

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.



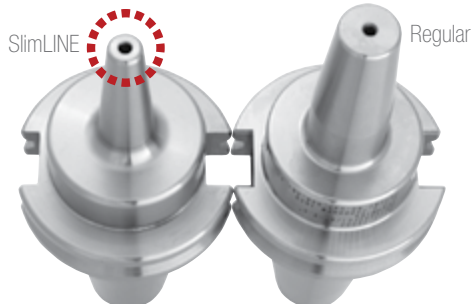
CoolBLAST ShrinkFIT

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

CoolBLAST features a 3° angle to better direct coolant on the cutting 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.

You lose 10% of tool life for every .0001" of T.I.R. ShrinkFIT toolholders offer outstanding rigidity to minimize 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
Machines
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ShrinkFIT
Extensions
pg. 104



Retention
Knobs
pg. 204

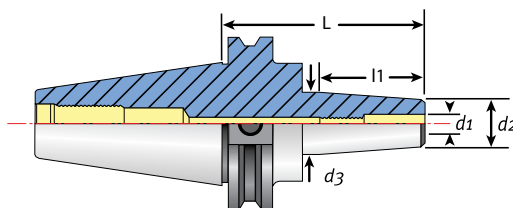


Wrenches
pg. 208

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.



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"	.36"	.63"	3.5"	.79"	M6 x 1.0P	16081C-20
29006	CAT40 x 3/16" I.D. - 3.5"	3/16"	.43"	.70"	3.5"	.79"	M6 x 1.0P	16081C-20
29010	CAT40 x 1/4" I.D. - 3"	1/4"	.71"	.94"	3"	1.42"	M5 x 0.8P	16080C-20
29011	CAT40 x 1/4" I.D. - 3.5"	1/4"	.71"	.94"	3.5"	1.42"	M5 x 0.8P	16080C-20
29016	CAT40 x 5/16" I.D. - 3.5"	5/16"	.79"	1.06"	3.5"	1.42"	M6 x 1.0P	16081C-20
29020	CAT40 x 3/8" I.D. - 3"	3/8"	.94"	1.18"	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"	1.06"	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"	2.04"	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

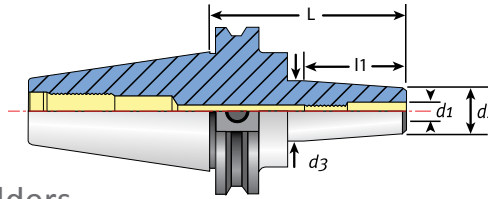
CAT40 Precision Extended Length & SlimLINE



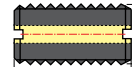
Techniks Certified for accuracy and balance

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"	.36"	.87"	5"	.79"	-	16081C-20
29008	CAT40 x 3/16" I.D. - 5"	3/16"	.43"	.71"	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"	1.37"	6"	1.42"	M5 x 0.8P	16080C-20
29018	CAT40 x 5/16" I.D. - 5"	5/16"	.79"	1.06"	5"	1.42"	M6 x 1.0P	16081C-20
29023	CAT40 x 3/8" I.D. - 5"	3/8"	.94"	1.37"	5"	1.53"	M8 x 1.25P	16082C-20
29024	CAT40 x 3/8" I.D. - 6"	3/8"	.94"	1.37"	6"	1.53"	M8 x 1.25P	16082C-20
29029	CAT40 x 1/2" I.D. - 5"	1/2"	1.10"	1.37"	5"	1.85"	M10 x 1.5P	16083C-20
29030	CAT40 x 1/2" I.D. - 6"	1/2"	1.10"	1.37"	6"	1.85"	M10 x 1.5P	16083C-20
29037	CAT40 x 3/4" I.D. - 5"	3/4"	1.26"	1.37"	5"	2.04"	M16 x 2.0P	16089C-20
29038	CAT40 x 3/4" I.D. - 6"	3/4"	1.26"	1.37"	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

CAT40 SlimLINE ShrinkFIT Holders Inch Sizes

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

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
31528	CAT40 x 1/8" I.D. - 3.15" SlimLINE	1/8"	.35"	.60"	3.15"	.78"	M6 x 1.0P	16081C-20
31538	CAT40 x 3/16" I.D. - 3.15" SlimLINE	3/16"	.43"	.68"	3.15"	.78"	M6 x 1.0P	16081C-20
31548	CAT40 x 1/4" I.D. - 3.15" SlimLINE	1/4"	.47"	.72"	3.15"	1.42"	M5 x 0.8P	16080C-20
31568	CAT40 x 3/8" I.D. - 3.15" SlimLINE	3/8"	.63"	.88"	3.15"	1.93"	M8 x 1.25P	16082C-20
31588	CAT40 x 1/2" I.D. - 3.15" SlimLINE	1/2"	.70"	.96"	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
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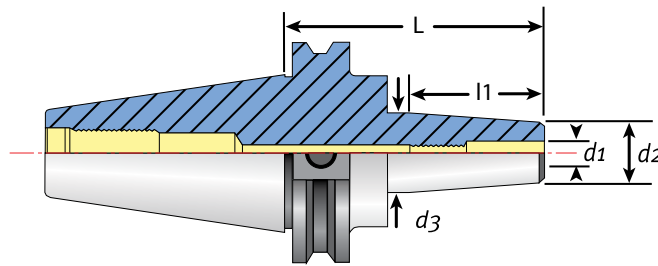
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Coolant-thru
set screw included.
Page 104 for dimensions.



