

# Hydros – Milling Chucks – Morse Taper – Drill Chucks

## Hydraulic Toolholders

For high-performance PLUS fast tool changes hydro's are a great choice. T.I.R. only 0.0001" at 3XD. Use reduction sleeves to run tool shanks from 1/8" up to 1" (pg. 130)



## Milling Chucks

New coolant option available for coolant-thru tools. Outstanding rigidity and performance (pg. 137)



<http://ow.ly/rKwCZ>  
View the video.

## Morse Taper Holders

Techniks Certified for accuracy (pg. 148)



## High-Precision Drill Chucks

Better accuracy and holding power than Jacobs Chucks (pg. 146)



Built for Speed.

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

**NEW**

# High Precision Hydraulic Toolholders

CAT40, CAT50, BT30, BT40,  
HSK63A, HSK100A, HSK63F

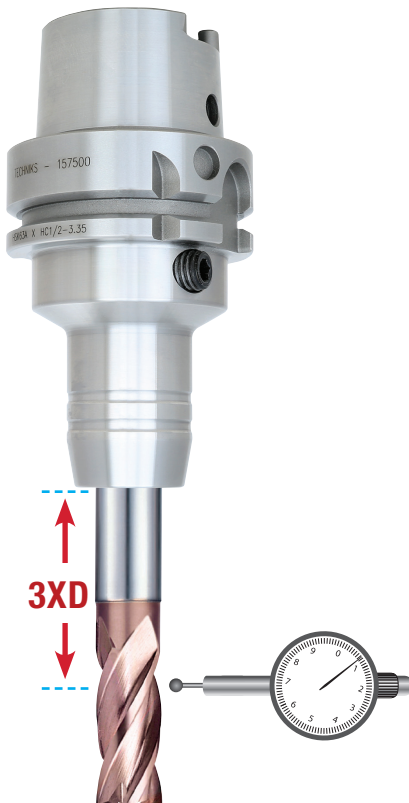


**Our hydraulic holders** extend tool life and improve surface finish because T.I.R. is only 0.0001". Each holder is factory balanced to 25,000 RPM at G2.5.

**Extended length** hydraulic holders are a great choice for mold work, or any time you need smooth, accurate cutting at extended lengths.

**Fast tool changes** are performed with just a twist of a wrench (included). You can change tools in-spindle without the need for setup equipment.

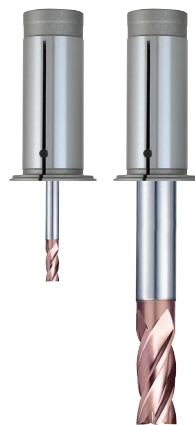
Runout Accuracy 0.0001"  
T.I.R. measured at 3xD



**Precision Reduction Sleeves**  
Use sleeves for fast tool changes

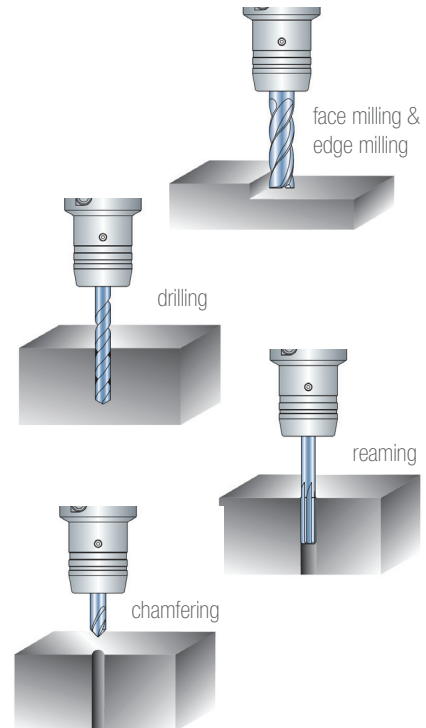


reduction sleeves fit shank sizes 1/8" up to 5/8" (3 - 16mm) see pg. 6



**Use Hydraulic Chucks for:**

- face milling and edge milling
- drilling
- reaming
- chamfering



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



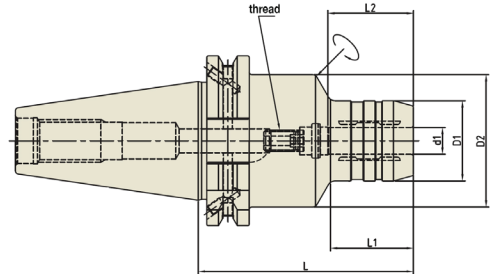
# CAT40 High Precision Hydraulic Toolholders



## Features

- Balanced to 25,000 RPM at G2.5
- T.I.R. 0.0001" measured at 3X shank diameter
- Taper precision ground to AT3 standard
- AD/B CoolFLEX coolant standard

Hydraulic Chucks provide powerful, vibration-free cutting. Hydros are a good choice when you need T.I.R. of 0.0001" and high holding power.



## CAT40 Hydraulic Toolholders – Inch and Metric

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
154500	CAT40AD/B-HC 1/2S-2.52 Hydro	1/2"	1.654"	-	2.520"	-	1.457"	M10x1.0
154625	CAT40AD/B-HC 5/8S-2.52 Hydro	5/8"	1.339"	1.772"	2.520"	-	1.654"	M12x1.0
154750	CAT40AD/B-HC 3/4S-2.52 Hydro	3/4"	1.496"	1.969"	2.520"	-	1.654"	M16x1.0
154100	CAT40AD/B- HC 1S-3.50 Hydro	1.0"	2.244"	2.598"	3.504"	-	1.890"	M16x1.0
154060	CAT40AD/B-HC 6-80.5 Hydro	6mm	26mm	50mm	80.5mm	20mm	27mm	M5x0.8
154080	CAT40AD/B-HC 8-80.5 Hydro	8mm	28mm	50mm	80.5mm	30mm	37mm	M12x1.0
154010	CAT40AD/B-HC 10-80.5 Hydro	10mm	30mm	50mm	80.5mm	32mm	32mm	M8x1.0
154012	CAT40AD/B-HC 12-80.5 Hydro	12mm	32mm	50mm	80.5mm	32mm	37mm	M10x1.0
154016	CAT40AD/B-HC 16-80.5 Hydro	16mm	38mm	50mm	80.5mm	33mm	42mm	M12x1.0
154020	CAT40AD/B-HC 20-64.5 Hydro	20mm	37mm	50mm	64.5mm	34mm	42mm	M16x1.0
154200	CAT40AD/B-HC 20-80.5 Hydro	20mm	42mm	50mm	80.5mm	34mm	42mm	M16x1.0



Extended length hydros are a great choice for mould work or wherever high accuracy and smooth cutting is required.

