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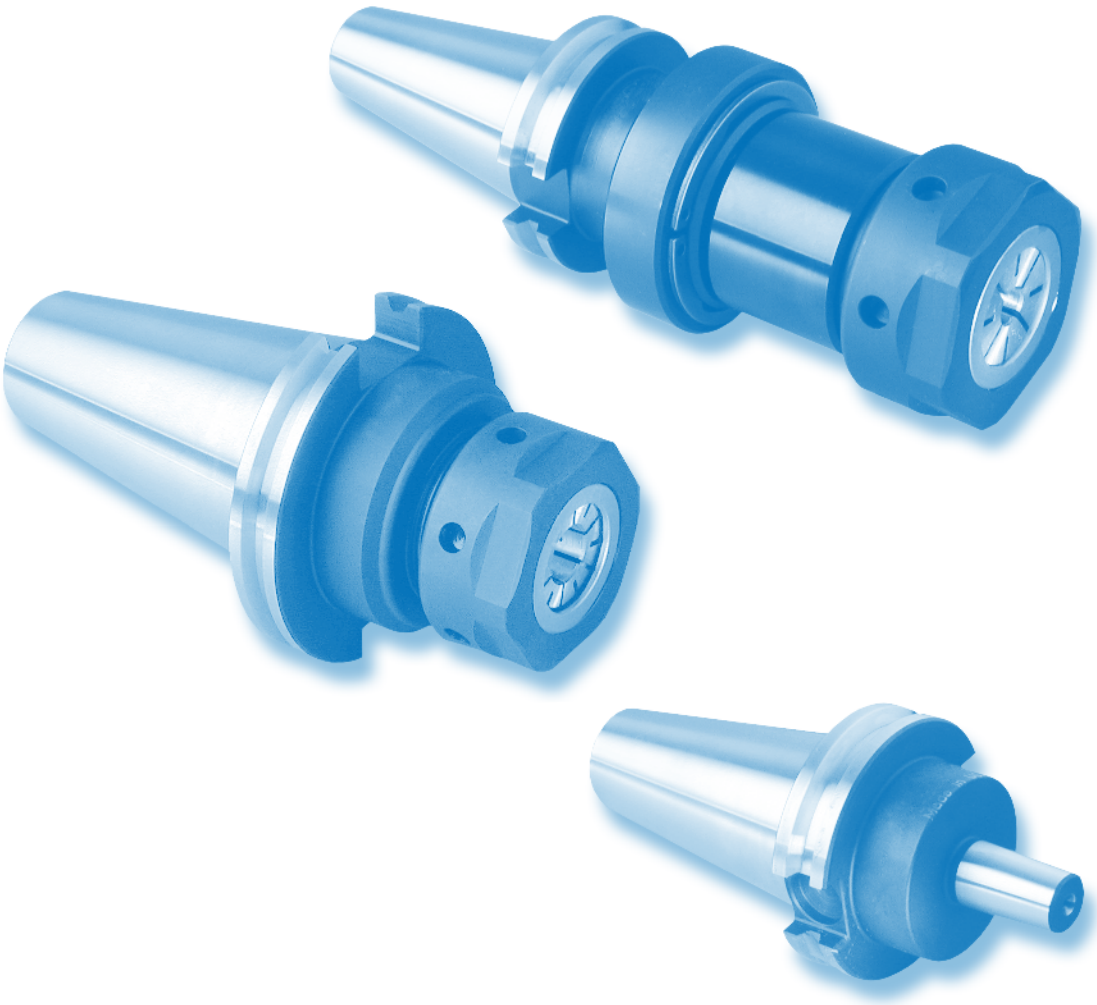
ValTRU™



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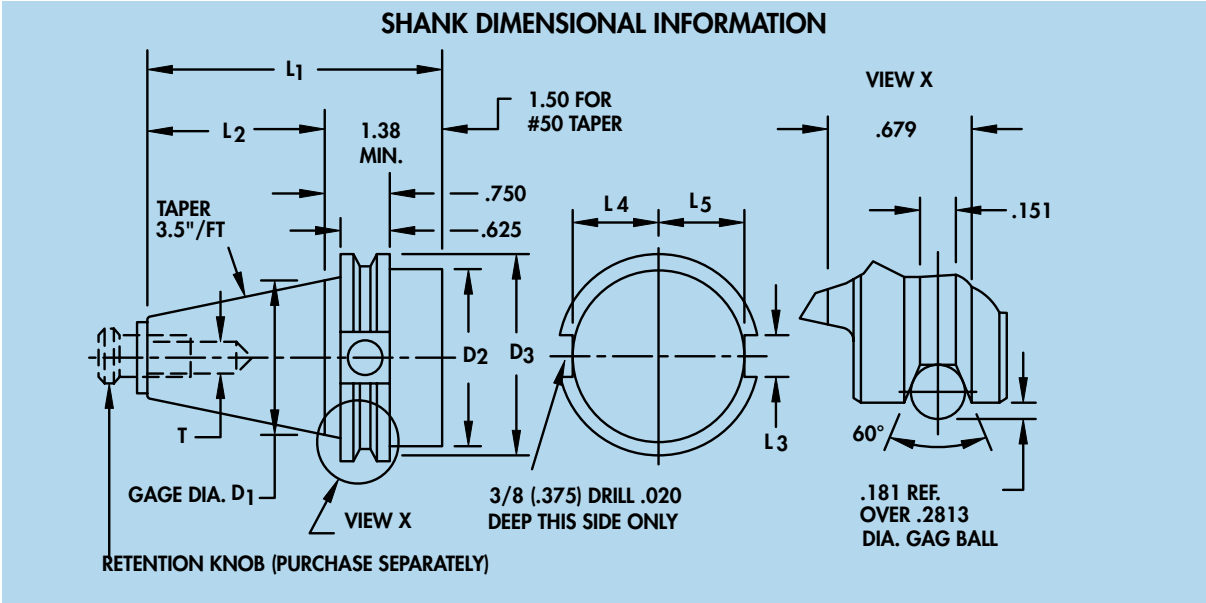
CAT "V" TAPER SHANK ADAPTERS



Taper	Dimensions								Thread
	D1	D2	D3	L1	L2	L3	L4	L5	
V30CT	1.250	1.25	1.812	3.250	1.875	.638	.735	.640	1/2 - 13
V40CT	1.750	1.75	2.500	4.062	2.687	.638	.985	.890	5/8 - 11
V45CT	2.250	2.25	3.250	4.625	3.250	.764	1.235	1.140	3/4 - 10
V50CT	2.750	2.75	3.875	5.375	4.000	1.016	1.485	1.390	1 - 8
V60CT	4.250	4.25	5.500	7.875	6.375	1.016	2.235	2.140	1 1/4 - 7

V30CT shanks are available upon request. Consult your local Valenite Sales Engineer for more details.

Balanced adapters
All Valenite adapters are design balanced for optimum tool life and machine performance.