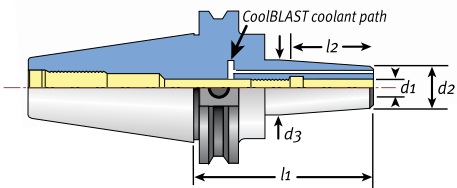
CAT40 Metric ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29204	CAT40 x 4mm I.D. - 100mm	4mm	10mm	18.7mm	100mm	20mm	M6 x 1.0P	16081C-20
29206	CAT40 x 5mm I.D. - 100mm	5mm	16mm	22mm	100mm	20mm	M8 x 1.25P	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	47mm	M10 x 1.5P	16083C-20
29228	CAT40 x 14mm I.D. - 152.4mm	14mm	27mm	34mm	152.4mm	47mm	M10 x 1.5P	16083C-20
29232	CAT40 x 16mm I.D. - 100mm	16mm	27mm	34mm	100mm	50mm	M12 x 1.75P	16085C-20
29234	CAT40 x 16mm I.D. - 160mm	16mm	27mm	34mm	160mm	50mm	M12 x 1.75P	16085C-20
29236	CAT40 x 18mm I.D. - 100mm	18mm	33mm	42mm	100mm	50mm	M12 x 1.75P	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	58mm	M20 x 2.0P	16091C-20

CAT40 CoolBLAST or CoolFLEX Holders



Techniks Certified for accuracy and balance



CoolBLAST features a 3° angle to better direct coolant on the cutting tool.

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"	M8 x 1.25P	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"	1.40"	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"	1.06"	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

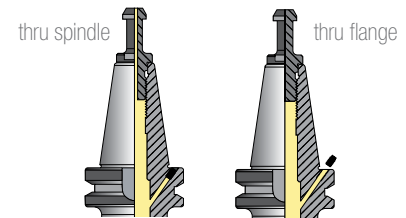
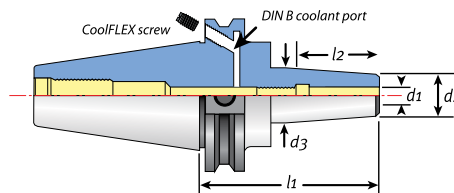
Blue indicates coolant.

CoolFLEX Features

Coolant-thru spindle or thru flange (DIN B)

CoolFLEX holders are factory set for coolant-thru spindle. Remove 2 setscrews 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"	2.04"	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

Blue indicates coolant.

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
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ShrinkFIT
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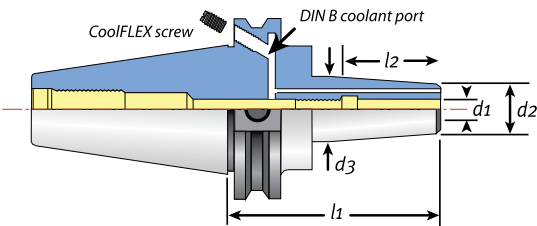


Retention
Knobs
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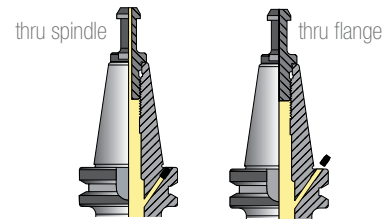


Wrenches
pg. 208

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



CoolBLAST features a 3° angle to better direct coolant on the cutting tool.



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

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



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"	-	M8 x 1.25P	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"	1.06"	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

Blue indicates coolant.



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

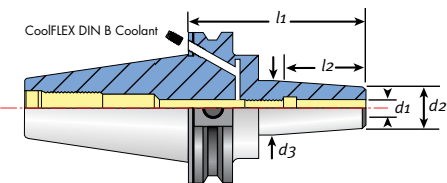
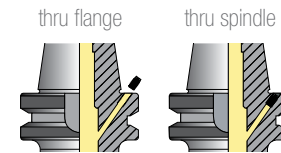
Dual-Contact is a spindle option offered by some machine tool builders. Dual-contact means both the toolholder taper and the flange make contact with the spindle. The dual-contact provides increased rigidity and accuracy during machining.

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



CoolFLEX Feature

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



CoolBLAST features a 3° angle to better direct coolant on the cutting tool.

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.

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

Blue indicates coolant.

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

Blue indicates coolant.

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



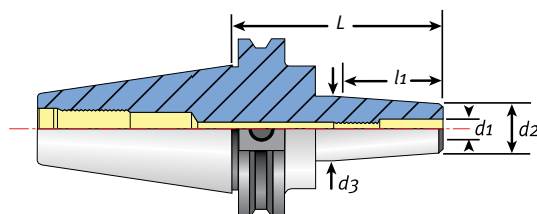
ShrinkFIT
Extensions
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Retention
Knobs
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Wrenches
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Coolant-thru
set screw included.
Page 104 for dimensions.