## CAT40 Extended Length Hydraulic Toolholders – Inch Size

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
854022	CAT40AD/B-EXT 1/4-4.72 Hydro	1/4"	0.787"	1.969"	4.724"	2.756"	1.063"	M5x0.8
854024	CAT40AD/B-EXT 1/4-5.91 Hydro	1/4"	0.787"	1.969"	5.906"	3.937"	1.063"	M5x0.8
854028	CAT40AD/B-EXT 3/8-4.72 Hydro	3/8"	0.945"	1.969"	4.724"	2.756"	1.260"	M8x1.0
854030	CAT40AD/B-EXT 3/8-5.91 Hydro	3/8"	0.945"	1.969"	5.906"	3.937"	1.260"	M8x1.0
854032	CAT40AD/B-EXT 1/2-4.72 Hydro	1/2"	1.024"	1.969"	4.724"	2.756"	1.457"	M10x1.0
854034	CAT40AD/B-EXT 1/2-5.91 Hydro	1/2"	1.024"	1.969"	5.906"	3.937"	1.457"	M10x1.0
854036	CAT40AD/B-EXT 5/8-4.72 Hydro	5/8"	1.260"	1.969"	4.724"	2.756"	1.654"	M12x1.0
854038	CAT40AD/B-EXT 5/8-5.90 Hydro	5/8"	1.260"	1.969"	5.906"	3.937"	1.654"	M12x1.0
854040	CAT40AD/B-EXT 3/4-4.72 Hydro	3/4"	1.339"	1.969"	4.724"	2.756"	1.654"	M16x1.0
854042	CAT40AD/B-EXT 3/4-5.90 Hydro	3/4"	1.339"	1.969"	5.906"	3.937"	1.654"	M16x1.0

\* Note: Wrench included with all toolholders



# CAT50 High Precision Hydraulic Toolholders



## Features

- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured at 3X shank diameter*
- *Taper precision ground to AT3 standard*
- *AD/B CoolFLEX coolant standard*



Retention  
Knobs  
pg. 228



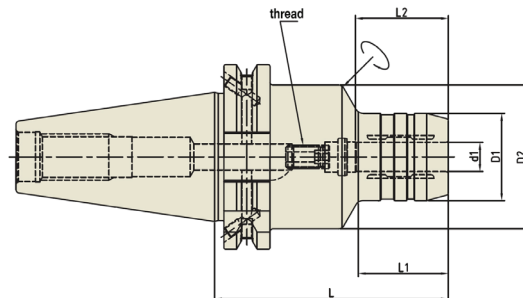
Wrenches  
pg. 232



Tightening  
Stands  
pg. 234

Hydraulic Chucks provide powerful, vibration-free cutting in all materials. Hydros are a good choice when you need T.I.R. of 0.0001" and high holding power.

Tool changes are fast and easy and can be performed in-spindle. Simply turn the adjusting screw to apply hydraulic clamping on tool shank. Use reduction sleeves to run a variety of shank sizes all from 1/8" up to 5/8".



## CAT50 Hydraulic Toolholders – Inch and Metric

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
155750	CAT50AD/B-HC 3/4S-3.19 Hydro	3/4"	2.205"	2.756"	3.189"	-	1.654"	M16x1.0
155100	CAT50AD/B-HC 1S-3.19 Hydro	1.0"	2.165"	2.756"	3.189"	-	1.890"	M16x1.0
155125	CAT50AD/B-HC 1.25S-3.19 Hydro	1 1/4"	2.165"	2.756"	3.189"	-	2.165"	M16x1.0
155060	CAT50AD/B-HC 6-80.5 Hydro	6mm	26mm	50mm	80.5mm	30mm	27mm	M5x0.8
155080	CAT50AD/B-HC 8-80.5 Hydro	8mm	28mm	50mm	80.5mm	30mm	27mm	M12x1.0
155010	CAT50AD/B-HC 10-80.5 Hydro	10mm	30mm	50mm	80.5mm	32mm	32mm	M8x1.0
155012	CAT50AD/B-HC 12-80.5 Hydro	12mm	32mm	50mm	80.5mm	35mm	37mm	M10x1.0
155016	CAT50AD/B-HC 16-80.5 Hydro	16mm	38mm	50mm	80.5mm	40mm	42mm	M12x1.0
155200	CAT50AD/B-HC 20-80.5 Hydro	20mm	42mm	50mm	80.5mm	40mm	42mm	M16x1.0

\* Note: Wrench included with all toolholders

# BT30, BT40 High Precision Hydraulic Holders



Use cutting tools with an H6 shank tolerance.

Hydraulic Chucks provide powerful, vibration-free cutting in all materials. Hydros are a good choice when you need T.I.R. of 0.0001" and high holding power.

Tool changes are fast and easy and can be performed in-spindle. Simply turn the adjusting screw to apply hydraulic clamping on tool shank. Use reduction sleeves to run a variety of shank sizes all from 1/8" up to 5/8".

## Features

- Balanced to 25,000 RPM at G2.5
- T.I.R. 0.0001" measured at 3X shank diameter
- Taper precision ground to AT3 standard
- AD/B CoolFLEX coolant standard



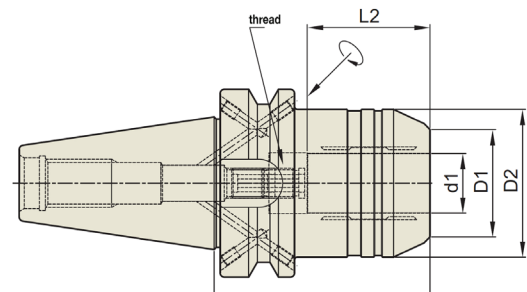
Retention  
Knobs  
pg. 228



Wrenches  
pg. 232



Tightening  
Stands  
pg. 234



## BT30 Hydraulic Toolholders – Inch Size

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
153250	BT30AD/B-HC 1/4-2.75 Hydro	1/4"	1.024"	1.772"	2.756"	1.142"	1.063"	M5x0.8
153312	BT30AD/B-HC 5/16-2.75 Hydro	5/16"	1.102"	1.772"	2.756"	1.181"	1.063"	M6x1.0
153375	BT30AD/B-HC 3/8-2.95 Hydro	3/8"	1.181"	1.772"	2.953"	1.220"	1.260"	M8x1.0
153500	BT30AD/B-HC 1/2-3.35 Hydro	1/2"	1.260"	1.772"	3.346"	1.575"	1.457"	M10x1.0
153675	BT30AD/B-HC 5/8-3.54 Hydro	5/8"	1.496"	1.772"	3.543"	1.811"	1.654"	M6x1.0
153750	BT30AD/B-HC 3/4-3.54 Hydro	3/4"	1.654"	1.772"	3.543"	1.890"	1.654"	M6x1.0

## BT40 Hydraulic Toolholders – Inch Size

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
156250	BT40AD/B-HC 1/4-3.54 Hydro	1/4"	1.024"	1.772"	3.543"	1.181"	1.063"	M5x0.8
156312	BT40AD/B-HC 5/16-3.54 Hydro	5/16"	1.102"	1.772"	3.543"	1.299"	1.063"	M6x1.0
156375	BT40AD/B-HC 3/8-3.54 Hydro	3/8"	1.181"	1.772"	3.543"	1.260"	1.260"	M8x1.0
156500	BT40AD/B-HC 1/2-3.54 Hydro	1/2"	1.260"	1.772"	3.543"	1.378"	1.457"	M10x1.0
156625	BT40AD/B-HC 5/8-3.54 Hydro	5/8"	1.496"	1.890"	3.543"	1.575"	1.654"	M12x1.0
156750	BT40AD/B-HC 3/4-3.54 Hydro	3/4"	1.654"	1.890"	3.543"	1.575"	1.654"	M16x1.0
156100	BT40AD/B-HC 1-3.94 Hydro	1.0"	1.969"	2.362"	3.937"	1.772"	1.890"	M16x1.0

\* Note: Wrench included with all toolholders



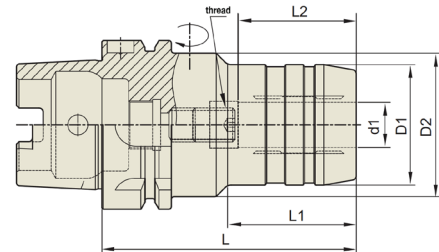
# HSK63A High Precision Hydraulic Holders



## Features

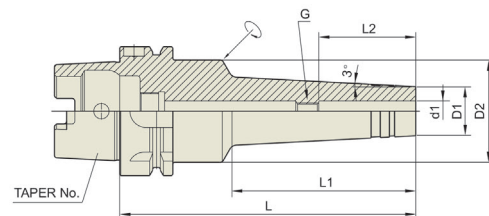
- *Balanced to 25,000 RPM at G2.5*
- *T.I.R. 0.0001" measured at 3X shank diameter*
- *Taper precision ground to AT3 standard*
- *AD coolant-thru is standard*

Hydraulic Chucks provide powerful, vibration-free cutting in all materials. Hydros are a good choice when you need T.I.R. of 0.0001" and high holding power. Use cutting tools with a H6 shank tolerance.



