BTKV and CVKV Shank Tools

- BTKV40 .......................................................... D2–D19
- BTKV50 .......................................................... D20–D37
- CVKV40 .......................................................... D38–D51
- CVKV50 .......................................................... D52–D67
ERICKSON™ Taper Face Contact Shank Tooling System • BTKV40 Series

Primary Application
ERICKSON Taper Face BT Contact Taper Tooling is manufactured from premium materials and to the latest JIS B 6339 specification standard with an AT3 7/24 Taper per ISO-1974. Controlled, increased flange thickness to the rear of the flange gains face contact between spindle and holder. The BTKV40 tools are prebalanced to a high specification that will perform effectively up to 20,000 RPM. For any applications higher than 20,000 RPM, Kennametal recommends that the complete toolholder assembly (toolholder, retention knobs, collets, hardware, and cutting tools) be balanced as one identity.

Features and Benefits
- JIS B 6339 7/24 taper.
- Standard M16 metric drawbar thread.
- High axial repeatability due to face contact.
- High radial positioning due to controlled, tighter drive key widths.
- All tools set to form AD coolant specification. Many can be converted to form B style.
- Maximum 20,000 RPM.
- Maximum 100 bar (1,500 psi) coolant pressure.
How Do Catalog Numbers Work?
Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.

### BTKV Face Contact Shank Tools
Catalog Numbering System

<table>
<thead>
<tr>
<th>BTKV</th>
<th>40</th>
<th>B</th>
<th>TG</th>
<th>100</th>
<th>M</th>
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<tbody>
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<td>Shank Style</td>
<td>Shank Taper Size</td>
<td>Special Feature (optional)</td>
<td>Toolholder Style</td>
<td>Toolholder Size</td>
<td>Identification Value</td>
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<td>JS B6339 Face Contact</td>
<td>J50 = 40, 50</td>
<td>B = DIN form B coolant feature, tool shipped to AD specification (design allows conversion to form B style) (blank) = (no “B” or “Z”) — tool built to form A/AD coolant style</td>
<td>HPV = High performance and balanceable</td>
<td>TD = Tunable</td>
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<tr>
<td>BB = Bar blank</td>
<td>EM = End mill adapter</td>
<td>ER = DIN 6499 single-angle collet chuck</td>
<td>KM = KM” adapter</td>
<td>SM2C = Shell mill adapter with coolant and small diameter</td>
<td>SMC = Shell mill adapter with coolant</td>
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<tr>
<td>TG = Tremendous Grip single-angle collet chuck</td>
<td>TT = Shrink Fit thermo toolholder</td>
<td>TTHT = Shrink Fit thermo toolholder — high torque</td>
<td>TG = Collet series xx (50), xxx (100)</td>
<td>EM = I.D. size: metric — xx = xx, (20); inch — xxx = x.xx, (075)</td>
<td>SM = O.D. size: metric — xx = xx, (20); inch — xxx = x.xx, (075)</td>
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(Gage line on taper to front of tool)

inch
xxx = x.xx

M = Tool built to metric values and has metric retention thread
BTKV40 Shank Tools
Shrink Fit Toolholders General Purpose (GP)

- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide and HSS cutting tools (requirements below).

ERICKSON

**TT GP HPV MM-BTKV Form B/AD**

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(continued)
BTKV40 Shank Tools
Shrink Fit Toolholders General Purpose (GP)

(TT GP HPV BTKV Form B/AD continued)

Cutting Tool Shank Requirements
inch (industry standard)
cutting tool shank diameters tolerance
1/4, 5/16, & 3/8 .0000/-.0004
7/16, 1/2, & 5/8 .0000/-.0004
3/4, 7/8, 1, & 1-1/4 .0000/-.0005

TT HPV IN-BTKV Form B/AD

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NOTE: Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.
Shrink Fit technical section, see page M78.
Supplied with stop screw.
Adjusting stop screw gage, see page M81.
Optional M6~1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.
For retention knobs, see page L45.
For Shrink Fit machine and accessories, see pages L12–L13.
BTKV40 Shank Tools
Shrink Fit Toolholders High Torque (HT)

- 30–50% higher clamping torque compared to GP line.
- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide only, designated by groove in front face (requirements below).
- 10 kW power or greater Shrink Fit device must be used.

Cutting Tool Shank Requirements
metric (ISO standard)

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<tr>
<th>cutting tool shank diameter</th>
<th>tolerance</th>
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<td>12, 14, 16, &amp; 18</td>
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**ERICKSON**

- TT HT HPV MM-BTKV Form B/AD

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<th>L9</th>
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## TT HT HPV IN-BTKV Form B/AD

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**NOTE:** Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.

- Shrink Fit technical section, see page M7/8.
- Supplied with stop screw.
- Adjusting stop screw gage, see page M61.
- Optional M6~1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.
- For retention knobs, see page L45.
- For Shrink Fit machine and accessories, see pages L12–L13.
### BTKV40 Shank Tools
#### TG Single-Angle Collet Chucks

- Tremendous Grip (3:1 advantage).

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**TG Round-BTKV Form B/AD**

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<td>4mm &amp; 5/32</td>
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<td>4mm &amp; 5/32</td>
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*NOTE: Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque. Collet chuck technical section, see page M98. Supplied with locknut and stop screw. Locknut wrench must be ordered separately. Interchangeable locknuts, coolant-style locknuts, and coolant disks are available and must be ordered separately; see page L19. Stop screw coolant caps are available and must be ordered separately; see pages L34-L35. Balanceable/interchangeable locknuts are available and must be ordered separately; see page L16. TG standard straight-bore collets, see page J10. TG tap collets, see page J10. For retention knobs, see page L45.*
ERICKSON™ & KM™
Names You Can Trust

For hydraulic chucks — ERICKSON and KM — the industry names you can trust.

- Most accurate chuck, ≤3μm (.0001"), achieves maximum performance from your cutting edge.
- Inherent dampening design extends tool life and improves surface finish.
- Pre-balanced to high specifications.
- Versatile as a collet chuck with the use of reduction sleeves.

