , material lifting, and CNC tooling solutions for live demos.

Magnetic Chuck Verification

Ever wonder if the magnetic chucks you own are still producing their maximum holding power?

Our experts will come to your facility and quickly perform a complimentary holding power check on ALL your magnetic chucks, and give you a detailed report on the condition and functionality of all your chucks and controls.



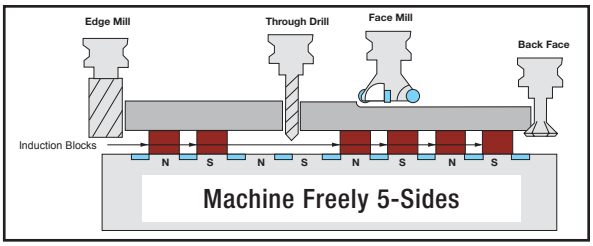


We can perform a complimentary holding power check on all your magnetic chucks, with full report.

Questions about MagVISE Workholding?

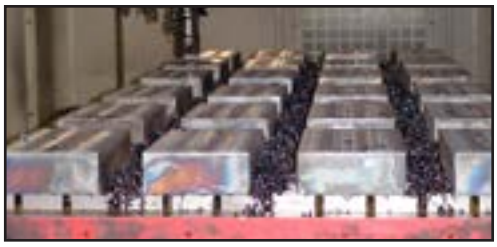
Why should I consider magnetic workholding?

Compared to traditional fixturing methods, magnetic workholding frees up all five sides of your workpiece so you can machine the entire profile of the part in one set-up. Magnetic workholding greatly reduces set up and part change-over time, giving your spindle more time to make chips.



How long does magnetic workholding take to pay for itself?

Magnetic chucks pay for themselves very quickly because machine up-time and production output are increased. Every case is unique, but in most cases payoff occurs in just a few months.



How does magnetic workholding simplify setups?

Once you have your part(s) indicated on the magnet, change-over only requires turning the magnet on/off to remove and load the parts.



What is magnetic workholding best suited for?

Thick or thin, large or small – just about any ferrous material can be held and machined magnetically. Bigger parts are easier to hold because there is more metal for the magnetism to be attracted to. For smaller parts, using work stops and nesting the part are options that work well. Magnetic workholding is used for just about any type of drilling, milling, and boring operation you can think of, on horizontal or vertical CNC machines.



How do I know magnetic workholding will work for me?

No matter what size parts you cut, we can verify your application on our "test bed" CNC so we can offer you a turn-key workholding solution. We will duplicate your application using magnetic workholding and machine your part to verify the process and document the time savings. All at no risk to you.

Should I get magnetic chucks or magnetic vises?

Magnetic vises have a smaller foot print, and are turned ON/OFF using a manual switch. Magnetic chucks require a controller to turn ON/OFF, but DO NOT require electrical connection to maintain holding power. Magnetic chucks provide more surface contact with the workpiece and feature a greater number of magnetic poles, so they can produce more holding power than magnetic vises. During a power outage magnetic chucks will not lose holding power, so they are just as safe to use as magnetic vises.

For more information you can call us at (800) 597-3921 or (317) 803-8000. Our team has been doing magnetic workholding installations for over 10 years, and in just a few minutes we can probably tell you everything you need to know.



EEPM magnetic chuck with control



ECB magnetic vises

MagVISE EEPM Magnetic Workholding Chucks

Features:

- *Up to 86,625 lbs. holding power**
- *Turn chuck ON/OFF in only a few seconds – chuck will not lose magnetism if a power loss occurs*
- *Induction blocks and subplates provide additional setup options for holding small parts or warped stock*

Advantages:

- *Machine freely on 5-sides & top so you can cut the full part profile in only 1 operation*
- *Reduce setup & part change-over time by 50% or more!*
- *Very uniform holding = No workpiece deformation*

EEPM chucks includes control and remote

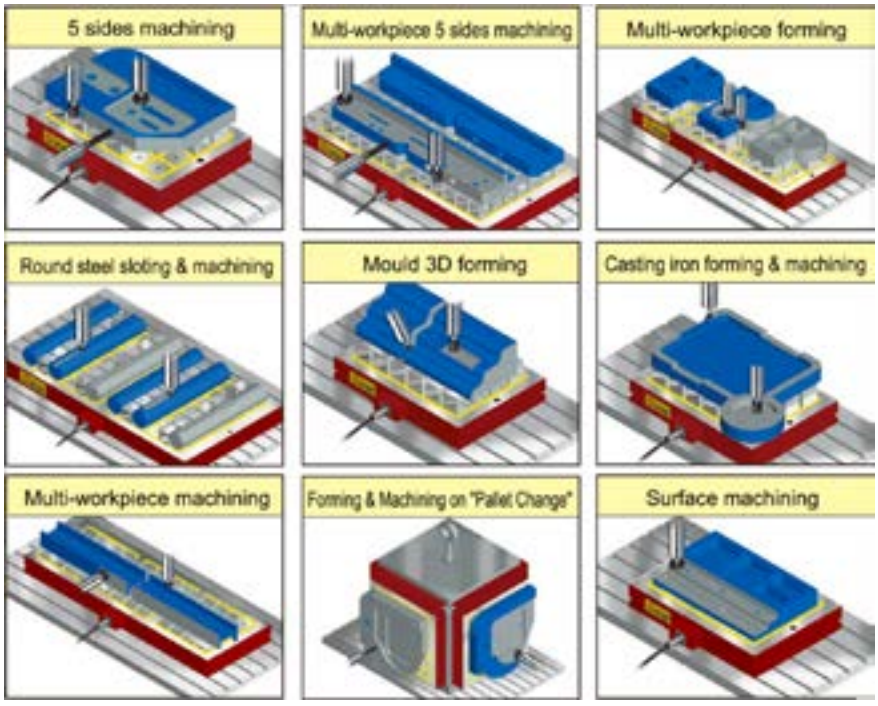


**26 sizes available*
See page 218 for holding power ratings.
For workholding of ferrous materials only.

Use magnetic workholding to speed up drilling, milling, and boring operations on either thick or thin workpieces. Magnetic chucks make setup and part change-over faster and safer, and reduce the number of required operations.

Our magnetic chucks easily integrate with pallet changing and tombstone systems used in production cells. Choose magnetic workholding for uniform holding of the workpiece, without part distortion or dead spots. Uniform workholding reduces chatter and harmonics for improved surface finish and tool life.

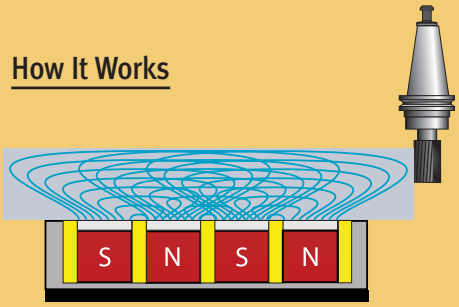
Application Examples



Holding Power Example

EEPM 3040W chuck (left) has 20 poles, and produces 16,500 ft/lbs of holding power.

How It Works



In the ON state, alnico and rare-earth magnets alternate poles, creating a powerful magnetic attraction. Holding power varies with type of material being held, surface finish, and part thickness.

Minimum recommended part size is 5" x 5" x 3/8" thick, so a minimum of 4 magnetic poles are covered by the part. Workstops, pins or part nesting techniques ensure the ability to hold small, thin parts without movement.

Induction Blocks and Subplates

We recommend using induction blocks or subplates at all times to preserve the precison ground finish and prevent damage to the face of the magnetic chuck. For more information see page 219.

Scan the QR code or enter the link below into your browser to view EEPM workholding application video.

http://ow.ly/u1YX0

MagVISE EEPM Application Examples



Gang part setups together and still machine 5-sides-



Easily hold over-size workpieces



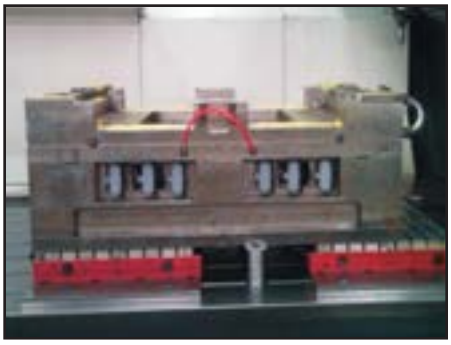
Machining mold cavities



Easy integration with auto-loading systems



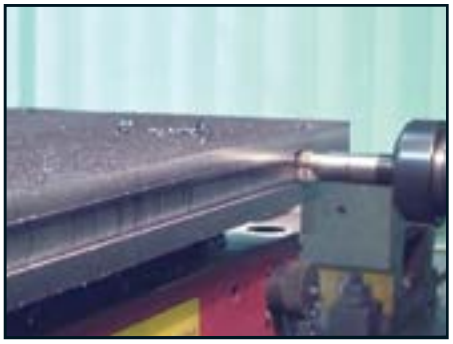
Slope milling unusual parts or 5-axis



Machining injection mold application



Use spring-loaded blocks for warped stock



Powerful workholding for machining heavy side loads



Fast and easy to gang multiple setups together



Custom solution for holding large flat plates



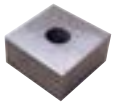
High holding power for heavy cutting



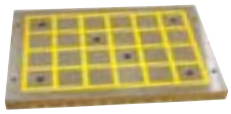
Face millilng on workpiece with work-stops installed

Ordering EEPM Workholding Chucks and Subplates

- *Select a chuck larger than your part for maximum holding power*
- *Subplates are sized to match the chuck but are 1" thick – See table below*
- *Control is included and requires dedicated, 480v, single phase, 30A power*



induction block



subplate

Use induction blocks or subplates at all times to preserve the precison ground finish and prevent damage to the face of the magnetic chuck.

S = 1.2" S1 = 1" G = 0.4 M = 1.2"