## HSK63A Hydraulic Toolholders – Inch and Metric

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
157250	HSK63A-HC 1/4-70 Hydro	1/4"	1.024"	1.969"	2.756"	0.945"	1.063"	M5x0.8
157500	HSK63A-HC 1/2-85 Hydro	1/2"	1.260"	1.969"	3.346"	1.575"	1.457"	M10x1.0
157750	HSK63A-HC 3/4-90 Hydro	3/4"	1.654"	1.969"	3.543"	1.890"	1.654"	M16x1.0
157100	HSK63A-HC 1-4.72 Hydro	1.0"	2.244"	2.480"	4.724"	2.323"	1.890"	M16x1.0
157125	HSK63A-HC 1.1/4-4.92 Hydro	1 1/4"	2.520"	2.953"	4.921"	2.480"	2.165"	M16x1.0
157060	HSK63A-HC 6-70 Hydro	6mm	26mm	50mm	70mm	24mm	27mm	M5x0.8
157080	HSK63A-HC 8-70 Hydro	8mm	28mm	50mm	70mm	25mm	27mm	M6x1.0
157010	HSK63A-HC 10-80 Hydro	10mm	30mm	50mm	80mm	35mm	32mm	M8x1.0
157012	HSK63A-HC 12-85 Hydro	12mm	32mm	50mm	85mm	-	37mm	M10x1.0
157014	HSK63A-HC 14-85 Hydro	14mm	34mm	50mm	85mm	40mm	37mm	M10x1.0
157016	HSK63A-HC 16-90 Hydro	16mm	38mm	50mm	90mm	46mm	42mm	M12x1.0
157018	HSK63A-HC 18-90 Hydro	18mm	40mm	50mm	90mm	47mm	42mm	M12x1.0
157200	HSK63A-HC 20-80 Hydro	20mm	53mm	53mm	80mm	-	42mm	M16x1.0
157020	HSK63A-HC 20-90 Hydro	20mm	42mm	50mm	90mm	48mm	42mm	M16x1.0
157025	HSK63A-HC 25-120 Hydro	25mm	57mm	63mm	120mm	54.5mm	48mm	M16x1.0
157032	HSK63A-HC 32-125 Hydro	32mm	64mm	75mm	125mm	63mm	55mm	M16x1.0



## HSK63A-HMC Hydraulic Toolholders – Inch

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
158250	HSK63A-HMC 1/4"-5.71 Hydro	1/4"	0.787"	1.969"	5.709"	3.543"	1.063"	M5x0.8
158312	HSK63A-HMC 5/16"-5.71 Hydro	5/16"	0.866"	1.969"	5.709"	3.543"	1.063"	M6x1.0
158375	HSK63A-HMC 3/8"-5.71 Hydro	3/8"	0.945"	1.969"	5.709"	3.543"	1.260"	M8x1.0
158500	HSK63A-HMC 1/2"-5.71 Hydro	1/2"	1.024"	1.969"	5.709"	3.543"	1.457"	M10x1.0
158625	HSK63A-HMC 5/8"-5.7 Hydro	5/8"	1.260"	1.969"	5.709"	3.543"	1.654"	M12x1.0
158750	HSK63A-HMC 3/4"-5.7 Hydro	3/4"	1.339"	1.969"	5.709"	3.543"	1.654"	M16x1.0

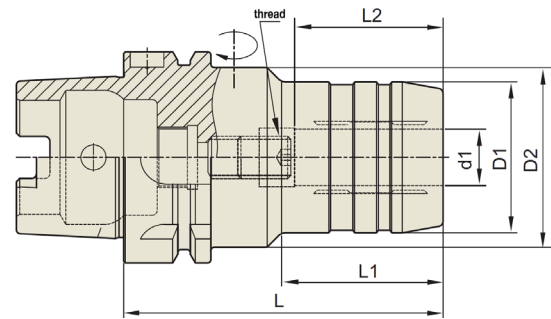
# HSK63F, HSK100A High Precision Hydraulic Holders



## Features

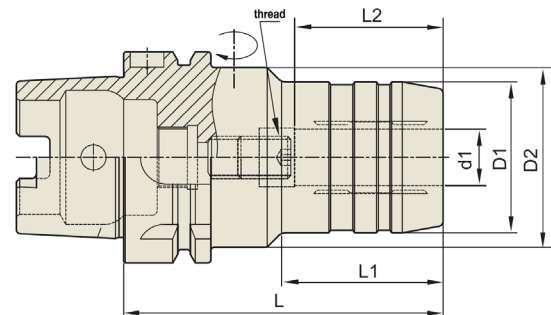
- Balanced to 25,000 RPM at G2.5
- T.I.R. 0.0001" measured at 3X shank diameter
- Taper precision ground to AT3 standard
- AD coolant-thru is standard

Hydraulic Chucks provide powerful, vibration-free cutting in all materials. Hydros are a good choice when you need T.I.R. of 0.0001" and high holding power. Use cutting tools with a H6 shank tolerance.



## HSK63F Hydraulic Toolholders – Inch Size

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
160750	HSK63F-HC 3/4-85 Hydro	3/4"	1.654"	1.969"	3.346"	1.693"	1.654"	M16x1.0
160100	HSK63F-HC 1-120 Hydro	1.0"	2.244"	2.480"	4.724"	2.323"	1.575"	M16x1.0



## HSK100A Hydraulic Toolholders – Inch and Metric

Part No.	Description	d1	D1	D2	L	L1	L2	Thread
159250	HSK100A-HC 1/4-75 Hydro	1/4"	1.024"	1.969"	2.953"	1.024"	1.063"	M5x0.8
159375	HSK100A-HC 3/8-90 Hydro	3/8"	1.181"	1.969"	3.543"	1.654"	1.260"	M8x1.0
159500	HSK100A-HC 1/2-95 Hydro	1/2"	1.260"	1.969"	3.740"	1.850"	1.457"	M10x1.0
159750	HSK100A-HC 3/4-105 Hydro	3/4"	1.654"	4.134"	2.323"	1.654"	1.654"	M16x1.0
159100	HSK100A-HC 1-110 Hydro	1.0"	2.244"	2.480"	4.331"	2.441"	1.890"	M16x1.0
159125	HSK100A-HC 31 1/4-110 Hydro	1 1/4"	2.520"	2.953"	4.331"	2.441"	2.165"	M16x1.0
159200	HSK100A-HC 20S-90 Hydro	20mm	53mm	53mm	90mm	-	42mm	M16x1.0



# High Precision Reduction Sleeves



## Features

- Made from high-grade tool steel
- Precision ground accuracy
- Fits tools 1/8" up to 5/8" (3-20mm)

## 20mm O.D. – Metric or Inch I.D. Sleeves

Part No.	Description, O.D. - I.D.
820030	20-03 reduction sleeve
820040	20-04 reduction sleeve
820050	20-05 reduction sleeve
820060	20-06 reduction sleeve
820080	20-08 reduction sleeve
820100	20-10 reduction sleeve
820120	20-12 reduction sleeve
820140	20-14 reduction sleeve
820160	20-16 reduction sleeve
520108	20-1/8" reduction sleeve
520316	20-3/16" reduction sleeve
520104	20-1/4" reduction sleeve
520516	20-5/16" reduction sleeve
520308	20-3/8" reduction sleeve
520102	20-1/2" reduction sleeve
520508	20-5/8" reduction sleeve

The slots in these high-precision sleeves are cut using ultra-precision sawing technology, ensuring the most accurate I.D. possible, and providing strong clamping force.