Experience the advantages at your Authorized Kennametal Distributor or at www.kennametal.com.
BTKV40 Shank Tools
ER Single-Angle Collet Chucks

- Grip (2:1 advantage).

Collet Capacity

<table>
<thead>
<tr>
<th>ER collet series</th>
<th>mm</th>
<th>inch</th>
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<tr>
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<td>.02</td>
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<td>ER25</td>
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<td>.04</td>
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<td>ER32</td>
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order number  catalog number  collet series  D11  L1  L1FC  L9  V  kg

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<th>order number</th>
<th>catalog number</th>
<th>collet series</th>
<th>D11</th>
<th>L1</th>
<th>L1FC</th>
<th>L9</th>
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Spare Parts

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<th>locknut</th>
<th>wrench</th>
<th>counterbore collet torque (Nm)</th>
<th>straight collet torque (Nm)</th>
<th>stop screw</th>
<th>wrench size stop screw</th>
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(continued)
BTKV40 Shank Tools
ER Single-Angle Collet Chucks

(ER BTKV Form B/AD continued)

![Diagram of collet series](image)

**ER Round-BTKV Form B/AD**

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<th>catalog number</th>
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**Spare Parts**

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<th>Nm</th>
<th>stop screw</th>
<th>wrench size</th>
<th>stop screw</th>
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NOTE: Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque.

Collet chuck technical section, see page M98.

Supplied with locknut and stop screw.

Locknut wrench must be ordered separately.

ER standard straight-bore collets, see page J50.

ER tap collets, see pages J58–J59.

ER TCT tension-only tap collets, see page J60.

For retention knobs, see page L45.
**BTKV40 Shank Tools**

End Mill Adapters

---

**ERICKSON**

- EM MM-BTKV Form B/AD

---

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<thead>
<tr>
<th>order number</th>
<th>catalog number</th>
<th>D1</th>
<th>D2</th>
<th>L1</th>
<th>L1FC</th>
<th>L9</th>
<th>lock screw</th>
<th>wrench size</th>
<th>Nm</th>
<th>kg</th>
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(continued)
(EM BTKV Form B/AD continued)

**EM IN-BTKV Form B/AD**

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<th>L1FC</th>
<th>L9</th>
<th>lock screw</th>
<th>wrench size lock screw</th>
<th>ft. lbs.</th>
<th>lbs</th>
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**NOTE:**
- Do not overtighten clamp screw; use torque recommendations above.
- Supplied with clamp screw.
- Clamp screw wrench not included.
- For retention knobs, see page L45.
### BTKV40 Shank Tools

**Tunable Shell Mill Adapters with Through Coolant**

**ERICKSON**

- **SMC TD Cap MM-BTKV Form B/AD**

<table>
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<tr>
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<th>catalog number</th>
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<th>D2</th>
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<th>L2</th>
<th>L20</th>
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<td>260</td>
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- **SMC TD Lock MM-BTKV Form B/AD**

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<th>D2</th>
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*Order numbers are 4136287 and 4136288.*

*Lock screw: MS1234, KDK22M*

*Drive key: KLSS27M, 10mm*
### SMC TD Lock IN-BTKV Form B/AD

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<th>order number</th>
<th>catalog number</th>
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<th>drive key</th>
<th>wrench size</th>
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<td>KDK06</td>
<td>5/16</td>
<td>11.84</td>
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**NOTE:** Do not overtighten lock screw.
- Supplied with lock screw and drive keys.
- Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38.
- Lock screw wrench not included.
- For retention knob, see page L45.
### BTKV40 Shank Tools

**Shell Mill Adapters with Through Coolant**

**ERICKSON**

- **SMC Cap MM-BTKV Form B/AD**

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<th>catalog number</th>
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<th>D2</th>
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<th>lock screw</th>
<th>drive key</th>
<th>wrench size lock screw</th>
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**SMC Lock MM-BTKV Form B/AD**

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<th>drive key</th>
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(continued)
## SMC TD Lock IN-BTKV Form B/AD

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**NOTE:** Do not overtighten lock screw. Supplied with lock screw and drive keys. Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38. Lock screw wrench not included. For retention knobs, see page L45.
### BTKV40 Shank Tools
#### KM™ Modular Adapters

**BTKV40 Shank Tools**

**KM-BTKV Form B/AD**

<table>
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<tr>
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<th>wrench size</th>
<th>actuation screw</th>
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<th>kg</th>
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</table>

**NOTE:** Do not overtorque actuation screw; use torque recommendations above. Supplied with KM actuation mechanism. For retention knobs, see page L45.
- Machinable front 20–30 RW C.

**ERICKSON**

- **BB-BTKV Form A**

<table>
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NOTE: For retention knobs, see page L45.
Primary Application

ERICKSON Taper Face BT Contact Taper Tooling is manufactured from premium materials and to the latest JIS B 6339 specification standard. Controlled, increased flange thickness to the rear of the flange gains face contact between spindle and holder. The BTKV50 tools are prebalanced to a high specification that will perform effectively up to 20,000 RPM. For any applications higher than 20,000 RPM, Kennametal recommends that the complete toolholder assembly (toolholder, retention knobs, collets, hardware, and cutting tools) be balanced as one identity.
Features and Benefits

- JIS B 6339 7/24 taper.
- Standard M24 metric drawbar thread.
- High axial repeatability due to face contact.
- High radial positioning due to controlled, tighter drive key widths.
- All tools set to form AD coolant specification. Many can be converted to form B style.
- Maximum 20,000 RPM.
- Maximum 100 bar (1,500 psi) coolant pressure.
BTKV50 Shank Tools
Shrink Fit Toolholders General Purpose (GP)

- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide and HSS cutting tools (requirements below).