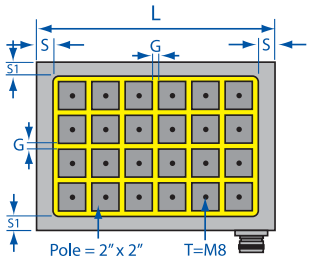


Fig. 1

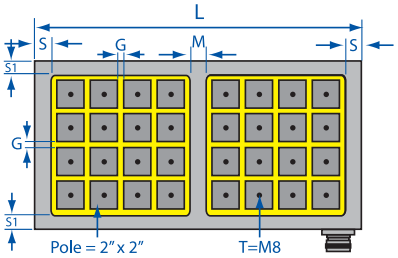


Fig. 2

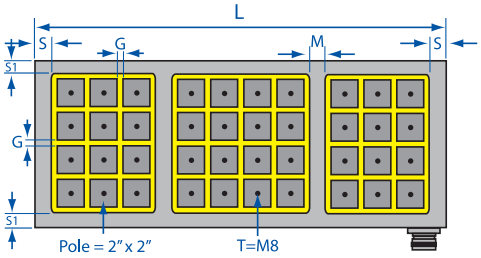


Fig. 3

Model	Fig	L x W x H	Poles	Holding Power	Chuck Weight	Subplate	Controller
EEPM-2540W-480	1	16.9" x 9.4" x 2.8"	18	12,375 lbs.	110 lbs.	EEPM-2540ISP	EEPM-C1
EEPM-2560W-480	2	23.2" x 9.4" x 2.8"	24	16,500 lbs.	152 lbs.	EEPM-2560ISP	EEPM-C1
EEPM-2580W-480	3	31.9" x 9.4" x 2.8"	33	22,687 lbs.	202 lbs.	EEPM-2580ISP	EEPM-C1
EEPM-2590W-480	3	34.3" x 9.4" x 2.8"	36	24,750 lbs.	216 lbs.	EEPM-2590ISP	EEPM-C2
EEPM-25100W-480	3	39.0" x 9.4" x 2.8"	42	28,875 lbs.	244 lbs.	EEPM-25100ISP	EEPM-C2
EEPM-3030W-480	1	12.2" x 11.8" x 2.8"	16	11,000 lbs.	97 lbs.	EEPM-3030ISP	EEPM-C1
EEPM-3040W-480	1	16.9" x 11.8" x 2.8"	24	16,500 lbs.	134 lbs.	EEPM-3040ISP	EEPM-C1
EEPM-3060W-480	2	23.2" x 11.8" x 2.8"	32	22,000 lbs.	180 lbs.	EEPM-3060ISP	EEPM-C1
EEPM-3080W-480	3	31.9" x 11.8" x 2.8"	44	30,250 lbs.	255 lbs.	EEPM-3080ISP	EEPM-C2
EEPM-3090W-480	3	34.3" x 11.8" x 2.8"	48	33,000 lbs.	271 lbs.	EEPM-3090ISP	EEPM-C2
EEPM-30100W-480	3	39.0" x 11.8" x 2.8"	56	38,500 lbs.	304 lbs.	EEPM-30100ISP	EEPM-C2
EEPM-4040W-480	1	16.9" x 16.5" x 2.8"	36	24,750 lbs.	185 lbs.	EEPM-4040ISP	EEPM-C2
EEPM-4050W-480	1	18.9" x 16.9" x 2.8"	42	28,875 lbs.	209 lbs.	EEPM-4050ISP	EEPM-C2
EEPM-4060W-480	2	23.2" x 16.5" x 2.8"	48	33,000 lbs.	255 lbs.	EEPM-4060ISP	EEPM-C2
EEPM-4080W-480	3	31.9" x 16.5" x 2.8"	66	45,375 lbs.	350 lbs.	EEPM-4080ISP	EEPM-C2
EEPM-4090W-480	3	34.3" x 16.5" x 2.8"	72	49,500 lbs.	372 lbs.	EEPM-4090ISP	EEPM-C4
EEPM-40100W-480	3	39.0" x 16.5" x 2.8"	84	57,750 lbs.	425 lbs.	EEPM-40100ISP	EEPM-C4
EEPM-5060W-480	2	23.2" x 18.9" x 2.8"	56	38,500 lbs.	284 lbs.	EEPM-5060ISP	EEPM-C2
EEPM-5080W-480	3	31.9" x 18.9" x 2.8"	77	52,937 lbs.	407 lbs.	EEPM-5080ISP	EEPM-C4
EEPM-5090W-480	3	34.3" x 18.9" x 2.8"	84	57,750 lbs.	431 lbs.	EEPM-5090ISP	EEPM-C2
EEPM-50100W -480	3	39.0" x 18.9" x 2.8"	98	67,375 lbs.	482 lbs.	EEPM-50100ISP	EEPM-C4
EEPM-6060W-480	2	23.2" x 23.6" x 2.8"	72	49,500 lbs.	363 lbs.	EEPM-6060ISP	EEPM-C4
EEPM-6080W-480	3	31.9" x 23.6" x 2.8"	99	68,062 lbs.	473 lbs.	EEPM-6080ISP	EEPM-C4
EEPM-6090W-480	3	34.3" x 23.6" x 2.8"	108	74,250 lbs.	528 lbs.	EEPM-6090ISP	EEPM-C4
EEPM-60100W-480	3	39.0" x 23.6" x 2.8"	126	86,625 lbs.	603 lbs.	EEPM-60100ISP	EEPM-C4
EEPM-8080W-480	3	31.9" x 29.7" x 2.8"	121	83,187 lbs.	596 lbs.	EEPM-8080ISP	EEPM-C4

MagVISE Induction Blocks & Subplates For EEPM

Induction Blocks and Subplates

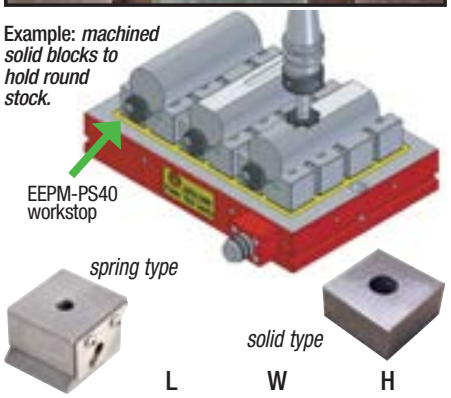
We recommend using induction blocks or subplates at all times to preserve the precison ground finish and prevent damage to the face of the magnetic chuck. Order subplates from the table on page 218.



EEPM-SP spring blocks adjust to hold warped stock.

Individual Induction Blocks

Use induction blocks to raise the workpiece above the surface of the magnet and permit machining 5 sides and thru-hole drilling. Individual induction blocks provide maximum flexibility for creating custom setups for holding difficult workpieces and warped stock.



Part No.	Description	L	W	H
EEPM-SP	spring loaded (2 piece set, 8mm screw)	1.89"	1.89"	1.41"
EEPM-SPF	solid, machinable (8mm screw)	1.97"	1.97"	1.23"

Connected Induction Blocks

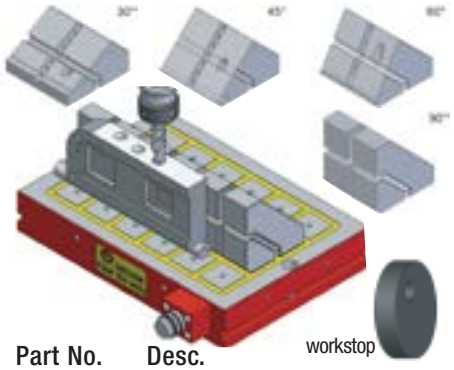
Makes setups faster and easier when large numbers of induction blocks are required. Choose from 2, 3, 4, or 6 pole configurations.





Part No.	Desc.	L	W	H
EEPM-IB225	2-pole block	4"	1.97"	.98"
EEPM-IB325	3-pole block	6"	1.97"	.98"
EEPM-IB425	4-pole block	8"	1.97"	.98"
EEPM-IB625	6-pole block	12"	1.97"	.98"

Angled Induction Blocks & Workstop



Part No.	Desc.
EEPM-IBT30	30˚ angle, 4-pole induction block
EEPM-IBT45	45˚ angle, 4-pole induction block
EEPM-IBT60	60˚ angle, 4-pole induction block
EEPM-IBT90	90˚ angle, 4-pole induction block
EEPM-PS40	round workstop (replacement)

Setup Notes

Always make sure you read, understand and follow all the Owner's Manual instructions and CAUTIONS that come with your EEPM Magnetic Chuck before setting it up and using it.

After installing your induction blocks we recommend cleanup milling the surface of your induction blocks before loading your work piece to insure that the surface height is uniform and parallel to the spindle. Subplates are precision ground and do not require cleanup milling.

Please note that the spring loaded induction blocks are NOT machineable, but the solid blocks are able to be drilled and machined as required.

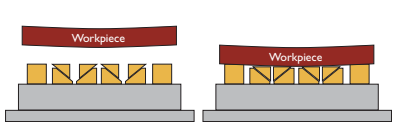
Setup Examples

Machining All 5-Sides Freely



For full machining on all 5-sides (including thru-hole drilling or boring) induction blocks or subplates are required or damage to the magnetic chuck may occur.

Holding Warped Material



Use EEPM-SPF induction blocks on the corners and EEPM-SP spring loaded blocks everywhere else so the induction blocks adjust to match the warped stock.

Part Nesting Techniques



For machining small, thin, or irregular parts that do not have much metal to attract the magnet, you can create a shallow nest, or pocket in a subplate or induction blocks to secure the part and prevent lateral movement. For part nests that you will use over-and-over again on repeat jobs use subplates to save setup time.

MagVISE EEPM-C Modular Workholding Chucks

Features:

- *Modular connection from 2, to 16 chucks as needed*
- *Operate as many as 16 chucks with 1 control*
- *8,250 lbs. holding power (each chuck)**

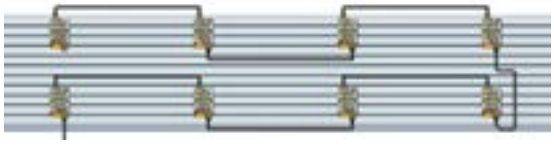
Advantages:

- *Easy to setup and adjust for large or irregular parts*
- *Reduced investment compared to larger EEPM chucks*
- *Easy to move and setup from machine to machine*



For workholding of ferrous materials only.

EEPM-C chucks provide almost unlimited flexibility to hold workpieces of varying sizes. Use toe-clamps or bolts to position EEPM-C magnets anywhere on your machine bed or pallet to fit your workpiece.



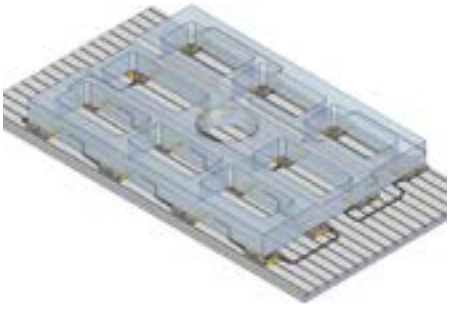
*Holding power varies with type of material being held, surface finish, and part thickness.



Use for fast setups on plate stock



Clean up induction blocks prior to loading part



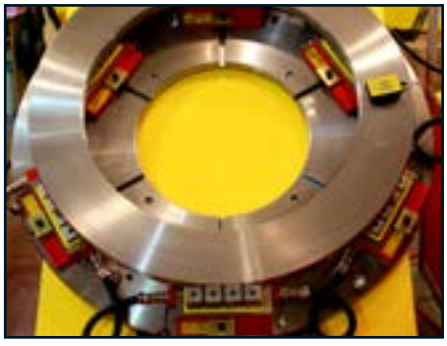
the possibilities are endless…



Modular setups adjust easily to part



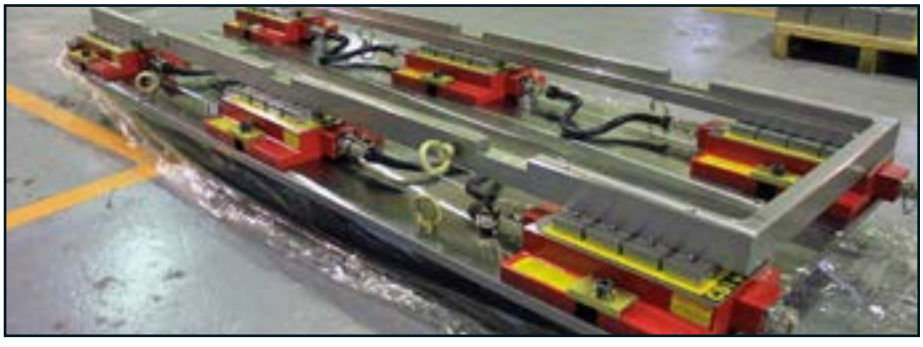
Provides uniform workholding - no part distortion



Circular applications are no problem



Large tooth sprocket being machined



Palletized setup staged for loading

Operate up to 16 chucks using 1 control

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers.

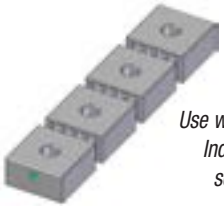
MagVISE WORKHOLDING

MagVISE EEPM-C Ordering Information

Ordering EEPM-C Modular Chucks

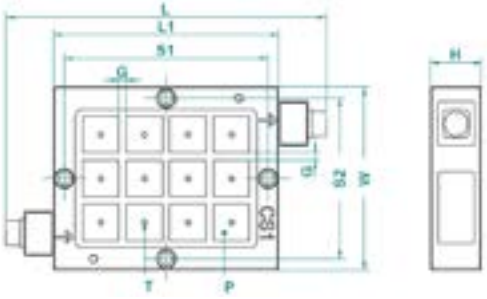
- *Select the number of chucks required*
- *Select the control required to operate the number of chucks needed*
- *Select the number and length of connection cables required*

We recommend using induction blocks at all times to preserve the surface finish of your magnetic chuck, and prevent damage to the face of the magnetic chuck.



Use with EEPM-IB425 Induction Blocks *see page 219*





Chuck	L	W	L1	S1	S2	Poles	Holding Power*
EEPM-2530C	16.75"	9.84"	12.25"	11.0"	8.66"	12	8,250 lbs.

**Holding power varies with type of material being held, surface finish, and part thickness.*

Control requires a dedicated 480V single phase, 30A power supply



C4 control features 4 channels to control up to 16 chucks. Control each channel independently.

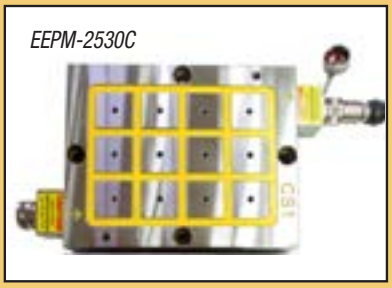
Control	Description	L x W x H	Channels	Qty. Chucks
EEPM-C1C	Control for 1-4 EEPM-C magnetic chucks	10.6" x 7" x 5"	1	1-4
EEPM-C2C	Control for 1-8 EEPM-C magnetic chucks	10.6" x 7" x 5"	2	1-8
EEPM-C4C	Control for 1-16 EEPM-C magnetic chucks	10.6" x 7" x 5"	4	1-16





Connection Cables	Length
EEPM-CC03	11.8"
EEPM-CC05	19.6"
EEPM-CC10	39.37"
EEPM-CC15	59"

Installation Example



Up to 16 chucks can be operated from 1 control.



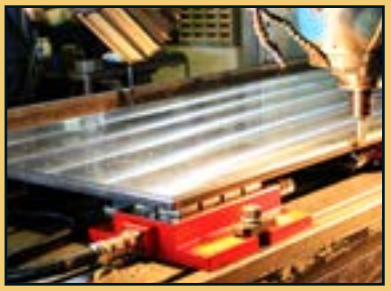
Position the chucks on the machine bed.



Lock them in position using bolts provided.



Connect the control cables to chucks and control



Position workpiece and start machining.