Assemble the cutting tool into the sleeve first, then insert the assembly into the hydraulic toolholder. Do not load sleeve and collet separately. Turn the clamping screw clockwise to apply clamping pressure.

NOTE: Do not turn clamping screw unless there is a sleeve or cutting tool in the toolholder, or damage may occur.

## 3/4" O.D. – Inch Size I.D. Sleeves

Part No.	Description, O.D. - I.D.
625108	3/4-1/8" reduction sleeve
625316	3/4-3/16" reduction sleeve
625104	3/4-1/4" reduction sleeve
625516	3/4-5/16" reduction sleeve
625308	3/4-3/8" reduction sleeve
625102	3/4-1/2" reduction sleeve
625508	3/4-5/8" reduction sleeve

## 1-1/4" O.D. – Inch I.D. Sleeves

Part No.	Description, O.D. - I.D.
632108	1-1/4-1/8" reduction sleeve
632316	1-1/4-3/16" reduction sleeve
632104	1-1/4-1/4" reduction Sleeve
632516	1-1/4-5/16" reduction sleeve
632308	1-1/4-3/8" reduction sleeve
632102	1-1/4-1/2" reduction sleeve
632508	1-1/4-5/8" reduction sleeve
632304	1-1/4-3/4" reduction sleeve
632508	1-1/4-1.0" reduction sleeve



# CAT40, CAT50 High-Performance Milling Chucks



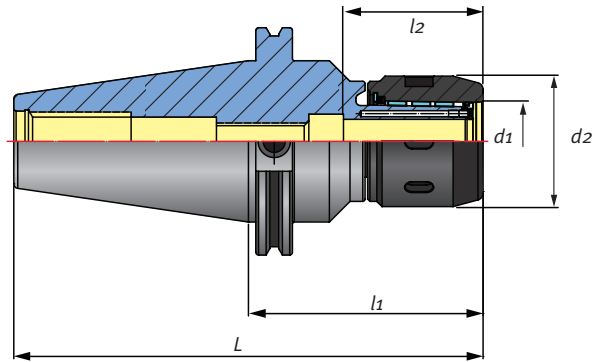
3/4" chuck shown above. Use milling chuck sleeves (page 140) to change tool shank size.



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

## Features

- Grips shank up to 5x tighter than ER 40 holders
- Nut seats against the flange when properly tightened (prevents overtightening)
- CoolBLAST coolant-thru standard on all milling chucks



## CAT40 Milling Chucks

Part No.	Description	L	l1	l2	d1	d2	Holding Power
23202G	CAT40 x MLD 3/4" - 4"	6.69"	4.0"	2.38"	0.75"	2.24"	350 ft/lbs
23204G	CAT40 x MLD 1" - 4"	6.69"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
23210G	CAT40 x MLD 1-1/4" - 4.2"	6.89"	4.2"	2.38"	1.25"	2.80"	500 ft/lbs

## CAT50 Milling Chucks

Part No.	Description	L	l1	l2	d1	d2	Holding Power
23214G	CAT50 x MLD 3/4" - 4"	8.0"	4.0"	2.38"	0.75"	2.24"	350 ft/lbs
23218G	CAT50 x MLD 1" - 4"	8.0"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
23222G	CAT50 x MLD 1-1/4" - 4.13"	8.13"	4.13"	2.38"	1.25"	2.80"	500 ft/lbs

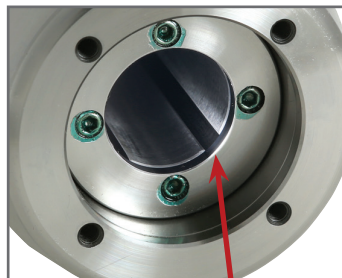
## Standard Features for Techniks Milling Chucks

### CoolBLAST Coolant-Thru



Coolant is channeled directly onto tool path.

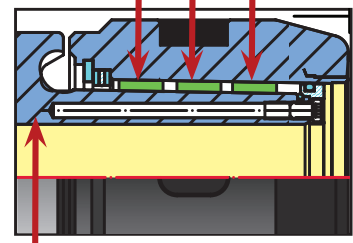
### Special Slotted Design



Special slotted design of bore I.D. increases holding power and reduces vibration.

### Machined Bearing Cage

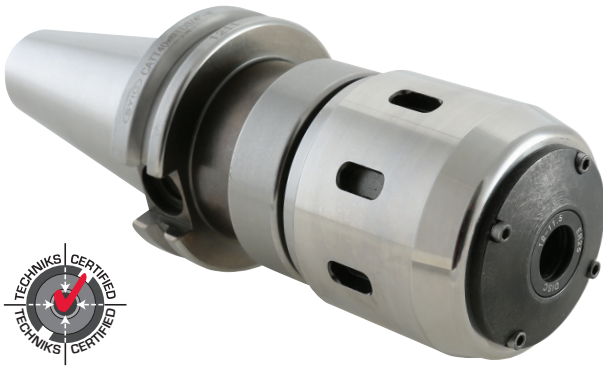
High-precision, individually matched needle bearings symmetrically placed for smooth and reliable operation.



Machined bearing cage ensures accuracy and gripping force.



# CAT40, 50 DualDRIVE for Dual-Contact Spindles



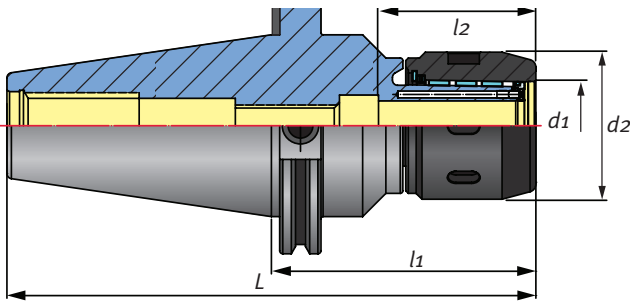
3/4" chuck shown with optional coolant cap and Black Gold coolant ring.

## Features

- Techniks Certified for dual-contact spindles
- Grips shank up to 5x tighter than ER 40 holders
- Nut seats against the flange when properly tightened (prevents overtightening)



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



## Torque Tested to 5x Tighter Grip

Techniks Milling Chucks provide up to 5x tighter grip on the shank than other manufacturer's ER 40 holders with an uncoated nut.

Toolholder Type	Shank Spins At:
Other ER 40 holders	100 ft/lbs
Techniks 3/4" milling chucks	350 ft/lbs
Techniks 1" milling chucks	425 ft/lbs
Techniks 1-1/4" milling chucks	500 ft/lbs

## CAT40, CAT50 Milling Chucks with DualDRIVE

Part No.	Description	L	l1	l2	d1	d2	Holding Power
43.463G.64.400	CAT40 x MLD 3/4" - 4" DualDRIVE	6.69"	4.00"	2.38"	0.75"	2.24"	350 ft/lbs
43.463G.68.400	CAT40 x MLD 1" - 4" DualDRIVE	6.69"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
43.463G.72.420	CAT40 x MLD 1-1/4" - 4.2" DualDRIVE	6.89"	4.20"	2.38"	1.25"	2.80"	500 ft/lbs
44.463G.64.400	CAT50 x MLD 3/4" - 4" DualDRIVE	8.00"	4.00"	2.38"	0.75"	2.24"	350 ft/lbs
44.463G.68.400	CAT50 x MLD 1" - 4" DualDrive	8.0"	4.0"	2.23"	1.0"	2.36"	425 ft/lbs
44.463G.72.413	CAT50 x MLD 1-1/4" - 4.13" DualDRIVE	8.13"	4.13"	2.38"	1.25"	2.80"	500 ft/lbs

## Coolant Cap option for all spindle types

Use coolant cap and Black Gold ring for coolant-thru tools.