Custom tool balancing:
Specify the suffix BAL after the Valenite Part Number for:
40 Taper adapters balanced to 20,000 RPM @ G2.5
50 Taper adapters balanced to 15,000 RPM @ G2.5

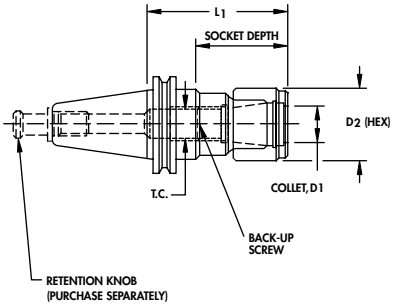
Specify the suffix FC after the Valenite Part Number for:
DIN style flange coolant and balance to G2.5

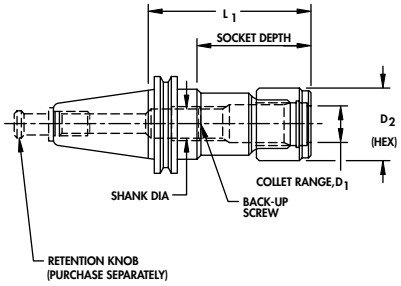
Check with your Valenite Distributor or representative for price and delivery.

WARNING:
Various retention knob styles are not necessarily interchangeable. To avoid the potential for injury, tooling damage or machine damage, always make sure the proper retention knob is used for a given adapter and according to machine specifications. Special care should be taken not to interchange metric and inch threaded retention knobs. Use of a metric threaded knob with a non-metric threaded adapter shank, or vice versa, could cause inadequate coupling of the adapter to the spindle during machining and a failure of the components. Always use machine guards, protective clothing and safety glasses to prevent burns or other injury to body or eyes from flying objects.

ValTRU™

CAT 'V' FLANGE TAPER SHANK ADAPTERS
COLLET CHUCKS





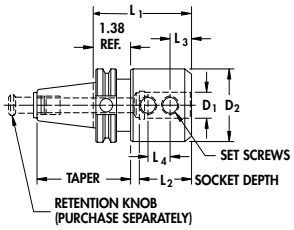
Part Number	Taper	Collet Series	Max. Shank Tool Slze	Dimensions		Shank Dia.	Max. Socket Depth	Wt. lbs	Torque ft-lbs	EDP#
				D2	L1					
V40CT SAC16 250	40	ER 16	0.375	1.10	2.500	0.394	2.430	1.7	36	**56770**
V40CT SAC16 295	40	ER 16	0.375	1.10	2.950	0.394	1.830	1.7	36	**56900**
V40CT SAC16 295BAL	40	ER 16	0.375	1.10	2.950	0.394	1.830	1.7	36	**62511**
V40CT SAC16 394A	40	ER 16	0.375	1.10	3.940	0.394	1.830	1.7	36	**56901**
V40CT SAC16 500	40	ER 16	0.375	1.10	5.000	0.394	2.000	1.7	36	**62608**
V40CT SAC20 300	40	ER 20	0.500	1 3/16 HEX	3.000	0.570	3.000	2.5	74	**62609**
V40CT SAC20 400	40	ER 20	0.500	1 3/16 HEX	4.000	0.570	4.000	2.9	74	**56771**
V40CT SAC20 600	40	ER 20	0.500	1 3/16 HEX	6.000	0.570	4.000	2.9	74	**62610**
V40CT SAC25 250	40	ER 25	0.625	1.67	2.500	0.710	2.500	3.3	95	**56903**
V40CT SAC25 250BAL	40	ER 25	0.625	1.67	2.500	0.710	2.500	3.3	95	**56772**
V40CT SAC25 400	40	ER 25	0.625	1.67	4.000	0.710	4.000	3.3	95	**56773**
V40CT SAC32 236	40	ER 32	0.750	1.97	2.360	0.787	2.670	2.0	85	**56904**
V40CT SAC32 236BAL	40	ER 32	0.750	1.97	2.360	0.787	2.670	2.0	85	**56774**
V40CT SAC32 300	40	ER 32	0.750	1.97	3.000	0.787	3.290	2.0	85	**56775**
V40CT SAC32 600	40	ER 32	0.750	1.97	6.000	0.787	4.000	2.0	85	**62611**
V40CT 20DA 30	40	VDA20	0.500	1.00	3.000	0.390	1.880	2.7	25	**56896**
V40CT 20DA 40	40	VDA20	0.500	1.00	4.000	0.390	2.880	3.0	25	**56897**
V40CT 18DA 30	40	VDA-18	0.750	1.5 HEX	3.000	0.760	8.750	3.2	45	**56893**
V40CT 18DA 40	40	VDA-18	0.750	1.5 HEX	4.000	0.760	3.750	3.5	45	**56894**
V40CT 10SG 30	40	VDF 10	1.000	2.50	2.690	0.750	3.190	3.0	60	**56891**
V40CT 10SG 30BAL	40	VDF 10	1.000	2.50	2.690	0.750	3.190	3.0	60	**57262**
V40CT 10SG 30FC	40	VDF 10	1.000	2.50	3.000	0.750	3.190	3.0	60	**56927**
V40CT 10SG 60	40	VDF 10	1.000	2.50	5.690	0.750	4.190	5.2	36	**56892**
V40CT 10SG 60BAL	40	VDF 10	1.000	2.50	5.690	0.750	4.190	5.2	36	**56780**
V40CT 15SG 488	40	VDF 15	1.500	3.25	4.880	1.500	4.210	7.7	75	**56781**
V50CT SAC16 394A	50	ER 16	0.375	1.10	3.940	0.394	1.830	7.94	36	**56916**
V50CT SAC16 394ABA	50	ER 16	0.375	1.10	3.940	0.394	1.830	7.94	36	**57264**
V50CT SAC32 394	50	ER 32	0.750	1.97	3.940	0.787	3.240	7.4	85	**56923**
V50CT SAC32 394BAL	50	ER 32	0.750	1.97	3.940	0.787	3.240	7.4	85	**56793**
V50CT SAC32 787	50	ER 32	0.750	1.97	7.870	0.787	3.240	10	85	**56925**
V50CT 10SG 35	50	VDF 10	1.000	2.50	3.190	1.000	4.940	7.6	60	**56907**
V50CT 10SG 35BAL	50	VDF 10	1.000	2.50	3.190	1.000	4.940	7.6	60	**62612**
V50CT 10SG 55	50	VDF 10	1.000	2.50	5.190	1.000	5.500	9.8	60	**55337**
V50CT 10SG 75	50	VDF 10	1.000	2.50	7.190	1.000	5.500	12.0	60	**56909**
V50CT 15SG 35	50	VDF 15	1.500	3.25	3.500	1.500	5.000	7.7	75	**56910**

5 digit EDP/Order Number indicates: stock standard Retention knobs are an option and must be ordered separately.
NOTE: To insure maximum grip on the cutting tool, adjust tool to proper length using a preset device,tighten collet to specified torque and them tighten the back screw against cutting tool shank.