MagVISE EEPM-V For Horizontal Machining

Features:

- *Up to 68,640 lbs. holding power**
- *Choose from 2 or 4 sided chucks*
- *36, 42, or 100 pole chucks, 16.9" to 29.9"*

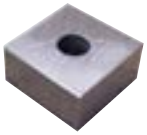
Advantages:

- *Reduce setup & part change-over time by 50% or more!*
- *Machine freely on all 5-sides to reduce operations*
- *Very uniform holding = No workpiece deformation*





**4 sizes available*
For workholding of ferrous materials only.
See page 223 for holding power ratings.



Induction Blocks see page 219

Induction Blocks and Subplates

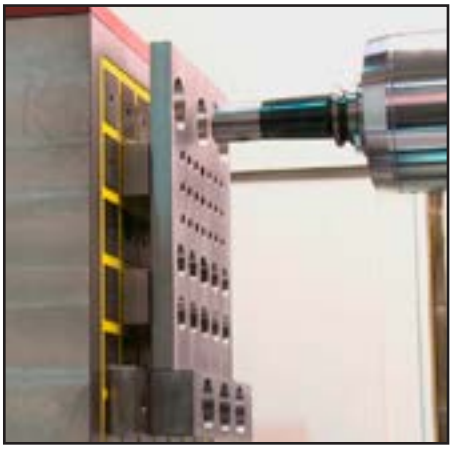
We recommend using induction blocks or subplates at all times to preserve the precison ground finish and prevent damage to the face of the magnetic chuck. For more information see page 219.



Mold making application



2-sided EEPM on palletized system



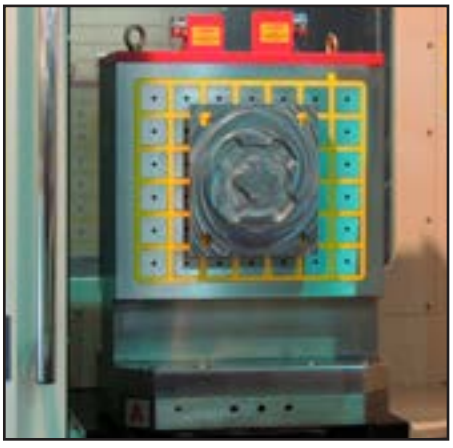
Hole-making applications are no problem



Complex part shapes - 5 sides machining



Finish pass using small tools



Palletized horizontal workholding chuck

MagVISE EEPM-V Ordering Information

Ordering EEPM-V Chucks

- *Select the number of faces and chucks required*
- *Control is included with chuck*
- *Order induction blocks from page 219*

We Manufacture Custom Tombstones

Built to your specifications.
Call us to discuss your needs.

(800) 597-3921 or local (317) 803-8000

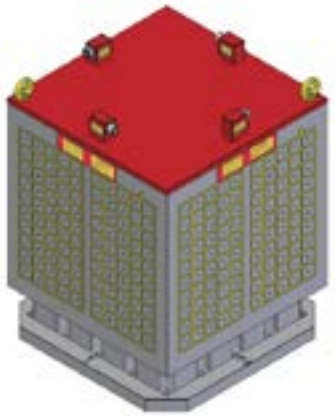


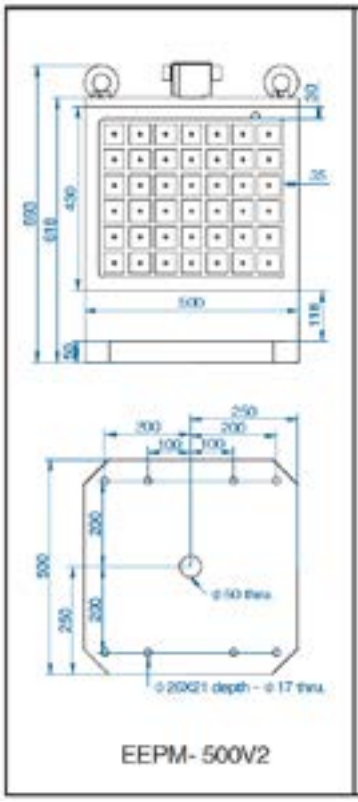
EEPM chucks includes controller and remote. Control requires a dedicated 480V single phase, 30A power supply



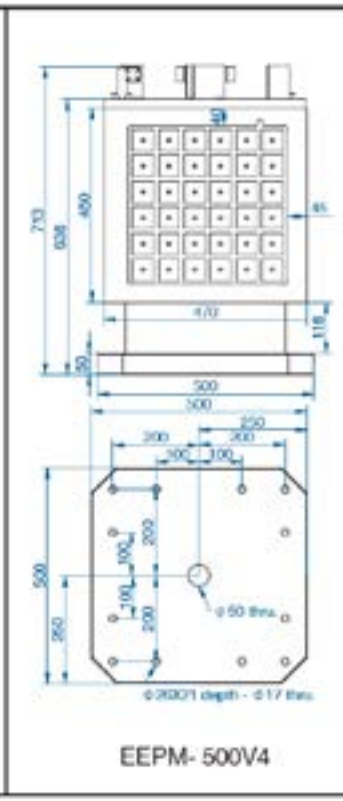




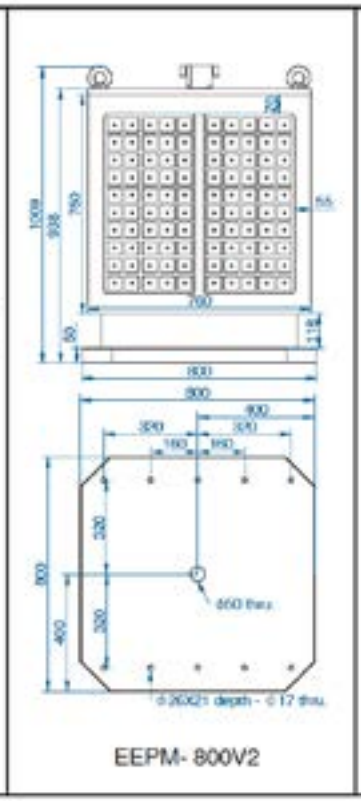




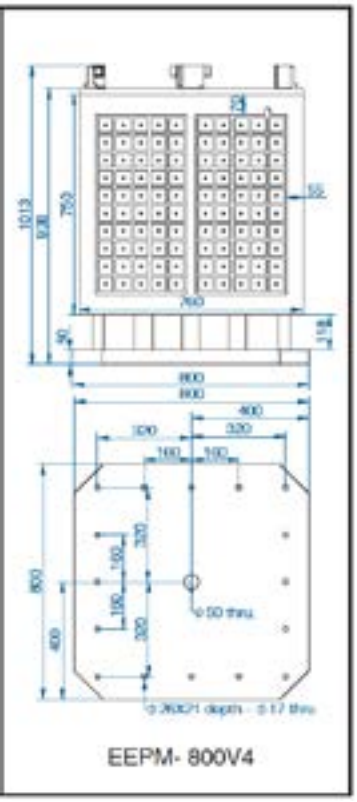
EEPM- 500V2



EEPM- 500V4



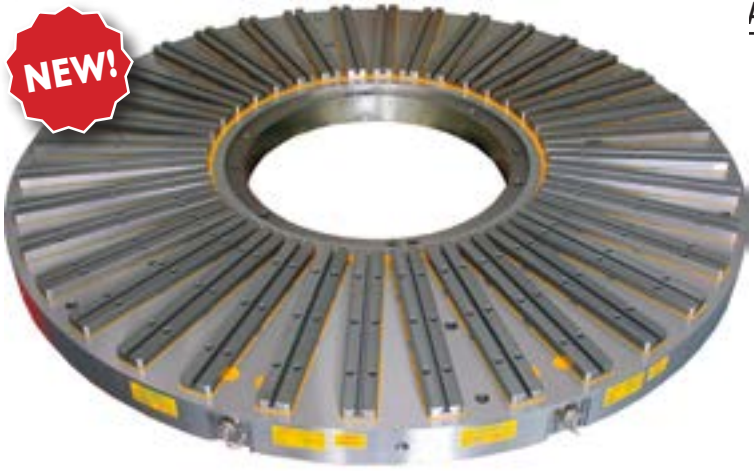
EEPM- 800V2



EEPM- 800V4

Model	Face (L x W)	No. Faces	No. Poles	Holding Power per Face	Chuck Weight	Controller
EEPM-500V2	16.9" x 19.68"	2	42	28,820 lbs.	1,058 lbs.	EEPM-C2
EEPM-500V4	17.7" x 18.5"	4	36	24,640 lbs.	1,124 lbs.	EEPM-C2
EEPM-800V2	29.5" x 29.9"	2	100	68,640 lbs.	1,675 lbs.	EEPM-C2
EEPM-800V4	29.5" x 29.9"	4	100	68,640 lbs.	1,786 lbs.	EEPM-C2

MagVISE EEPM-CIR for Vertical Turning & 5-Axis

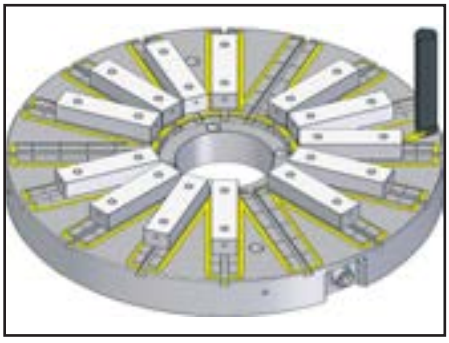


For workholding of ferrous materials only.
9 sizes to choose from. Custom sizes available. includes controller and remote

Advantages:

- *Reduce setup & part change-over time by 50% or more!*
- *Machine freely on all 4-sides & top so you can cut the full part profile in only 1 operation*
- *Very uniform holding = No workpiece deformation*

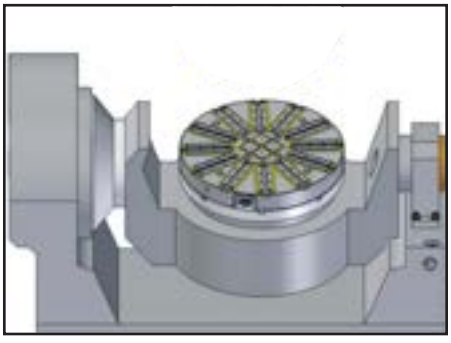
EEPM-CIR chucks are a powerful and fast workholding solution optimized for horizontal or vertical turning centers and 5-axis machining. Using magnetic workholding you can clamp/unclamp the part in only seconds. Reduce setup down-time to increase machine up-time. Control is included with chuck.



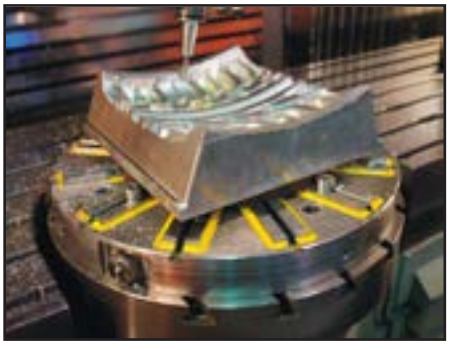
Machine induction blocks for easy part positioning



Use with EEPM-SP blocks to hold warped stock



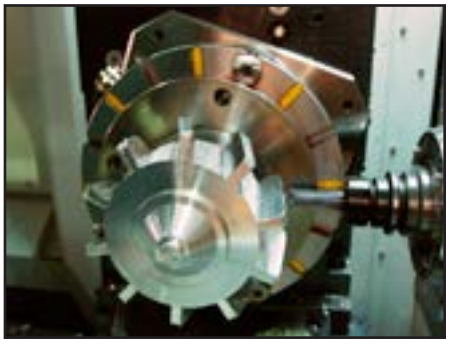
Speed up setups for 5-axis tables



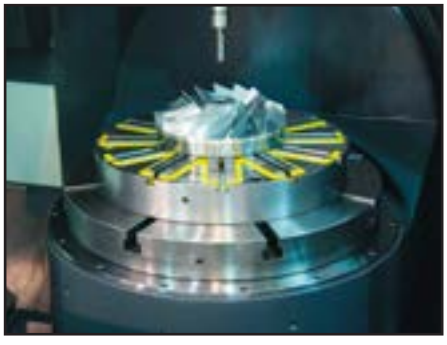
3, 4, and 5-axis applications



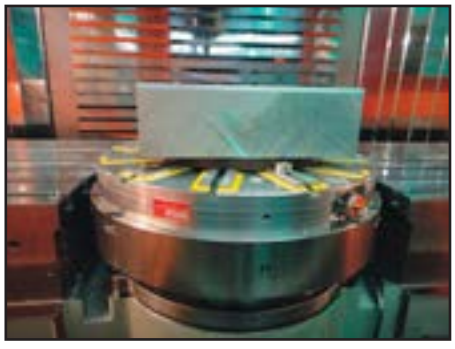
Even workholding - no part distortion



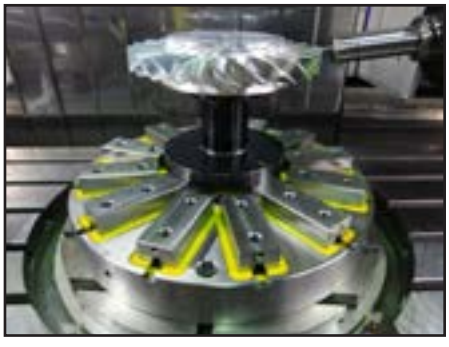
Off-axis rotation on horizontal mill



Holds very small or very large parts



Custom chucks available to suit your machine



Hold complex parts without complicated setups!

