

Precision Shrink-Fit Holders and Shrink Machines

Precision Shrink-Fit Holders and Shrink Machines

Maximum rigidity and accuracy provide extended cutting tool life.

Full Line of Shrink Fit

CAT, BT, HSK, ISO – standard and extended lengths, inch and metric sizes. See our DualDRIVE shrink fit holders for maximum rigidity at extended lengths.



CoolBLAST Shrink-Fit

CoolBLAST holders feature coolant ports that put coolant right on the tool. (page 82)



Shrink Fit Machines

Induction heat for fast tool changes and automatic cooling cycle. (page 94)



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

**We don't sell tools.
We sell tool life.**

I guarantee your satisfaction with every Techniks product.



John A. Stagge
PRESIDENT

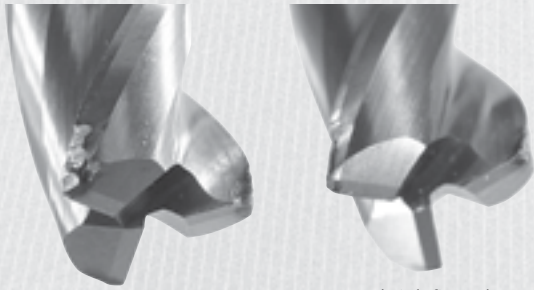
Tool Life Comparison: ER Chucks v.s. Shrink Fit

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 end mills 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 end mills. The identical tool paths involved a variety of cutting directions.



shrink fit tool

TEST RESULTS

Tool Life

The most significant comparison between these tool holding technologies is in the area of tool life. The end mill in the shrink-fit toolholder showed dramatically less wear (photos) compared to the end mill used in the collet chuck (note the fractured surface). Our results back up other reports that shrink-fit 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 shrink-fit holder (visible in photo above). This was attributed to the superior wear characteristics of H-13 tool steel over 8620.



ER chuck wear detail



shrink fit 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 shrink fit tool holder required less spindle load than the ER collet chuck tool holder. The increased rigidity of shrink-fit 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 shrink-fit toolholder (below)



ER chuck fretting

shrink fit

CONCLUSION

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

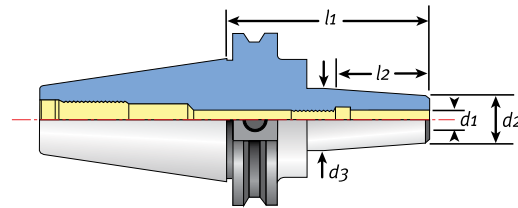
CAT 40 Standard Inch Size and Slim Line Shrink Fit



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Shrink-Fit Holder Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



CAT 40 Standard Length Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29002	CAT 40 x 1/8" I.D. - 3.5"	1/8"	.63"	.87"	3.5"	.79"
29006	CAT 40 x 3/16" I.D. - 3.5"	3/16"	.63"	.87"	3.5"	.79"
29010	CAT 40 x 1/4" I.D. - 3"	1/4"	.71"	1.06"	3"	1.42"
29011	CAT 40 x 1/4" I.D. - 3.5"	1/4"	.71"	1.06"	3.5"	1.42"
29016	CAT 40 x 5/16" I.D. - 3.5"	5/16"	.78"	1.06"	3.5"	1.42"
29020	CAT 40 x 3/8" I.D. - 3"	3/8"	.94"	1.26"	3"	1.53"
29021	CAT 40 x 3/8" I.D. - 3.75"	3/8"	.94"	1.26"	3.75"	1.53"
29026	CAT 40 x 1/2" I.D. - 3"	1/2"	1.10"	1.34"	3"	1.85"
29027	CAT 40 x 1/2" I.D. - 3.75"	1/2"	1.10"	1.34"	3.75"	1.85"
29032	CAT 40 x 5/8" I.D. - 3.75"	5/8"	1.26"	1.34"	3.75"	1.97"
29034	CAT 40 x 3/4" I.D. - 3"	3/4"	1.42"	1.65"	3"	2.04"
29036	CAT 40 x 3/4" I.D. - 4"	3/4"	1.42"	1.65"	4"	2.04"
29040	CAT 40 x 1.0" I.D. - 3"	1.0"	1.81"	2.09"	3"	2.28"
29042	CAT 40 x 1.0" I.D. - 4"	1.0"	1.81"	2.09"	4"	2.28"
29046	CAT 40 x 1-1/4" I.D. - 4"	1-1/4"	1.81"	2.09"	4"	2.28"



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Slim Line Features

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

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

CAT 40 Slim Line Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
31528	CAT 40 x 1/8" I.D. - 80mm Slim Line	1/8"	.44"	.63"	80mm	20mm
31538	CAT 40 x 3/16" I.D. - 80mm Slim Line	3/16"	.5"	.69"	80mm	20mm
31548	CAT 40 x 1/4" I.D. - 80mm Slim Line	1/4"	.56"	.81"	80mm	36mm
31568	CAT 40 x 3/8" I.D. - 80mm Slim Line	3/8"	.69"	.94"	80mm	47mm
31588	CAT 40 x 1/2" I.D. - 80mm Slim Line	1/2"	.81"	1.06"	80mm	47mm

CAT 40 Extended Length Shrink Fit Inch Size



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Features

- Maximum T.I.R. only .0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



Shrink
Machines
pg. 94



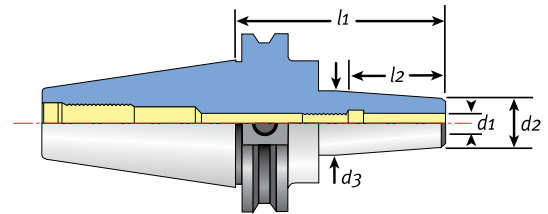
Shrink
Extensions
pg. 93



Retention
Knobs
pg. 161



Wrenches
pg. 166



CAT 40 Extended Length Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29004	CAT 40 x 1/8" I.D. - 5"	1/8"	.63"	.87"	5"	.79"
29008	CAT 40 x 3/16" I.D. - 5"	3/16"	.63"	.87"	5"	.79"
29013	CAT 40 x 1/4" I.D. - 5"	1/4"	.71"	1.06"	5"	1.42"
29014	CAT 40 x 1/4" I.D. - 6"	1/4"	.71"	1.06"	6"	1.42"
29018	CAT 40 x 5/16" I.D. - 5"	5/16"	.78"	1.06"	5"	1.42"
29023	CAT 40 x 3/8" I.D. - 5"	3/8"	.94"	1.26"	5"	1.53"
29024	CAT 40 x 3/8" I.D. - 6"	3/8"	.94"	1.26"	6"	1.53"
29029	CAT 40 x 1/2" I.D. - 5"	1/2"	1.10"	1.34"	5"	1.85"
29030	CAT 40 x 1/2" I.D. - 6"	1/2"	1.10"	1.34"	6"	1.85"
29037	CAT 40 x 3/4" I.D. - 5"	3/4"	1.42"	1.65"	5"	2.04"
29038	CAT 40 x 3/4" I.D. - 6"	3/4"	1.42"	1.65"	6"	2.04"
29044	CAT 40 x 1.0" I.D. - 6"	1.0"	1.81"	2.09"	6"	2.28"

CAT 40 Precision Shrink-Fit Tool Holders Metric Size



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Shrink Fit Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