CAT50 ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
29051	CAT50 x 1/8" I.D. - 4"	1/8"	.36"	.72"	4"	.79"	M6 x 1.0P	16081C-20
29052	CAT50 x 3/16" I.D. - 3.54"	3/16"	.42"	.74"	3.54"	.79"	M6 x 1.0P	16081C-20
29054	CAT50 x 1/4" I.D. - 3.54"	1/4"	.71"	1.02"	3.54"	1.42"	M5 x 0.8P	16080C-20
29056	CAT50 x 5/16" I.D. - 3.54"	5/16"	.79"	1.06"	3.54"	1.42"	M6 x 1.0P	16081C-20
29058	CAT50 x 3/8" I.D. - 3.94"	3/8"	.94"	1.26"	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"	1.06"	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"	2.09"	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"	.42"	.71"	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"	M8 x 1.25P	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"	.78"	1.06"	6"	1.42"	M8 x 1.25P	16082C-20
29058-8	CAT50 x 3/8" I.D. - 8"	3/8"	.78"	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"	M10 x 1.5P	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"	1.06"	1.34"	6"	1.97"	M12 x 1.75P	16085C-20
29066	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

CAT50 Precision ShrinkFIT Toolholders – Metric Size

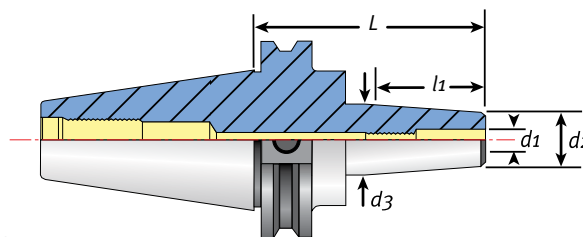


Features

- 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	M5 x 0.8P	16081C-20
29258-8	CAT50 x 8mm I.D. - 203mm	8 mm	21 mm	27 mm	203 mm	36 mm	M5 x 0.8P	16081C-20
29262	CAT50 x 10mm I.D. - 150mm	10 mm	24 mm	32 mm	150 mm	42 mm	M5 x 0.8P	16082C-20
29266	CAT50 x 12mm I.D. - 150mm	12 mm	24 mm	32 mm	150 mm	47 mm	M5 x 0.8P	16083C-20
29266-8	CAT50 x 12mm I.D. - 203mm	12 mm	24 mm	32 mm	203 mm	47mm	M5 x 0.8P	16083C-20
29270	CAT50 x 14mm I.D. - 150mm	14 mm	27 mm	34 mm	150 mm	47 mm	M5 x 0.8P	16083C-20
29274	CAT50 x 16mm I.D. - 160mm	16 mm	27 mm	34 mm	160 mm	50 mm	M5 x 0.8P	16085C-20

CAT50 Precision CoolBLAST ShrinkFIT Toolholders



CoolBLAST Features

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



Techniks Certified for accuracy and balance



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

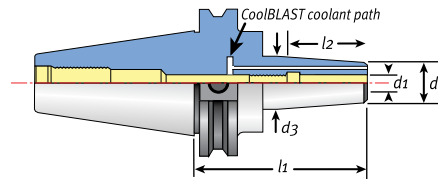


Retention
Knobs
pg. 204



Wrenches
pg. 208

CoolBLAST features a 3° angle to better direct coolant on the cutting tool.



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	0.83"	1.06"	100mm	1.42"	M5 x 0.8P	16080C-20
29054B	CAT50 x SF 1/4" - 3.54" with CoolBLAST	1/4"	0.71"	0.98"	3.54"	1.42"	M5 x 0.8P	16080C-20
29058B	CAT50 x SF 3/8" - 3.94" with CoolBLAST	3/8"	0.94"	1.26"	3.94"	1.42"	M8 x 1.25P	16082C-20
29260B	CAT50 x SF 10mm - 100mm w/ CoolBlast	10mm	0.94"	1.26"	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"	1.06"	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

Blue indicates coolant.

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"	0.71"	1.06"	6"	1.42"	M5 x 0.8P	16080C-20
29058-6B	CAT50 x SF 3/8" - 6" with CoolBLAST	3/8"	0.94"	1.26"	6"	1.65"	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"	1.06"	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

Blue indicates coolant.



BT30 ShrinkFIT & DualDRIVE for Dual-Contact Spindles

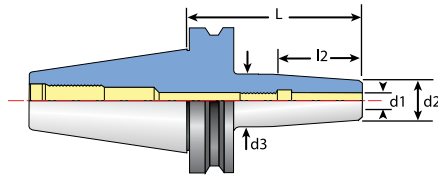


Techniks Certified for accuracy and balance

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	l2	thread	coolant screw
67250	BT30 x 1/4" I.D. - 3"	1/4"	0.82"	1.06"	3"	1.42"	M5 x 0.8P	16082C-20
67375	BT30 x 3/8" I.D. - 3"	3/8"	0.94"	1.25"	3"	1.42"	M8 x 1.25P	16082C-20
67500	BT30 x 1/2" I.D. - 3"	1/2"	0.94"	1.25"	3"	1.85"	M10 x 1.5P	16083C-20
67625	BT30 x 5/8" I.D. - 3"	5/8"	1.06"	1.33"	3"	1.97"	M12 x 1.75P	16085C-20
67750	BT30 x 3/4" I.D. - 3"	3/4"	1.29"	1.62"	3"	2.04"	M16 x 2.0P	16089C-20