MagVISE EEPM-CIR Ordering Information

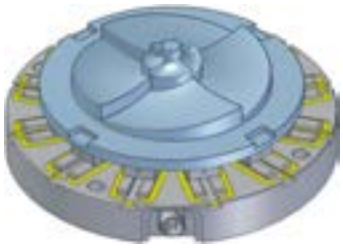
Select the Chucks From Tables Below

We build custom chucks for your specific needs. Call us to discuss.

(800) 597-3921 or local (317) 803-8000

EEPM chucks includes controller and remote Control requires a dedicated 480V single phase, 30A power supply





step and slope milling for an impeller

Induction Blocks & T-Slot Sliding Blocks for EEPM CIR Chucks



EEPM-SP



EEPM-SPF



Sliding T-Slot



EEPM-CIRB120



EEPM-CIRB170



EEPM-CIRB245



EEPM-CIRB335



EEPM-CIRB220



EEPM-CIRB270

Use induction blocks to preserve the precison ground finish and prevent damage to the face of the chuck. Induction blocks to raise the workpiece above the surface of the magnet and permit machining 5 sides and thru-hole drilling.

Use T-Slot Sliding Blocks as adjustable work-stops for part alignment. See pg. 219 for more induction block options and ideas.

Part No.	Description	L	W	H
EEPM-SP	spring loaded (2 piece set, 8mm screw)	1.89"	1.89"	1.41"
EEPM-SPF	solid, machinable (8mm screw)	1.97"	1.97"	1.23"
EEPM-20T	sliding T-slot for use with EEPM-SPF	4.72"	1.97"	.78"
EEPM-30T	sliding T-slot for use with EEPM-SP blocks	4.72"	1.97"	1.18"
EEPM-CIRIB120	induction block for CIR500 chuck	4.72"	1.97"	.78"
EEPM-CIRIB170	induction block for CIR600 chuck	6.69"	1.97"	.78"
EEPM-CIRIB245	induction block for CIR800 chuck	9.64"	1.97"	.78"
EEPM-CIRIB335	induction block for CIR1000 chuck	13.18"	1.97"	.78"
EEPM-CIRIB220	induction block for CIR500 chuck	8.66"	1.97"	.78"
EEPM-CIRIB270	induction block for CIR600 chuck	10.62"	1.97"	.78"

Model	Dim. (O.D. x I.D. x H)	No. Poles	Holding Power	Weight	Control
EEPM-CIR500	19.7" x 0" x 2.75"	12 + 4	12,345 lbs.	229 lbs.	C1
EEPM-CIR600	23.6" x 0" x 2.75"	12 + 4	17,636 lbs.	326 lbs.	C2
EEPM-CIR800	31.5" x 9.84" x 3.34"	16	28,219 lbs.	665 lbs.	C2
EEPM-CIR1000	39.4" x 9.84" x 3.34"	16	42,328 lbs.	1,038 lbs.	C4
EEPM-CIR1250	49.6" x 19.68" x 4.33"	24	52,910 lbs.	1,825 lbs.	C4
EEPM-CIR1500	59.0" x 19.68" x 4.72"	24	74,075 lbs.	2,921 lbs.	C8
EEPM-CIR1600	64.2" x 19.68" x 4.72"	24	84,657 lbs.	3,322 lbs.	C8
EEPM-CIR1800	71.6" x 31.49" x 4.72"	36	111,112 lbs.	5,048 lbs.	C8
EEPM-CIR2000	80.7" x 39.37" x 5.11"	36	111,112 lbs.	5,489 lbs.	C8

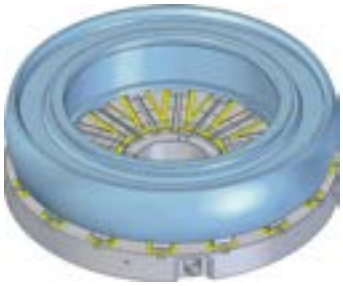


circular chuck setup for gear cutting

pocket milling and face milling



5-axis turbine blade machining



round part turning O.D. and I.D.

MagVISE EEPM-CIRS for Machining & Grinding



For workholding of ferrous materials only.

Advantages:

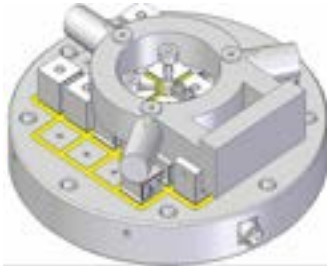
- *Versatile round chucks for many different applicatons*
- *Reduce setup & part change-over time by 50% or more!*
- *Machine freely on 5-sides so you can cut the full part profile in only 1 operation*

There are 9 stock sizes of EEPM-CIRS chucks to choose from (see table below). We also can build custom chucks for your machine.

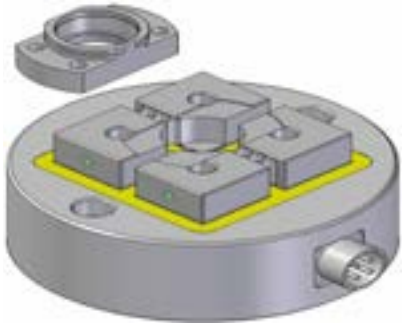
We recommend using induction blocks at all times to preserve the precison ground finish and prevent damage to the face of the chuck. You can easily modify induction blocks to your part requirements. Use EEPM-SP induction blocks for holding warped stock.



EEPM chucks includes controller and remote. Control requires a dedicated 480V single phase, 30A power supply



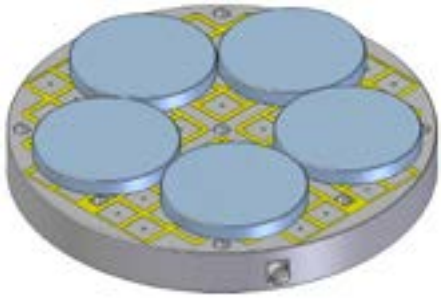
Use induction blocks as workstops to hold hard parts



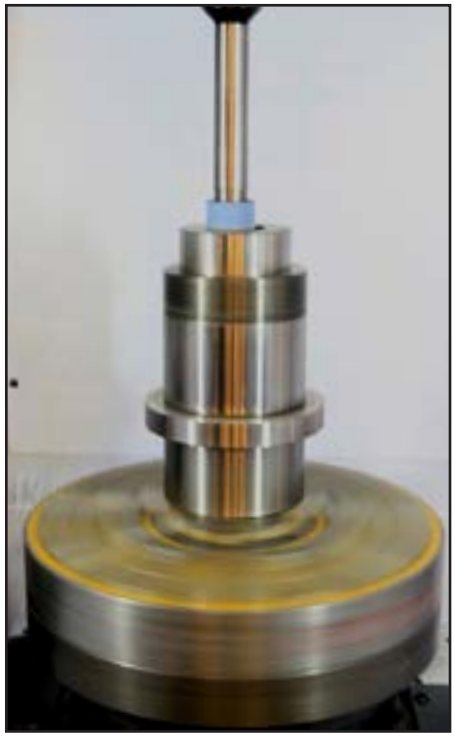
Machine nests to hold smaller parts



Machine full 5 sides using induction blocks

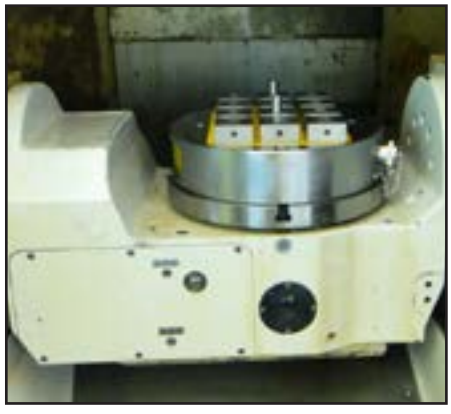


Gang parts together on larger chucks for efficiency



Honing application

Model	Dim. (O.D. x H)	No. Poles	Holding Power	Weight	Control
EEPM-CIRS200	7.99" x 2.75"	4	2,204 lbs.	35 lbs.	C1
EEPM-CIRS300	12.0" x 2.75"	12	6,612 lbs.	77 lbs.	C1
EEPM-CIRS500	19.68" x 2.75"	32	17,632 lbs.	214 lbs.	C1
EEPM-CIRS600	24.4" x 2.75"	52	28,652 lbs.	330 lbs.	C2
EEPM-CIRS700	27.55" x 2.75"	76	41,876 lbs.	421 lbs.	C4
EEPM-CIRS800	32.28" x 2.75"	96	52,896 lbs.	578 lbs.	C4
EEPM-CIRS900	35.82" x 3.14"	120	66,120 lbs.	798 lbs.	C4
EEPM-CIRS1000	40.15" x 3.14"	164	90,364 lbs.	1,022 lbs.	C8
EEPM-CIRS1100	45.54" x 3.14"	204	112,404 lbs.	1,203 lbs.	C8



Easy integration with 5-axis tables

MagVISE EEPM-IT Index Table

Features:

- *Pneumatic table makes rotation easy*
- *Indexed in 5 degree increments*
- *Full 360˚ rotation either left or right*

Advantages:

- *Add indexing capability to your horizontal mill*
- *Machine 5-sides freely and reduce setup time 50%*
- *Very uniform holding = No workpiece deformation*



includes C4 control and remote

For workholding of ferrous materials only.

Pull the black knob out to unclamp table and rotate part. Push knob in to clamp. Index table requires 90 psi shop air for rotation.

We recommend using induction blocks or subplates at all times to preserve the precison ground finish and prevent damage to the face of the magnetic chuck. For more information see page 219.

Scan QR code above or visit: *http://goo.gl/fb4nkk*





Use EZ-Lift lifting magnet to quickly load your workpiece



Pull knob to rotate part up to 360 degrees



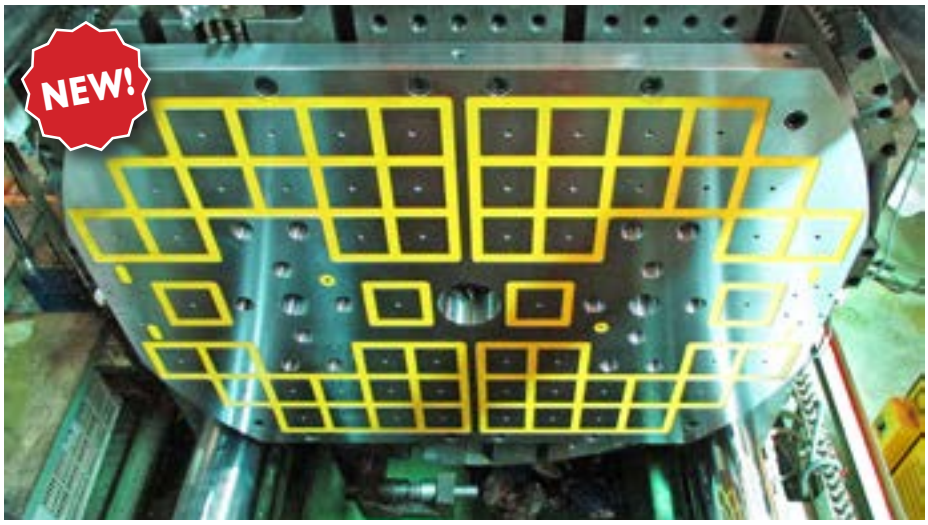
Use induction blocks to machine full 5 sides freely



Add indexing capability to your mill

Model	Face (L x W x H)	Max. Load	No. Poles	Holding Power	Squareness	Repeatability	Weight
EEPM-300IT	11.81" x 11.81" x 7.59"	1,100 lbs.	16	11,023 lbs.	.0004"	.0004"	229 lbs.
EEPM-470IT	18.5" x 18.5" x 7.36"	2,200 lbs.	49	33,730 lbs.	.0005"	.0004"	490 lbs.
EEPM-600IT	23.6" x 23.6" x 8.89"	4,400 lbs.	72	49,604 lbs.	.0007"	.0005"	996.5 lbs.
EEPM-800IT	31.5" x 31.5" x 11.88"	6,600 lbs.	144	99,208 lbs.	.0007"	.0005"	2,162.5 lbs.

MagVISE EEPM-PIM Injection Mold Magnets



Magnetic mold clamping is much faster than other methods to save machine time.

