



- Meets or exceeds DIN69871 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-oxidized, which provides better fitments.
- All non-critical surfaces are black-oxidized, except for the high-performance toolholders.
- Wherever the toolholder design allows, through coolant is a standard feature.
- Depending on application and symmetry of toolholder assembly (toolholder, components, retention knob, collets, cutting tools, etc.) DV40 and DV50 toolholders will perform effectively up to 10,000 rpm before the complete toolholder assembly needs to be balanced. At speeds above 10,000 rpm, Kennametal recommends that the toolholder assembly 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.

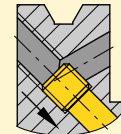
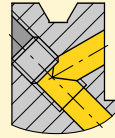
For retention knobs, please see page D50.



Form B coolant

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

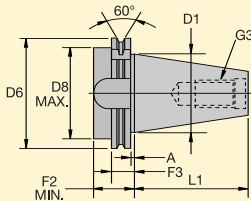
CAUTION!



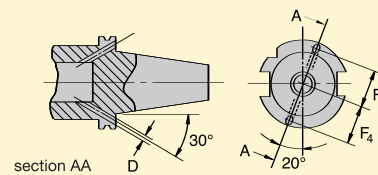
Toolholders are factory set to the form B coolant supply position. When relocating coolant position screws, use of a removable liquid (small screw thread locker) is recommended.

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

DIN 69871 DV Form A



DIN 69871 DV Form B – Flange Coolant Entry Ports



	D1	D6	D8 Max.	L1	F2 min.	F3	A	G3
30	1.250 (31,75)	1.967 (49,95)	1.772 (45,00)	1.876 (47,65)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M12 thread
40	1.750 (44,45)	2.480 (63,00)	1.969 (50,00)	2.687 (68,25)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M16 thread
45	2.250 (57,15)	3.228 (82,00)	2.480 (63,00)	3.250 (82,55)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M20 thread
50	2.750 (69,85)	3.837 (97,45)	3.150 (80,00)	4.000 (101,60)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M24 thread

	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)