Shrink Machines
pg. 94



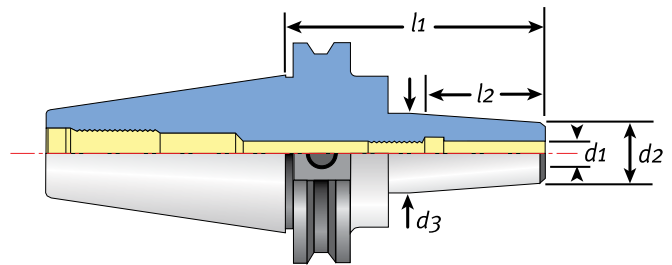
Shrink Extensions
pg. 93



Retention Knobs
pg. 161



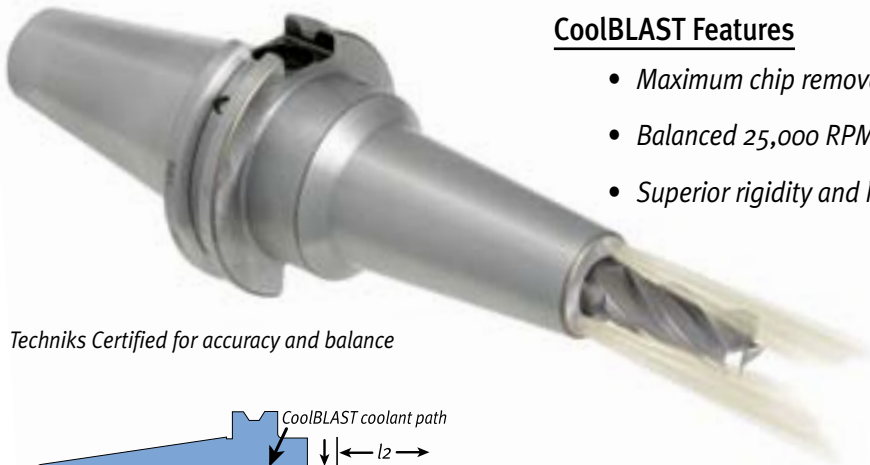
Wrenches
pg. 166



CAT 40 Metric Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29208	CAT 40 x 6mm I.D. - 100mm	6mm	21mm	27mm	100mm	36mm
29210	CAT 40 x 6mm I.D. - 150mm	6mm	21mm	27mm	150mm	36mm
29212	CAT 40 x 8mm I.D. - 100mm	8mm	21mm	27mm	100mm	36mm
29214	CAT 40 x 8mm I.D. - 150mm	8mm	21mm	27mm	150mm	36mm
29216	CAT 40 x 10mm I.D. - 100mm	10mm	24mm	32mm	100mm	42mm
29218	CAT 40 x 10mm I.D. - 150mm	10mm	24mm	32mm	150mm	42mm
29220	CAT 40 x 12mm I.D. - 100mm	12mm	24mm	32mm	100mm	47mm
29222	CAT 40 x 12mm I.D. - 150mm	12mm	24mm	32mm	150mm	47mm
29226	CAT 40 x 14mm I.D. - 100mm	14mm	27mm	34mm	100mm	47mm
29228	CAT 40 x 14mm I.D. - 152.4mm	14mm	27mm	34mm	152.4mm	47mm
29232	CAT 40 x 16mm I.D. - 100mm	16mm	27mm	34mm	100mm	50mm
29234	CAT 40 x 16mm I.D. - 160mm	16mm	27mm	34mm	160mm	50mm
29236	CAT 40 x 18mm I.D. - 100mm	18mm	33mm	42mm	100mm	50mm
29238	CAT 40 x 20mm I.D. - 80mm	20mm	33mm	42mm	80mm	52mm

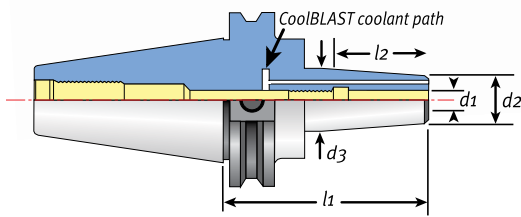
CAT 40 CoolBLAST or CoolFLEX Shrink Fit Holders



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CoolBLAST Features

- Maximum chip removal for maximum feed rates
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



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



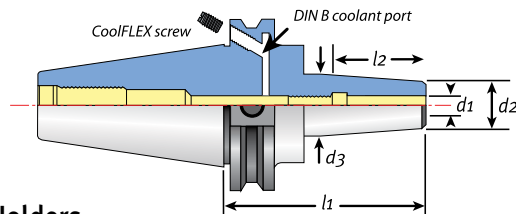
CAT 40 CoolBLAST Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29023B	CAT 40 x 3/8" I.D. - 5" with CoolBLAST	3/8"	.94"	1.26"	5"	1.53"
29029B	CAT 40 x 1/2" I.D. - 5" with CoolBLAST	1/2"	1.10"	1.34"	5"	1.85"
29033B	CAT 40 x 5/8" I.D. - 5" with CoolBLAST	5/8"	1.26"	1.34"	5"	1.97"
29036B	CAT 40 x 3/4" I.D. - 4" with CoolBLAST	3/4"	1.42"	1.65"	4"	2.04"
29037B	CAT 40 x 3/4" I.D. - 5" with CoolBLAST	3/4"	1.42"	1.65"	5"	2.04"

CoolFLEX Features

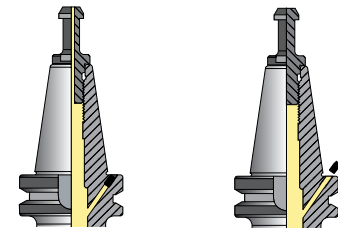
- Coolant thru spindle or thru flange (DIN B)
- Bore tolerance is H5 (Best in Industry)

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



thru spindle

thru flange



Replacement CoolFLEX Screws

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

CAT 40 CoolFLEX Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29011F	CAT 40 x 1/4" I.D. - 3.5" with CoolFLEX	1/4"	.71"	1.06"	3.5"	1.42"
29021F	CAT 40 x 3/8" I.D. - 3.75" with CoolFLEX	3/8"	.94"	1.26"	3.75"	1.53"
29027F	CAT 40 x 1/2" I.D. - 3.75" with CoolFLEX	1/2"	1.10"	1.34"	3.75"	1.85"
29040F	CAT 40 x 1.0" I.D. - 3" with CoolFLEX	1.0"	1.81"	2.09"	3"	2.28"
29042F	CAT 40 x 1.0" I.D. - 4" with CoolFLEX	1.0"	1.81"	2.09"	4"	2.28"
29046F	CAT 40 x 1-1/4" I.D. - 4" with CoolFLEX	1-1/4"	1.81"	2.09"	4"	2.28"

CAT 40 Shrink-Fit Holders with CoolBLAST and CoolFLEX



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Features

- Get CoolBLAST performance from DIN B spindles
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



Shrink Machines
pg. 94



Shrink Extensions
pg. 93



Retention Knobs
pg. 161



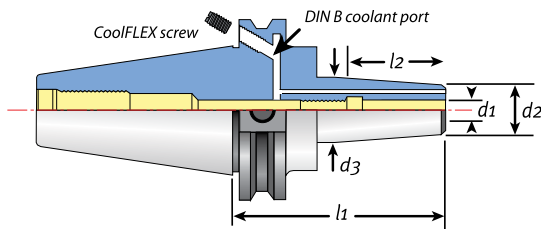
Wrenches
pg. 166



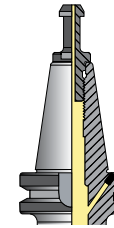
CoolBLAST coolant ports direct coolant on the tool path, even at high RPMs. No need to purchase coolant thru cutting tools.

