BT Shank Tools

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

IMPORTANT!

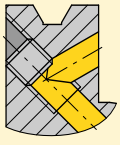
- All critical surfaces must be protected from damage. Neglect from dings and scratches will impair accuracy and performance.
- All assembly components must be clean. Never overtighten the components; this can permanently destroy the function and accuracy of the toolholder.

For retention knobs, please see page D50.

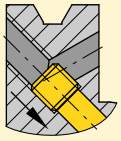
Form B coolant

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

CAUTION!

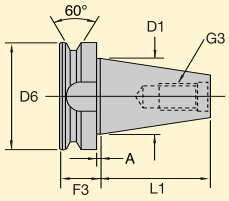


Toolholders are factory set to the form B coolant supply position. When relocating coolant position screws, use of a removable liquid (small screw thread locker) is recommended.



Possible variation of coolant supply to DIN 69871 form AD; tightening screws will stop coolant from escaping through the flange.

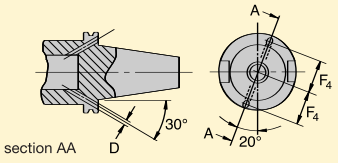
Tooling Standard Dimensions – JIS B6339



	D1	D6	L1	F3	A	G3
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 ±.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)