Features

- *Position and clamp in just minutes!*
- *Proximity sensors ensure position*
- *Dual controls lock-out machine during operation for safety*

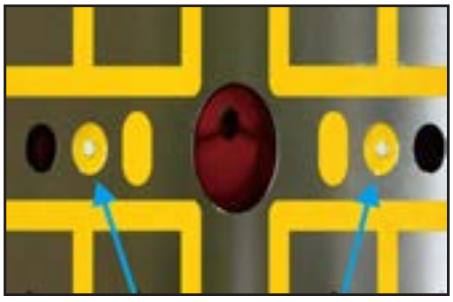
Benefits

- *Save 60% setup & change-over time*
- *Increase machine capacity 20%*
- *Greatly increase your productivity just by changing clamping method*

Injection-mold magnets are quickly replacing traditional mold clamping methods world-wide. The investment in PIM magnets is quickly repaid by faster mold setup and change-over times. Also, machine capacity increases by an average of 20% because PIM magnets require less room in the machine cube. Call us for custom size magnets.



Watch the video demo at this url: http://ow.ly/tajls



Proximity sensors ensure correct positioning.



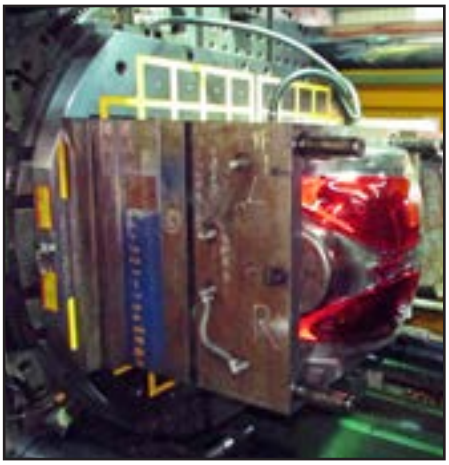
Controls require operator to use both hands.



Load and install PIM magnet with bolts



PIM & controls integrate with your machine.



Mold is held perfectly, & change-over is fast.

Model	Face (L x W x H)	Max Temp (F)	Holding Power	Pole Size (mm)	Power Supply
EEPM-1200PIM	59" x 59" x 2.75"	248˚	185,188 lbs.	92 x 92	35A, 480V single phase
EEPM-950PIM	57" x 41.3" x 2.75"	248˚	148,150 lbs.	92 x 92	30A, 480V single phase
EEPM-400PIM	41.3" x 25.6" x 2.75"	248˚	52,910 lbs.	92 x 92	40A, 480V single phase

MagVISE ECB Magnetic Workholding Vises



4 sizes available

For workholding of ferrous materials only.
Each ECB vise includes everything required to setup and begin workholding.

Scan the QR code or enter this link: http://ow.ly/u21Nm to view a video demo.



Features

- *Powerful rare-earth magnets for up to 4,620 lbs. holding power (per vise)*
- *Gang multiple vises together and increase holding power as needed*
- *Quickly and easily adjust size of setup and number of chucks as needed*

Benefits

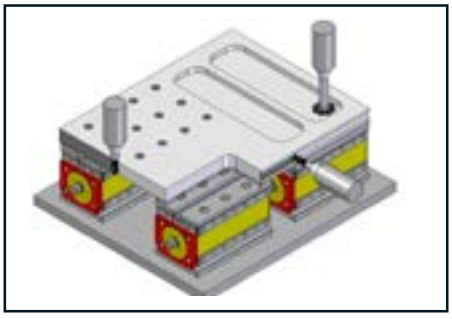
- *Reduce setup and change-over down time by 50%*
- *Freely machine on all 5-sides to reduce number of operations*
- *No workpiece deformation*

ECB Magnetic Vises provide fast, efficient workholding for all types of CNC machining applications. They are easy to install or move from machine to machine, and making changes to existing setups is fast.

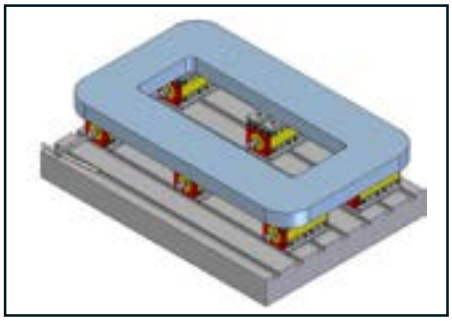


ECB magnetic vises hold irregular stock sizes, warped stock, and large workpieces, without special fixturing.

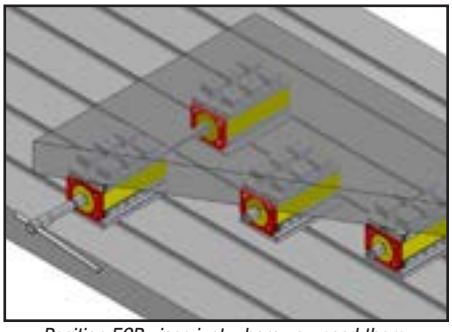
Setup Examples



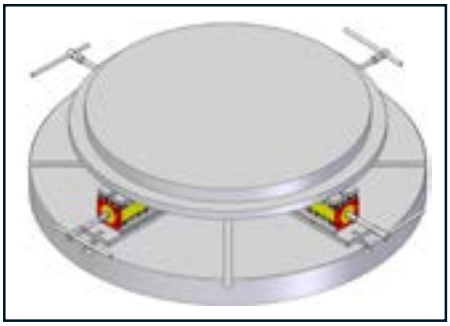
Machine freely on 5-sides using induction blocks



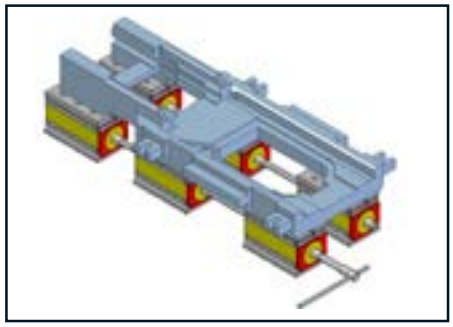
Switch-connect to turn ON/OFF multiple vises



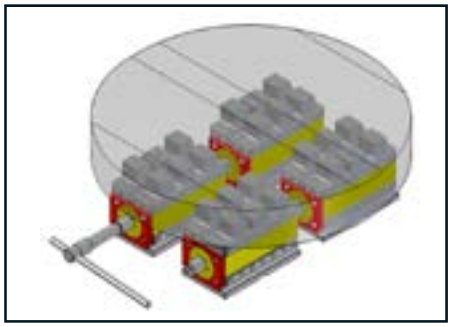
Position ECB vises just where you need them



Vertical turning setups are faster with ECB vises



Cut complex part shapes O.D. and I.D.



Hold large and small parts of all shapes

MagVISE ECB Applications



You can use 1 ECB vise for each part…



…or use multiple ECB vises positioned as needed to hold large parts.



Machine freely on 5-sides



Switch-connect ECB vises to turn ON/OFF simultaneously



Tombstones for horizontal milling



ECB magnetic vises are easy to setup for vertical turning. Machine both O.D. and I.D.



ECB vises are used for large or small parts



Even huge workpieces like this one are easily held and can be machined on 5-sides.

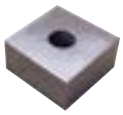
MagVISE ECB Ordering Information



4 sizes available to fit your application needs. Each ECB vise includes 2 machinable induction blocks, wrench, extension and socket, switch-connect socket assembly, 2 stop plates, 4 toe clamps.



EEPM-SP spring type



EEPM-SPF solid type



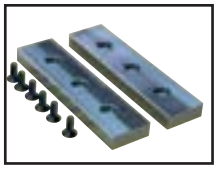
Use EEPM-SP spring-loaded induction blocks and EEPM-SPF blocks together to hold warped stock. See page 219.

Use induction blocks at all times to prevent damage to the face of the magnetic vise. You can easily modify induction blocks to adapt your setup to part requirements. Please note that the spring loaded induction blocks are NOT machineable, but the solid blocks are able to be drilled and machined as required.

After installing your ECB vise we recommend cleanup milling the surface of your induction blocks before loading your work piece to insure that the surface height is uniform and parallel to the spindle.



ECB magnetic vises easily integrate with pallet changing and tombstone systems used in production cells. Call us at (800) 597-3921 or (317) 803-8000 for a fast quote.



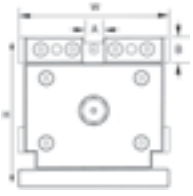


Inductdion blocks and work stops are included.

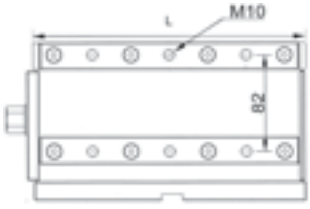




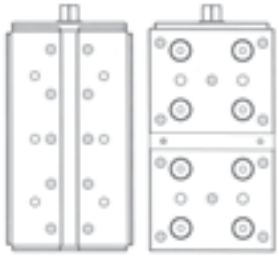
Switch-connect vises to turn them ON/OFF in unison.



end view



side view



top and bottom view



Ordering Information

Part No.	L x W x H	A	B	Min. Stock Thickness	Holding Power	Weight
ECB-050	5" x 3" x 3"	.47"	.47"	0.4"	1,100 lbs.	15 lbs.
ECB-075	6.8" x 3" x 3"	.47"	.47"	0.4"	1,650 lbs.	19 lbs.
ECB-120	7.3" x 4.2" x 4.2"	.62"	.59"	0.6"	2,640 lbs.	40 lbs.
ECB-210	9.2" x 5.2" x 5.3"	.65"	.84"	0.8"	4,620 lbs.	80 lbs.

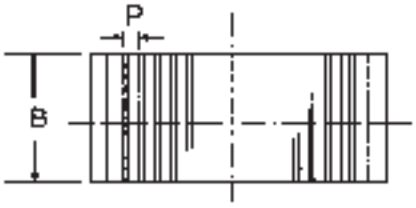
Part No.	Description	L x W x H
EEPM-SPF	1, soft fixed induction block, 8mm screw - use with ECB-SP50 spring blocks.	1.97" x 1.97" x 1.23"
EEPM-SP	2, spring loaded induction block, 8mm screw - use with ECB-SPF50 on corners.	1.89" x 1.89" x 1.41"

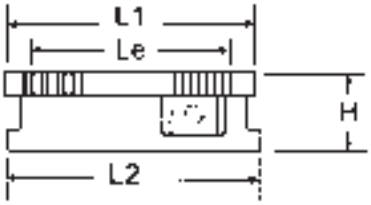
Note: Holding power depends on workpiece size, material, surface finish, contact area with magnet, and workpiece thickness. Always make sure your read, understand and follow the instructions that come with your ECB vise.

MagVISE EDMT Surface Grinding Chucks



For induction blocks see page 236.



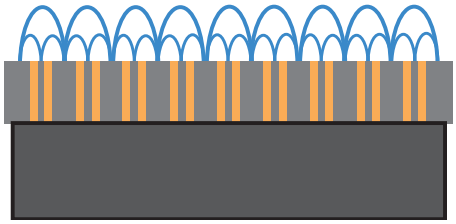


EDMT (All-Purpose Variable Pole Design)

Alternating thick/thin magnetic poles provides best holding power for both thick and thin workpieces.

- *EDM-READY: fully submersible, brass welded faceplate which can be machined if needed, and protects the magnetic system from penetration of coolant.*
- *Powerful Rare Earth Neodymium Iron Boron magnets are 5 times stronger than other magnets*
- *Needs no electricity. Provides a constant source of work-holding power.*
- *Low-profile design increases Z-axis stroke*
- *Housing and bottom plate are free of magnetism —will not magnetize machine bed or bearings.*

Variable Pole



**New variable pole design creates magnetic fields that hold both thin and thick workpieces equally well.*

Model	Pole Pitch (P)	L x W x H	Weight
EDMT-1018	11.2 (1.6+2+1.6+6)	7" x 4" x 2.5"	16 lbs.
EDMT-1325	11.2 (1.6+2+1.6+6)	10" x 5" x 2.5"	23 lbs.
EDMT-1530	11.2 (1.6+2+1.6+6)	12" x 6" x 2.5"	33 lbs.
EDMT-1535	11.2 (1.6+2+1.6+6)	14" x 6" x 2.5"	38 lbs.
EDMT-1545	11.2 (1.6+2+1.6+6)	18" x 6" x 2.5"	44 lbs.
EDMT-2040	11.2 (1.6+2+1.6+6)	16" x 8" x 2.5"	57 lbs.
EDMT-2045	11.2 (1.6+2+1.6+6)	18" x 8" x 2.5"	66 lbs.
EDMT-2050	11.2 (1.6+2+1.6+6)	20" x 8" x 2.5"	79 lbs.
EDMT-2550	4 + 12	20" x 10" x 2.5"	130 lbs.
EDMT-3060	3 + 15	24" x 12" x 2.5"	198 lbs.

MagVISE EDTW Fine Pole Surface Grinding Chucks



For induction blocks see page 236.