FC= DIN Style Flange Coolant and Balance to G2.5
BAL= Balanced to : 40 Taper to 20,000 RPM @ G2.5
50 Taper to 15,000 RPM @ G2.5

CAT 'V' FLANGE TAPER SHANK ADAPTERS

END MILL ADAPTERS



Part Number	Taper	Dimensions						Set Screw ( ) No. Req'd	Torque FT/LB	Wt. lbs.	EDP#
		D1	D2	L1	L2	L3	L4				
V40CT E12 250	40	0.125	0.69	2.50	3.80	0.19	-	10-32 x 1/4 FPSS	3.0	2.7	**56935**
V40CT E12 250BAL	40	0.125	0.69	2.50	3.80	0.19	-	10-32 x 1/4 FPSS	3.0	2.7	**57263**
V40CT E18 300	40	0.188	0.75	3.00	4.25	0.50	-	1/4-28 x 1/4 WSS (1)	5.4	2.8	**56940**
V40CT E18 300BAL	40	0.188	0.75	3.00	4.25	0.50	-	1/4-28 x 1/4 WSS (1)	5.4	2.8	**56753**
V40CT E18 300FC	40	0.188	0.75	3.00	4.25	0.50	-	1/4-28 x 1/4 WSS (1)	5.4	2.8	**55364**
V40CT E18 600	40	0.188	1.00	6.00	3.80	0.44	-	10-32 x 1/4 FPSS	3.0	3.8	**56941**
V40CT E25 175	40	0.250	0.88	1.75	3.00	0.44	-	1/4-28 x 1/4 FPSS	5.4	2.8	**56754**
V40CT E25 300	40	0.250	0.81	3.00	4.25	0.59	-	1/4-28 x 1/4 WSS (1)	5.4	2.8	**56942**
V40CT E25 300BAL	40	0.250	0.81	3.00	4.25	0.59	-	1/4-28 x 1/4 WSS (1)	5.4	2.8	**56755**
V40CT E25 300FC	40	0.250	0.81	3.00	4.25	0.59	-	1/4-28 x 1/4 WSS (1)	5.4	2.8	**55365**
V40CT E25 600	40	0.250	1.00	6.00	3.80	0.44	-	1/4-28 x 1/4 FPSS	5.4	3.8	**55366**
V40CT E31 300	40	0.312	1.00	3.00	4.25	0.60	-	5/16-24 x 5/16 FPSS (1)	10.4	3.0	**56943**
V40CT E31 300BAL	40	0.312	1.00	3.00	4.25	0.60	-	5/16-24 x 5/16 FPSS (1)	10.4	3.0	**56756**
V40CT E31 600	40	0.312	1.00	6.00	3.80	0.44	-	1/4-28 x 1/4 FPSS	10.4	3.7	**56944**
V40CT E37 175	40	0.375	1.00	1.75	3.00	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	2.3	**56758**
V40CT E37	40	0.375	1.38	2.50	3.88	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	2.7	**56945**
V40CT E37 FC	40	0.375	1.38	2.50	3.88	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	2.7	**56947**
V40CT E37 BAL	40	0.375	1.38	2.50	3.88	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	2.7	**56757**
V40CT E37 500	40	0.375	1.38	5.00	3.50	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	3.8	**56946**
V40CT E37 500 BAL	40	0.375	1.38	5.00	3.50	0.75	-	3/8-24 x5/16 WSS (1)	16.7	3.8	**56759**
V40CT E37 600	40	0.375	1.00	6.00	3.80	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	3.7	**56760**
V40CT E43 262	40	0.437	1.25	2.62	3.80	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	2.7	**56948**
V40CT E43 262 BAL	40	0.437	1.25	2.62	3.80	0.75	-	3/8-24 x 5/16 WSS (1)	16.7	2.7	**56761**
V40CT E50 175	40	0.500	1.75	1.75	1.50	0.88	-	7/16-20 x 3/8 WSS (1)	25.0	1.4	**56950**
V40CT E50175BAL	40	0.500	1.75	1.75	1.50	0.88	-	7/16-20 x 3/8 WSS (1)	25.0	1.4	**56765**
V40CT E50175FC	40	0.500	1.75	1.75	1.50	0.88	-	7/16-20 x 3/8 WSS (1)	25.0	1.4	**56951**
V40CT E50	40	0.500	1.38	2.62	3.88	0.88	-	7/16-20 x 3/8 WSS	25.0	2.7	**56949**
V40CT E50 BAL	40	0.500	1.38	2.62	3.88	0.88	-	7/16-20 x 3/8 WSS	25.0	2.7	**56762**
V40CT E50 FC	40	0.500	1.38	2.62	3.88	0.88	-	7/16-20 x 3/8 WSS	25	2.7	**56953**
V40CT E50 500	40	0.500	1.38	5.00	3.50	0.88	-	7/16-20 x 3/8 WSS (1)	25	3.8	**56952**
V40CT E50 500BAL	40	0.500	1.38	5.00	3.50	0.88	-	7/16-20 x 3/8 WSS (1)	25	3.8	**56766**
V40CT E50 600	40	0.500	1.25	6.00	3.12	0.88	-	7/16-20 x 3/8 WSS	25	4	**56764**
V40CT E56 262	40	0.562	1.50	2.62	3.00	0.88	-	7/16-20 x 3/8 WSS	25	3.1	**56954**
V40CT E62 175	40	0.625	1.75	1.75	2.00	0.94	-	9/16-18 x 1/2 WSS (1)	45	2	**56956**
V40CT E62 175BAL	40	0.625	1.75	1.75	2.00	0.94	-	9/16-18 x 1/2 WSS (1)	45	2	**56768**
V40CT E62	40	0.625	1.62	3.75	3.50	0.94	-	9/16-18 x 1/2 WSS (1)	45	3.1	**56955**
V40CT E62 500	40	0.625	1.62	3.75	3.50	0.94	-	9/16-18 x 1/2 WSS (1)	45	3.1	**56958**
V40CT E75 175	40	0.750	1.75	1.75	2.25	1.00	-	5/8-18 x 1/2 WSS (1)	110	1.9	**56961**
V40CT E75 175BAL	40	0.750	1.75	1.75	2.25	1.00	-	5/8-18 x 1/2 WSS (1)	110	1.9	**61049**
V40CT E75 175FC	40	0.750	1.75	1.75	2.25	1.00	-	5/8-18 x 1/2 WSS (1)	110	1.9	**56962**
V40CT E75	40	0.750	2.00	3.75	3.88	1.00	-	5/8-18 x 1/2 WSS (1)	110	3.6	**56960**
V40CT E75 BAL	40	0.750	2.00	3.75	3.88	1.00		5/8-18 x 1/2 WSS (1)	110	3.6	**56769**
V40CT E75 FC	40	0.750	2.00	3.75	3.88	1.00		5/8-18 x 1/2 WSS (1)	110	3.6	**55367**
V40CT E75 550	40	0.750	2.00	3.75	3.88	1.00		5/8-18 x 1/2 WSS (1)	110	3.6	**56963**
V40CT E87	40	0.875	2.00	4.00	4.18	1.00	0.81	5/8-18 x 1/2 WSS (2)	110	3.6	**56964**
V40CT E25MM 400	40	25	2.00	4.00	3.00	1.12	1.00	3/4-16 x 1/2 WSS (2)	90	4.5	**57014**

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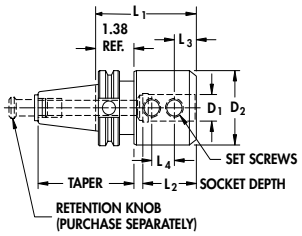