<table>
<thead>
<tr>
<th>order number</th>
<th>catalog number</th>
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<th>D2</th>
<th>D21</th>
<th>L1</th>
<th>L1FC</th>
<th>L2</th>
<th>L9</th>
<th>V</th>
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**Cutting Tool Shank Requirements**

- **metric (ISO standard)**
  - 6: h6 0.000/-0.008
  - 8 & 10: h6 0.000/-0.009
  - 12, 14, 16, & 18: h6 0.000/-0.011
  - 20 & 25: h6 0.000/-0.013
  - 32: h6 0.000/-0.018

**Cutting Tool Shank Requirements**

- **TT GP HPV MM-BTKV Form B/AD**
BTKV50 Shank Tools
Shrink Fit Toolholders General Purpose (GP)

(TT GP HPV BTKV Form B/AD continued)

Cutting Tool Shank Requirements
inch (industry standard)

<table>
<thead>
<tr>
<th>cutting tool shank diameters</th>
<th>tolerance</th>
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TT GP HPV In-BTKV Form B/AD

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<th>L1</th>
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<th>L2</th>
<th>L9</th>
<th>V</th>
<th>stop screw</th>
<th>wrench size</th>
<th>lbs</th>
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NOTE: Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.
Supplied with stop screw.
Adjusting stop screw gage, see page M81.
Optional M6~1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.
For retention knobs, see page L45.
For Shrink Fit machine and accessories, see page L12–L13.
BTKV50 Shank Tools
Shrink Fit Toolholders High Torque (HT)

- 30–50% higher clamping torque compared to GP line.
- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide only, designated by groove in front face (requirements below).
- 10 kW power or greater Shrink Fit device must be used.

Cutting Tool Shank Requirements
metric (ISO standard)

<table>
<thead>
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<th>cutting tool shank diameter</th>
<th>tolerance</th>
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</thead>
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<tr>
<td>32</td>
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</table>

BTKV50 Shank Tools
Shrink Fit Toolholders High Torque (HT)

- 30–50% higher clamping torque compared to GP line.
- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide only, designated by groove in front face (requirements below).
- 10 kW power or greater Shrink Fit device must be used.

**ERICKSON**

**TT HT HPV MM-BTKV Form B/AD**

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<th>L1FC</th>
<th>L2</th>
<th>L9</th>
<th>V</th>
<th>stop screw</th>
<th>wrench size</th>
<th>kg</th>
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TT HT HPV In-BTKV Form B/AD

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NOTE: Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.
Shrink Fit technical section, see page M78.
Supplied with stop screw.
Adjusting stop screw gage, see page M81.
Optional M6–1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.
For retention knobs, see page L45.
For Shrink Fit machine and accessories, see pages L12–L13.
BTK50 Shank Tools
TG Single-Angle Collet Chucks

Collet Capacity

<table>
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<th>TG collet series</th>
<th>mm</th>
<th>inch</th>
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NOTE: Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque.

Collet chuck technical section, see page M98.

Supplied with locknut and stop screw.

Interchangeable locknuts, coolant-style locknuts, and coolant disks are available and must be ordered separately; see pages L16–L17.

Stop screw coolant caps are available and must be ordered separately; see pages L34–L35.

Balanced/interchangeable locknuts are available and must be ordered separately; see page L16.

TG standard straight-bore collets, see page J10.

TG tap collets, see page J10.

For retention knobs, see page L45.
To BEAT the HEAT

B/K284 Solid Carbide Drills

B/K284 Series Solid Carbide Drills offer a material-specific design and grade for machining high-temperature-resistant alloys, like titanium and nickel-based alloys, in aerospace applications. This drill minimizes subsurface deformation.

- HP drill point — prevents workpiece flexing.
- Straight cut edge — rigid corner wedge withstands high thermal and mechanical stress.
- Unique flute design — improves chip evacuation.
- K715™ grade — specified, uncoated 9% Co fine-grain carbide.
- Customization — intermediate diameters, length variations, and step drills available as customized solutions.
- For the latest product catalog, please refer to the e-catalog at www.kennametal.com.

Experience the advantages at your Authorized Kennametal Distributor or at www.kennametal.com.
BTKV50 Shank Tools
ER Single-Angle Collet Chucks

• Grip (2:1 advantage).

L1 = from taper gage diameter
L1FC = from flange face

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ERICKSON

■ ER Hex-BTKV Form B/AD

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■ Spare Parts

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<th>straight collet torque (Nm)</th>
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(continued)
BTKV50 Shank Tools
ER Single-Angle Collet Chucks

(ER BTKV Form B/AD continued)

**ER Round-BTKV Form B/AD**

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**Spare Parts**

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NOTE: Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque. Collet chuck technical section, see page M98. Supplied with locknut and stop screw. Locknut wrench must be ordered separately. ER standard straight-bore collets, see page J50. ER tap collets, see pages J58–J59. ER TCT tension-only tap collets, see page J60. For retention knobs, see page L45.
## BTKV50 Shank Tools

**End Mill Adapters**

L1FC = from flange face

L1 = from taper gage diameter

---

**ERICKSON**

- EM MM-BTK Form B/AD

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<td>1/2</td>
<td>1.37</td>
<td>3.00</td>
<td>2.94</td>
<td>ELS044038PKG</td>
<td>7/32</td>
<td>20</td>
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<tr>
<td>3856573</td>
<td>BTKV50BEM075400</td>
<td>3/4</td>
<td>1.75</td>
<td>4.00</td>
<td>3.94</td>
<td>ELS062050PKG</td>
<td>5/16</td>
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<td>8.99</td>
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<td>3856574</td>
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<td>3.94</td>
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<td>110</td>
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<tr>
<td>3856575</td>
<td>BTKV50BEM125400</td>
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<td>4.00</td>
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<tr>
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<td>BTKV50BEM150450</td>
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<td>4.50</td>
<td>4.44</td>
<td>ELS075069PKG</td>
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<td>BTKV50BEM200550</td>
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<td>3.75</td>
<td>5.50</td>
<td>5.44</td>
<td>ELS100088PKG</td>
<td>1/2</td>
<td>148</td>
<td>16.28</td>
</tr>
</tbody>
</table>