Techniks Certified for accuracy and balance

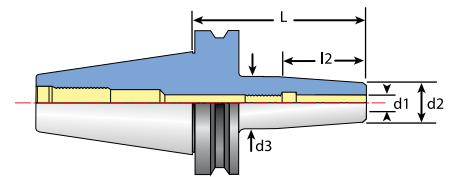
Features

- 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 toolholder 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	l2	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

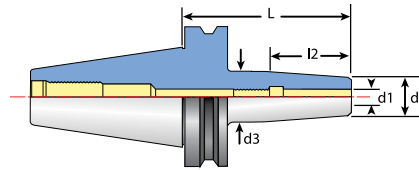
BT40 Precision ShrinkFIT Toolholders



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	l2	thread	coolant screw
39110	BT40 x 3/16" I.D. - 3.54	3/16"	.43"	.75"	6"	.79"	M6 x 1.0P	16081C-20
39111	BT40 x 1/4" I.D. - 3.54	1/4"	.82"	1.06"	6"	1.42"	M5 x 0.8P	16080C-20
39113	BT40 x 3/8" I.D. - 3.54	3/8"	.94"	1.25"	6"	1.65"	-	16082C-20
39114	BT40 x 1/2" I.D. - 3.54	1/2"	1.10"	1.34"	6"	1.85"	M10 x 1.5P	16083C-20
19029	BT40 x 5/8" I.D. - 3.54	5/8"	1.06"	1.34"	6"	1.96"	M12 x 1.75P	16089C-20
39115	BT40 x 3/4" I.D. - 3.54	3/4"	1.29"	1.65"	6"	2.04"	M16 x 2.0P	16085C-20
39117	BT40 x 1.0" I.D. - 3.54	1.0"	1.73"	2.08"	6"	2.28"	M20 x 2.0P	16089C-20
39119-4.13	BT40 x 1-1/4" I.D. - 4.13	1-1/4"	1.81"	2.08"	6"	2.28"	M20 x 2.0P	16091C-20

Extended BT40 ShrinkFIT Holders

Part No.	Description	d1	d2	d3	L	l2	thread	coolant screw
19019-6	BT40 x 1/8" I.D. - 6"	1/8"	.36"	.63"	6"	0.70"	M6 x 1.0P	16081C-20
19020-6	BT40 x 3/16" I.D. - 6"	3/16"	.43"	.70"	6"	0.79"	M6 x 1.0P	16081C-20
19022-6	BT40 x 1/4" I.D. - 6"	1/4"	.49"	.83"	6"	1.42"	M5 x 0.8P	16080C-20
19026-6	BT40 x 3/8" I.D. - 6"	3/8"	.61"	.94"	6"	1.65"	M8 x 1.25P	16082C-20
19028-6	BT40 x 1/2" I.D. - 6"	1/2"	.74"	1.06"	6"	1.85"	M10 x 1.5P	16083C-20
19030-6	BT40 x 5/8" I.D. - 6"	5/8"	1.06"	1.34"	6"	1.96"	M12 x 1.75P	16085C-20
19032-6	BT40 x 3/4" I.D. - 6"	3/4"	1.29"	1.65"	6"	1.65"	M16 x 2.0P	16089C-20
19034-6	BT40 x 1" I.D. - 6"	1"	1.73"	2.09"	6"	2.28"	M20 x 2.0P	16091C-20

BT40 ShrinkFIT Holders Metric Size

Part No.	Description	d1	d2	d3	L	l2	thread	coolant screw
19136-135	BT40 x 6mm I.D. - 135mm	6mm	12mm	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	14mm	36mm	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	16mm	36mm	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

HSK40E, 50E Precision ShrinkFIT Holders

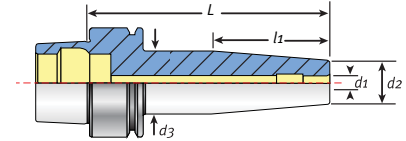


Features

- 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"	.36"	.47"	3.54"	.79"	-	16081C-20
39002-E	HSK40E x 3/16" I.D. - 3.54"	3/16"	.63"	.71"	3.54"	.79"	-	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"	.83"	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"	1.65"	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	9mm	18mm	80mm	18mm	-	16081C-20
39084-E	HSK40E x 4mm I.D. - 80mm	4mm	10mm	22mm	80mm	20mm	-	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"	.36"	.87"	3.15"	.79"	M6 x 1.0P	16081C-20
39016-E	HSK50E x 3/16" I.D. - 3.54"	3/16"	.43"	.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"	.83"	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"	1.65"	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"	1.06"	1.34"	3.54"	.97"	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"	.36"	.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"	1.65"	M8 x 1.25P	16082C-20
99588	HSK40E x 1/2" I.D. - 2.36" SlimLINE	1/2"	.71"	1.06"	2.36"	1.85"	M10 x 1.5P	16083C-20