CAT 'V' FLANGE TAPER SHANK ADAPTERS

END MILL ADAPTERS

CONTINUED FROM PREVIOUS PAGE

Part Number	Taper	Dimensions						Set Screw ( ) No. Req'd	Torque FT/LB	Wt. lbs.	EDP#
		D1	D2	L1	L2	L3	L4				
V40CT E100 162	40	1.000	1.75	1.62	2.50	1.12		5/8-18 x 1/2 WSS (1)	110	2.7	**56931**
V40CT E100 162 BAL	40	1.000	1.75	1.62	2.50	1.12		5/8-18 x 1/2 WSS (1)	110	2.7	**61045**
V40CT E100 162 FC	40	1.000	1.75	1.62	2.50	1.12		5/8-18 x 1/2 WSS (1)	110	2.7	**56932**
V40CT E100	40	1.000	2.50	4.25	2.50	1.12	1.00	3/4-16 x 11/16 WSS (2)	150	5.3	**56930**
V40CT E100 BAL	40	1.000	2.50	4.25	2.50	1.12	1.00	3/4-16 x 11/16 WSS (2)	150	5.3	**56751**
V40CT E100 FC	40	1.000	2.50	4.25	2.50	1.12	1.00	3/4-16 x 11/16 WSS (2)	150	5.3	**56934**
V40CT E100 600	40	1.000	2.00	6.00	4.50	1.12	1.00	3/4-16 x 1/2 WSS (2)	90	5.7	**56933**
V40CT E125 200	40	1.250	2.50	2.00	2.50	1.12		3/4-16 x 11/16 WSS (1)	110	2	**56937**
V40CT E125 200 BAL	40	1.250	2.50	2.00	2.50	1.12		3/4-16 x 11/16 WSS (1)	110	2	**56752**
V40CT E125	40	1.250	2.50	4.25	3.00	1.12	1.00	3/4-l 6 x 11/16 WSS (2)	150	4.9	**56936**
V40CT E125 638	40	1.250	2.50	4.25	3.00	1.12	1.00	3/4-l 6 x 11/16 WSS (2)	150	4.9	**56938**
V40CT E32MM 400	40	32	2.50	4.00	2.60	1.12	1.00	3/4-16 x 5/8 WSS (2)	120	5.5	**57015**
V40CT E150 400	40	1.500	2.62	4.00	2.38	1.12	1.00	3/4-16 x 5/8 WSS (2)	120	5.5	**56939**
V50CT E25 250	50	0.250	0.88	2.50	3.00	0.44		1/4-28 X 1/4 FPSS	5.4	6	**56785**
V50CT E37	50	0.375	1.50	3.00	5.25	0.75		3/8-24 x 5/16 WSS (1)	16.7	7	**56998**
V50CT E37L	50	0.375	1.50	3.00	5.25	0.75		3/8-24 x 5/16 WSS (1)	16.7	7	**56999**
V50CT E37 800	50	0.375	1.00	8.00	3.00	0.75		3/8-24 x 5/16 WSS (1)	16.7	9	**56786**
V50CT E50	50	0.500	1.50	3.00	5.25	0.88		7/16-20 x 3/8 WSS (1)	25	7.1	**57000**
V50CT E50 L	50	0.500	1.50	6.00	5.75	0.88		7/16-20 x 3/8 WSS (1)	25	8.1	**57002**
V50CT E50 662	50	0.500	1.25	6.62	3.00	0.88		7/16-20 x 3/8 WSS	25	8	**56787**
V50CT E50 800	50	0.500	1.25	8.00	3.00	0.88		7/16-20 x 3/8 WSS	25	8	**56788**
V50CT E62	50	0.625	2.00	3.00	5.25	0.94		9/16-18 x 1/2 WSS (1)	45	7.6	**57003**
V50CT E62 L	50	0.625	2.00	3.00	5.25	0.94		9/16-18 x 1/2 WSS (1)	45	7.6	**57004**
V50CT E62 775	50	0.625	1.50	7.75	3.50	0.94		9/16-18 x 7/16 WSS (1)	40	8	**56789**
V50CT E75 S	50	0.750	2.50	4.00	6.25	1.00		5/8-18 x 1/2 WSS (1)	110	9.7	**57008**
V50CT E75	50	0.750	2.50	4.00	6.25	1.00		5/8-18 x 1/2 WSS (1)	110	9.7	**57005**
V50CT E75 BAL	50	0.750	2.50	4.00	6.25	1.00		5/8-18 x 1/2 WSS (1)	110	9.7	**56790**
V50CT E75 L	50	0.750	2.50	6.50	5.75	1.00		5/8-18 x 1/2 WSS (1)	110	12.5	**57007**
V50CT E75 775	50	0.750	2.50	4.00	6.25	1.00		5/8-18 x 1/2 WSS (1)	110	9.7	**61108**
V50CT E87	50	0.875	1.88	7.75	4.19	1.00	0.81	5/8-1 8 x 1/2 WSS (2)	90	12	**57009**
V50CT E87 775	50	0.875	1.88	7.75	4.19	1.00	0.81	5/8-1 8 x 1/2 WSS (2)	90	12	**56792**
V50CT E25MM 400	50	25	2.00	4.00	3.00	1.12	1.00	3/4-16 x 1/2 WSS (2)	90	8	**57027**
V50CT E100S	50	1.000	2.75	2.62	3.00	1.12		3/4-16 x 11/16 WSS (1)	150	7.7	**56986**
V50CT E100	50	1.000	2.50	4.00	4.44	1.12	1.00	3/4-16 x 11/16 WSS (2)	150	9.5	**56983**
V50CT E100 BAL	50	1.000	2.50	4.00	4.44	1.12	1.00	3/4-16 x 11/16 WSS (2)	150	9.5	**56782**
V50CT E100 FC	50	1.000	2.50	4.00	4.44	1.12	1.00	3/4-16 x 11/16 WSS (2)	150	9.5	**56984**
V50CT E100 600	50	1.000	2.00	6.00	4.44	1.12	1.00	3/4-16 X 1/2 WSS (2)	90	10	**56783**
V50CT E100 800	50	1.000	2.00	8.00	3.00	1.12	1.00	3/4-16 X 1/2 WSS (2)	90	12	**56784**
V50CT E125 S	50	1.250	2.75	2.62	3.50	1.12		3/4-16 x 11/16 WSS (1)	150	7.3	**56990**
V50CT 125	50	1.250	2.50	4.00	3.50	1.12	1.00	3/4-1 6 X 11/16 WSS (2)	150	9	**56987**
V50CT E125 L	50	1.250	2.50	7.00	3.50	1.12	1.00	3/4-16 x 11/16 WSS (2)	150	13.6	**56989**
V50CT E150 200	50	1.500	2.75	2.00	3.38	1.50		3/4-16 x 11/16 WSS (1)	150	8.5	**56992**
V50CT E150	50	1.500	2.75	4.62	4.50	1.50	1.00	3/4-16 X 11/16 WSS (2)	150	10.9	**56991**
V50CT E150-600	50	1.500	2.75	6.00	4.50	1.12	1.00	3/4-1 6 x 11/16 WSS (2)	150	13.1	**56993**
V50CT E200	50	2.000	3.75	5.25	3.90	1.38	1.12	1-14 x 7/8 WSS (2)	283	15.4	**56994**
V50CT E200 A	50	2.000	3.75	5.25	3.90	1.38	1.12	1-14 x 7/8 WSS (2)	283	15.4	**56995**
V50CT E250 650	50	2.000	3.75	5.25	3.90	1.38	1.12	1-14 x 7/8 WSS (2)	283	15.4	**56996**
V50CT E250 A 650®	50	2.500	4.25	6.50	4.12	1.53	1.56	1-14 x 7/8 WSS (2)	283	19.9	**56997**