CoolFLEX Features

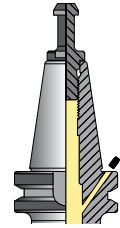
- Coolant thru spindle or thru flange (DIN B)
- Bore tolerance is H5 (Best in Industry)



thru spindle



thru flange



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

CAT 40 CoolBLAST and CoolFLEX DIN B Coolant Capability

Part No.	Description	d1	d2	d3	l1	l2
29002FB	CAT 40 x 1/8" I.D. - 3.5"	1/8"	.63"	.87"	3.5"	-
29006FB	CAT 40 x 3/16" I.D. - 3.5"	3/16"	.63"	.87"	3.5"	-
29011FB	CAT 40 x 1/4" I.D. - 3.5"	1/4"	.71"	1.06"	3.5"	1.42"
29016FB	CAT 40 x 5/16" I.D. - 3.5"	5/16"	.78"	1.06"	3.5"	1.42"
29021FB	CAT 40 x 3/8" I.D. - 3.75"	3/8"	.94"	1.26"	3.75"	1.53"
29027FB	CAT 40 x 1/2" I.D. - 3.75"	1/2"	1.10"	1.34"	3.75"	1.85"
29032FB	CAT 40 x 5/8" I.D. - 3.75"	5/8"	1.26"	1.34"	3.75"	1.97"
29036FB	CAT 40 x 3/4" I.D. - 4"	3/4"	1.42"	1.65"	4"	2.04"
29042FB	CAT 40 x 1.0" I.D. - 4"	1.0"	1.81"	2.09"	4"	2.28"

DualDRIVE CAT 40 Shrink-Fit – CoolFLEX and CoolBLAST



Features

- Dual-contact machining on any CAT 40 spindle
- Coolant-thru spindle or thru flange (DIN B)
- Balanced to 25,000 RPM at G2.5

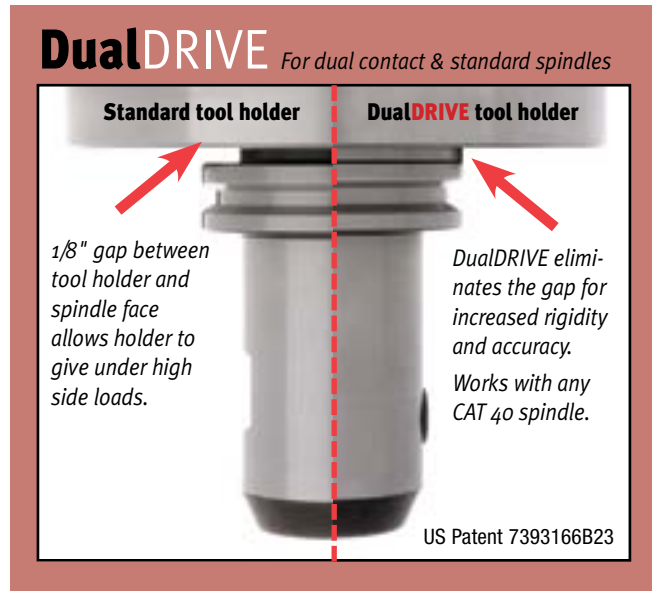
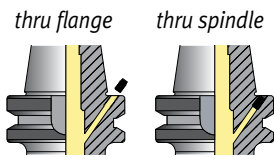
Benefits

- Better rigidity and reduced vibration (chatter)
- Improved performance at high metal removal rates and when machining at extended lengths
- Provides the benefits of dual-contact machining on standard spindles too!

See an on machine demonstration video of DualDRIVE compared to standard toolholders at: www.technikusa.com/videos2008/DD

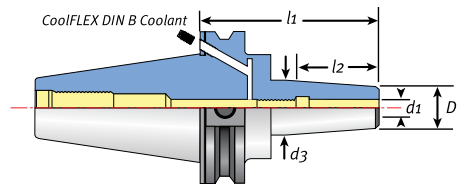
CoolFLEX Feature

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



CAT 40 DualDRIVE CoolFLEX Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
79011	CAT 40 x SF 1/4" - 3.5" DualDRIVE with CoolFLEX	1/4"	18mm	27mm	3.5"	36mm
79021	CAT 40 x SF 3/8" - 3.75" DualDRIVE with CoolFLEX	3/8"	24mm	32mm	3.75"	42mm
79027	CAT 40 x SF 1/2" - 3.75" DualDRIVE with CoolFLEX	1/2"	28mm	34mm	3.75"	47mm
79036	CAT 40 x SF 3/4" - 4" DualDRIVE with CoolFLEX	3/4"	36mm	42mm	4"	52mm
79042	CAT 40 x SF 1.0" - 4" DualDRIVE with CoolFLEX	1.0"	46mm	53mm	4"	58mm
79046	CAT 40 x SF 1-1/4" DualDRIVE with CoolFLEX	1-1/4"	46mm	53mm	4"	58mm



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



CAT 40 DualDRIVE CoolBLAST Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
79027B	CAT 40 x SF 1/2" - 3.15" DualDRIVE with CoolBLAST	1/2"	28mm	34mm	3.15"	47mm
79036B	CAT 40 x SF 3/4" - 3.15" DualDRIVE with CoolBLAST	3/4"	36mm	42mm	3.15"	52mm



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

CAT 50 Precision Shrink-Fit Tool Holders Inch Size



Techniks Certified for accuracy and balance

Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



Shrink Machines
pg. 94



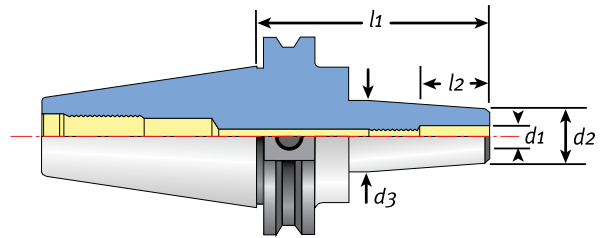
Shrink Extensions
pg. 93



Retention Knobs
pg. 161



Wrenches
pg. 166



CAT 50 Standard Length Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29050	CAT 50 x 1/8" I.D. - 4"	1/8"	.63"	.87"	4"	.79"
29052	CAT 50 x 3/16" I.D. - 3.54"	3/16"	.63"	.87"	3.54"	.79"
29054	CAT 50 x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"
29056	CAT 50 x 5/16" I.D. - 3.54"	5/16"	.71"	1.06"	3.54"	1.42"
29058	CAT 50 x 3/8" I.D. - 3.94"	3/8"	.71"	1.06"	3.94"	1.42"
29060	CAT 50 x 1/2" I.D. - 3.94"	1/2"	1.10"	1.34"	3.94"	1.85"
29062	CAT 50 x 5/8" I.D. - 3.94"	5/8"	1.26"	1.34"	3.94"	1.97"
29064	CAT 50 x 3/4" I.D. - 4.13"	3/4"	1.42"	1.65"	4.13"	2.04"
29068	CAT 50 x 1.0" I.D. - 4.13"	1"	1.81"	2.09"	4.13"	2.28"
29072	CAT 50 x 1-1/4" I.D. - 4.13"	1-1/4"	1.81"	2.09"	4.13"	2.28"
29074	CAT 50 x 1-1/4" I.D. - 4.72"	1-1/4"	1.81"	1.81"	4.72"	2.28"