EDTW (MicroPITCH Fine Pole Design)

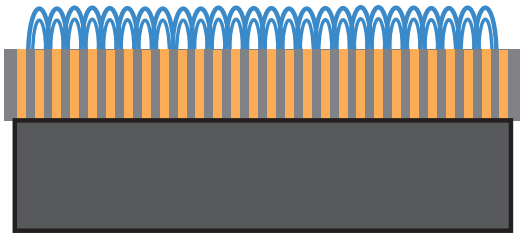
Fine pole design provides best holding power for surface grinding of small or thin workpieces.

- *Brass welded faceplate can be machined if needed, and protects the magnetic system from penetration of coolant.*
- *Powerful Rare Earth Neodymium Iron Boron magnets are 5 times stronger than other magnets*
- *Needs no electricity. Provides a constant source of work-holding power.*
- *Low-profile design increases Z-axis stroke*
- *Housing and bottom plate are free of magnetism —will not magnetize machine bed or bearings.*



EDTW chucks have up to 15 tons of holding force. (150 lbs./inch²)

Fine Pole



Fine pole magnets creates strongest magnetic field close to surface for holding thin workpieces.

Model	Pole Pitch (P)	L x W x H	Weight
EDTW-1018	2 (1+1)	7" x 4" x 2"	15 lbs.
EDTW-1325	2 (1+1)	10" x 5" x 2.25"	29 lbs.
EDTW-1515	2 (1+1)	6" x 6" x 2.25"	20 lbs.
EDTW-1530	2 (1+1)	12" x 6" x 2.5"	49 lbs.
EDTW-1535	2 (1+1)	14" x 6" x 2.5"	53 lbs.
EDTW-1545	2 (1+1)	18" x 6" x 2.5"	68 lbs.
EDTW-2040	2 (1+1)	16" x 8" x 2.5"	82 lbs.
EDTW-2045	2 (1+1)	18" x 8" x 2.5"	90 lbs.
EDTW-2050	2 (1+1)	20" x 8" x 2.5"	99 lbs.
EDTW-2550	2 (1+1)	20" x 10" x 2.5"	132 lbs.

MagVISE EET Surface Grinding Chucks

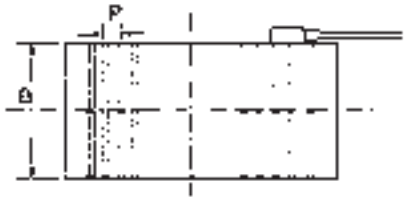


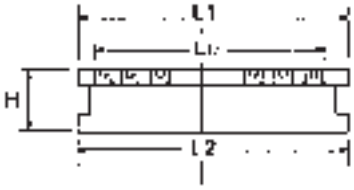
For induction blocks see page 236.

EET (Wide Spaced Pole Design)

Wider spacing magnetic poles for general surface grinding of both thick and thin workpieces.

- *Brass welded faceplate which can be machined if needed, and protects the magnetic system from penetration of coolant.*
- *More than 1,000 OHMs resistance*
- *Low-profile design increases Z-axis stroke*
- *Housing and bottom plate are free of magnetism —will not magnetize machine bed or bearings.*





Model	Pole Pitch (P)	L x W x H	Volts	Amps	Weight
EET-1530	15 (3+12)	12" x 6" x 3"	DC90V	0.18	44 lbs.
EET-1535	15 (3+12)	14" x 6" x 3"	DC90V	0.19	53 lbs.
EET-1545	15 (3+12)	18" x 6" x 3"	DC90V	0.19	66 lbs.
EET-2040	15 (3+12)	16" x 8" x 3"	DC90V	0.28	84 lbs.
EET-2045	15 (3+12)	18" x 8" x 3"	DC90V	0.28	90 lbs.
EET-2050	15 (3+12)	20" x 8" x 3"	DC90V	0.36	99 lbs.
EET-2550	15 (3+12)	20" x 10" x 3"	DC90V	0.46	143 lbs.
EET-3060	15 (3+12)	24" x 12" x 3"	DC90V	0.86	179 lbs.
EET-3070	15 (3+12)	28" x 12" x 3"	DC90V	0.81	205 lbs.
EET-3090	15 (3+12)	35" x 12" x 3"	DC90V	1.05	276 lbs.
EET-4060	19 (3+16)	24" x 16" x 3.5"	DC90V	0.95	287 lbs.
EET-4070	19 (3+16)	28" x 16" x 3.5"	DC90V	1.21	333 lbs.
EET-4080	19 (3+16)	32" x 16" x 3.5"	DC90V	1.31	384 lbs.
EET-40100	19 (3+16)	40" x 16" x 3.5"	DC90V	1.33	487 lbs.
EET-50100	19 (3+16)	40" x 20" x 3.5"	DC90V	1.46	595 lbs.
EET-50150	19 (3+16)	60" x 20" x 3.5"	DC90V	3.37	893 lbs.
EET-60100	19 (3+16)	40" x 24" x 3.5"	DC90V	2.80	728 lbs.
EET-60150	19 (3+16)	60" x 24" x 3.5"	DC90V	2.85	1091 lbs.
EET-80100	19 (3+16)	40" x 32" x 3.5"	DC90V	3.80	970 lbs.

MagVISE EET-W Fine Pole Surface Grinding Chucks

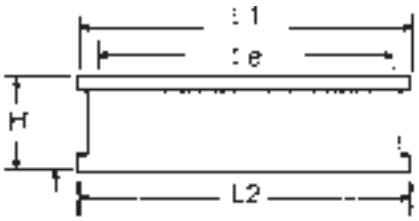


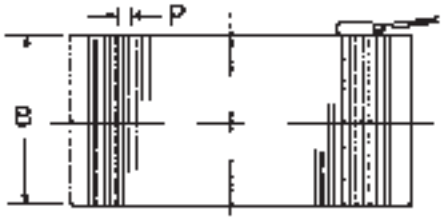
For induction blocks see page 236.

EET-W (Fine Pole Design)

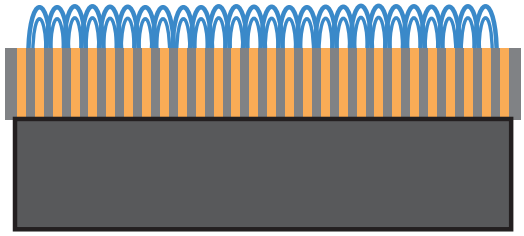
Fine pole design optimized for maximum holding power for surface grinding of thin workpieces

- *Brass welded faceplate which can be machined if needed, protects the magnetic system from penetration of coolant*
- *More than 1,000 OHMs resistance*
- *Low-profile design increases Z-axis stroke*
- *Housing and bottom plate are free of magnetism —will not magnetize machine bed or bearings.*





Fine Pole



Fine pole magnets creates strongest magnetic field close to surface for holding thin workpieces.

Model	Pole Pitch (P)	L x W x H	Volts	Amps	Weight
EET-1530W	4(1+3)	12" x 6" x 4.5"	DC90V	0.73	73 lbs.
EET-1535W	4(1+3)	14" x 6" x 4.5"	DC90V	0.61	88 lbs.
EET-1545W	4(1+3)	18" x 6" x 4.5"	DC90V	0.98	110 lbs.
EET-2040W	4(1+3)	16" x 8" x 4.5"	DC90V	1.10	139 lbs.
EET-2045W	4(1+3)	18" x 8" x 4.5"	DC90V	1.20	157 lbs.
EET-2050W	4(1+3)	20" x 8" x 4.5"	DC90V	1.40	176 lbs.
EET-2550W	4(1+3)	20" x 10" x 4.5"	DC90V	1.00	247 lbs.
EET-3060W	4(1+3)	24" x 12" x 4.5"	DC90V	1.50	331 lbs.

EHT Induction Blocks:

- *Extends magnetic force to hold bar, round, or irregular shapes*
- *EDM-READY: fully submersible, brass sealed*
- *For fine-pole and standard pole applications*

Choose from lengthwise (L) or width-wise (W) pole direction





EHT-100 (set of 2)





EHT-150W

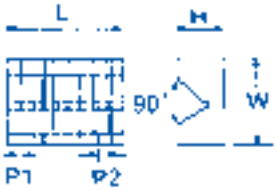


EHT-72 (set of 2)





EHT-150L





EHT-65V (set of 2)





EHT-150



EHT-300W (fine pole)



EHT-300L (lengthwise pole)



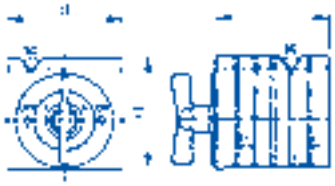
EHT-300 (width-wise pole)

Model	Qty.	L x W x H	Pole Pitch P1	Pole Pitch P2	Weight
EHT-65V	2	2.5" x 2.5" x 1.5"	2	3	4 lbs. (x2)
EHT-72	2	3" x 2" x 1"	2	3	7 lbs. (x2)
EHT-100	2	4" x 3" x 1.5"	2	3	10 lbs. (x2)
EHT-150	1	6" x 3" x 1"	2	3	5 lbs.
EHT-300	1	12" x 3" x 1"	2	3	10 lbs.
EHT-150L	1	6" x 3" x 1"	2	3	5 lbs.
EHT-300L	1	12" x 3" x 1"	2	3	10 lbs.
EHT-150W	1	6" x 3" x 1"	1+1	1+1	5 lbs.
EHT-300W	1	12" x 3" x 1"	1+1	1+1	10 lbs.

ECE Magnetic Blocks

- *Dozens of uses around the shop*
- *Fast setups of bar stock or round steel*
- *Powerful magnetic base, ON-OFF switch*





ECE-100 /ECE-150





ECE-208 /ECE-212





ECE-612

Model	Holding Power V-Face	Holding Power Surface	Dimensions mm B	L	H	C	H1	H2	S1	S2	Weight
ECE-100	61 lbs.	88 lbs.	100	100	100	-	-	-	-	-	14.5 lbs.
ECE-150	110 lbs.	308 lbs.	150	150	150	-	-	-	-	-	53 lbs.
ECE-208	121 lbs.	154 lbs.	56	80	72	-	-	-	-	-	6.5 lbs.
ECE-212	198 lbs.	242 lbs.	75	115	100	-	-	-	-	-	11 lbs.
ECE-612	242 lbs.	350 lbs.	76	118	62	50	50	12	48	62	5.5 lbs.

ECE Magnetic V-Block Sets

- *For grinding, marking, measuring and other light machining operations*
- *Each pair made to identical dimensions*
- *Sold in pairs only*

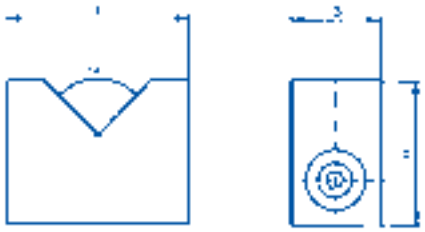


ECE-507



ECE-510

Model	Holding Power	Applicable Diameter mm	Dimension mm B	L	H	Weight
ECE-507	33 lbs.	50	40	72	50	2.2 lbs. x 2
ECE-510	44 lbs.	80	50	100	80	6.6 lbs. x 2



ERD-505, 510, 515 Features:

- *Work with any electromagnetic chucks*
- *Demagnetizing time is 6-15 seconds*
- *Precisely regulates the magnetic force*

ERD-520 Features:

- *For larger, more powerful electromagnetic chucks*
- *Can operate two chucks at the same time*
- *Demagnetizing time is 8-15 seconds*



ERD-505



ERD-510, ERD-515



ERD-520

Model	Input Voltage/Single Phase	Output Volts	Output Amps	Dim. L x W x H	Wt.
ERD-505-110	AC 110/220V	DC 0-100V	5A	8" x 5.5" x 5"	8 lbs.
ERD-510-220	AC110/220/440V	DC 0-120V	10A	6" x 13" x 10"	33 lbs.
ERD-515-220	AC 220/440V	DC 0-120V	15A	6" x 13" x 10"	44 lbs.
ERD-520-220	AC 220/440V	DC 0-120V	20A	7" x 15" x 12"	71 lbs.

Please specify voltage when ordering.

EDH Demagnetizers





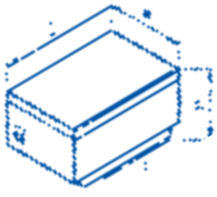
EDH-123



EDH-180



EDH-200









Model	Description	Power	Capacity	Duty Cycle	Dim. L x W x H	Wt.
EDH-123-110	Portable, light weight, for big machines	AC 110V	110VA	90%	123 x 83 x 83mm	4 lbs.
EDB-180-110	Up to 20 minutes continuous operation	AC 110/220V	220VA	50%	127 x 180 x 90mm	9 lbs.
EDS-200-110	Continuous operation, double-coil design	AC 110V	330VA	100%	150 x 200 x 100mm	19 lbs.

EZ-Lift Magnets – sPINner Small Parts Deburring





the sPINner

sPINner Small Parts Deburring

- *Fast deburring service*
- *sPINner machine sales*



"One Twist" Indicator Arms

with magnetic base



ECE EARTH-CHAIN
Power that works.