Notes: 5 digit EDP/Order Number indicates: stock standard
- These tools do not accept double end end mills.
- Adapters are supplied complete with set screw(s), less retention knobs and hex wrench.
- Retention knobs are an option and must be ordered separately.
- Heavy Duty Adapter: do not have the 2.75 D_2 DIA. groove in front of flange adapters are supplied complete with set screw(s), less retention knobs and hex wrench.
- FC= DIN Style Flange Coolant and Balance to G2.5
- BAL= Balanced to : 40 Taper to 20,000 RPM @ G2.5
  50 Taper to 15,000 RPM @ G2.5

CAT 'V' FLANGE TAPER SHANK ADAPTERS

SHELL MILL MOUNT ADAPTERS

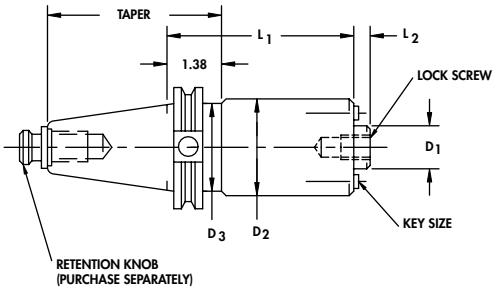


Figure 1

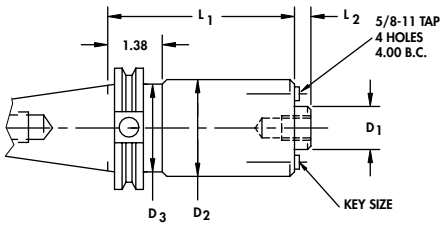


Figure 2

Part Number	Taper	Dimensions					Key Size	Lock Screw ( ) No. Req'd	Torque ft-lb	Wt. lbs.	EDP#
		D1	D2	D3	L1	L2					
V40CT S75 20	40	0.75	2.00	1.75	2.00	0.69	5/16	3/8-24 x 1SHCS	45	2.9	**57021**
V40CT S75 20BAL	40	.075	2.00	1.75	2.00	0.69	5/16	3/8-24 x 1SHCS	45	2.9	**56779**
V40CT S100 20	40	1.00	2.38	1.75	2.00	0.69	3/8	1/2-20 x 1 1/4 SHCS	110	3.2	**57016**
V40CT S100 20 BAL	40	1.00	2.38	1.75	2.00	0.69	3/8	1/2-20 x 1 1/4 SHCS	110	3.2	**62782**
V40CT S125 22	40	1.25	2.88	1.75	2.25	0.69	1/2	5/8-18 x 1 1/4 SHCS	208	4.2	**57018**
V40CT S150 24	40	1.50	3.80	1.75	2.40	0.94	5/8	#5005 UNIV SCR	208	7	**57020**
V50CT S75 20	50	0.75	2.00	2.75	2.00	0.69	5/16	3/8-24 x1SHCS	45	7.3	**57046**
V50CT S100 20	50	1.00	2.75	2.75	2.00	0.69	3/8	1/2-20 x 1 1/4 SHCS	110	7.9	**57030**
V50CT S100 40	50	1.00	2.75	2.75	4.00	0.69	3/8	1/2-20 x 1 1/4 SHCS	110	11.2	**57031**
V50CT S100 40 BAL	50	1.00	2.75	2.75	4.00	0.69	3/8	1/2-20 x 1 1/4 SHCS	110	11.2	**62783**
V50CT S125 22	50	1.25	2.88	2.75	2.25	0.69	1/2	5/8-18 x 1 1/4 SHCS	208	9.3	**57034**
V50CT S125 575	50	1.25	2.88	2.75	5.75	".69	1/2	5/8-18 x 1 1/4 SHCS	208	14.1	**57037**
V50CT S150 24	50	1.50	3.80	2.75	2.4	0.94	5/8	#5005 UNIV SCR	208	10.8	**57039**
V50CT S150 24 BAL	50	1.50	3.80	2.75	2.4	0.94	5/8	#5005 UNIV SCR			**62784**
V50CT S150 40	50	1.50	3.80	2.75	4.00	0.94	5/8	#5005 UNIV SCR	208	15	**57041**
V50CT S150 575	50	1.50	3.80	2.75	5.75	0.94	5/8	#5005 UNIV SCR	208	21.6	**56960**
V50CT S150 775	50	1.50	3.80	2.75	7.75	0.94	5/8	#5005 UNIV SCR	208	29.1	**56964**
V50CT S200 23	50	2.00	4.38	2.75	2.312	0.94	3/4	#5006 UNIV SCR	366	12.1	**56931**
V50CT S250 24	50	2.50	5.00	2.75	2.4	1.12	1	-	-	13.9	**57045**

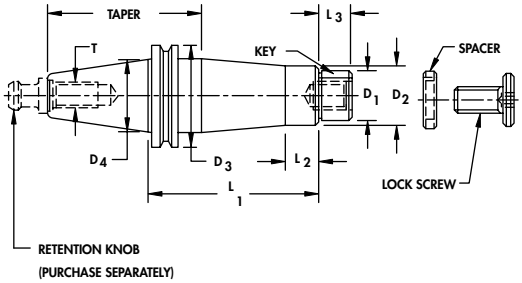
5 digit EDP/Order Number indicates: stock standard
- Figure 1 adapters are supplied complete with lock screw, less retention knob.
- Figure 2 adapters are supplied complete, less mounting screws and retention knob.•
- Retention knobs are an option and must be ordered separately.