CAT 50 Extended Length Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29052-6	CAT 50 x 3/16" I.D. - 6"	3/16"	.63"	.87"	6"	.79"
29054-6	CAT 50 x 1/4" I.D. - 6"	1/4"	.71"	1.06"	6"	1.42"
29058-6	CAT 50 x 3/8" I.D. - 6"	3/8"	.78"	1.06"	6"	1.42"
29060-6	CAT 50 x 1/2" I.D. - 6"	1/2"	1.10"	1.34"	6"	1.85"
29064-6	CAT 50 x 3/4" I.D. - 6"	3/4"	1.42"	1.65"	6"	2.04"
29070	CAT 50 x 1.0" I.D. - 6"	1"	1.81"	2.09"	6"	2.28"
29076	CAT 50 x 1-1/4" I.D. - 6"	1-1/4"	1.81"	2.09"	6"	2.28"

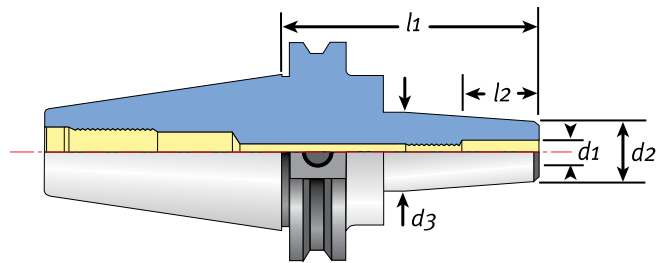
CAT 50 Precision Shrink-Fit Tool Holders Metric Size



Techniks Certified for accuracy and balance

Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



CAT 50 Standard Length Metric Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29252	CAT 50 x 6mm - 100mm	6 mm	21 mm	27 mm	100 mm	36 mm
29256	CAT 50 x 8mm - 100mm	8 mm	21 mm	27 mm	100 mm	36 mm
29260	CAT 50 x 10mm - 100mm	10 mm	24 mm	32 mm	100 mm	42 mm
29264	CAT 50 x 12mm - 100mm	12 mm	24 mm	32 mm	100 mm	47 mm
29268	CAT 50 x 14mm - 100mm	14 mm	27 mm	34 mm	100 mm	47 mm
29272	CAT 50 x 16mm - 100mm	16 mm	27 mm	34 mm	100 mm	50 mm
29276	CAT 50 x 18mm - 100mm	18 mm	33 mm	42 mm	100 mm	50 mm
29278-100	CAT 50 x 20mm - 100mm	20 mm	33 mm	42 mm	100 mm	52 mm
29280	CAT 50 x 25mm - 100mm	25 mm	44 mm	53 mm	100 mm	58 mm
29282	CAT 50 x 32mm - 100mm	32 mm	44 mm	53 mm	100 mm	58 mm

CAT 50 Extended Length Metric Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29254	CAT 50 x 6mm - 150mm	6 mm	21 mm	27 mm	150mm	36 mm
29258	CAT 50 x 8mm - 150mm	8 mm	21 mm	27 mm	150mm	36 mm
29262	CAT 50 x 10mm - 150mm	10 mm	24 mm	32 mm	150mm	42 mm
29266	CAT 50 x 12mm - 150mm	12 mm	24 mm	32 mm	150mm	47 mm
29270	CAT 50 x 14mm - 150mm	14 mm	27 mm	34 mm	150mm	47 mm
29274	CAT 50 x 16mm - 160mm	16 mm	27 mm	34 mm	150mm	50 mm



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CAT 50 CoolBLAST Shrink-Fit Tool Holders



Techniks Certified for accuracy and balance

CoolBLAST Features

- Maximum chip removal for maximum feed rates
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



Shrink Machines
pg. 94



Shrink Extensions
pg. 93

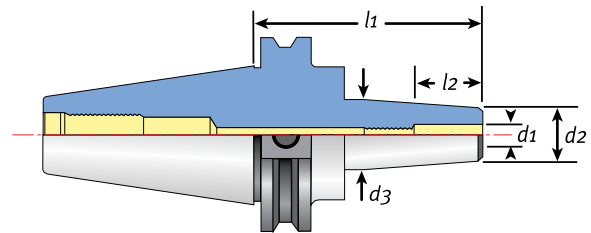


Retention Knobs
pg. 161



Wrenches
pg. 166

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



CAT 50 Standard Length CoolBLAST Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29054B	CAT 50 x SF 1/4" - 3.54" with CoolBLAST	1/4"	.71"	1.06"	3.54"	1.42"
29058B	CAT 50 x SF 3/8" - 3.94" with CoolBLAST	3/8"	.78"	1.06"	3.94"	1.42"
29060B	CAT 50 x SF 1/2" - 3.94" with CoolBLAST	1/2"	1.10"	1.34"	3.94"	1.85"
29062B	CAT 50 x SF 5/8" - 3.94" with CoolBLAST	5/8"	1.26"	1.34"	3.94"	1.97"
29064B	CAT 50 x SF 3/4" - 4.13" with CoolBLAST	3/4"	1.42"	1.65"	4.13"	2.04"
29068B	CAT 50 x SF 1" - 4.13" with CoolBLAST	1"	1.81"	2.09"	4.13"	2.28"
29072B	CAT 50 x SF 1-1/4" - 4.13" w/ CoolBLAST	1-1/4"	1.81"	2.09"	4.13"	2.28"

CAT 50 Extended Length CoolBLAST Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
29054-6B	CAT 50 x SF 1/4" - 6" with CoolBLAST	1/4"	.71"	1.06"	6"	1.42"
29058-6B	CAT 50 x SF 3/8" - 6" with CoolBLAST	3/8"	.78"	1.06"	6"	1.42"
29060-6B	CAT 50 x SF 1/2" - 6" with CoolBLAST	1/2"	1.10"	1.34"	6"	1.85"
29062-6B	CAT 50 x SF 5/8" - 6" with CoolBLAST	5/8"	1.26"	1.34"	6"	1.97"
29066B	CAT 50 x SF 3/4" - 6" with CoolBLAST	3/4"	1.42"	1.65"	6"	2.04"
29070B	CAT 50 x SF 1" - 6" with CoolBLAST	1"	1.81"	2.09"	6"	2.28"

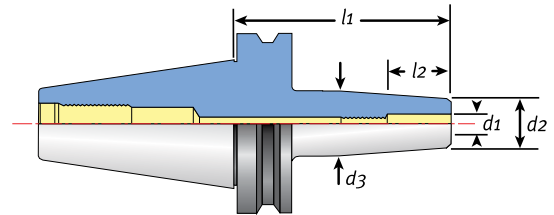
BT 30, BT 40, ISO 30 Precision Shrink-Fit Tool Holders