**NOTE:** Do not overtighten clamp screw; use torque recommendations above.
- Supplied with clamp screw.
- Clamp screw wrench not included.
- For retention knobs, see page L45.
### ERICKSON

**SMC TD Cap MM-BTKV Form B/AD**

<table>
<thead>
<tr>
<th>order number</th>
<th>catalog number</th>
<th>D1</th>
<th>D2</th>
<th>D21</th>
<th>L1</th>
<th>L1FC</th>
<th>L2</th>
<th>L20</th>
<th>L21</th>
<th>lock screw</th>
<th>drive key</th>
<th>wrench size</th>
<th>lock screw</th>
<th>kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>4136291</td>
<td>BTKV50BTDSMC22260M</td>
<td>22</td>
<td>49</td>
<td>70</td>
<td>260.0</td>
<td>258.5</td>
<td>13.5</td>
<td>211.8</td>
<td>222</td>
<td>MS1234</td>
<td>KDK22M</td>
<td>8mm</td>
<td>8.27</td>
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</table>

### SMC TD Lock MM-BTKV Form B/AD

<table>
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<tr>
<th>order number</th>
<th>catalog number</th>
<th>D1</th>
<th>D2</th>
<th>D21</th>
<th>L1</th>
<th>L1FC</th>
<th>L2</th>
<th>L20</th>
<th>L21</th>
<th>lock screw</th>
<th>drive key</th>
<th>wrench size</th>
<th>lock screw</th>
<th>kg</th>
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<tbody>
<tr>
<td>4136292</td>
<td>BTKV50BTDSMC27320M</td>
<td>27</td>
<td>61</td>
<td>80</td>
<td>320</td>
<td>318.5</td>
<td>13.5</td>
<td>271.8</td>
<td>282</td>
<td>KLS327M</td>
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<td>10mm</td>
<td>11.99</td>
<td></td>
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<tr>
<td>4136303</td>
<td>BTKV50BTDSMC32330M</td>
<td>32</td>
<td>78</td>
<td>—</td>
<td>330</td>
<td>328.5</td>
<td>292.0</td>
<td>—</td>
<td>—</td>
<td>KLS32M</td>
<td>KDK32M</td>
<td>14mm</td>
<td>16.22</td>
<td></td>
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</tbody>
</table>

(continued)
BTKV50 Shank Tools
Tunable Shell Mill Adapters with Through Coolant

(SMC continued)

L1FC = from flange face
L1 = from taper gage diameter

SMC TD Lock IN-BTKV Form B/AD

<table>
<thead>
<tr>
<th>order number</th>
<th>catalog number</th>
<th>D1</th>
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<th>L1</th>
<th>L1FC</th>
<th>L2</th>
<th>L20</th>
<th>L21</th>
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<tr>
<td>4136304</td>
<td>BTKV50BTDSMC0751050</td>
<td>3/4</td>
<td>1.75</td>
<td>2.56</td>
<td>10.50</td>
<td>10.44</td>
<td>8.60</td>
<td>9.00</td>
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<tr>
<td>4136305</td>
<td>BTKV50BTDSMC1001250</td>
<td>1</td>
<td>2.75</td>
<td>—</td>
<td>12.50</td>
<td>—</td>
<td>12.44</td>
<td>11.00</td>
<td>10.50</td>
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<tr>
<td>4136306</td>
<td>BTKV50BTDSMC1251300</td>
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<td>2.88</td>
<td>—</td>
<td>13.00</td>
<td>13.00</td>
<td>12.74</td>
<td>11.50</td>
<td>11.50</td>
</tr>
</tbody>
</table>

NOTE: Do not overtighten lock screw.
Supplied with lock screw and drive keys.
Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38.
Lock screw wrench not included.
For retention knobs, see page L45.
BTKV50 Shank Tools
Shell Mill Adapters with Through Coolant

**ERICKSON**

- SMC Cap MM-BTKV Form B/AD

<table>
<thead>
<tr>
<th>order number</th>
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<th>D1</th>
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<th>D4</th>
<th>G1</th>
<th>L1</th>
<th>L1FC</th>
<th>lock screw</th>
<th>drive key</th>
<th>wrench size</th>
<th>lock screw kg</th>
</tr>
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<tbody>
<tr>
<td>3857069</td>
<td>BTKV50BSM2C16045M</td>
<td>16</td>
<td>38</td>
<td>5,0</td>
<td>43,5</td>
<td></td>
<td></td>
<td>MS1294</td>
<td>KDK16M</td>
<td>6mm</td>
<td>3,66</td>
</tr>
<tr>
<td>3857068</td>
<td>BTKV50BSMC16045M</td>
<td>16</td>
<td>44</td>
<td>5,0</td>
<td>43,5</td>
<td></td>
<td></td>
<td>MS1294</td>
<td>KDK16M</td>
<td>6mm</td>
<td>3,67</td>
</tr>
<tr>
<td>3857071</td>
<td>BTKV50BSM2C22045M</td>
<td>22</td>
<td>42</td>
<td>5,0</td>
<td>43,5</td>
<td></td>
<td></td>
<td>MS1234</td>
<td>—</td>
<td>8mm</td>
<td>3,66</td>
</tr>
<tr>
<td>3857070</td>
<td>BTKV50BSMC22045M</td>
<td>22</td>
<td>49</td>
<td>5,0</td>
<td>43,5</td>
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<td>MS1234</td>
<td>KDK22M</td>
<td>8mm</td>
<td>3,69</td>
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**SMC Lock MM-BTKV Form B/AD**

