

- Meets or exceeds JIS B 6339 specifications and all current standard updates.
- The 7/24 shank cones are produced to the highest industry standards according to ISO-1947, with a taper accuracy of AT3 or better, enabling an optimum fit between the spindle and toolholder.
- Essential surfaces are not black-oxide to provide better fits.
- All non-critical surfaces are black-oxide, except for the high-performance toolholders.
- Through-coolant is a standard feature when the toolholder design allows.
- Depending on the application, Kennametal's BT30, BT40, and BT50 balanced-by-design toolholders perform effectively up to 12,000 rpm. All other toolholders are effective at speeds up to 10,000 rpm, unless stated otherwise. Kennametal recommends that toolholder assemblies (toolholder, components, retention knob, collets, and cutting tools) should be balanced when used at speeds in excess of 10,000 rpm.



### IMPORTANT!

- All critical surfaces must be protected against damage. Neglect from dings and scratches will impair accuracy and performance.
- All assembly components must be clean. Never overtighten the components; this can permanently destroy the function and accuracy of the toolholder.

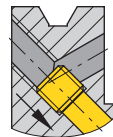
For retention knobs, please see page 764.



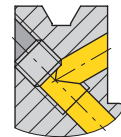
### Form B Coolant

Some toolholders are equipped with the form B coolant-style feature.

### CAUTION!

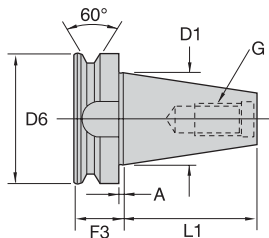


*Toolholders are factory set to the form B coolant supply position. When relocating coolant position screws, use of a removable liquid (small screw thread locker) is recommended.*



*The toolholder can be easily converted to DIN 69871 form AD coolant supply; tightening screws will stop coolant from escaping through the flange.*

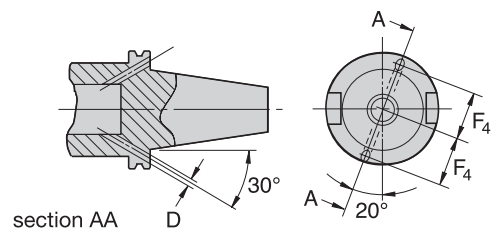
### Tooling Standard Dimensions – JIS B6339



	D1	D6	L1	F3	A	G
30	1.250 (31,75)	1.811 (46,00)	1.906 (48,40)	.866 (22,00)	.079 (2,00)	M12 thread
35*	1.500 (38,10)	2.087 (53,00)	2.224 (56,50)	.945 (24,00)	.079 (2,00)	M12 thread
40	1.750 (44,45)	2.480 (63,00)	2.575 (65,40)	1.063 (27,00)	.079 (2,00)	M16 thread
45	2.250 (57,15)	3.346 (85,00)	3.260 (82,80)	1.299 (33,00)	.118 (3,00)	M20 thread
50	2.750 (69,85)	3.937 (100,00)	4.008 (101,80)	1.496 (38,00)	.118 (3,00)	M24 thread

\* Manufactured to MAS-403-1972 standards.

### Form B – Flange Coolant Entry Ports



	D	F4 ±0.004
30	.157 (4,00)	.827 (21,00)
40	.157 (4,00)	1.063 (27,00)
45	.197 (5,00)	1.378 (35,00)
50	.236 (6,00)	1.654 (42,00)