Techniks Certified for accuracy and balance

Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power

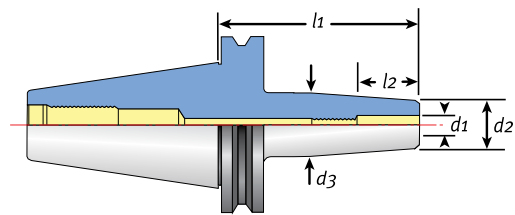


BT 30 Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
67250	BT 30 x 1/4" I.D. - 3"	1/4"	.71"	1.06"	3"	1.42"
67375	BT 30 x 3/8" I.D. - 3"	3/8"	.78"	1.06"	3"	1.42"
67500	BT 30 x 1/2" I.D. - 3"	1/2"	1.10"	1.34"	3"	1.85"
67625	BT 30 x 5/8" I.D. - 3"	5/8"	1.26"	1.34"	3"	1.97"
67750	BT 30 x 3/4" I.D. - 3"	3/4"	1.42"	1.15"	3"	2.04"

BT 40 Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
39110	BT 40 x 3/16" I.D. - 3.54	3/16"	.63"	.87"	3.54"	.79"
39111	BT 40 x 1/4" I.D. - 3.54	1/4"	.71"	1.06"	3.54"	1.42"
39113	BT 40 x 3/8" I.D. - 3.54	3/8"	.78"	1.06"	3.54"	1.42"
39114	BT 40 x 1/2" I.D. - 3.54	1/2"	1.10"	1.34"	3.54"	1.85"
39115	BT 40 x 3/4" I.D. - 3.54	3/4"	1.42"	1.65"	3.54"	2.04"
39117	BT 40 x 1.0" I.D. - 3.54	1.0"	1.81"	2.09"	3.54"	2.28"



ISO 30 Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
64250	ISO 30 x 1/4" I.D. - 3.15"	1/4"	.71"	1.06"	3.15"	1.42"
64375	ISO 30 x 3/8" I.D. - 3.15"	3/8"	.78"	1.06"	3.15"	1.42"
64500	ISO 30 x 1/2" I.D. - 3.15"	1/2"	1.10"	1.34"	3.15"	1.85"
64625	ISO 30 x 5/8" I.D. - 3.15"	5/8"	1.26"	1.34"	3.15"	1.97"
64750	ISO 30 x 3/4" I.D. - 3.15"	3/4"	1.42"	1.65"	3.15"	2.04"



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

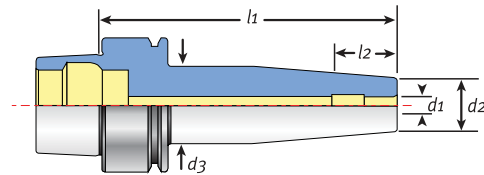
HSK 40E, HSK 50E, Standard and Slim Line Shrink-Fit



Techniks Certified for accuracy and balance

Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



HSK 40E Inch Size Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
39000	HSK 40E x 1/8" I.D. - 3.54"	1/8"	.63"	.87"	3.54"	.79"
39002	HSK 40E x 3/16" I.D. - 3.54"	3/16"	.63"	.87"	3.54"	.79"
39004	HSK 40E x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"
39006	HSK 40E x 5/16" I.D. - 3.54"	5/16"	.79"	1.06"	3.54"	1.42"
39008	HSK 40E x 3/8" I.D. - 3.54"	3/8"	.94"	1.26"	3.54"	1.53"

HSK 40E Metric Size Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
39082	HSK 40E x 3mm I.D. - 80mm	3mm	10mm	18mm	80mm	18mm
39084	HSK 40E x 4mm I.D. - 80mm	4mm	14mm	22mm	80mm	20mm
39088	HSK 40E x 6mm I.D. - 80mm	6mm	21mm	27mm	80mm	36mm
39090	HSK 40E x 8mm I.D. - 80mm	8mm	21mm	27mm	80mm	36mm
39092	HSK 40E x 10mm I.D. - 80mm	10mm	24mm	32mm	85mm	42mm

HSK 50E Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
39016	HSK 50E x 3/16" I.D. - 3.54"	3/16"	.63"	.87"	3.54"	.79"
39018	HSK 50E x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"
39020	HSK 50E x 5/16" I.D. - 3.54"	5/16"	.79"	1.06"	3.54"	1.42"
39022	HSK 50E x 3/8" I.D. - 3.54"	3/8"	.94"	1.26"	3.54"	1.53"
39024	HSK 50E x 1/2" I.D. - 3.54"	1/2"	1.10"	1.34"	3.54"	1.85"



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

Slim Line Features

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

HSK 40E Slim Line Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
99528	HSK 40E x 1/8" I.D. - 80mm Slim Line	1/8"	.44"	.63"	80mm	20mm
99538	HSK 40E x 3/16" I.D. - 80mm Slim Line	3/16"	.5"	.69"	80mm	20mm
99548	HSK 40E x 1/4" I.D. - 80mm Slim Line	1/4"	.56"	.81"	80mm	36mm
99568	HSK 40E x 3/8" I.D. - 80mm Slim Line	3/8"	.69"	.94"	80mm	47mm
99588	HSK 40E x 1/2" I.D. - 80mm Slim Line	1/2"	.81"	1.06"	80mm	47mm

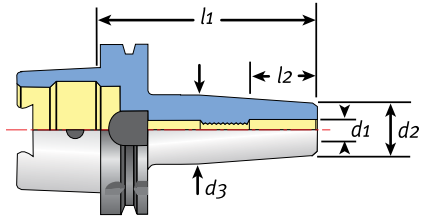
HSK 63A Standard and Slim Line Shrink Fit



Techniks Certified for accuracy and balance

Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



HSK 63A Inch Size Standard Length Shrink-Fit Tool Holders

Part No.	Description	d1	d2	d3	l1	l2
93115	HSK 63A x 1/4" I.D. - 3.15"	1/4"	.71"	1.06"	3.15"	1.42"
93116	HSK 63A x 5/16" I.D. - 3.15"	5/16"	.79"	1.06"	3.15"	1.42"
93117	HSK 63A x 3/8" I.D. - 3.35"	3/8"	.94"	1.26"	3.35"	1.53"
93118	HSK 63A x 7/16" I.D. - 3.54"	7/16"	1.10"	1.34"	3.54"	1.85"
93119	HSK 63A x 1/2" I.D. - 3.54"	1/2"	1.10"	1.34"	3.54"	1.85"
93120	HSK 63A x 9/16" I.D. - 3.54"	9/16"	1.10"	1.34"	3.54"	1.85"
93121	HSK 63A x 5/8" I.D. - 3.74"	5/8"	1.26"	1.34"	3.74"	1.97"
93124	HSK 63A x 3/4" I.D. - 3.94"	3/4"	1.26"	1.65"	3.94"	1.97"
93126	HSK 63A x 1.0" I.D. - 4.53"	1.0"	1.42"	1.65"	4.53"	2.04"
93128	HSK 63A x 1-1/4" I.D. - 4.72"	1-1/4"	1.81"	2.09"	4.72"	2.28"