FC= DIN Style Flange Coolant and Balance to G2.5
BAL=Balanced to :40 Taper to 20,000 RPM @G2.5
50 Taper to 15,000 RPM @G2.5

ValTRU™

CAT 'V' FLANGE TAPER SHANK ADAPTERS

STUB (STYLE "B") ARBOR ADAPTERS



Part Number	Taper	Dimensions							Thread	Wt. lbs.	EDP#
		D1	D2	D3	D4	L1	L2	L3			
V40CT B100 400	#40	1.000	1.75	2.50	1.750	4.00	2.62	.715	5/8-11	5.0	**57050**
V40CT B125 400	#40	1.250	1.75	2.50	1.750	4.00	2.62	.715	5/8-11	5.0	**57051**
V40CT B150 400	#40	1.500	2.12	2.50	1.750	4.00	1.50	.975	5/8-1 1	6.3	**57052**
V50CT B100 500	#50	1.000	1.50	3.88	2.750	5.00	1.20	7.15	1"- 8	12.8	**57053**
V50CT B125 600	#50	1.250	1.75	3.88	2.750	6.00	1.50	.715	1"- 8	12.8	**57054**
V50CT B150 600	#50	1.500	2.12	3.88	2.750	6.00	1.50	.975	1"- 8	14.5	**57055**
V50CT B200 600	#50	2.000	2.75	3.88	2.750	6.00		3.00	1"- 8	16.1	**50206**

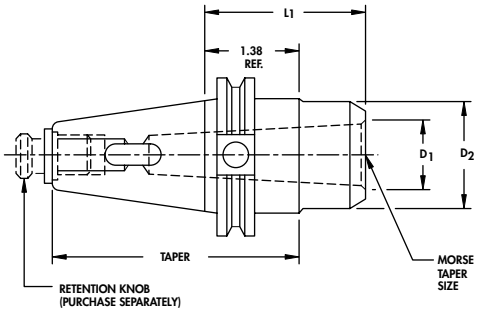
Complete with spacers

Spare Parts

Part Number	Lock Screw		Spacer		Key		Torque ft-lb
	Part#	EDP#	Part#	EDP#	Part#	EDP#	
V40CT B100 400 V50CT B100 500	#5003 UNIV SCR	**55403**	PT-566 1/8	**55455**	PT-569	•	110
			PT-566 1/4	**55454**			
			PT-566 3/8	**55456**			
V40CT B125 400 V50CT B125 600	#5004 UNIV SCR	**55402**	PT-518 1/4	**55448**	PT-516	**56479**	110
			PT-518 3/8	**55449**			
V40CT B150 400 V50CT B150 600	#5005 UNIV SCR	**55403**	PT-519 1/8	**55452**	PT-517	**56480**	208
			PT-519 1/4	**55451**			
			PT-519 1/2	**55450**			
V50CT B200 600	#5006 UNIV SCR	**55404**	PT-1241 1/8	•	PT1240	•	250
			PT-1242 3/8	•			
			PT-1243 3/4	•			

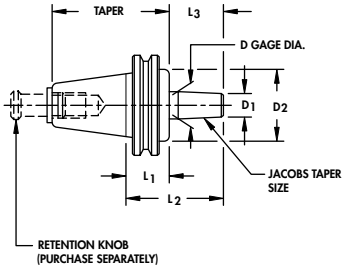
5 digit EDP/Order Number indicates: stock standard Retention knobs are an option and must be ordered separately.
Comes with spacers, lock screw & key.
• Denotes non-stock standard

CAT 'V' FLANGE TAPER SHANK ADAPTERS
MORSE TAPER ADAPTERS



Part Number	Taper	Morse Taper Size	Dimensions			Wt. lbs.	EDP#
			D1	D2	L1		
V40CT-2M	#40	2	.700	1.75	2.38	2.5	**57057**
V40CT-3M	#40	3	.938	1.75	2.50	2.3	**57058**
V40CT-4M	#40	4	1.231	2.25	3.50	3.0	**57059**
V50CT-2M	#50	2	.700	1.62	2.00	7.0	**57062**
V50CT-3M	#50	3	.938	1.62	2.50	6.6	**57063**
V50CT-4M	#50	4	1.231	2.00	3.38	6.8	**57064**
V50CT-5M	#50	5	1.748	2.75	4.62	10.3	**57065**

CAT 'V' FLANGE TAPER SHANK ADAPTERS
JACOBS INTEGRAL TAPER ADAPTERS



Part Number	Taper	Jacobs Taper Size	Dimensions						Wt. lbs.	EDP#
			D	D1	D2	L1	L2	L3		
V40CT-JT2-243	#40	2	.559	.488	1.75	1.562	2.437	1.06	2.3	**57070**
V40CT-JT3-278	#40	3	.811	.740	1.75	1.562	2.781	1.44	3.0	**57071**
V40CT-JT33-256	#40	33	.624	.561	1.75	1.562	2.562	1.22	2.3	**57072**
V50CT-JT3-281	#50	3	.811	.740	2.75	1.594	2.812	1.44	7.5	**57074**
V50CT-JT33-259	#50	33	.624	.561	2.75	1.594	2.594	1.22	6.8	**57075**

CAT 'V' FLANGE TAPER SHANK ADAPTERS
INTEGRAL SHANK DRILL CHUCK

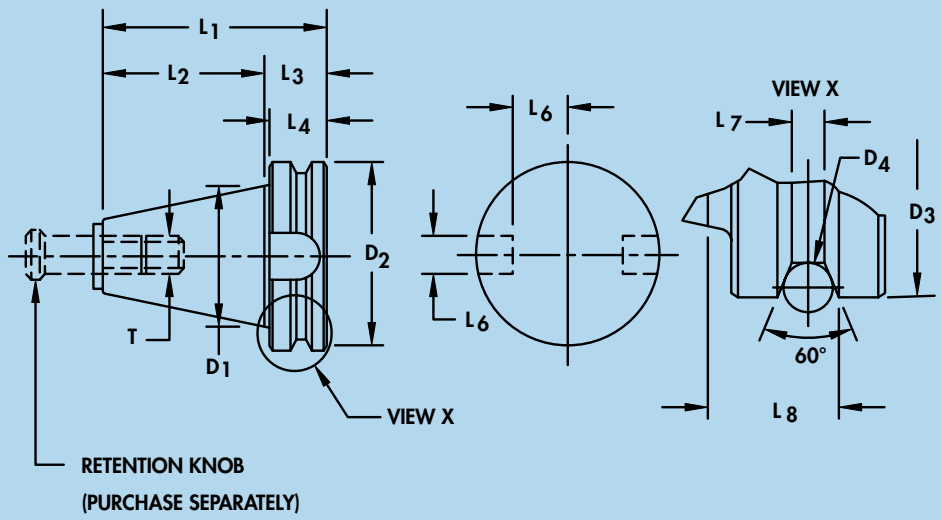
No Photo Available

Part Number	Taper	Chuck Size	Nose Diameter	gage Length	Weight. lbs.	EDP#
V40CT50DC400	#40	.500	1.97	2.17	2.3	**62509**
V50CT50DC400	#50	.500	1.97	2.96	6.6	**62510**