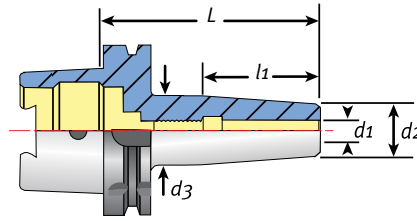
HSK63A Precision ShrinkFIT Holders



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"	.83"	1.06"	3.15"	1.42"	M5 x 0.8P	16082C-20
93116	HSK63A x 5/16" I.D. - 3.15"	5/16"	.83"	1.06"	3.15"	1.42"	M6 x 1.0P	16082C-20
93117	HSK63A x 3/8" I.D. - 3.35"	3/8"	.94"	1.26"	3.35"	1.65"	M8 x 1.25P	16082C-20
93118	HSK63A x 7/16" I.D. - 3.54"	7/16"	.94"	1.26"	3.54"	1.85"	M8 x 1.25P	16082C-20
93119	HSK63A x 1/2" I.D. - 3.54"	1/2"	.94"	1.26"	3.54"	1.85"	M10 x 1.5P	16083C-20
93120	HSK63A x 9/16" I.D. - 3.54"	9/16"	1.06"	1.34"	3.54"	1.85"	M10 x 1.5P	16083C-20
93121	HSK63A x 5/8" I.D. - 3.74"	5/8"	1.06"	1.34"	3.74"	1.97"	M12 x 1.75P	16085C-20
93124	HSK63A x 3/4" I.D. - 3.94"	3/4"	1.30"	1.65"	3.94"	2.05"	M16 x 2.0P	16089C-20
93126	HSK63A x 1.0" I.D. - 4.53"	1.0"	1.73"	2.05"	4.53"	2.28"	M20 x 2.0P	16091C-20
93128	HSK63A x 1-1/4" I.D. - 4.72"	1-1/4"	1.73"	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"	.94"	1.26"	6.3"	1.65"	M8 x 1.25P	16082C-20
93135	HSK63A x 1/2" I.D. - 6.3"	1/2"	.94"	1.10"	6.3"	1.85"	M10 x 1.5P	16083C-20
93140	HSK63A x 3/4" I.D. - 6.3"	3/4"	1.42"	1.65"	6.3"	2.05"	M16 x 2.0P	16089C-20
93145	HSK63A x 1.0" I.D. - 6.3"	1.0"	1.73"	2.09"	6.3"	2.28"	M20 x 2.0P	16091C-20

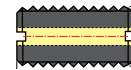


Use SlimLINE holders for finish passes where small nose diameter (d2) tooling is required.

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"	1.65"	M8x1.25P	16082C-20
73588	HSK63A x 1/2" I.D. - 3.15" SlimLINE	1/2"	.71"	1.06"	3.15"	1.85"	M10x1.5P	16083C-20

HSK63A 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



ShrinkFIT
Machines
pg. 105



ShrinkFIT
Extensions
pg. 104



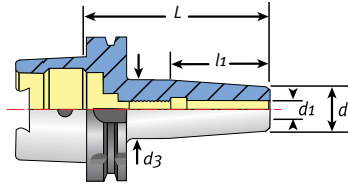
Retention
Knobs
pg. 204



Wrenches
pg. 208



Techniks Certified for accuracy and balance



HSK63A Metric Size ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	L	l1	thread	coolant screw
39132	HSK63A x 4mm I.D. - 80mm	4mm	10mm	22mm	80mm	20mm	M6 x 1.0P	16082C-20
39134	HSK63A x 5mm I.D. - 80mm	5mm	16mm	22mm	80mm	20mm	M6 x 1.0P	16082C-20
39136	HSK63A x 6mm I.D. - 80mm	6mm	21mm	27mm	80mm	36mm	M5 x 0.8P	16082C-20
39138	HSK63A x 8mm I.D. - 80mm	8mm	21mm	27mm	80mm	36mm	M6 x 1.0P	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	27mm	34mm	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 features a 3° angle to better direct coolant on the cutting tool.

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

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



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"	M6 x 1.0P	16082C-20
93115B	HSK63A x 1/4" I.D. - 3.15" with CoolBLAST	1/4"	.83"	1.06"	3.15"	1.42"	M5 x 0.8P	16082C-20
93117B	HSK63A x 3/8" I.D. - 3.35" with CoolBLAST	3/8"	.94"	1.26"	3.35"	1.65"	M8 x 1.25P	16082C-20
93119B	HSK63A x 1/2" I.D. - 3.54" with CoolBLAST	1/2"	1.110"	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"	1.06"	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"	1.30"	1.65"	3.94"	2.05"	M16 x 2.0P	16089C-20

Blue indicates coolant.

All orders ship same day! Ground orders in by 2:00 and expedited orders in by 5:00 EST.

www.technikusa.com

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



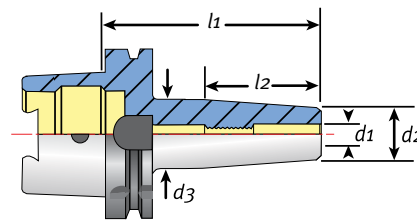
ShrinkFIT
Extensions
pg. 104



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"	.35"	.87"	3.54"	.79"	M6 x 1.0P	16081C-20
39306	HSK100A x 1/4" I.D. - 3.54"	1/4"	.83"	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"	1.65"	M8 x 1.25P	16082C-20
39310-6	HSK100A x 3/8" I.D. - 6"	3/8"	.94"	1.26"	6"	1.65"	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"	1.06"	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

Precision ShrinkFIT Toolholders for CNC Routers



Techniks Certified for accuracy and balance

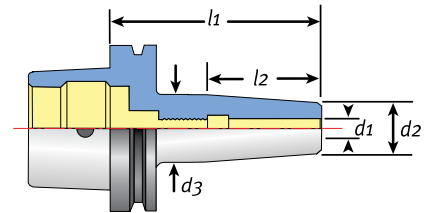


Scan the QR code with a smartphone or enter this url: <http://ow.ly/rks6W> to request our new 76 page CNC Router Tooling catalog. Or, you can call us at (800) 597-3921 to have it sent to you.