<table>
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<th>order number</th>
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<th>D2</th>
<th>D4</th>
<th>G1</th>
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<th>L1FC</th>
<th>lock screw</th>
<th>drive key</th>
<th>wrench size</th>
<th>lock screw kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>3857072</td>
<td>BTKV50BSM2C27045M</td>
<td>27</td>
<td>60</td>
<td>—</td>
<td>—</td>
<td>45,0</td>
<td>43,5</td>
<td>KLSS27M</td>
<td>KDK27M</td>
<td>10mm</td>
<td>3,80</td>
</tr>
<tr>
<td>3857093</td>
<td>BTKV50BSMC32045M</td>
<td>32</td>
<td>78</td>
<td>—</td>
<td>—</td>
<td>45,0</td>
<td>43,5</td>
<td>KLSS32M</td>
<td>KDK32M</td>
<td>14mm</td>
<td>4,01</td>
</tr>
<tr>
<td>3857094</td>
<td>BTKV50BSM40050M</td>
<td>40</td>
<td>89</td>
<td>66,7</td>
<td>50,0</td>
<td>48,5</td>
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<td>KLSS40M</td>
<td>KDK40M</td>
<td>17mm</td>
<td>4,46</td>
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<tr>
<td>3857095</td>
<td>BTKV50BSMC60090M</td>
<td>60</td>
<td>129</td>
<td>101,6</td>
<td>90,0</td>
<td>88,5</td>
<td></td>
<td>—</td>
<td>KDK60M</td>
<td>—</td>
<td>8,55</td>
</tr>
</tbody>
</table>

(continued)
L1FC = from flange face
L1 = from taper gage diameter

SMC Lock MM-BTKV Form B/AD

<table>
<thead>
<tr>
<th>order number</th>
<th>catalog number</th>
<th>D1</th>
<th>D2</th>
<th>L1</th>
<th>L1FC</th>
<th>lock screw</th>
<th>drive key</th>
<th>wrench size</th>
<th>lock screw</th>
<th>lbs</th>
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<tbody>
<tr>
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<td>1.46</td>
<td>2.00</td>
<td>1.941</td>
<td>KLS07</td>
<td>–</td>
<td>1/4</td>
<td>8.14</td>
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</tr>
<tr>
<td>3857096</td>
<td>BTKV50BSMC075200</td>
<td>3/4</td>
<td>1.75</td>
<td>2.00</td>
<td>1.941</td>
<td>KLS07</td>
<td>KDK05</td>
<td>1/4</td>
<td>8.25</td>
<td></td>
</tr>
<tr>
<td>3857099</td>
<td>BTKV50BSMC2100200</td>
<td>1</td>
<td>2.19</td>
<td>2.00</td>
<td>1.941</td>
<td>KLS10</td>
<td>KDK06</td>
<td>5/16</td>
<td>8.45</td>
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<td>BTKV50BSMC100200</td>
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<td>2.75</td>
<td>2.00</td>
<td>1.941</td>
<td>KLS10</td>
<td>KDK06</td>
<td>5/16</td>
<td>8.75</td>
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<td>3857100</td>
<td>BTKV50BSMC125200</td>
<td>1 1/4</td>
<td>2.88</td>
<td>2.00</td>
<td>1.941</td>
<td>KLS12</td>
<td>KDK08</td>
<td>5/16</td>
<td>9.05</td>
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<tr>
<td>3857101</td>
<td>BTKV50BSMC150200</td>
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<td>1.941</td>
<td>KLS15</td>
<td>KDK10</td>
<td>3/8</td>
<td>10.07</td>
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</table>

NOTE: Do not overtighten lock screw.
Supplied with lock screw and drive keys.
Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38.
Lock screw wrench not included.
For retention knob, see page L45.

SMC Lock IN-BTKV Form B/AD

<table>
<thead>
<tr>
<th>order number</th>
<th>catalog number</th>
<th>D1</th>
<th>D2</th>
<th>D4</th>
<th>G1</th>
<th>L1</th>
<th>L1FC</th>
<th>lock screw</th>
<th>drive key</th>
<th>wrench size</th>
<th>lock screw</th>
<th>lbs</th>
</tr>
</thead>
<tbody>
<tr>
<td>3857102</td>
<td>BTKV50BSMC200300</td>
<td>2</td>
<td>4.88</td>
<td>4.00</td>
<td>5/8-11 UNC</td>
<td>3.00</td>
<td>2.94</td>
<td>KLS20</td>
<td>KDK12</td>
<td>9/16</td>
<td>15.08</td>
<td></td>
</tr>
<tr>
<td>3857103</td>
<td>BTKV50BSMC250300</td>
<td>2 1/2</td>
<td>4.88</td>
<td>4.00</td>
<td>5/8-11 UNC</td>
<td>3.00</td>
<td>2.94</td>
<td>KLS25</td>
<td>KDK16</td>
<td>9/16</td>
<td>16.33</td>
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</tbody>
</table>
### BTKV50 Shank Tools

**KM™ Modular Adapters**

![Diagram showing BTKV50 Shank Tools](image)