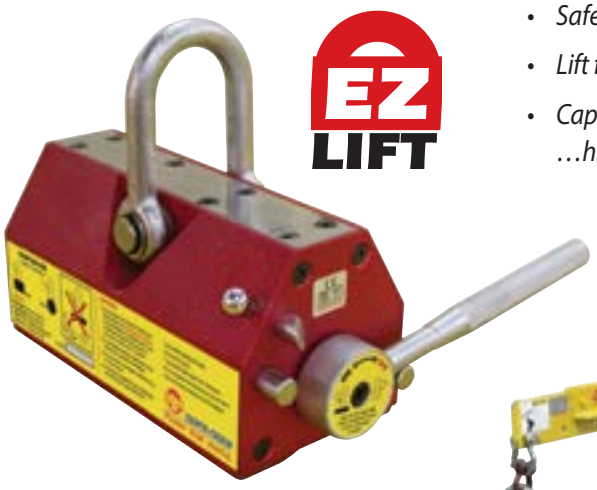
EZ-Lift Material Handling Magnets

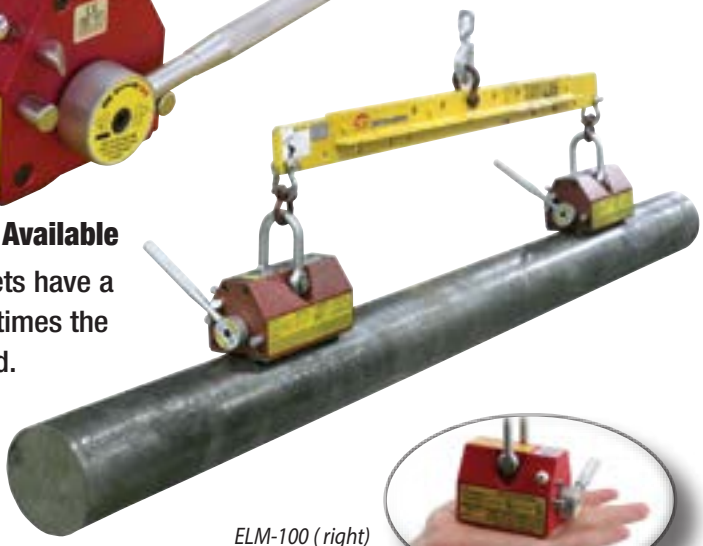
Features

- *Safety Factor 3.5X above max rating*
- *Lift flat or round stock*
- *Capacity up to 6,600 lbs, …higher with spreader bars*

Benefits

- *Will not wear out like straps/slings*
- *Less risk of pinched fingers or toes*
- *Much faster setup and transport*





ELM-100 (right) weighs 5.5 lbs. and lifts 220 lbs.

Best Safety Factor Available

All our lifting magnets have a safety factor of 3.5 times the maximum rated load.



Watch live demonstration video for more information.

Scan QR code or visit: *http://ow.ly/t0hUB*

How It Works:

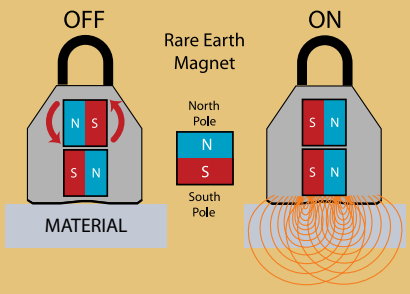


Lever in the "ON" position engages safety lock.



The "OFF" position.

Each ELM lifting magnet contains super powerful rare earth magnets arranged in 3 rows. The OFF position is when the magnetic poles are in alignment as shown (top left).



Turning the lever to the ON position rotates the center row of magnets 180˚ so the poles alternate, creating a powerful magnetic field.

Never attempt to turn the magnet ON unless it is placed on a correctly sized piece of material to be moved, or you may cause injury to yourself, or the ELM lifting magnet. Always follow all instructions carefully.

Smallest, Most Powerful Lifter – With The Industry's Best Safety Factor (3.5 X Above Maximum Rated Load)

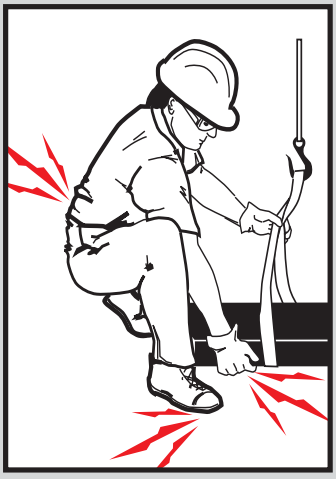
ELM lifters feature super-powerful rare-earth neodymium iron boron lifting magnets that require no electricity and have dozens of uses. Load and unload plate, block, or round steel and iron stock. Use them on press molds, machined parts, and other ferrous materials. Use spreader bars to lift large material.

The Old Way: Material Handling

A) Risk of Injury
Risk of injury to back, fingers, or toes when moving material in order to position sling or chain.

B) Slings & Chains Wear Out
Lifting equipment needs to be recertified and replaced periodically.

C) Lost Productivity
It takes time to properly setup slings or chains to safely move materials.



EZ-Lift Application Examples



3.5 X Safety Factor above rated load capacity



Workpiece transport is faster with EZ-Lift.



Use to setup CNC machining centers.



Use spreader bars for long, difficult round stock



Center magnet on most workpieces to lift.



Beveled bottom surface lifts round stock.



Eliminate straps, slings and associated dangers.



Locate magnet at balance point for lifting.



Use spreaderbars to gang stock in one operation



Vertical Lifters can be operated by one person.



Move round or rectangular stock vertically.



Spreader bars are used for long or very heavy loads.



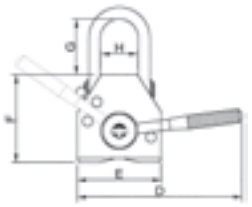
EZ-Lift Magnets Ordering Information

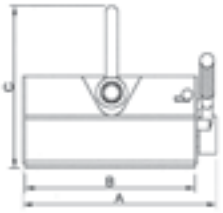
EZ-Lift Capacities – Plate & Round Steel

CAUTION: Follow all directions in the Operating Instructions that comes with your magnet.

Refer to the instructions for Calculating Maximum Loads on the next page to determine required size.



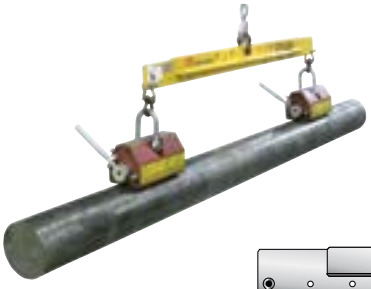




Part No.	Plate	Round	A	B	C	D	E	F	G	H	Weight
ELM-100	220 lbs.	99 lbs.	4.2"	3.3"	4.7"	4.9"	2.4"	2.8"	1.6"	1.2"	5.5 lbs.
ELM-300	660 lbs.	300 lbs.	7.1"	6.1"	6.1"	7.3"	3.6"	3.7"	2.0"	1.6"	18.9 lbs.
ELM-600	1,320 lbs.	600 lbs.	10.0"	8.8"	8.3"	10.2"	4.5"	4.7"	3.0"	2.0"	46 lbs.
ELM-1000	2,200 lbs.	990 lbs.	11.0"	9.6"	11.3"	14.6"	6.5"	6.7"	3.8"	3.4"	101 lbs.
ELM-2000	4,400 lbs.	1,980 lbs.	16.6"	15.0"	13.7"	20.2"	8.5"	8.5"	4.1"	4.8"	259 lbs.
ELM-3000	6,600 lbs.	2,970 lbs.	22.3"	20.9"	15.7"	30.3"	8.5"	8.7"	5.8"	3.2"	399 lbs.

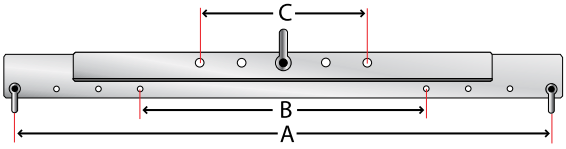
EZ-Lift Spreader Bars

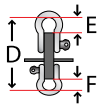
- *Better for unbalanced loads*
- *Use with multiple magnetic lifters*
- *Lifter span adjustable*



Keeps large materials balanced for safer transport.

Control large or irregular loads during transport. Increase lifting power by adding more magnets. Includes bar, 1 upper and 2 lower S.P.A. shackles. Order magnets separately.





Part No.	Capacity	A	B	C	D	E	F	Weight
ELM-SB250	250 lbs.	36"	18"	12"	5.1"	1.25"	.85"	20 lbs.
ELM-SB500	500 lbs.	46"	22"	16"	5.7"	1.35"	1.34"	25 lbs.
ELM-SB1000	1,000 lbs.	72"	36"	24"	6.9"	1.35"	1.34"	65 lbs.
ELM-SB2000	2,000 lbs.	72"	36"	24"	7.3"	2.02"	1.35"	115 lbs.
ELM-SB4000	4,000 lbs.	77"	41"	24"	10.5"	2.43"	1.63"	195 lbs.
ELM-SB8000	8,000 lbs.	96"	48"	24"	12.3"	2.94"	1.78"	300 lbs.
ELM-SB10000	10,000 lbs.	116"	56"	24"	14.7"	3.5"	1.65"	600 lbs.
ELM-SB13500	13,500 lbs.	140"	68"	36"	17.1"	4.0"	2.02"	880 lbs.

EZ-Lift Vertical Lifters

- *Fast loading for vertical transport*
- *One person can load and unload*
- *No dangerous straps & slings*



Used for vertical transport of plate stock.
Includes ELM lifting magnet.



Part No.	Size L x W x H	Capacity	Weight	Plate Size L x W x H (min/max) L	W	H
ELM-300V	37.5" x 8.5" x 10"	660 lbs.	57 lbs.	8"/60"	11.8"/31.5"	0.25"/5.9"
ELM-600V	46" x 11" x 10"	1,320 lbs.	86 lbs.	12"/72"	11.8"/39.4"	0.31"/9.8"
ELM-1000V	48" x 14" x 12"	2,200 lbs.	128 lbs.	12.5"/79"	11.8"/39.4"	0.39"/11.8"

Position lifter on stock and turn the lever to the on position. Hoist into vertical position for transport. Always follow operating instructions included.

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers.

EARTH-CHAIN Power that works.

Instructions for Calculating Maximum Load by Material Type

T (thickness) x **F** (finish) x **M** (material) x Capacity = ML

Example: (ELM-600/plate steel) 2" (T=100%) x F2(100%) x M2 (85%) x 1,320 lbs. = **1,122 lbs.**

Calculating Maximum Loads

Calculate that the magnet will safely lift your material. Maximum Load (ML) is different for plate and round materials, and also depends upon stock thickness, carbon content, and surface finish. Follow the instructions and use the tables to calculate ML for your material type.

Rated Capacity

Part No.	Plate Steel*
ELM-100	220 lbs.
ELM-300	660 lbs.
ELM-600	1,320 lbs.
ELM-1000	2,200 lbs.
ELM-2000	4,400 lbs.
ELM-3000	6,600 lbs.

Part No.	Round Steel*
ELM-100	99 lbs.
ELM-300	300 lbs.
ELM-600	600 lbs.
ELM-1000	990 lbs.
ELM-2000	1,980 lbs.
ELM-3000	2,970 lbs.