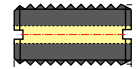


Features

- 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.



HSK63F Inch ShrinkFIT Toolholders

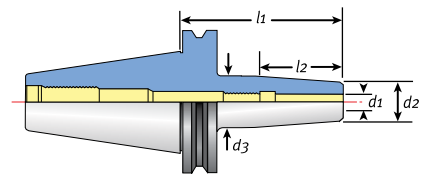
Part No.	Description	d1	d2	d3	l1	l2	thread	coolant screw
71250	HSK63F x 1/4" I.D. - 3.15"	1/4"	.83"	1.06"	3.15"	1.42"	M5 x 0.8P	16080C-20
71312	HSK63F x 5/16" I.D. - 3.74"	5/16"	.79"	1.06"	3.74"	1.42"	M6 x 1.0P	16081C-20
71375	HSK63F x 3/8" I.D. - 3.74"	3/8"	.94"	1.26"	3.74"	1.65"	M8 x 1.25P	16082C-20
71500	HSK63F x 1/2" I.D. - 3.74"	1/2"	.94"	1.26"	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"	1.97"	M12 x 1.75P	16085C-20
71750	HSK63F x 3/4" I.D. - 3.94"	3/4"	1.42"	1.65"	3.94"	2.05"	M16 x 2.0P	16089C-20
71100	HSK63F x 1.0" I.D. - 4.53"	1"	1.42"	1.65"	4.53"	2.28"	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



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.



ISO30 ShrinkFIT Toolholders

Part No.	Description	d1	d2	d3	l1	l2	thread	coolant screw
64250	ISO30 x 1/4" - 80	1/4"	21	27	80	39	M5 x 0.8P	16082C-20
64375	ISO30 x 3/8" - 80	3/8"	24	32	80	42	M8 x 1.25P	16082C-20
64500	ISO30 x 1/2" - 80	1/2"	28	32	80	47	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"	33	42	80	52	M16 x 2.0P	16089C-20
64110	ISO30 x 1.0" - 4"	1.0"	46	53	4"	58	M20 x 2.0P	16091C-20

Techniks Certified tools are individually tested, inspected, and measured for quality.

Techniks SFS ShrinkFIT Holders & Adapters

NEW! SFS Shrink Adapters provide excellent accuracy and clearance at extended lengths. A great choice for mold & die applications.



Features

- T.I.R 0.0001" measured from the taper to the I.D.
- Balanced to 25,000 RPM @ G2.5
- Compatible with other modular shrink fit systems
- Coolant thru capable

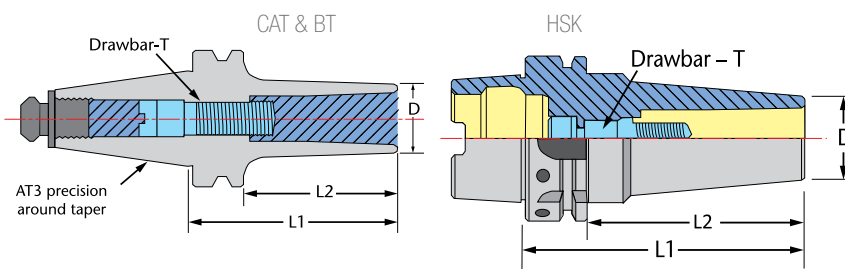
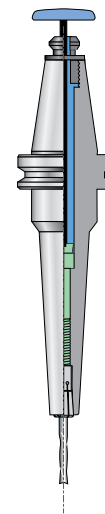
Use with ShrinkFIT Adapters on the next page.

How It Works

SFS toolholders feature a powerful internal drawbar design for maximum holding power and accuracy.

Advantages of H13 Tool Steel

SFS toolholders and ShrinkFIT adapters are made from H13 tool steel for compatibility with fast induction heat shrink machines like Techniks ShrinkPRO that provide tool changes in only 3–5 seconds. Toolholders made from H13 also provide reduced wear and tear on the machine spindle when compared to stainless steel holders.



BT30 Retention Knobs & Drawbars for 10.780.12.138

Style	Part No.
45°	17817-MAS-1
60°	17806-MAS-2

Drawbar wrench requires coolant pull stud.