ValTRU™

BT TAPER SHANK ADAPTERS

SHANK DIMENSIONAL INFORMATION

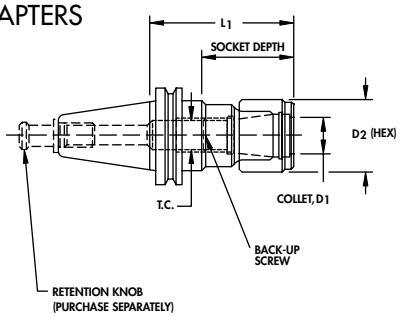


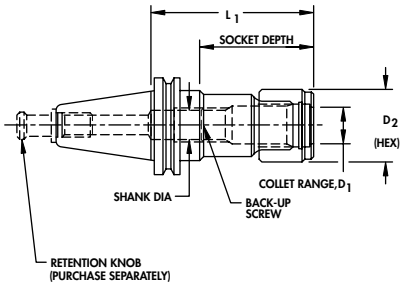
Taper	Dimensions													Retention Knob
	D1	D2	D3	D4	T	L1	L2	L3	L4	L5	L6	L7	L8	
BT30	1.250	1.811	2.210	.3125	M12x l.75	1)2.772	1.906	.866	.787	.646	.637	.157	.693	Retention knobs are an option and must be ordered seperately.
BT35	1.500	2.085	2.336	.3125	M12x 1.75	2)3.168	2.224	.945	.866	.756	.555	.197	.668	
BT40	1.750	2.479	2.731	.3125	M16x2.0	3)3.637	2.575	1.062	.984	.886	.637	.197	.810	
BT45	2.250	3.345	3.650	.3750	M20x2.5	4.559	3.260	1.299	1.181	1.141	.764	.236	1.022	
BT50	2.750	3.937	4.410	.5000	M24 x 3.0	4)5.504	4.008	1.496	1.378	1.390	1.016	.276	1.163	

Notes
1. This dimension is 2.862 when tooling has a larger diameter than D2
2. This dimension is 3.208 when tooling has a larger diameter than D2
3. This dimension is 3.911 when tooling has a larger diameter than D2
4. This dimension is 6.291 when tooling has a larger diameter than D2

WARNING:
Various retention knob styles are not necessarily interchangeable. To avoid the potential for injury, tooling damage or machine damage, always make sure the proper retention knob is used for a given adapter and according to machine specifications. Special care should be taken not to interchange metric and inch threaded retention knobs. Use of a metric threaded knob with a non-metric threaded adapter shank, or vice versa, could cause inadequate coupling of the adapter to the spindle during machining and a failure of the components. Always use machine guards, protective clothing and safety glasses to prevent burns or other injury to body or eyes from flying objects.

BT TAPER SHANK ADAPTERS
COLLET CHUCK ADAPTERS

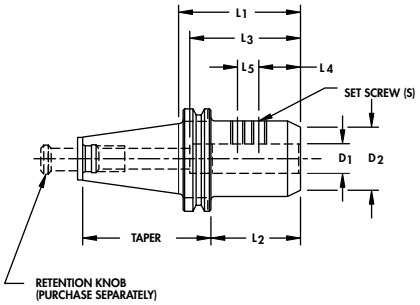




Part Number	Taper	Collet Series	Dimensions			Shank Dia.	Max. Socket Dia.	Min. Socket Dia.	Wt. lbs.	Torque Ft-lb	EDP#
			D1	D2	L1						
BT40 SAC16 075	40	VSAC-16 VCFC-16	.020 - .393 .157 - .393	1.10	2.95	0.394	1.25	1.83	1.7	36	**57085**
BT40 SAC16 100A	40	VSAC-16 VCFC-16	.020 - .393 .157 - .393	1.10	3.94	0.394	1.25	1.83	2.58	36	**57086**
BT40 SAC16 100ABAL	40	VSAC-16 VCFC-16	.020 - .393 .157 - .393	1.10	3.94	0.394	1.25	1.83	2.58	36	**56567**
BT40 SAC32 060	40	VSAC-32 VCFC-32	.078 - .787 .157 - .787	1.97	2.36	0.787	1.81	2.67	1.9	85	**57087**
BT40 SAC32 060BAL	40										**56568**
BT40 20DA 100	40	VDA-20	.062 - .375	1.0 HEX	3.94	0.39	1.62	2.88	2.7	25	**57084**
BT40 18DA 100	40	VDA-18	.062 - .750	1.5 HEX	3.94	0.76	1.68	3.75	3.3	45	**57083**
BT40 10SG 070	40	VDF-IO VCSC-IO VDFNP-10	.094 - 1.000 .172 - 1.000 .375 - 1.000	2.5	2.45	0.87	2.56	2.96	3.6	60	**57082**

NOTE: To insure maximum grip on the cutting tool, adjust tool to proper length using a preset device, tighten collet to specified torque and then tighten the back up screw against cutting tool shank. 5 digit EDP/Order Number indicates: stock standard Retention knobs are an option and must be ordered separately.Non coolant type back up screw supplied.

BT TAPER SHANK ADAPTERS
END MILL ADAPTERS

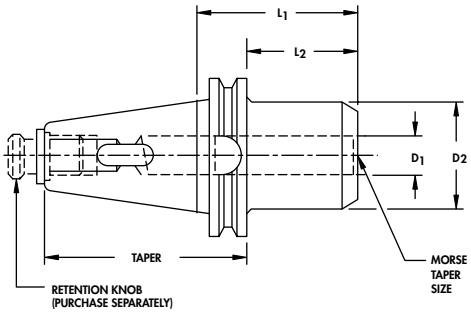


Part Number	Taper	Dimensions						Wt. lbs.	Torque Ft-lb	EDP#
		D1	D2	L1	L2	L3	L4			
BT40 E12225	40	0.125	0.69	2.25	1.13	3.00	0.38	2.8	3.0	**56551**
BT40 E12225BAL	40	0.125	0.69	2.25	1.13	3.00	0.38	2.8	3.0	**56552**
BT40 E1 8225	40	0.188	0.69	2.25	1.13	3.00	0.38	2.8	5.4	**56554**
BT40 E1 8225BAL	40	0.188	0.69	2.25	1.13	3.00	0.38	2.8	5.4	**56555**
BT40 E25225	40	0.250	0.88	2.25	1.13	3.00	0.38	2.8	5.4	**56556**
BT40 E31225	40	0.312	1.00	2.25	1.13	3.00	0.44	2.8	5.4	**56561**
BT40 E37225	40	0.375	1.00	2.25	1.13	3.00	0.75	3.0	16.7	**56562**
BT40 E37225BAL	40	0.375	1.00	2.25	1.13	3.00	0.75	3.0	16.7	**56563**
BT40 E50175	40	0.500	1.75	1.75	0.69	3.00	0.88	3.0	25.0	**57120**
BT40 E50225	40	0.500	1.25	2.25	1.12	3.00	0.88	3.0	25.0	**56564**
BT40 E50225BAL	40	0.500	1.25	2.25	1.12	3.00	0.88	3.0	25.0	**56565**
BT40 E62175	40	0.625	1.50	1.75	0.69	2.00	0.94	1.9	45.0	**57122**
BT40 E75175	40	0.750	1.75	1.75	0.69	2.25	1.00	1.9	110.0	**57124**
BT40 E75338	40	0.750	1.75	3.38	2.26	3.35	1.00	3.8	110.0	**56566**
BT40 E100175	40	1.000	2.00	1.75	0.69	2.38	1.12	1.7	110.0	**57114**
BT40 E100400	40	1.000	2.00	4.00	2.88	4.50	1.12	5.6	110.0	**57112**
BT40 E125200	40	1.250	2.25	2.00	0.88	2.38	1.12	2.1	80.0	**56553**
BT40 E125400	40	1.250	2.50	4.00	2.88	3.35	1.12	5.6	150.0	**61126**