**L1FC** = from flange face  
**L1** = from taper gage diameter

#### KM-BTKV Form B/AD

<table>
<thead>
<tr>
<th>Order Number</th>
<th>Catalog Number</th>
<th>System Size</th>
<th>D2</th>
<th>L1</th>
<th>L1FC</th>
<th>KM Spare Parts Package</th>
<th>Wrench Size</th>
<th>Actuation Screw</th>
<th>Nm</th>
<th>Kg</th>
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<tr>
<td>3815301</td>
<td>BTKV50BKM32060M</td>
<td>KM32</td>
<td>32</td>
<td>60</td>
<td>58.5</td>
<td>KM32PKG3S</td>
<td>5mm</td>
<td>8-11</td>
<td>3.63</td>
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<tr>
<td>3815302</td>
<td>BTKV50BKM32090M</td>
<td>KM32</td>
<td>32</td>
<td>90</td>
<td>88.5</td>
<td>KM32PKG3S</td>
<td>5mm</td>
<td>8-11</td>
<td>3.78</td>
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</tr>
<tr>
<td>3815333</td>
<td>BTKV50BKM40065M</td>
<td>KM40</td>
<td>40</td>
<td>65</td>
<td>63.5</td>
<td>KM40PKG3S</td>
<td>6mm</td>
<td>12-16</td>
<td>3.72</td>
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</tr>
<tr>
<td>3815334</td>
<td>BTKV50BKM40100M</td>
<td>KM40</td>
<td>40</td>
<td>100</td>
<td>98.5</td>
<td>KM40PKG3S</td>
<td>6mm</td>
<td>12-16</td>
<td>4.01</td>
<td></td>
</tr>
<tr>
<td>3815335</td>
<td>BTKV50BKM50070M</td>
<td>KM50</td>
<td>50</td>
<td>70</td>
<td>68.5</td>
<td>KM50PKG3S</td>
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<td>27-34</td>
<td>3.86</td>
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<td>BTKV50BKM50120M</td>
<td>KM50</td>
<td>50</td>
<td>120</td>
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<td>4.54</td>
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<td>KM63</td>
<td>63</td>
<td>80</td>
<td>78.5</td>
<td>KM63PKG3S</td>
<td>12mm</td>
<td>47-54</td>
<td>4.22</td>
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<tr>
<td>3815338</td>
<td>BTKV50BKM63140M</td>
<td>KM63</td>
<td>63</td>
<td>140</td>
<td>138.5</td>
<td>KM63PKG3S</td>
<td>12mm</td>
<td>47-54</td>
<td>5.55</td>
<td></td>
</tr>
<tr>
<td>3815339</td>
<td>BTKV50BKM80090M</td>
<td>KM80</td>
<td>80</td>
<td>90</td>
<td>88.5</td>
<td>KM80PKG3S</td>
<td>14mm</td>
<td>79-85</td>
<td>5.00</td>
<td></td>
</tr>
</tbody>
</table>

**NOTE:** Do not overtorque actuation screw; use torque recommendations above. Supplied with KM actuation mechanism. For retention knobs, see page L45. These products are only available in the U.S., Canada, and Japan.

---

**Form AD**

| 40 | (2x) MS2221S | 2.5mm |
| 50 | (2x) MS1256S | 3mm  |

---

**Form B**
Machinable front 20–30 RW C.

L1FC = from flange face
L1 = from taper gage diameter

**ERICKSON**

- BB-BTKV Form B/AD

<table>
<thead>
<tr>
<th>order number</th>
<th>catalog number</th>
<th>D2</th>
<th>L1</th>
<th>L1FC</th>
<th>kg</th>
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<tbody>
<tr>
<td>3830226</td>
<td>BTKV50BB104350M</td>
<td>104</td>
<td>350</td>
<td>348.5</td>
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<td>BTKV50BB134250M</td>
<td>134</td>
<td>250</td>
<td>248.5</td>
<td>26.58</td>
</tr>
</tbody>
</table>

NOTE: For retention knobs, see page L45.
ERICKSON™ Taper Face Contact Shank Tooling System • CVKV40 Series

Primary Application
ERICKSON Taper Face CV Contact Taper Tooling is manufactured from premium materials and to the latest ANSI B5.50 specification standard. Controlled, increased flange thickness to the rear of the flange gains face contact between spindle and holder. The CVKV40 tools are prebalanced to a high specification that will perform effectively up to 20,000 RPM. For any applications higher than 20,000 RPM, Kennametal recommends that the complete toolholder assembly (toolholder, retention knobs, collets, hardware, and cutting tools) be balanced as one identity.

Features and Benefits

- ANSI B5.50 7/24 taper.
- Standard 5/8-11 drawbar thread.
- High axial repeatability due to face contact.
- High radial positioning due to controlled, tighter drive key widths.
- All tools set to form AD coolant specification. Many can be converted to form B style.
- Maximum 20,000 RPM.
- Maximum 100 bar (1,500 psi) coolant pressure.

Drive key slots are unequal depths. Detent hole identifies shallow drive key slot.
## How Do Catalog Numbers Work?

Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.

<table>
<thead>
<tr>
<th>CVKV</th>
<th>40</th>
<th>B</th>
<th>TG</th>
<th>100</th>
<th>M</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shank Style</td>
<td>Shank Taper Size</td>
<td>Special Feature (optional)</td>
<td>Toolholder Style</td>
<td>Tool Length</td>
<td>Identification Value</td>
</tr>
<tr>
<td>ANSI B5.50 Face Contact</td>
<td>40 = 40</td>
<td>B = DIN form B coolant feature, tool shipped to AD specification (design allows conversion to form B style)</td>
<td>HPV = High performance and balanceable</td>
<td>50 = 50</td>
<td>(Gage line on taper to front of tool)</td>
</tr>
<tr>
<td></td>
<td>50 = 50</td>
<td>(blank) = (no “B” or “Z”) — tool built to form A/AD coolant style</td>
<td>TD = Tunable</td>
<td></td>
<td>inch</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>xxx = x.xx</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>M = Tool built to metric values and has metric retention thread</td>
</tr>
</tbody>
</table>

- **BB** = Bar blank
- **EM** = End mill adapter
- **ER** = DIN 6499 single-angle collet chuck
- **KM** = KM™ adapter
- **SM2C** = Shell mill adapter with coolant and small diameter
- **SMC** = Shell mill adapter with coolant
- **TG** = Tremendous Grip single-angle collet chuck
- **TT** = Shrink Fit thermo toolholder
- **TTHT** = Shrink Fit thermo toolholder — high torque

**TG** = Collet series xx (50), xxx (100)

**EM** =
- I.D. size: metric — xx = xx, (20);
- inch — xxx = x.xx, (075)

**SM** =
- O.D. size: metric — xx = xx, (20);
- inch — xxx = x.xx, (075)
CVKV40 Shank Tools
Shrink Fit Toolholders General Purpose (GP)

- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide and HSS cutting tools (requirements below).

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TT GP HPV MM-CVKV Form B/AD

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## TT GP HPV IN-CVKV Form B/AD

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**NOTE:** Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.