M Lifting Power by Material

Carbon Content	0% 50% 100%
M1	Low Carbon 100%
M2	Moderate Carbon 85%
M3	High Carbon 75%
M4	Cast Iron 70%

F Effect of Surface Finish

Surface Finish	0% 50% 100% 150%
F1	Ground Surface 125%
F2	Rough Machined 100%
F3	Foundry Finish 90%
F4	~ Rough Cast 65%

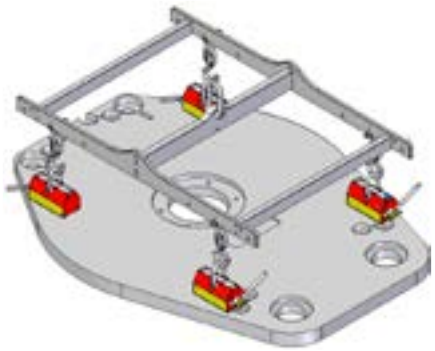
T Equals Percent of Lifting Power by T (thickness)

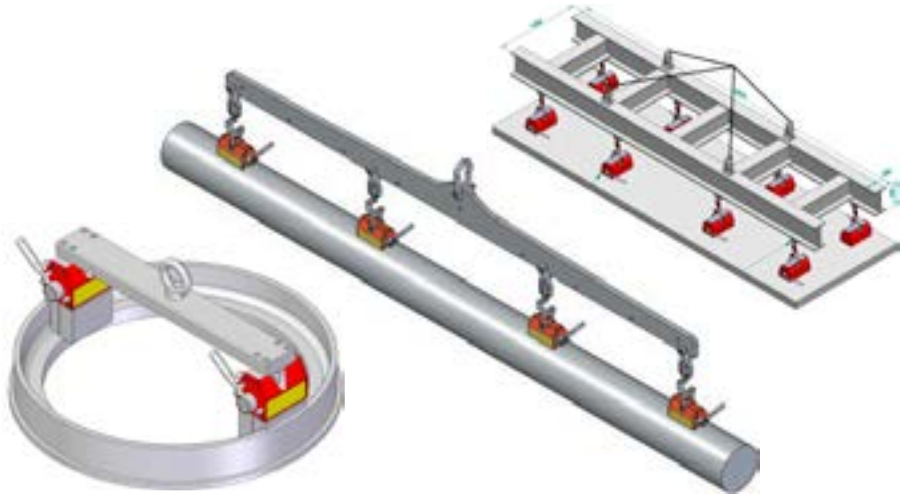
T	ELM-100	ELM-300	ELM-600	ELM-1000	ELM-2000	ELM-3000
2 3/8" (60mm)	100%	100%	100%	100%	100%	100%
2 1/8" (55mm)	100%	100%	100%	100%	100%	95%
2.0" (50mm)	100%	100%	100%	100%	95%	90%
1 3/4" (45mm)	100%	100%	100%	100%	90%	85%
1 1/2" (40mm)	100%	100%	100%	100%	85%	80%
1 3/8" (35mm)	100%	100%	100%	90%	75%	70%
1 1/8" (30mm)	100%	100%	100%	80%	65%	60%
1.0" (25mm)	100%	100%	90%	70%	55%	50%
3/4" (20mm)	100%	90%	75%	60%	45%	40%
1/2" (15mm)	100%	70%	60%	50%	35%	30%
3/8" (10mm)	70%	50%	45%	35%	25%	20%
1/4" (5mm)	40%	30%	25%	20%	15%	10%

**Follow all directions in the Operating Instructions that comes with your magnet.*

Custom Lifting Solutions

Engineered to meet your requirements
Call (800) 597-3921 for a fast quote





sPINner Small Parts Deburring

The sPINner batch deburrs small parts and eliminates time-consuming hand deburring. Send us your parts for complimentary testing or a deburring services quote.

Applications

- *medical parts - swiss turned*
- *drilled or threaded parts*
- *machined or stamped parts*



before *after*

Benefits

- *costs less than hand deburring*
- *deburr parts faster & better*
- *improve quality of parts*

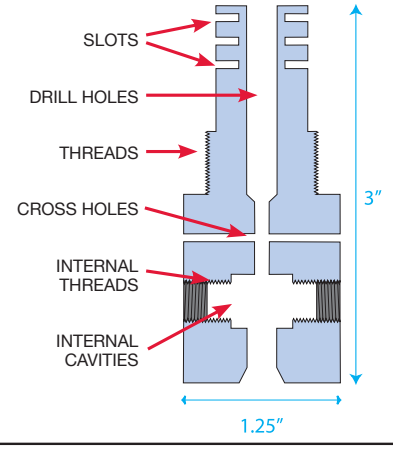








The sPINner machine deburrs:



Hand Deburring Small Parts

A) Time Consuming
Hand deburring is a labor intensive process

B) Production Bottleneck
Hand deburring puts a limit on your productivity

C) Expensive
Hand deburring requires costly manual labor



Batch Deburring Small Parts

A) Deburr Faster & Better
Improve part quality and get more consistent results

B) Speed Up Production
Batch deburr dozens, hundreds, or thousands of parts in minutes

C) Reduce Cost-per-part
Eliminate expensive hand deburring costs



Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers.

EARTH-CHAIN
Power that works.

Reduce Your Small Parts Deburring Costs



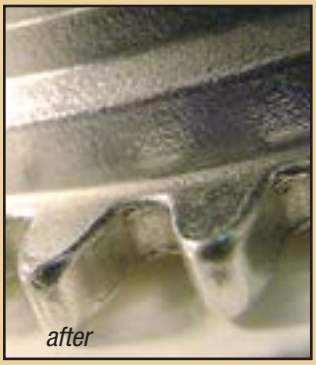
Send us your part samples for complimentary deburring testing

Techniks sPINner Deburring • 9930 East 56th St., • Indianapolis, IN 46236
We will deburr your parts and provide a full test report or a deburring services quote.

Aluminum Gear Application

Burrs and rough edges. Deburred part in only 10 minutes. Part Dimensions: 1 9/16" diameter x 5/16" high.





Complex Turned & Machined Aluminum

Burrs on O.D. and in I.D. slots. Batch deburring in only 10 minutes! Part Dim.: 3/16" diameter x 1 3/16" long.





Stainless Steel Turned and Machined Part

Internal cavity burrs left in cross-drilled holes
Eliminated costly hand deburring and improved quality.
Part Dimensions: 3/4" diameter x 1 7/16" long.





0.01" Diameter Slot in Light Alloy Collar

Fine burrs in hard-to-reach slotted area. Eliminated part quality problem and saved labor costs. Part Dimensions: 1 7/32" diameter x 1/8" high.

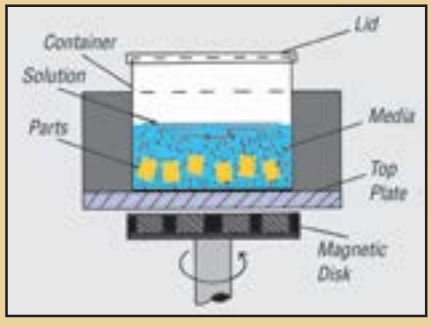




The sPINner features special pin media that deburrs both internal and external part features



Stainless steel pin media reaches burrs other media can't touch.



Rotating magnetic field activates pins, creating a gentle deburring action.



sPINner deburrs parts like these. Send us your parts for a complimentary test.

sPINner Small Parts Deburring Machines

sPINner Machine Includes

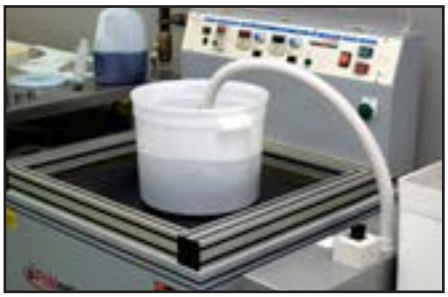
- *sPINner pin media and deburring container*
- *Deburring solution and media separating sieve*
- *Operation manual*



Use multiple containers to increase the number of parts you can deburr in one cycle.



sPINner deburring is gentle and safe and the operator can pull parts by hand durring operation to check deburring progress.



Filtration system reduces the need for changing deburring solution, so production time is optimized and parts are sparkling clean.

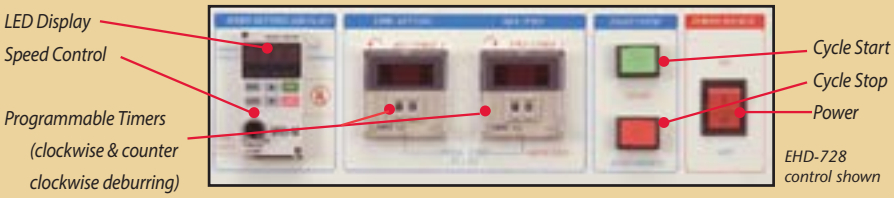


EHD-728



EHD-765
high-capacity machine

Each sPINner features adjustable speed / intensity controls and automatic timers for each direction. Controls are intuitive and easy to use.



Choose the sPINner machine that fits your needs. Typical deburring cycles are only 15-20 minutes, and all sPINner machines allow variable intensity and duration of deburring cycles using the programmable control panel.

You can also increase or decrease the deburring action by changing the diameter and length of media. Choose the size required for your part from the table on the next page.

For high-volume, continuous cycle deburring we recommend EDH-SFS200 filtration system. (left)



sPINner pin media can deburr holes and internal part features other media cannot reach.

Part No.	L x W x H	Tank Size L x W	Container Size W x H	Power Supply	Amps	Weight
EHD-716	10.5" x 9" x 11.5"	6.25" x 6.25"	-	110V	-	36 lbs.
EHD-728	19" x 19" x 37"	11" x 11"	9" x 8"	220V Single Phase	5	160 lbs.
EHD-735	23" x 26" x 34"	15" x 16"	13" x 9"	220V Single Phase	10	220 lbs.
EHD-750	29" x 30" x 36"	21" x 23"	19" x 10"	220V Single Phase	15	385 lbs.
EHD-765	37" x 39" x 43"	29" x 26.75"	25" x 10"	220V Single Phase	10	516 lbs.
EDH-SFS200	SFS filtration system for high-volume deburring applications					

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers.

ECE EARTH-CHAIN
Power that works.

Vibratory Parts & Media Separator



- *Quickly separates parts from media*
- *Speeds production*

Part No.	L x W x H	Power	Weight
ESS-660	18" x 18" x 26"	110/220VAC	97 lbs.

High-Capacity Parts & Media Separator



- *Magnetic attraction separates media from parts—FAST!*
- *Handles large batches of parts easily*

Part No.	L x W x H	Container L x W x H	Power	Weight
HD-712	28" x 21" x 26"	26" x 17.75" x 9.5"	110/220VAC 5A	163 lbs.

Do You Need Deburring Help Now?



Are you looking for a source to deburr small parts? We offer deburring services from our Indianapolis location at very competitive rates.

Call (800) 597-3921 and ask to speak to a representative. We will test run your parts and send you results next day with an estimate.

Call (800) 597-3921 for deburring

sPINner Stainless Steel Pin Media



sPINner stainless pin media lasts for years

Our special stainless steel media is the reason the sPINner can deburr where other media is ineffective. Each SUS 304 stainless steel pin is hardened to HRC 30 and features a magnetic treatment to enhance deburring action.

To deburr hard materials like stainless steel, steel, etc., use a diameter of media bigger than 0.5mm. Use sizes less than 0.5mm for soft material like brass, copper, aluminum, gold, etc. If you want to deburr small holes, choose a diameter of pin media that is smaller than the hole. 3mm length media will work better for small holes and crevices. Choose larger pins for harder material or to increase the deburring action on stubborn burrs.

Part No.	diameter x length
EHD-S1	0.2mm x 5mm
EHD-P1	0.3mm x 3mm
EHD-S2	0.3mm x 5mm
EHD-S13	0.3mm x 7mm
EHD-P2	0.4mm x 3mm
EHD-S3	0.4mm x 5mm
EHD-P3	0.5mm x 1mm
EHD-P4	0.5mm x 3mm
EHD-S4	0.5mm x 5mm
EHD-P5	0.7mm x 3mm
EHD-S5	0.7mm x 5mm
EHD-P6	0.8mm x 3mm
EHD-S6	0.8mm x 5mm

Part No.	diameter x length
EHD-P7	1.0mm x 1mm
EHD-P8	1.0mm x 3mm
EHD-S7	1.0mm x 5mm
EHD-A1	1.0mm x 7mm
EHD-P41	1.0mm x 10mm
EHD-P10	1.2mm x 3mm
EHD-S8	1.2mm x 5mm
EHD-P42	1.2mm x 10mm
EHD-P9	1.5mm x 3mm
EHD-S9	1.5mm x 5mm
EHD-A3	1.5mm x 7mm
EHD-P43	1.5mm x 10mm
EHD-S10	2.0mm x 5mm

PFS-747 Deburring Solution

It is important to use the proper mix of deburring solution to facillitate part deburring and cleaning parts. Use PFS-747 with all sizes of sPINner media. Dilute to a 50:1 ratio with water.



Part No.	Description
PFS-747	1/2 gallon deburring solution
PFS-7475G	5 gallons deburring solution

“One Twist” Indicator Arms (hydraulic and mechnical)

ECE Indicator Arms Features

- *"One Twist" 360˚ adjustable joints*
- *Check concentricity on bench or your machine*
- *Powerful magnetic base*

Advantages of Hydraulic Arms

- *Hydraulic arms are faster, stronger, and more precise than mechanical joints*
- *Hydraulic joints make fine adjustments easy because they don't lose position when loosened like mechanical arms*





Indicator Arms are used to check concentricity on bench or machine. Dial Indicators not included.



ECE-300 series



ECE-330 series



ECE-340

Part No.	Description	Arm Length	Base Dim. Lmm x Wmm x H	Holding Power	Weight lb
ECE-300ALL	Precision hydraulic arm, gold	23 1/2"	4 3/4"mm x 2"mm x 2 1/8"	352 lbs.	7.75
ECE-300AL	Precision hydraulic arm, gold	16 3/4"	3 1/8"mm x 2"mm x 2 1/8"	220 lbs.	5.5
ECE-300B	Precision hydraulic arm, gold	13 3/8"	2 3/8"mm x 2"mm x 2 1/8"	176 lbs.	4.5
ECE-330AL	Precision mechanical arm, red	16 3/4"	3 1/8"mm x 2"mm x 2 1/8"	220 lbs.	5.0
ECE-330B	Precision mechanical arm, red	13 3/8"	2 3/8" x 2" x 2 1/8"	176 lbs.	3.75
ECE-340	Standard mechanical arm, red	13 3/8"	2 3/8" x 2" x 2 1/8"	176 lbs.	3.5

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