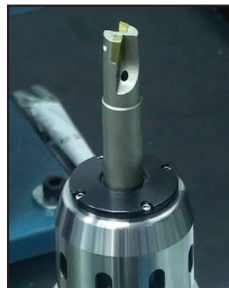
- Maximum chip removal, increase feed rates, extend tool life



Insert Black Gold coolant ring into cap



Cap screws onto end of milling chuck



Coolant-thru tool installed

Use coolant cap with Black Gold ER25 or ER40 coolant rings. Select the coolant ring to fit your shank size. See page 66.



Part No.	Description	Ring
19496G	For 3/4" chuck	ER25
19489G	For 1-1/4" chuck	ER40
19497G	For 1/8" - 3/4"	NA
19497G-2	For 1" ONLY	NA

# BT40, HSK63A, and HSK100A Milling Chucks



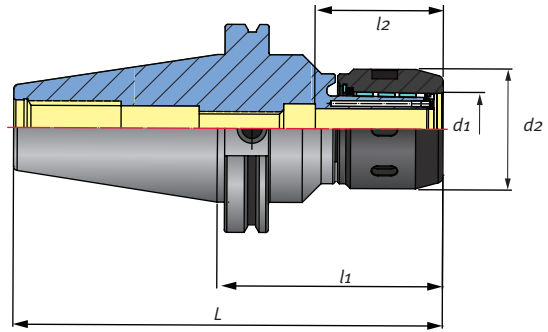
1-1/4" chuck shown above. Use milling chuck sleeves (page 140) to change tool shank size.



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

## Features

- Grips shank up to 5x tighter than ER 40 holders
- Nut seats against the flange when properly tightened (prevents overtightening)
- CoolBLAST coolant-thru standard on all milling chucks



## BT40 Milling Chucks

Part No.	Description	L	l1	l2	d1	d2	Holding Power
15994G	BT40 X MLD 3/4" - 3.15	5.75"	3.15"	1.97"	0.75"	2.22"	350 ft/lbs
15995G	BT40 X MLD 1" - 3.15	5.75"	3.15"	2.07"	1.0"	2.36"	425 ft/lbs
15996G	BT40 x MLD 1-1/4" - 4"	6.57"	4"	2.62"	1.25"	2.80"	500 ft/lbs



3/4" chuck shown above. Use milling chuck sleeves (page 140) to change tool shank size.



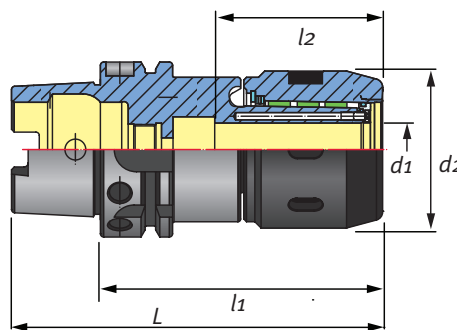
Tightening  
Stands  
pg. 234



Retention  
Knobs  
pg. 228



Wrenches  
pg. 232



For coolant-thru tools order the coolant ring that fits your shank size (pg. 138)



## HSK63A and HSK100A Milling Chucks

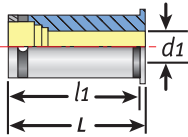
Part No.	Description	L	l1	l2	d1	d2	Holding Power
33232G	HSK63A X MLD 3/4" - 4"	5.30"	4"	2.01"	.75"	2.22"	350 ft/lbs
33236G	HSK63A x MLD 1-1/4" - 4.72"	5.98"	4.72"	2.65"	1.25"	2.80"	500 ft/lbs
33252G	HSK100A X MLD 3/4" - 4.72"	6.70"	4.72"	2.01"	.75"	2.22"	350 ft/lbs
33256G	HSK100A x MLD 1-1/4" - 4.72"	6.70"	4.72"	2.65"	1.25"	2.79"	500 ft/lbs



# Precision Reduction Sleeves for Milling Chucks



Use sleeves to change tool shank sizes just like you would collets.



## Milling Chuck Reduction Sleeves

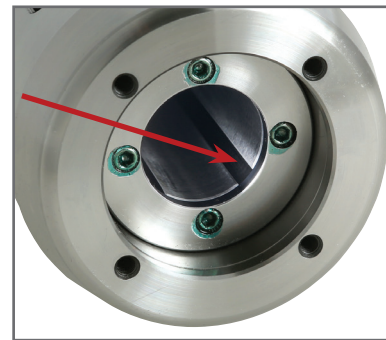
- For inch and metric shanks
- T.I.R only .0001"
- Precision ground for maximum accuracy
- Maximize your milling chuck capability

### 3/4" O.D. Reduction Sleeves for 3/4" Chucks

Part No.	Description	d1	l1	L
84126-1/8	3/4" O.D., x 1/8" I.D.	1/8"	1.93"	2.09"
84126-3/16	3/4" O.D., x 3/16" I.D.	3/16"	1.93"	2.09"
84126-1/4	3/4" O.D., x 1/4" I.D.	1/4"	1.93"	2.09"
84126-5/16	3/4" O.D., x 5/16" I.D.	5/16"	1.93"	2.09"
84126-3/8	3/4" O.D., x 3/8" I.D.	3/8"	1.93"	2.09"
84126-7/16	3/4" O.D., x 7/16" I.D.	7/16"	1.93"	2.09"
84126-1/2	3/4" O.D., x 1/2" I.D.	1/2"	1.93"	2.09"
84126-9/16	3/4" O.D., x 9/16" I.D.	9/16"	1.93"	2.09"
84126-5/8	3/4" O.D., x 5/8" I.D.	5/8"	1.93"	2.09"
84126-06	3/4" O.D., x 6mm I.D.	6mm	1.93"	2.09"
84126-08	3/4" O.D., x 8mm I.D.	8mm	1.93"	2.09"
84126-10	3/4" O.D., x 10mm I.D.	10mm	1.93"	2.09"
84126-12	3/4" O.D., x 12mm I.D.	12mm	1.93"	2.09"

Special slotted design (right) of bore I.D. increases holding power and reduces vibration.

Insert sleeve into chuck, then insert cutting tool, and tighten chuck last.



### 1-1/4" O.D. Reduction Sleeves for 1-1/4" Chucks

Part No.	Description	d1	l1	L
84127-1/8	1-1/4" O.D., x 1/8" I.D.	1/8"	2.56"	2.75"
84127-3/16	1-1/4" O.D., x 3/16" I.D.	3/16"	2.56"	2.75"
84127-1/4	1-1/4" O.D., x 1/4" I.D.	1/4"	2.56"	2.75"
84127-5/16	1-1/4" O.D., x 5/16" I.D.	5/16"	2.56"	2.75"
84127-3/8	1-1/4" O.D., x 3/8" I.D.	3/8"	2.56"	2.75"
84127-7/16	1-1/4" O.D., x 7/16" I.D.	7/16"	2.56"	2.75"
84127-1/2	1-1/4" O.D., x 1/2" I.D.	1/2"	2.56"	2.75"
84127-9/16	1-1/4" O.D., x 9/16" I.D.	9/16"	2.56"	2.75"
84127-5/8	1-1/4" O.D., x 5/8" I.D.	5/8"	2.56"	2.75"
84127-3/4	1-1/4" O.D., x 3/4" I.D.	3/4"	2.56"	2.75"
84127-7/8	1-1/4" O.D., x 7/8" I.D.	7/8"	2.56"	2.75"
84127-1	1-1/4" O.D., x 1.0" I.D.	1.0"	2.56"	2.75"
84127-08	1-1/4" O.D., x 8mm I.D.	8mm	2.56"	2.75"
84127-10	1-1/4" O.D., x 10mm I.D.	10mm	2.56"	2.75"
84127-12	1-1/4" O.D., x 12mm I.D.	12mm	2.56"	2.75"
84127-14	1-1/4" O.D., x 14mm I.D.	14mm	2.56"	2.75"
84127-16	1-1/4" O.D., x 16mm I.D.	16mm	2.56"	2.75"
84127-20	1-1/4" O.D., x 20mm I.D.	20mm	2.56"	2.75"
84127-25	1-1/4" O.D., x 25mm I.D.	25mm	2.56"	2.75"

