

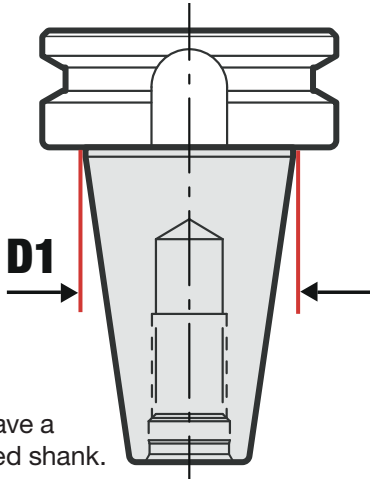
# CNC Toolholder Identification

When ordering Huot products it is important to determine what type and size toolholder you possess. Compare your toolholder to those illustrated, measure the D1 dimension and compare

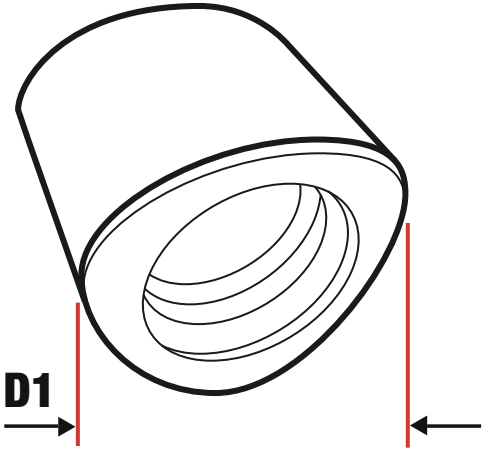
that to the dimension charts. The information and dimensions displayed are for part identification purposes only. Dimensions shown in (parentheses) are in millimeters, all others are in inches.



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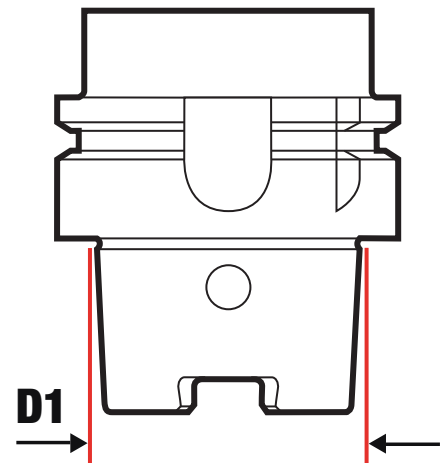
“V-Flange” toolholders have a conical tapered shank.



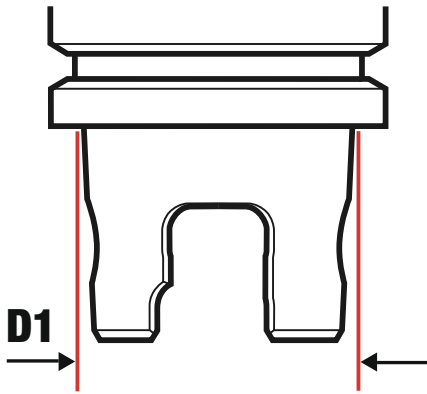
CAPTO™ including C4, C5, C6, and C8 are distinctively known for their tapered polygon shape as shown.  
 CAPTO Registered Trademark Sandvik Corp.

V-Flange Style				
Size	BT	CV (CAT)	DV	NMTB
25	N/A	N/A	N/A	N/A
30	1.25	1.25	1.25	1.25
32	N/A	N/A	N/A	N/A
35	1.5	N/A	N/A	N/A
40	1.75	1.75	1.75	1.75
45	2.25	2.25	2.25	N/A
50	2.75	2.75	2.75	2.75
60	N/A	4.25	N/A	N/A

HSK Style						
Size	HSK A	HSK B	HSK C	HSK D	HSK E	HSK F
25	N/A	N/A	N/A	N/A	0.748 (19)	N/A
30	N/A	N/A	N/A	N/A	N/A	N/A
32	0.945 (24)	N/A	0.945 (24)	N/A	0.945 (24)	N/A
35	N/A	N/A	N/A	N/A	N/A	N/A
40	1.181 (30)	0.945 (24)	1.181 (30)	0.945 (24)	1.181 (30)	N/A
45	N/A	N/A	N/A	N/A	N/A	N/A
50	1.496 (38)	1.181 (30)	1.496 (38)	1.181 (30)	1.496 (38)	1.181 (30)
60	N/A	N/A	N/A	N/A	N/A	N/A
63	1.89 (48)	1.496 (38)	1.89 (48)	1.496 (38)	1.89 (48)	1.496 (38)
80	2.362 (60)	1.89 (48)	2.362 (60)	1.89 (48)	N/A	N/A
100	2.952 (75)	2.362 (60)	2.952 (75)	2.362 (60)	N/A	N/A
125	3.740 (95)	2.952 (75)	N/A	N/A	N/A	N/A
160	4.724 (120)	3.740 (95)	N/A	N/A	N/A	N/A



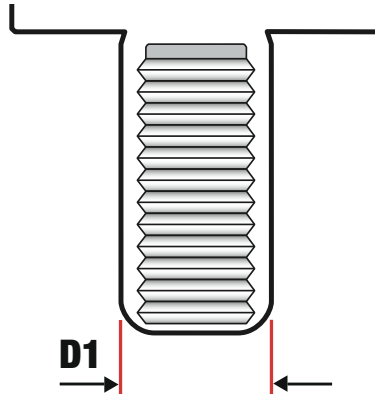
HSK's have a short hollow taper and we have identified 6 different styles.