*Shrink Fit technical section, see page M78.*

*Supplied with stop screw.*

*Adjusting stop screw gage, see page M81.*

*Optional M6–1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.*

*For retention knobs, see page L45.*

*For Shrink Fit machine and accessories, see pages L12–L13.*

---

**Cutting Tool Shank Requirements**

<table>
<thead>
<tr>
<th>inch</th>
<th>Shank diameters</th>
<th>Tolerance</th>
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<tr>
<td>3/4, 7/8, 1, &amp; 1-1/4</td>
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</table>

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www.kennametal.com
CVKV40 Shank Tools
Shrink Fit Toolholders High Torque (HT)

• 30–50% higher clamping torque compared to GP line.
• Balanceable — fine tune with optional M6 set screws.
• Suitable for carbide only, designated by groove in front face (requirements below).
• 10 kW power or greater Shrink Fit device must be used.

<table>
<thead>
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<th>catalog number</th>
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<th>D2</th>
<th>D21</th>
<th>L1</th>
<th>L1FC</th>
<th>L2</th>
<th>L9</th>
<th>V</th>
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(TT HT HPV CVKV Form B/AD continued)

**TT HT HPV IN-CVKV Form B/AD**

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**Cutting Tool Shank Requirements**

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**NOTE:** Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.

Shrink Fit technical section, see page M78.

Supplied with stop screw.

Adjusting stop screw gage, see page M81.

Optional M6–1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.

For retention knobs, see page L45.

For Shrink Fit machine and accessories, see pages L12–L13.
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CVKV40 Shank Tools
TG Single-Angle Collet Chucks

• Tremendous Grip (3:1 advantage).

Collet Capacity

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L1FC = from flange face
L1 = from taper gage diameter

ERICKSON

■ TG Round-CVKV Form B/AD

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NOTE: Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque. Collet chuck technical section, see page M98. Supplied with locknut and stop screw. Locknut wrench must be ordered separately. Interchangeable locknuts, coolant-style locknuts, and coolant disks are available and must be ordered separately; see pages L16–L17. Stop screw coolant caps are available and must be ordered separately; see pages L34–L36. Balanceable/interchangeable locknuts are available and must be ordered separately; see page L16. TG standard straight-bore collets, see page J10. TG tap collets, see page J10. For retention knobs, see page L45.
CVKV40 Shank Tools
ER Single-Angle Collet Chucks

- Grip (2:1 advantage).

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**ERICKSON**

- ER Hex-CVKV Form B/AD

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**Spare Parts**

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(continued)
## ER Round-CVKV Form B/AD

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### Spare Parts

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**NOTE:** Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque. Collet chuck technical section, see page M98. Supplied with locknut and stop screw. Locknut wrench must be ordered separately. ER standard straight-bore collets, see page J50. ER tap collets, see pages J58–J59. ER TCT tension-only tap collets, see page J60. For retention knobs, see page L45.
**CVKV40 Shank Tools**  
**End Mill Adapters**

---

**EM IN-CVKV Form B/AD**

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NOTE: Do not overtighten lock screw; use torque recommendations above.  
Supplied with lock screw.  
Lock screw wrench not included.  
For retention knobs, see page L46.
ERICKSON

SMC TD Lock IN-CVK Form B/AD

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<td>lock screw</td>
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NOTE: Do not overtighten lock screw.
Supplied with lock screw and drive keys.
Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38.
Lock screw wrench not included.
For retention knob, see page L46.
## CVKV40 Shank Tools

### Shell Mill Adapters with Through Coolant

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**ERICKSON**

- SMC TD Lock IN-CVKV Form B/AD

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**NOTE:**
- Do not overtighten lock screw; use torque recommendations above.
- Supplied with lock screw and drive keys.
- Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38.
- Lock screw wrench not included.
- For retention knobs, see page L45.

---

**Form AD**

**Form B**

---

KENNAMETAL

www.kennametal.com
**KM-CVKV Form B/AD**

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**NOTE:** Do not overtorque actuation screw; use torque recommendations above.

Supplied with KM actuation mechanism.

For retention knobs, see page L45.

**• Machinable front 20–30 RW C.**

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<tr>
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**NOTE:** For retention knobs, see page L45.
ERICKSON™ Taper Face Contact Shank Tooling System • CVKV50 Series

Primary Application
ERICKSON Taper Face CV Contact Taper Tooling is manufactured from premium materials and to the latest ANSI B5.50 specification standard. Controlled, increased flange thickness to the rear of the flange gains face contact between spindle and holder. The CVKV50 tools are prebalanced to a high specification that will perform effectively up to 20,000 RPM. For any applications higher than 20,000 RPM, Kennametal recommends that the complete toolholder assembly (toolholder, retention knobs, collets, hardware, and cutting tools) be balanced as one identity.
Features and Benefits

• ANSI B5.50 7/24 taper.
• Standard 1-8 drawbar thread.
• High axial repeatability due to face contact.
• High radial positioning due to controlled, tighter drive key widths.
• All tools set to form AD coolant specification. Many can be converted to form B style.
• Maximum 20,000 RPM.
• Maximum 100 bar (1,500 psi) coolant pressure.
**CVKV50 Shank Tools**

Shrink Fit Toolholders General Purpose (GP)

- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide and HSS cutting tools (requirements below).

---

**Cutting Tool Shank Requirements**

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<thead>
<tr>
<th>Shank Diameter</th>
<th>Tolerance</th>
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<td>12, 14, 16, &amp; 18</td>
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**CVKV50 Shank Tools**

- Shrink Fit Toolholders
- General Purpose (GP)
- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide and HSS cutting tools.

---

**ERICKSON**

**TT GP HPV MM-CVKV Form B/AD**

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<th>L9</th>
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<th>Wrench Size Stop Screw</th>
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## TT GP HPV IN-CVKV Form B/AD

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### Cutting Tool Shank Requirements

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<th>Tolerance</th>
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**NOTE:** Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.