### 1" O.D. Reduction Sleeves for 1" Chucks

Part No.	Description	d1	l1	L
84128-1/2	SSC 1" - 1/2" I.D.	1/2"	2.16"	2.36"
84128-1/4	SSC 1" - 1/4" I.D.	1/4"	2.16"	2.36"
84128-1/8	SSC 1" - 1/8" I.D.	1/8"	2.16"	2.36"
84128-3/16	SSC 1" - 3/16" I.D.	3/16"	2.16"	2.36"
84128-3/4	SSC 1" - 3/4" I.D.	3/4"	2.16"	2.36"
84128-3/8	SSC 1" - 3/8" I.D.	3/8"	2.16"	2.36"
84128-5/16	SSC 1" - 5/16" I.D.	5/16"	2.16"	2.36"
84128-5/8	SSC 1" - 5/8" I.D.	5/8"	2.16"	2.36"
84128-7/16	SSC 1" - 7/16" I.D.	7/16"	2.16"	2.36"
84128-7/8	SSC 1" - 7/8" I.D.	7/8"	2.16"	2.36"
84128-9/16	SSC 1" - 9/16" I.D.	9/16"	2.16"	2.36"

# Precision CAT and HSK Tool Blanks for Machining



## Techniks Certified Features

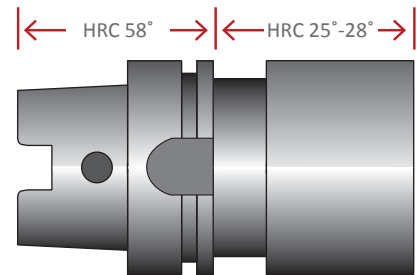
- Taper ground to AT3 accuracy or better
- Each blank is individually tested, measured and certified for accuracy



## Machinable Blanks

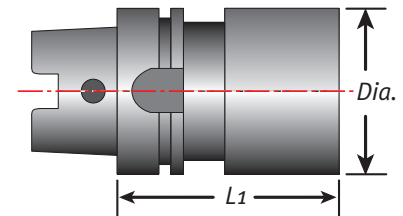
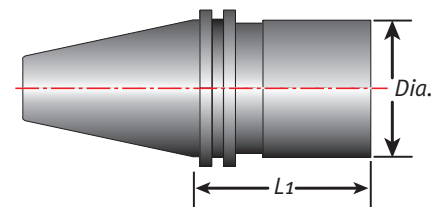
Techniks machinable blanks provide a quality platform for creating your own custom tools. They are made from high-grade tool steel for best performance.

Material analysis shows that the hardness at the spindle end is HRC 58° for long life and reduced spindle wear. The hardness on the machining end is HRC 25°-28° and remains stable from the surface all the way to the core.



## CAT and HSK Machinable Blanks

Part No.	Description	Dia.	L1
31.001.92.600	CAT40 x 2.5"-6	2.5"	6"
31.001.92.100	CAT40 x 2.5"-10	2.5"	10"
32.001.98.800	CAT50 x 3"-8	3"	8"
32.001.A2.110	CAT50 x 3.5"-11	3.5"	11"
73.001.98.600	HSK63A x 3"-6	3"	6"
73.001.A2.100	HSK63A x 3.5"-10	3.5"	10"
75.001.99.100	HSK100A x 4"-10	4"	10"



# Precision CAT and BT Morse Taper Toolholders



## Techniks Certified Tooling Features

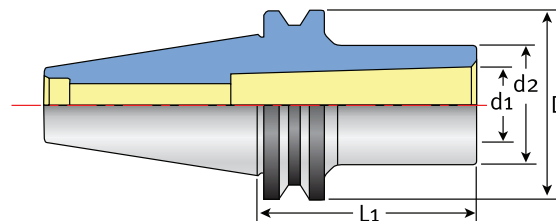
- Taper ground to AT3 accuracy or better
- .0002" runout from taper to tool pocket
- Each holder lab certified for accuracy



Tightening  
Stands  
pg. 234

Retention  
Knobs  
pg. 228

Wrenches  
pg. 232



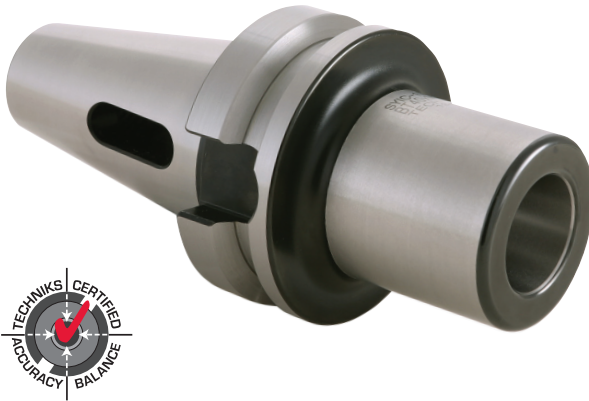
## CAT40, CAT50 Morse Taper Toolholders

Part No.	Taper	Size	L1	d1	d2	D
22611	CAT40 Morse Taper	MT#1	1.75"	.475"	.984"	2.5"
22613	CAT40 Morse Taper	MT#2	2.00"	.7"	1.26"	2.5"
22615	CAT40 Morse Taper	MT#3	2.75"	.937"	1.575"	2.5"
22617	CAT40 Morse Taper	MT#4	3.75"	1.231"	1.889"	2.5"

## CAT50 Morse Taper Toolholders

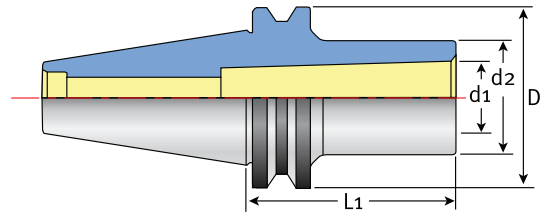
Part No.	Taper	Size	L1	d1	d2	D
22623	CAT50 Morse Taper	MT#2	2.00"	.7"	1.26"	3.875"
22625	CAT50 Morse Taper	MT#3	2.56"	.937"	1.575"	3.875"
22627	CAT50 Morse Taper	MT#4	3.75"	1.231"	1.889"	3.875"
22629	CAT50 Morse Taper	MT#5	4.13"	1.75"	2.48"	3.875"

# Precision BT30, BT40, BT50 Morse Taper Toolholders



## Techniks Certified Tooling Features

- Taper ground to AT3 accuracy or better
- .0002" runout from taper to tool pocket
- Each holder lab certified for accuracy



## BT30, BT40, BT50 Morse Taper Toolholders

Part No.	Taper	Size	L1	d1	d2	D
17001	BT30 Morse Taper	MT#1	1.77"	.475"	.984"	1.811"
17006	BT30 Morse Taper	MT#2	2.36"	.7"	1.26"	1.811"
17010	BT30 Morse Taper	MT#3	3.14"	.937"	1.575"	1.811"