SFS Toolholders for CAT, BT, HSK

Part No.	Description	L1	L2	D	Drawbar-T
10.780.12.138	BT 30 x SFS 12 - 1.38"	1.38"	0.51"	1.50"	See above table.
11.780.12.045	BT 40 x SFS 12 - 45mm	45mm	0.71"	1.50"	SBL-M10C-25
31.780.12.177	CAT 40 x SFS 12 - 1.77"	1.77"	0.34"	1.61"	SBL-M10C-25
32.780.12.295	CAT 50 x SFS 12 - 2.95"	2.95"	1.46"	1.50"	SBL-M10C-25
99.780.12.075	HSK 40E x SFS 12 - 75mm	75mm	55mm	38.1mm	SFS-M10C-20.6
73.780.12.075	HSK 63A x SFS 12 - 75mm	75mm	47mm	38mm	SFS-M10C-20.6

Techniks SFS ShrinkFIT Adapters – Inch Size

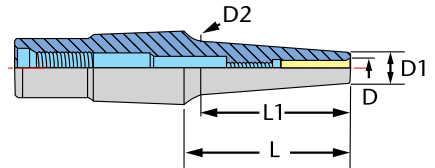


Use with SFS Holders on page 104.

Inch Size Adapters

Tighten to 44 ft/lbs

- H13 tool steel for easy tool changes
- Compatible with other holders
- Coolant thru capable



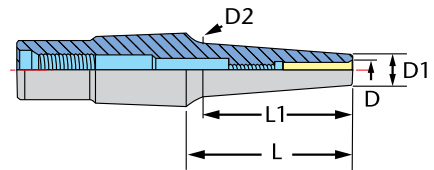
Part No.	Description	D	L	L1	D1	D2
258.SFS12.52.138	SFS 12 x 1/8" - 1.38"	1/8"	1.38"	0.87"	.24"	.33"
258.SFS12.53.138	SFS 12 x 3/16" - 1.38"	3/16"	1.38"	0.87"	.31"	.40"
258.SFS12.54.138	SFS 12 x 1/4" - 1.38"	1/4"	1.38"	0.87"	.37"	.46"
258.SFS12.56.138	SFS 12 x 3/8" - 1.38"	3/8"	1.38"	0.87"	.49"	.58"
258.SFS12.58.138	SFS 12 x 1/2" - 1.38"	1/2"	1.38"	0.87"	.62"	.71"
258.SFS12.52.055	SFS 12 x 1/8" - 55mm	1/8"	55mm	42	6.2	10.6mm
258.SFS12.53.055	SFS 12 x 3/16" - 55mm	3/16"	55mm	42	7.8	12.2mm
258.SFS12.54.055	SFS 12 x 1/4" - 55mm	1/4"	55mm	42	9.4	13.8mm
258.SFS12.56.055	SFS 12 x 3/8" - 55mm	3/8"	55mm	42	12.5	16.9mm
258.SFS12.58.055	SFS 12 x 1/2" - 55mm	1/2"	55mm	42	15.7	20.1mm
258.SFS12.52.315	SFS 12 x 1/8" - 3.15"	1/8"	3.15"	2.64"	.24"	.52"
258.SFS12.53.315	SFS 12 x 3/16" - 3.15"	3/16"	3.15"	2.64"	.31"	.58"
258.SFS12.54.315	SFS 12 x 1/4" - 3.15"	1/4"	3.15"	2.64"	.37"	.64"
258.SFS12.56.315	SFS 12 x 3/8" - 3.15"	3/8"	3.15"	2.64"	.49"	.77"
258.SFS12.58.315	SFS 12 x 1/2" - 3.15"	1/2"	3.15"	2.64"	.62"	.89"
258.SFS12.52.433	SFS 12 x 1/8" - 4.33"	1/8"	4.33"	3.82"	.24"	.64"
258.SFS12.53.433	SFS 12 x 3/16" - 4.33"	3/16"	4.33"	3.82"	.31"	.71"
258.SFS12.54.433	SFS 12 x 1/4" - 4.33"	1/4"	4.33"	3.82"	.37"	.77"
258.SFS12.56.433	SFS 12 x 3/8" - 4.33"	3/8"	4.33"	3.82"	.49"	.89"
258.SFS12.58.433	SFS 12 x 1/2" - 4.33"	1/2"	4.33"	3.82"	.62"	1.02"

Techniks SFS ShrinkFIT Adapters – Metric Size



Use with SFS Holders on page 104.

- H13 tool steel for easy tool changes
- Compatible with other holders
- Coolant thru capable