HSK 63A Inch Size Extended Length Shrink-Fit Tool Holders

Part No.	Description	d1	d2	d3	l1	l2
93130	HSK 63A x 3/8" I.D. - 6.3"	3/8"	.71"	1.02"	6.3"	1.53"
93135	HSK 63A x 1/2" I.D. - 6.3"	1/2"	.79"	1.10"	6.3"	1.85"
93140	HSK 63A x 3/4" I.D. - 6.3"	3/4"	1.02"	1.42"	6.3"	1.97"
93145	HSK 63A x 1.0" I.D. - 6.3"	1.0"	1.26"	1.65"	6.3"	2.04"



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

Slim Line Features

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

HSK 63A Slim Line Shrink-Fit Holders

Part No.	Description	d1	d2	d3	l1	l2
73528	HSK 63A x 1/8" I.D. - 80mm Slim Line	1/8"	.44"	.63"	80mm	20mm
73538	HSK 63A x 3/16" I.D. - 80mm Slim Line	3/16"	.5"	.69"	80mm	20mm
73548	HSK 63A x 1/4" I.D. - 80mm Slim Line	1/4"	.56"	.81"	80mm	36mm
73568	HSK 63A x 3/8" I.D. - 80mm Slim Line	3/8"	.69"	.94"	80mm	47mm
73588	HSK 63A x 1/2" I.D. - 80mm Slim Line	1/2"	.81"	1.06"	80mm	47mm

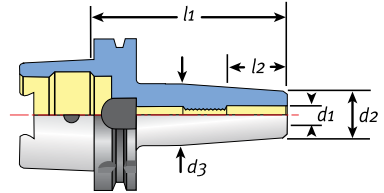
HSK 63A Metric Size and CoolBLAST Shrink-Fit



Techniks Certified for accuracy and balance

Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



HSK 63A Metric Size Shrink-Fit Tool Holders

Part No.	Description	d1	d2	d3	l1	l2
39132	HSK 63A x 4mm I.D. - 80mm"	4mm	14mm	22mm	80mm	20mm
39134	HSK 63A x 5mm I.D. - 80mm"	5mm	16mm	22mm	80mm	20mm
39136	HSK 63A x 6mm I.D. - 80mm"	6mm	21mm	27mm	80mm	36mm
39138	HSK 63A x 8mm I.D. - 80mm"	8mm	21mm	27mm	80mm	36mm
39140	HSK 63A x 10mm I.D. - 85mm"	10mm	24mm	32mm	85mm	42mm
39142	HSK 63A x 12mm I.D. - 90mm"	12mm	24mm	32mm	90mm	47mm
39144	HSK 63A x 14mm I.D. - 90mm"	14mm	24mm	32mm	90mm	47mm
39146	HSK 63A x 16mm I.D. - 95mm"	16mm	27mm	34mm	95mm	50mm
39148	HSK 63A x 18mm I.D. - 95mm"	18mm	33mm	42mm	95mm	50mm
39150	HSK 63A x 20mm I.D. - 100mm"	20mm	33mm	42mm	100mm	52mm
39152	HSK 63A x 25mm I.D. - 115mm"	25mm	44mm	53mm	115mm	58mm
39154	HSK 63A x 32mm I.D. - 120mm"	32mm	44mm	53mm	120mm	58mm



CoolBLAST Features

- Maximum chip removal for maximum feed rates
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power

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



HSK 63A Inch Size CoolBLAST Shrink-Fit Tool Holders

Part No.	Description	d1	d2	d3	l1	l2
93113B	HSK 63A x 1/8" I.D. - 3.15" with CoolBLAST	1/8"	.63"	.87"	3.15"	.79"
93114B	HSK 63A x 3/16" I.D. - 3.15" with CoolBLAST	3/16"	.63"	.87"	3.15"	.79"
93115B	HSK 63A x 1/4" I.D. - 3.15" with CoolBLAST	1/4"	.71"	1.06"	3.15"	1.42"
93117B	HSK 63A x 3/8" I.D. - 3.35" with CoolBLAST	3/8"	.94"	1.26"	3.35"	1.53"
93119B	HSK 63A x 1/2" I.D. - 3.54" with CoolBLAST	1/2"	1.10"	1.34"	3.54"	1.85"
93121B	HSK 63A x 5/8" I.D. - 3.74" with CoolBLAST	5/8"	1.26"	1.34"	3.74"	1.97"
93124B	HSK 63A x 3/4" I.D. - 3.94" with CoolBLAST	3/4"	1.26"	1.65"	3.94"	1.97"

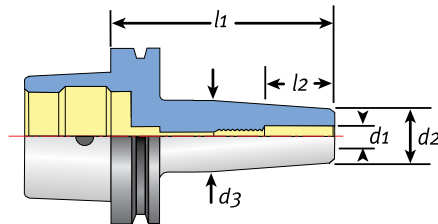
HSK 63F Precision Shrink-Fit Tool Holders



Techniks Certified for accuracy and balance

Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



Shrink
Machines
pg. 94



Shrink
Extensions
pg. 93



Retention
Knobs
pg. 161



Wrenches
pg. 166

HSK 63F Inch Shrink-Fit Tool Holders

Part No.	Description	d1	d2	d3	l1	l2
71250	HSK 63F x 1/4" I.D. - 3.15"	1/4"	.71"	1.06"	3.15"	1.42"
71375	HSK 63F x 3/8" I.D. - 3.74"	3/8"	.94"	1.26"	3.74"	1.53"
71500	HSK 63F x 1/2" I.D. - 3.74"	1/2"	1.10"	1.34"	3.74"	1.85"
71750	HSK 63F x 3/4" I.D. - 3.94"	3/4"	1.26"	1.34"	3.94"	1.97"
71100	HSK 63F x 1.0" I.D. - 4.53"	1"	1.42"	1.65"	4.53"	2.04"

HSK 63F Metric Shrink-Fit Tool Holders

Part No.	Description	d1	d2	d3	l1	l2
71010	HSK 63F x 20mm I.D. - 100mm	20mm	33mm	42mm	100mm	47mm
71011	HSK 63F x 25mm I.D. - 115mm	25mm	44mm	53mm	115mm	58mm

HSK 100A Precision Shrink-Fit Tool Holders



Features

- Maximum T.I.R. only 0.0001"
- Balanced 25,000 RPM at G2.5
- Superior rigidity and holding power