## BT40 Morse Taper Toolholders

Part No.	Taper	Size	L1	d1	d2	D
17011	BT40 Morse Taper	MT#1	1.77"	.475"	.984"	2.48"
17014	BT40 Morse Taper	MT#2	1.96"	.7"	1.26"	2.48"
17018	BT40 Morse Taper	MT#3	2.75"	.937"	1.575"	2.48"
17023	BT40 Morse Taper	MT#4	3.75"	1.231"	1.889"	2.48"

## BT50 Morse Taper Toolholders

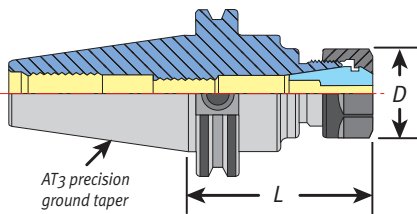
Part No.	Taper	Size	L1	d1	d2	D
17036	BT50 Morse Taper	MT#2	2.36"	.7"	1.26"	3.937"
17039	BT50 Morse Taper	MT#2-135	5.31"	.7"	1.26"	3.937"
17042	BT50 Morse Taper	MT#3	2.56"	.937"	1.575"	3.937"
17046	BT50 Morse Taper	MT3-150	5.9"	.937"	1.575"	3.937"
17048	BT50 Morse Taper	MT#4	3.74"	1.231"	1.889"	3.937"
17051	BT50 Morse Taper	MT4-180	7.08"	1.231"	1.889"	3.937"
17053	BT50 Morse Taper	MT#5	4.13"	1.75"	2.48"	3.937"

# CAT40 and CAT50 SIMIS ER Collet Chucks



## SIMIS Economy Collet Chucks vs. Techniks

Feature	SIMIS	Techniks Certified
Lab Certified for Accuracy & Balance	NO	YES
Balance Specification	YES - uncoated	YES - PowerCOAT
DIN B Coolant Available	18,000 RPMs	25,000 RPMs
End Mill Bore Tolerance	NO	YES
Available Sizes	most common	wide selection



## ER Nut Included

Part No.	Description
11116	ER16 uncoated hex nut
11120	ER20 uncoated hex nut
11125	ER25 uncoated slotted nut
11132	ER32 uncoated slotted nut
11140	ER40 uncoated slotted nut



## CAT40 ER Toolholders

Part No.	Description	L	D	Collet	Max. Shank	Stop Screw	Wrench
CAT40ER11-3	CAT40 x ER11-3"	3	.748"	ER11	.275"	06081	04608
CAT40ER11-4	CAT40 x ER11-4"	4	.748	ER11	.275"	06081	04608
CAT40ER11-6	CAT40 x ER11-6"	6	.748	ER11	.275"	06081	04608
CAT40ER16-2.76	CAT40 x ER16-2.76"	2.76"	1.08"	ER16	.406"	06083	04609 hex
CAT40ER16-4	CAT40 x ER16-4"	4"	1.08"	ER16	.406"	06083	04609 hex
CAT40ER20-2.76	CAT40 x ER20-2.76"	2.76"	1.34"	ER20	.512"	06087	04610 hex
CAT40ER20-4	CAT40 x ER20-4"	4"	1.34"	ER20	.512"	06087	04610 hex
CAT40ER20-6	CAT40 x ER20-6"	6"	1.34"	ER20	.512"	06087	04610 hex
CAT40ER25-2.76	CAT40 x ER25-2.76"	2.76"	1.65"	ER25	.63"	06089	04615
CAT40ER25-4	CAT40 x ER25-4"	4"	1.65"	ER25	.63"	06089	04615
CAT40ER32-2.76	CAT40 x ER32-2.76"	2.76"	1.97"	ER32	.788"	06089	04616
CAT40ER32-4	CAT40 x ER32-4"	4"	1.97"	ER32	.788"	06089	04616
CAT40ER40-3.15	CAT40 x ER40-3.15"	3.15"	2.48"	ER40	1.023"	06091	04617

## CAT50 ER Toolholders

Part No.	Description	L	D	Collet	Max. Shank	Stop Screw	Wrench
CAT50ER16-4	CAT50 x ER16-4	4"	1.08"	ER16	.406"	06083	04609 hex
CAT50ER16-6	CAT50 x ER16-6	6"	1.08"	ER16	.406"	06083	04609 hex
CAT50ER20-4	CAT50 x ER20-4	4"	1.34"	ER20	.512"	06087	04610 hex
CAT50ER20-6	CAT50 x ER20-6	6"	1.34"	ER20	.512"	06087	04610 hex
CAT50ER32-4	CAT50 x ER32-4	4"	1.97"	ER32	.788"	06089	04616
CAT50ER32-6	CAT50 x ER32-6	6"	1.97"	ER32	.788"	06089	04616
CAT50ER40-4	CAT50 x ER40-4	4"	2.48"	ER40	1.023"	06091	04617



# CAT40 and CAT50 SIMIS End Mill Holders



## SIMIS Economy End Mill Holders vs. Techniks

	SIMIS	Techniks Certified
Lab Certified for Accuracy & Balance	NO	YES
Balance Specification	8,000 RPMs	15,000 RPMs
DIN B Coolant Available	NO	YES
End Mill Bore Tolerance	H7	H5
Available Sizes	most common	wide selection



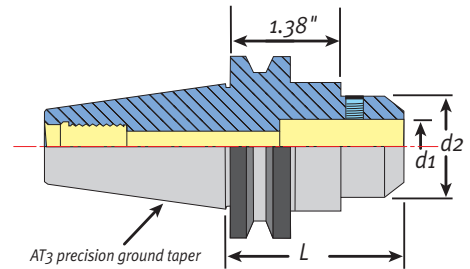
Tightening  
Stands  
pg. 234



Retention  
Knobs  
pg. 228



Wrenches  
pg. 232



## CAT40 End Mill Holders

Part No.	Description – d1	L	d2
CAT40SLN1/8	CAT40 x SLN - 1/8"	2.375"	.69"
CAT40SLN3/16	CAT40 x SLN - 3/16"	2.5"	.69"
CAT40SLN1/4	CAT40 x SLN - 1/4"	3"	.78"
CAT40SLN1/4-1.75	CAT40 x SLN - 1/4"	1.75"	.795"
CAT40SLN3/8	CAT40 x SLN - 3/8"	3"	.88"
CAT40SLN3/8-1.75	CAT40 x SLN - 3/8"	1.75"	.88"
CAT40SLN1/2	CAT40 x SLN - 1/2"	3"	1.25"
CAT40SLN1/2-1.75	CAT40 x SLN - 1/2"	1.75"	1.5"
CAT40SLN5/8	CAT40 x SLN - 5/8"	3"	1.5"
CAT40SLN3/4	CAT40 x SLN - 3/4"	3.5"	1.75"
CAT40SLN3/4-1.75	CAT40 x SLN - 3/4"	1.75"	1.75"
CAT40SLN1	CAT40 x SLN - 1.0"	4"	2"
CAT40SLN1-1.75	CAT40 x SLN - 1.0"	1.75"	1.75"
CAT40SLN1 1/4-2	CAT40 x SLN - 1-1/4"	2"	1.75"

## CAT50 End Mill Holders

Part No.	Description – d1	d2	L
CAT50SLN1/4	CAT50 x SLN - 1/4"	.78	4"
CAT50SLN3/8	CAT50 x SLN - 3/8"	1.0"	4"
CAT50SLN1/2	CAT50 x SLN - 1/2"	1.25"	4"
CAT50SLN5/8	CAT50 x SLN - 5/8"	1.5"	4"
CAT50SLN3/4	CAT50 x SLN - 3/4"	1.75"	4"
CAT50SLN1	CAT50 x SLN - 1.0"	2"	4"
CAT50SLN11/4	CAT50 x SLN - 1-1/4"	2.5"	4.6"

# HP3 High Precision and Keyless Jacobs Drill Chucks

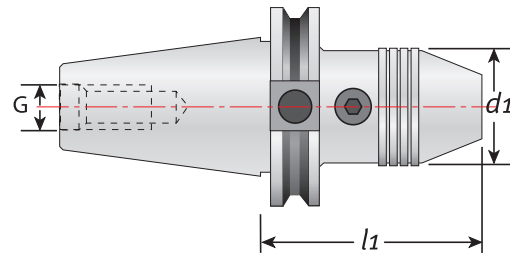


## Features

- Capacity from 1/16" to 1/2"
- 4 times greater holding power
- Balanced to 10,000 RPM

Our HP3 High-Precision Drill Chucks have the flexibility to hold a wide range of shank sizes and deliver superior performance too. Maximum runout (T.I.R.) is only .0008".