KM™ toolholders have two angled holes through the shank called “ball tracks” which act as a clamping mechanism.

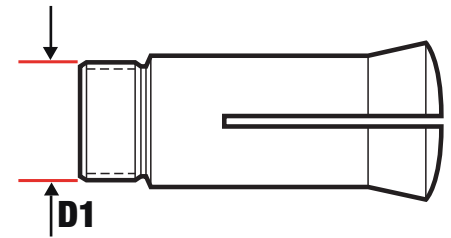
KM™	
Size	D1
32	0.945 (24)
40	1.181 (30)
50	1.575 (40)
63	1.969 (50)
80	2.52 (64)

KM Registered Trademark Kennametal



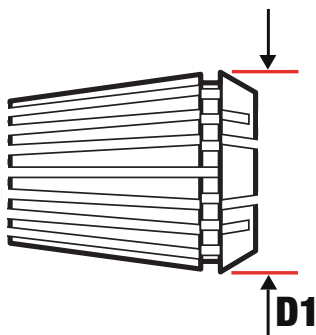
VDI toolholders come in many different shapes and sizes. One distinctive feature is the shaft is serrated on one side as shown in the illustration.

VDI Type	
Size	Diameter
25	0.983 (25)
30	1.181 (30)
40	1.575 (40)
50	1.969 (50)
60	2.362 (60)



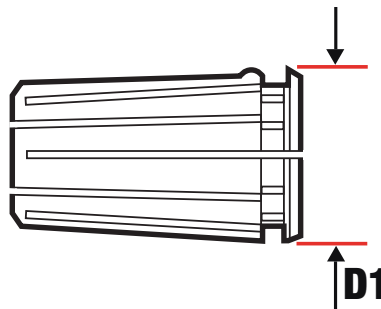
C/3J/R8 collets have a narrow cylindrical body, a short tapered head, and are threaded at one end.

C Series/3J/R8 Collets		
Size	Dia - A	Length
5C	1.250	3.281
16C	1.889	4.312
20C	2.378	6.250
25C	2.930	6.480
3J	2.000	3.750
R8	.950	4.000



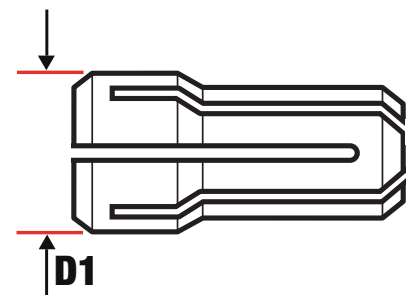
ER/RD/DR collets have a single shallow angled taper.

ER/RD/DR Collets		
Size	Diameter	Length
8	0.335	0.531
11	0.435	0.709
12	0.472	0.768
16	0.669	1.063
20	0.827	1.22
25	1.024	1.378
32	1.299	1.575
40	1.614	1.811
50	2.047	2.362



TG collets, short for tremendous grip, have a single shallow-angled taper similar to ER/RD/DR collets, but the difference between the types can be discerned by comparing dimensions.

TG Collets		
Size	Diameter	Length
TG50	0.76	1.438
TG75	1.062	1.844
TG100	1.379	2.375
TG150	2.001	3
TG200	2.671	3.25



DA is short for double angle which refers to the two short angles which hold the tool in place.

DA Collets		
Size	Diameter	Length
DA100	0.769	1.44
DA180	1.035	1.62
DA200	0.539	1.18
DA300	0.375	1.08
DA400	1.455	2
DA500	2.255	2

Information and dimensions provided were compiled from multiple sources including but not limited to the following: "HSK Overview." Guhring The Tool Company. Guhring, Inc., n.d. Web. 31 May 2012. <<http://www.guhring.com/PS/Toolholders/Overview.htm>>. • Kennametal. Kennametal Inc., n.d. Web. 31 May 2012. <[http://www.kennametal.com/en-US/home.jhtml?\\_requestid=904656](http://www.kennametal.com/en-US/home.jhtml?_requestid=904656)>. • "Spindle Tooling for Manual and CNC Lathes." Hardinge. Hardinge Inc., 03 May 2010. Web. 31 May 2012. <[http://www.hardinge.com/usr/pdf/collet/2348F\\_LR.pdf](http://www.hardinge.com/usr/pdf/collet/2348F_LR.pdf)>. • Stovner, Steve. "Machine Tool Shanks (Tapers)." Tools-n-Gizmos, n.d.. Web. 31 May 2012.