- Shrink Fit technical section, see page M78.
- Supplied with stop screw.
- Adjusting stop screw gage, see page M81.
- Optional M6~1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.
- For retention knobs, see page L45.
- For Shrink Fit machine and accessories, see pages L12–L13.
CVKV50 Shank Tools
Shrink Fit Toolholders High Torque (HT)

- 30–50% higher clamping torque compared to GP line.
- Balanceable — fine tune with optional M6 set screws.
- Suitable for carbide only, designated by groove in front face (requirements below).
- 10 kW power or greater Shrink Fit device must be used.

**Cutting Tool Shank Requirements**

<table>
<thead>
<tr>
<th>cutting tool shank diameter</th>
<th>tolerance</th>
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<tbody>
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**ERICKSON**

- TT HT HPV MM-CVKV Form B/AD

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## TT HT HPV IN-CVKV Form B/AD

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**NOTE:** Do not overheat. Overheating will destroy the accuracy and functionality of the toolholder.

- Shrink Fit technical section, see page M78.
- Supplied with stop screw.
- Adjusting stop screw gage, see page M81.
- Optional M6-1.0P x 5mm lg fine-balancing screw set (10 pieces) is available. Order number is MS1276PKG and must be ordered separately.
- For retention knobs, see page L45.
- For Shrink Fit machine and accessories, see pages L12–L13.
**CVKV50 Shank Tools**

**TG Single-Angle Collet Chucks**

**NOTE:** Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque. Collet chuck technical section, see page M98. Supplied with locknut and stop screw. Locknut wrench must be ordered separately. Interchangeable locknuts, coolant-style locknuts, and coolant disks are available and must be ordered separately; see pages L16–L17. Stop screw coolant caps are available and must be ordered separately; see pages L34–L35. Balanceable/interchangeable locknuts are available and must be ordered separately; see page L16. TG standard straight-bore collets, see page J10. TG tap collets, see page J10. For retention knobs, see page L45.

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**ERICKSON**

- **TG Round-CVKV Form B/AD**
The **SPEED** to **EXCEED**

**Solid Carbide Taps**

The Kennametal Solid Carbide Taps deliver the accuracy you demand at up to four times the speed of HSS taps. Longer tool life, exceptional thread quality, and an array of sizes for ferrous and non-ferrous materials make our taps the most trusted and productive tools in the industry.

- Reduce your operating costs by up to 65%.
- Workpiece-specific grades: KC7542™ for steels and cast irons, KC7512™ for aluminum.
- Go 4x faster with 4x the service life of conventional HSS offerings.
- Wide array of styles and sizes for through or blind hole applications.

Tap into something great at your Authorized Kennametal Distributor or at [www.kennametal.com](http://www.kennametal.com).
CVKV50 Shank Tools
ER Single-Angle Collet Chucks

- Grip (2:1 advantage).

![Diagram of ER single-angle collet chuck]

L1FC = from flange face
L1 = from taper gage diameter

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**ERICKSON**

- **ER Hex-CVKV Form B/AD**

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(ER CVK Form B/AD continued)

**CVKV50 Shank Tools**
**ER Single-Angle Collet Chucks**

**Note:** Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque.

Collet chuck technical section, see page M98.

Supplied with locknut and stop screw.

ER standard straight-bore collets, see page J50.

ER tap collets, see pages J58–J59.

ER TCT tension-only tap collets, see page J60.

For retention knobs, see page L45.

### ER Round-CVKV Form B/AD

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**Note:** Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque.

Collet chuck technical section, see page M98.

Supplied with locknut and stop screw.

ER standard straight-bore collets, see page J50.

ER tap collets, see pages J58–J59.

ER TCT tension-only tap collets, see page J60.

For retention knobs, see page L45.
More than just the right tool • the ultimate solution.

That’s Beyond BLAST.™
That’s Different Thinking.

At Kennametal, innovation follows vision. Our revolutionary products and services are inspired by asking “what if?” The solutions that follow — like our Beyond BLAST through-coolant inserts — deliver remarkable results in the world’s most demanding machining environments.

A cutting-edge insert that delivers coolant precisely at the cutting edge. Now that’s Different Thinking. That’s Kennametal.

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Milling

- Beyond BLAST technology uses low-pressure conditions to offer many of the high-pressure performance benefits.
- Delivers superior performance on titanium, using either high- or low-pressure coolant systems.
- Effective thermal management results in reduced cutting temperatures, improved lubricity, superior chip control, and longer tool life.
- Beyond BLAST for milling increases tool life by up to 300% compared with conventional coolant delivery systems.
### EM IN-CVKV Form B/AD

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**NOTE:** Do not overtighten lock screw; use torque recommendations above.
- Supplied with lock screw.
- Lock screw wrench not included.
- For retention knobs, see page L45.
**CVKV50 Shank Tools**

Tunable Shell Mill Adapters with Through Coolant

---

**ERICKSON**

- **SMC TD Lock IN-CVKV Form B/AD**

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**NOTE:** Do not overtighten lock screw.

- Supplied with lock screw and drive keys.
- Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38.
- Lock screw wrench not included.
- For retention knobs, see page L45.
## CVKV50 Shank Tools

**Shell Mill Adapters with Through Coolant**

L1FC = from flange face
L1 = from taper gage diameter

### ERICKSON

- **SMC Lock IN-CVKV Form B/AD**

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**NOTE:** Do not overtighten lock screw.
- Supplied with lock screw and drive keys.
- Interchangeable coolant-style lock screws are available and must be ordered separately; see page L38.
- Lock screw wrench not included.
- For retention knobs, see page L45.
## CVKV50 Shank Tools

**KM™ Modular Adapters**

### KM-CVKV Form B/AD

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**NOTE:** Do not overtorque actuation screw; use torque recommendations above.

Supplied with KM actuation mechanism.

For retention knobs, see page L45.

These products are only available in the U.S., Canada, and Japan.
• Machinable front 20–30 RW C.

![Diagram of CVKV50 Shank Tools]

**ERICKSON**

- **BB-CVKV Form A**

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NOTE: For retention knobs, see page L45.