They also feature a one-piece design that provides greater rigidity and safety because the chuck cannot break free during operation.



## HP3 Precision Drill Toolholders (ISO, BT, HSK)

Part No.	Description	d1	l1	G
24.05.046.005	CAT40 HP3 drill chuck 1/2"	50	103	-
17.05.046.005	CAT50 HP3 drill chuck 1/2"	50	87.5	-
64.05.046.051	ISO30 HP3 drill chuck 1/2"	50	103	M12
67.05.046.001	BT30 HP3 drill chuck 1/2"	50	92.5	M12
39.05.046.001	BT40 HP3 drill chuck 1/2"	50	95.5	M16
93.05.046.003	HSK 63A HP3 drill chuck 1/2"	50	123.5	-
171.05.046.003	HSK63F HP3 drill chuck 1/2"	50	123.5	-



## Features

- For milling machines & drilling machines
- All hardened parts for long life and safety
- Use with CAT or BT holders

## Keyless Jacobs Taper Drill Chucks

Part No.	Description	Length Closed	Outer Diameter	Range
82150	08S x JT1	76mm	38mm	0 - 5/16"
82153	13S x JT6	102mm	49mm	0 - 1/2"
82151-JT33	10S x JT33	92mm	43mm	0 - 3/8"
82153-JT33	13S x JT33	102mm	49mm	0 - 1/2"

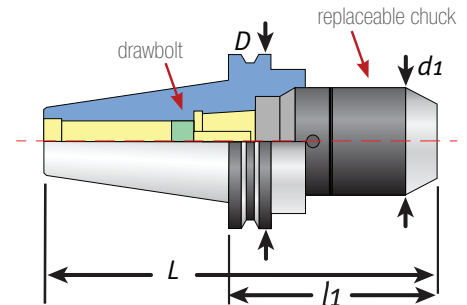
# CAT, BT, HSK Replaceable Keyless Drill Chucks



## Features

- 3 times more holding power than other chucks
- Holds non-standard shank sizes up to 1/2"
- Replaceable chuck is held by a drawbolt

Order Part No. 82164 replaceable chuck



## CAT Replaceable Drill Chucks

Part No.	Description	l1	L	D	d1
22403	CAT40 SPU x 1/2" - 4"	101.6mm	169.9mm	63.5mm	50mm
22405	CAT50 SPU x 1/2" - 4"	101.6mm	203.2mm	98.4mm	50mm
82164	SPU drill chuck (replacement)				
82172	SPU drill chuck wrench (replacement)				

## BT Replaceable Drill Chucks

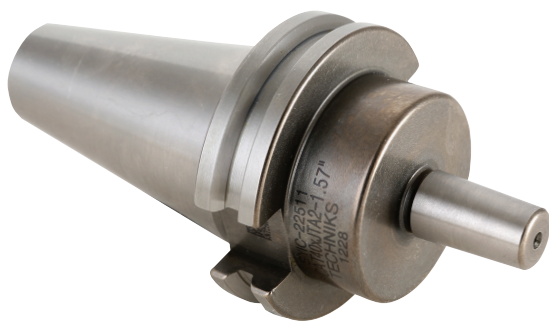
Part No.	Description	l1	L	D	d1
16456-W	BT30 x SPU 13mm - 110mm (no slots)	110mm	170.4mm	46mm	50mm
16456	BT30 x SPU 13mm - 110mm	110mm	170.4mm	46mm	50mm
16466	BT40 x SPU 13mm - 100mm	100mm	177.4mm	63mm	50mm
16476	BT50 x SPU 13mm - 100mm	100mm	213.8mm	100mm	50mm
82164	SPU drill chuck (replacement)				
82172	SPU drill chuck wrench (replacement)				

## HSK Replaceable Drill Chucks

Part No.	Description	l1	L	D	d1
34905	HSK 63A x SPU 13mm - 150mm	150mm	182.5mm	63mm	50mm
34905-F	HSK 63F x SPU 13mm - 150mm	150mm	175mm	63mm	50mm
82164	SPU drill chuck (replacement)				
82172	SPU drill chuck wrench (replacement)				

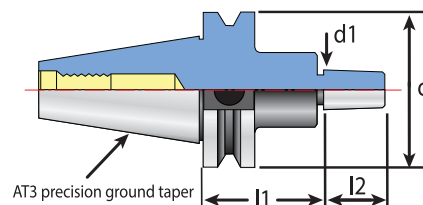


# CAT and BT Toolholders For Jacobs Taper Drill Chucks



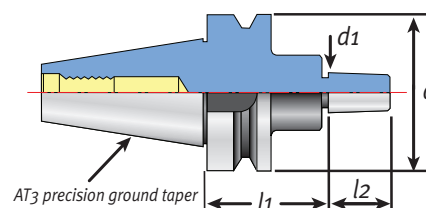
## Features

- Better T.I.R. and rigidity than standard drill chucks
- Taper ground to AT3 accuracy
- Use with keyless Jacobs chucks



## CAT Toolholders For Jacobs Taper Drill Chucks

Part No.	Description	l1	l2	d1	Jacobs Taper
22511	CAT40 x JT2 - 1.57"	1.57"	.875"	.559"	2
22512	CAT40 x JT3 - 1.57"	1.57"	1.2"	.811"	3
22513	CAT40 x JT6 - 1.57"	1.57"	.945"	.676"	6
22515	CAT40 x JT33 - 1.57"	1.57"	.945"	.624"	33
22521	CAT50 x JT2 - 1.57"	1.57"	.875"	.559"	2
22527	CAT50 x JT3 - 1.57"	1.57"	1.2"	.811"	3
22529	CAT50 x JT4 - 1.57"	1.57"	1.656"	1.124"	4
22531	CAT50 x JT5 - 1.57"	1.57"	1.875"	1.413"	5
22523	CAT50 x JT6 - 1.57"	1.57"	.945"	.676"	6
22525	CAT50 x JT33 - 1.57"	1.57"	.945"	.624"	33



## BT Toolholders For Jacobs Taper Drill Chucks

Part No.	Description	l1	l2	d1
16502	BT30 x JT2 - 45mm	45mm	20mm	14.199
16504	BT30 x JT33 - 45mm	45mm	24mm	15.850
16506	BT30 x JT6 - 45mm	45mm	24mm	17.170
16522	BT40 x JT2 - 45mm	45mm	20mm	14.199
16523	BT40 x JT33 - 45mm	45mm	24mm	15.850
16524	BT40 x JT6 - 45mm	45mm	24mm	17.170
16542	BT50 x JT2 - 45mm	45mm	20mm	14.199
16543	BT50 x JT33 - 45mm	45mm	24mm	15.850
16544	BT50 x JT6 - 45mm	45mm	24mm	17.170