Shrink Machines
pg. 94



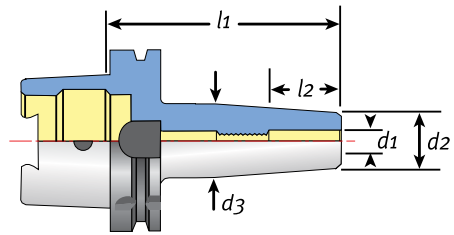
Shrink Extensions
pg. 93



Retention Knobs
pg. 161



Wrenches
pg. 166



HSK 100A Shrink-Fit Tool Holders

Part No.	Description	d1	d2	d3	l1	l2
39304	HSK 100A x 1/8" I.D. - 3.54"	1/8"	.63"	.87"	3.54"	.79"
39306	HSK 100A x 1/4" I.D. - 3.54"	1/4"	.71"	1.06"	3.54"	1.42"
39308	HSK 100A x 5/16" I.D. - 3.35"	5/16"	.79"	1.06"	3.35"	1.42"
39310	HSK 100A x 3/8" I.D. - 3.54"	3/8"	.94"	1.26"	3.54"	1.53"
39311	HSK 100A x 3/8" I.D. - 6"	3/8"	.94"	1.26"	6"	1.53"
39312	HSK 100A x 7/16" I.D. - 3.74"	7/16"	.94"	1.26"	3.74"	1.85"
39314	HSK 100A x 1/2" I.D. - 3.74"	1/2"	1.10"	1.34"	3.74"	1.85"
39315	HSK 100A x 1/2" I.D. - 6"	1/2"	1.10"	1.34"	6"	1.85"
39318	HSK 100A x 5/8" I.D. - 3.94"	5/8"	1.26"	1.34"	3.94"	1.97"
39319	HSK 100A x 5/8" I.D. - 6"	5/8"	1.26"	1.34"	6"	1.97"
39320	HSK 100A x 3/4" I.D. - 4.13"	3/4"	1.42"	1.65"	4.13"	2.04"
39321	HSK 100A x 3/4" I.D. - 6"	3/4"	1.42"	1.65"	6"	2.04"
39324	HSK 100A x 1.0" I.D. - 4.53"	1.0"	1.81"	2.09"	4.53"	2.28"
39325	HSK 100A x 1.0" I.D. - 6.3"	1.0"	1.81"	2.09"	6.3"	2.28"
39326	HSK 100A x 1-1/4" I.D. - 4.72"	1-1/4"	1.81"	2.09"	4.72"	2.28"
39327	HSK 100A x 1-1/4" I.D. - 6.3"	1-1/4"	1.81"	2.09"	6.3"	2.28"

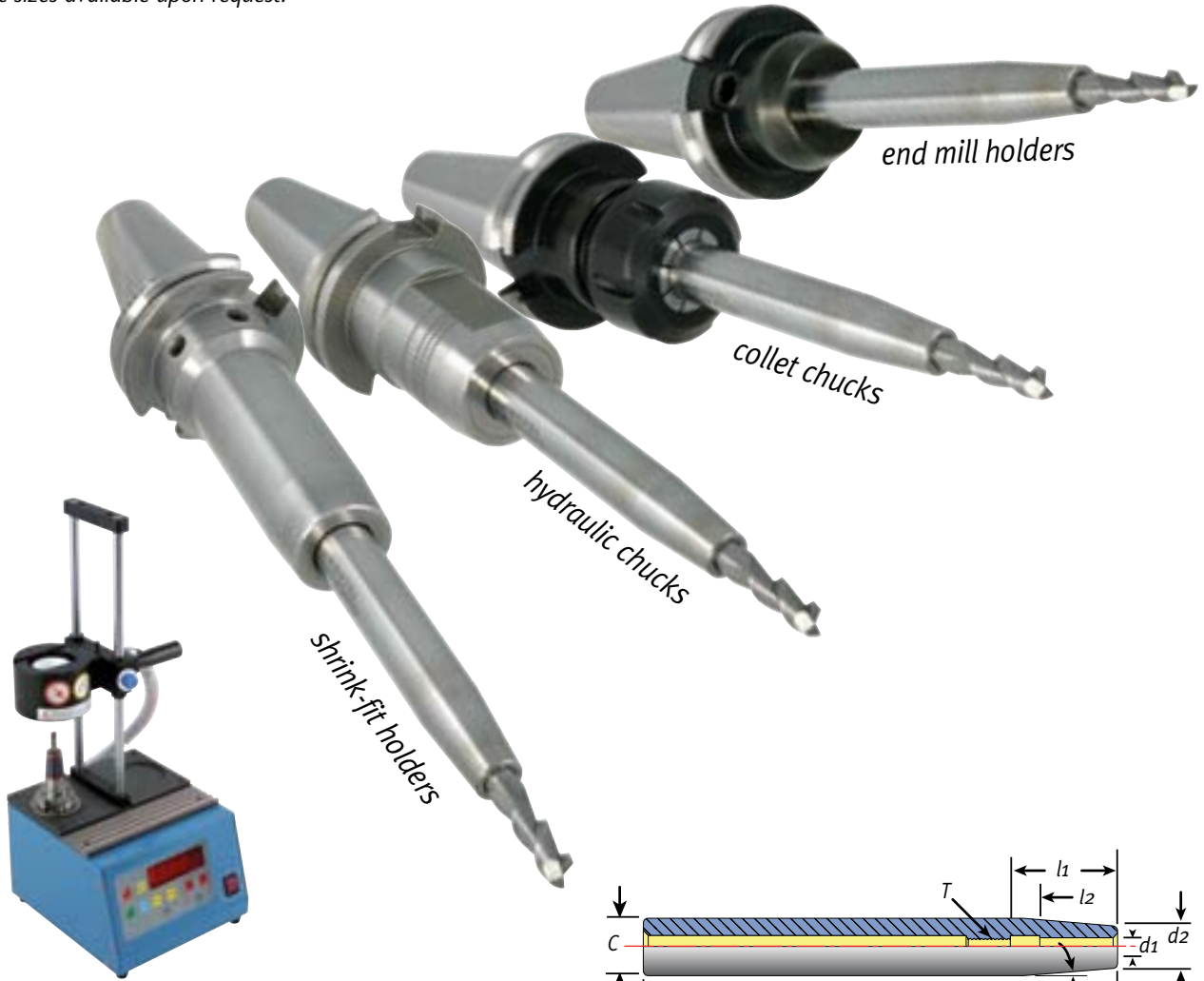
Universal Shrink-Fit Tool Holder Extensions



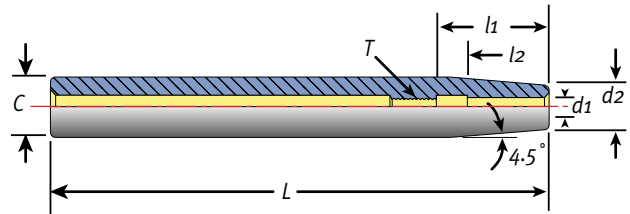
Metric sizes available upon request.

Features

- Better rigidity and T.I.R. extends tool life
- Works with a variety of toolholders
- Slim nose diameter

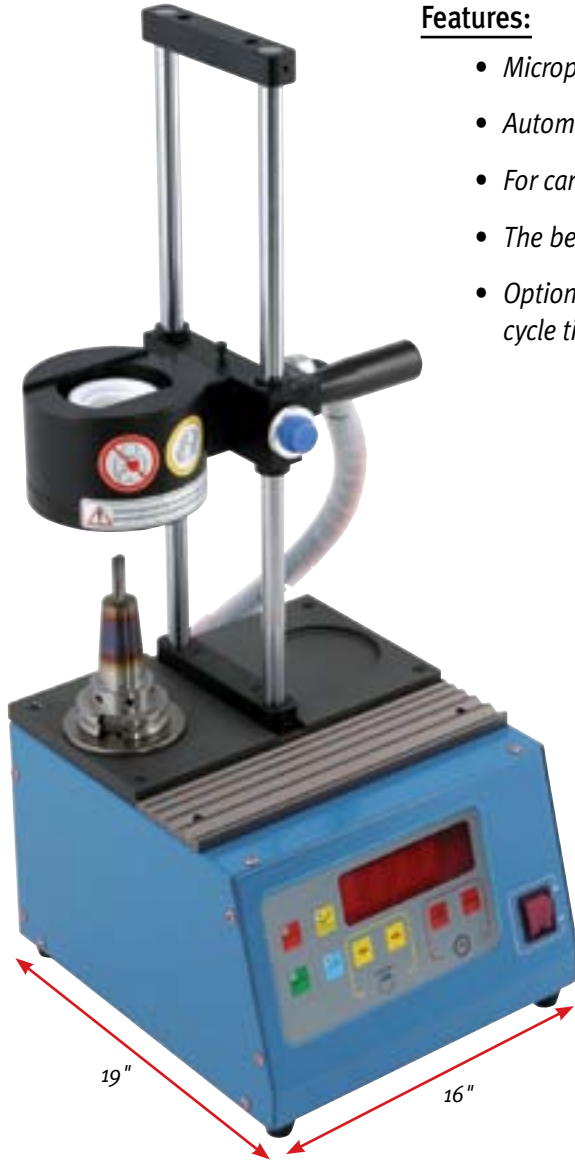


Shrink fit extensions and our TechnoSHRINK II machine are a great way to try out shrink fit.