Metric Size Adapters

Part No.	Description	D	L	L1	D1	D2
258.SFS12.03.035	SFS 12 x 3mm - 35mm	3mm	35mm	22	6	8.3mm
258.SFS12.04.035	SFS 12 x 4mm - 35mm	4mm	35mm	22	7	9.3mm
258.SFS12.06.035	SFS 12 x 6mm - 35mm	6mm	35mm	22	9	11.3mm
258.SFS12.08.035	SFS 12 x 8mm - 35mm	8mm	35mm	22	11	13.3mm
258.SFS12.10.035	SFS 12 x 10mm - 35mm	10mm	35mm	22	13	15.3mm
258.SFS12.12.035	SFS 12 x 12mm - 35mm	12mm	35mm	22	15	17.3mm
258.SFS12.03.055	SFS 12 x 3mm - 55mm	3mm	55mm	42	6	10.4mm
258.SFS12.04.055	SFS 12 x 4mm - 55mm	4mm	55mm	42	7	11.4mm
258.SFS12.06.055	SFS 12 x 6mm - 55mm	6mm	55mm	42	9	13.4mm
258.SFS12.08.055	SFS 12 x 8mm - 55mm	8mm	55mm	42	11	15.4mm
258.SFS12.10.055	SFS 12 x 10mm - 55mm	10mm	55mm	42	13	17.4mm
258.SFS12.12.055	SFS 12 x 12mm - 55mm	12mm	55mm	42	15	19.4mm
258.SFS12.03.080	SFS 12 x 3mm - 80mm	3mm	80mm	67	6	13mm
258.SFS12.04.080	SFS 12 x 4mm - 80mm	4mm	80mm	67	7	14mm
258.SFS12.06.080	SFS 12 x 6mm - 80mm	6mm	80mm	67	9	16.2mm
258.SFS12.08.080	SFS 12 x 8mm - 80mm	8mm	80mm	67	11	18mm
258.SFS12.10.080	SFS 12 x 10mm - 80mm	10mm	80mm	67	13	20mm
258.SFS12.03.110	SFS 12 x 3mm - 110mm	3mm	110mm	97	6	16.2mm
258.SFS12.04.110	SFS 12 x 4mm - 110mm	4mm	110mm	97	7	17.2mm
258.SFS12.06.110	SFS 12 x 6mm - 110mm	6mm	110mm	97	9	19.2mm
258.SFS12.08.110	SFS 12 x 8mm - 110mm	8mm	110mm	97	11	21.2mm
258.SFS12.10.110	SFS 12 x 10mm - 110mm	10mm	110mm	97	13	23.1mm
258.SFS12.12.110	SFS 12 x 12mm - 110mm	12mm	110mm	97	15	25.2mm

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 Shrink-STATION machine.

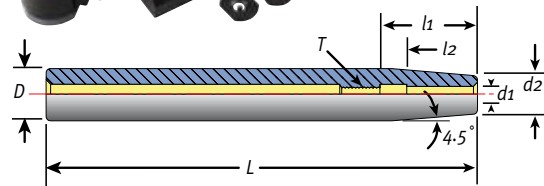


end mill holders

collet chucks

hydraulic chucks

ShrinkFIT holders



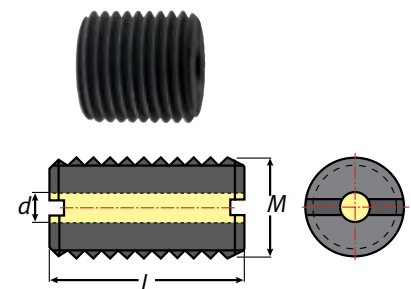
Metric sizes available upon request.

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"	-	.39"	-
86064	5/8" O.D., x 3/16" I.D. - 6.3" length	5/8"	3/16"	.394"	6.3"	-	.39"	-
86066	5/8" O.D., x 1/4" I.D. - 6.3" length	5/8"	1/4"	.394"	6.3"	1.42	1.02"	M6x1.0
86076	3/4" O.D., x 1/4" I.D. - 6.3" length	3/4"	1/4"	.551"	6.3"	1.42	1.02"	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	1.46"	M10x1.5
86094	1.0" O.D., x 5/8" I.D. - 6.3" length	1.0"	5/8"	.87"	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 </td <td>4</td>	4
16089C-20	Coolant Set Screw	M16 x 02.0P	20mm	5
16091C-20	Coolant Set Screw	M20 x 2.0P	20mm	5

Blue indicates coolant.



We stand behind all our CNC tooling solutions from spindle to workpiece.

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



Features

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

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.

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

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.



20" wide x 20" deep x 37" tall

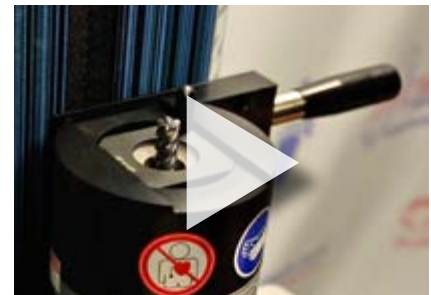
Easy-to-Use Touchscreen



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

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.

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.

We stand behind all our CNC tooling solutions from spindle to workpiece.

The Quencher Cools Tools in Only 30 Seconds

NEW!



fast, safe,
induction heat

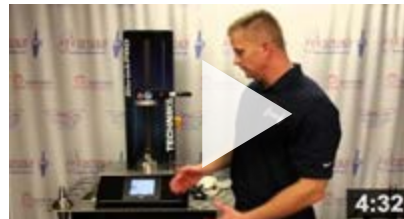
Features

- 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.

36.75" wide x 24" deep x 71" tall

Description	Tool Change	Electrical Supply	Ship Wt.
00500 Quencher	2-5 seconds	3 phase, 480V, 20A	660 lbs.

"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.



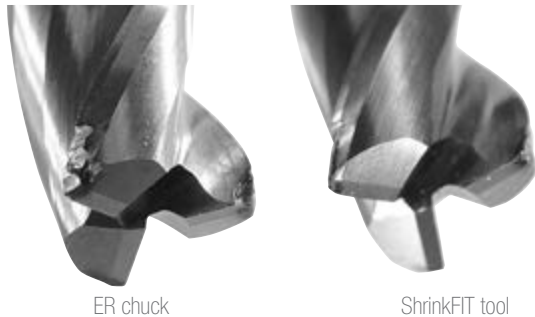
Tool Life Comparison: ER Chucks vs. ShrinkFIT

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 over ER8620.



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.