Part No.	Description	C	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"	.61"	6.3"	1.97	1.57"	M12x1.75

TechnoSHRINK II – Shrink-Fit Machine



Features:

- Microprocessor controlled induction heat changes tools in 30 seconds
- Automatic cooling using shop air eliminates handling hot tools
- For carbide shank sizes 1/8" to 1-1/4" (works best with h6 shanks)
- The benefits of shrink-fit without the high cost!
- Optional heat sinks reduce cooling cycle time by 50% to only 90 seconds!

Easy to use – simply align the induction head with your toolholder, enter your shank size, and press START.



Included With TechnoSHRINK II Machine

Part No.	Description	QTY.	Part No.	Description	QTY.
00300-02-1	small induction head (3-16mm)	1	00152	toolholder adapter - 40 taper	1
00300-02-2	large induction head (20-32mm)	1	00153	toolholder adapter - 50 taper	1
00165	induction stop ring (3-5mm)	1	00157	toolholder adapter - HSK 40	1
00166	induction stop ring (6-12mm)	1	00158	toolholder adapter - HSK 50	1
00167	induction stop ring (14-20mm)	1	00159	toolholder adapter - HSK 63	1
00168	induction stop ring (25-32mm)	1	00170	toolholder sleeve	1
00151	toolholder adapter - 30 taper	1	200.001.018	thermal insulated glove	1

Part No.	Description	Tool Change	Rating	L x D x H	Ship Wt.
00300	TechnoSHRINK II	30 seconds	1 phase, 220V, 20A	16" x 19" x 28"	42 lbs

TechnoSHRINK Ultra – High Output Shrink-Fit Machine

Features:

- Microprocessor controlled induction heat changes tools in only 6 seconds
- For carbide or HSS shank sizes 1/8" to 1-1/4" (works best with h6 shanks)
- Rotary cooling rack (Ultra Pro only) for continuous tool changes
- Optional heat sinks (shown) reduce cooling cycle time by 50% to only 90 seconds!

TechnoSHRINK Ultra machines are designed for high-output tool changing in medium to large machine shops and production facilities.

All Techniks shrink-fit machines use shop air for cooling to eliminate the safety, maintenance, and reliability issues associated with water-cooled shrink fit machines.

Place heat sink over hot toolholder to reduce cooling time by 50%.

Can be used with any shrink fit machine to speed cooling process.



Ultra Pro shown

Heat Sinks

Part No.	Shank Range
00100-HS1	1/8" thru 1/4"
00100-HS2	1/4" thru 5/16"
00100-HS3	3/8" thru 5/8"
00100-HS4	5/8" thru 3/4"
00100-HS5	3/4" thru 1"
00100-HS6	1" thru 1 1/4"

Included With TechnoSHRINK Ultra Machines

Part No.	Description	QTY.	Part No.	Description	QTY.
00165	induction stop ring (3-5mm)	1	00153	toolholder adapter - 50 taper	1
00166	induction stop ring (6-12mm)	1	00157	toolholder adapter - HSK 40	1
00167	induction stop ring (14-20mm)	1	00158	toolholder adapter - HSK 50	1
00168	induction stop ring (25-32mm)	1	00159	toolholder adapter - HSK 63	1
00151	toolholder adapter - 30 taper	1	00170	toolholder sleeve	1
00152	toolholder adapter - 40 taper	1	200.001.018	thermal insulated glove	1

Part No.	Description	Tool Change	Rating	L x D x H	Ship Wt.
00100	TechnoSHRINK Ultra	6-9 seconds	3 phase, 480V, 30A	16" x 16" x 32"	147 lbs
00200	TechnoSHRINK Ultra Pro w/rotary rack	6-9 seconds	3 phase, 480V, 30A	16" x 16" x 32"	182 lbs



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

Measurement Guide For Special Order Toolholders

**V-flange CNC machine
make, model and spindle**

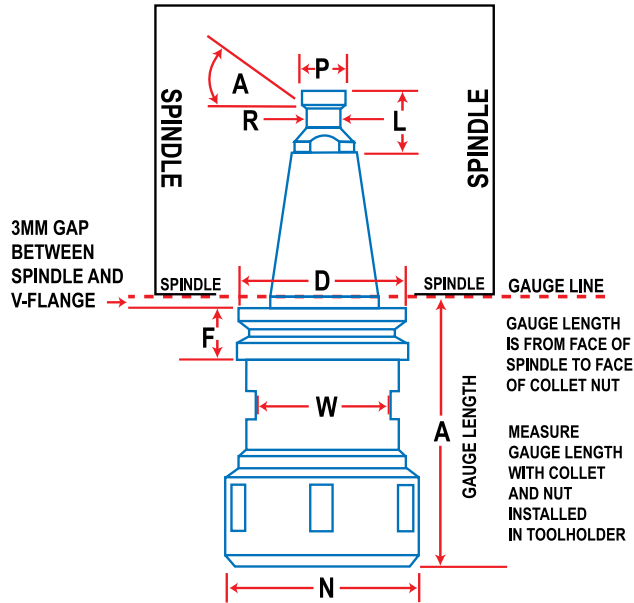
**Fill in all the required dimensions (left).
Then, fax or phone in your order for a fast quote.**

V-Flange tool #1 dimensions

D = _____
F = _____
W = _____
A = _____
N = _____

V-Flange tool #2 dimensions

D = _____
F = _____
W = _____
A = _____
N = _____



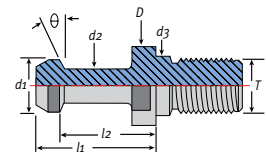
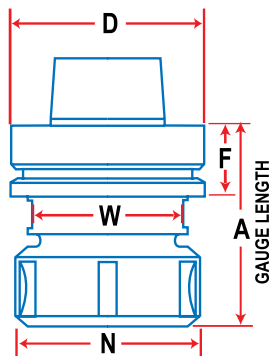
**HSK CNC machine
make, model and spindle**

HSK tool #1 dimensions

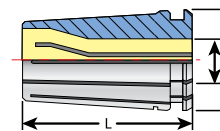
D = _____
F = _____
W = _____
A = _____
N = _____

HSK tool #2 dimensions

D = _____
F = _____
W = _____
A = _____
N = _____



*Call for special order
retention knobs.*



*For special order collets
see page 60.*