BAL= Balanced to : 40 Taper to 20,000 RPM @ G2.5
50 Taper to 15,000 RPM @ G2.5

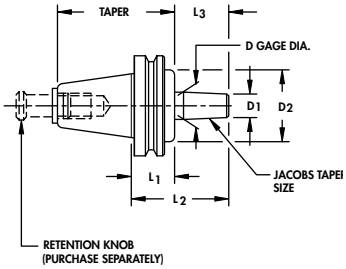
ValTRU™

BT TAPER SHANK ADAPTERS
MORSE TAPER ADAPTERS



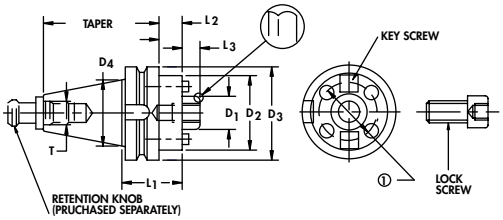
Part Number	Taper	Morse Taper Size	Dimensions				Thread	Wt. lbs.	EDP#
			D1	D2	L1	L2			
BT40-1M-045	40	1	.475	1.75	1.77	.71	M16	2.1	**57161**
BT40-2M-050	40	2	.700	1.26	1.98	.91	M16	2.3	**57162**
BT40-3M-065	40	3	.938	1.57	2.56	1.50	M16	2.3	**57163**

BT TAPER SHANK ADAPTERS
JACOBS INTEGRAL TAPER ADAPTERS



Part Number	Taper	Jacobs Taper Size	Dimensions					Wt. lbs.	EDP#
			D	D1	L1	L2	L3		
BT40 JT33 228	40	33	0.624	0.561	1.18	1.12	1.18	2.6	**57171**

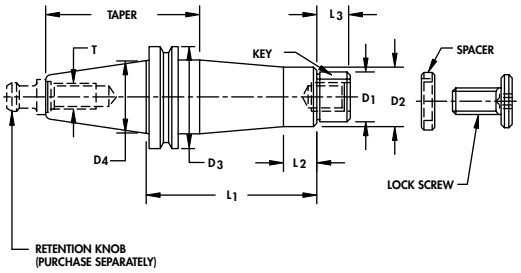
BT TAPER SHANK ADAPTERS
SHELL MILL ADAPTERS



Part Number	Taper	Dimensions							Thread	Key Size	Wt. lbs.	Torque Ft-lb	EDP#
		D1	D2	D3	D4	L1	L2	L3					
BT40-S75-240	40	0.75	2	2.48	1.75	2.4	1.34	0.69	M16	Vl6	3.1	45	**57151**
BT40-S100-240	40	1	2.38	2.48	1.75	2.4	1.34	0.69	M16	3/8	4.4	110	**57148**
BT40-S125-240	40	1.25	2.88	2.48	1.75	2.4	1.34	0.69	M16	'/2	5.4	208	**57149**
BT40-S150-240	40	1.5	3.8	2.48	1.75	2.4	1.34	0.94	M16	5/8	7.2	208	**57150**

5 digit EDP/Order Number indicates: stock standard Retention knobs are an option and must be ordered separately.
1) AC 334 3/8 Key requires drive key screw #8 32 x 3/8SHCS, (1) per key.

BT TAPER SHANK ADAPTERS
STUB (STYLE "B") ARBOR ADAPTERS



Part Number	Taper	Dimensions							Thread	Wt. lbs.	Torque Ft-lb	EDP#
		D1	D2	D3	D4	L1	L2	L3				
BT40-B100-400	40	1	1.75	2.48	1.75		4	0.72	Ml 6-2,0	5.2	110	**57158**

5 digit EDP/Order Number indicates: stock standard Non stock standard Retention knobs are an option and must be ordered separately.
Comes with spacers, lock screw & key.

COLLETS

VDA Double Angle	294
VDF Single Angle	295
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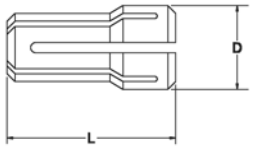
VCSC Single Angle	297
VDF Collet Sets	298
VDA Collet Sets	298
Collet Extensions	298
Collet Extensions & Kits	298-299

VDA DOUBLE ANGLE COLLETS

SERIES 18, 10, 20 & 25



Collet Series	Dimensions	
	D	L
VDA 18	1.025	1.639
VDA 10	.769	1.437
VDA 20	.539	1.187
VDA 30	.375	1.000

Internal Diameter		VDA 18 Series		VDA 10 Series		VDA 20 Series		VDA 30 Series	
Fraction	Decimal	Part Number	EDP#	Part Number	EDP#	Part Number	EDP#	Part Number	EDP#
3/64	0.0468							VDA 30 0047	**55854**
1/16	0.0625	VDA 18 0062	**55727**	VDA 10 0062	**55781**	VDA 20 0062	**55825**	VDA 30 0062	**55855**
5/64	0.0781	VDA 18 0078	**55728**	VDA 10 0078	**55782**	VDA 20 0078	**55826**	VDA 30 0078	**55856**
3/32	0.0937	VDA 18 0094	**55729**	VDA 10 0094	**55783**	VDA 20 0094	**55827**	VDA 30 0094	**55857**
7/64	0.1094	VDA 18 0109	**55730**	VDA 10 0109	**55784**	VDA 20 0109	**55828**	VDA 30 0109	**55858**
1/8	0.1250	VDA 18 0125	**55731**	VDA 10 0125	**55785**	VDA 20 0125	**55829**	VDA 30 0125	**55859**
9/64	0.1406	VDA 18 0141	**55732**	VDA 10 0141	**55786**	VDA 20 0141	**55830**	VDA 30 0141	**55860**
5/32	0.1562	VDA 18 0156	**55733**	VDA 10 0156	**55787**	VDA 20 0156	**55831**	VDA 30 0156	**55861**
11/64	0.1719	VDA 18 0172	**55734**	VDA 10 0172	**55788**	VDA 20 0172	**55832**	VDA 300172	**55862**
3/16	0.1875	VDA 18 0187	**55735**	VDA 10 0187	**55789**	VDA 20 0187	**55833**	VDA 30 0187	**55863**
13/64	0.2031	VDA 18 0203	**55736**	VDA 10 0203	**55790**	VDA 20 0203	**55834**	VDA 30 0203	**55864**
7/32	0.2138	VDA 18 0219	**55737**	VDA 10 0219	**55791**	VDA 20 0219	**55835**	VDA 30 0219	**55865**
15/64	0.2344	VDA 18 0234	**55738**	VDA 10 0234	**55792**	VDA 20 0234	**55836**	VDA 30 0234	**55866**
1/4	0.2500	VDA 18 0250	**55739**	VDA 10 0250	**55793**	VDA 20 0250	**55837**	VDA 30 0250	**55867**
17/64	0.2656	VDA 18 0266	**55740**	VDA 10 0266	**55794**	VDA 20 0266	**55838**	-	-
9/32	0.2812	VDA 18 0281	**55741**	VDA 10 0281	**55795**	VDA 20 0281	**55839**	-	-
19/64	0.2969	VDA 18 0297	**55742**	VDA 10 0297	**55796**	VDA 20 0297	**55840**	-	-
5/16	0.3125	VDA 18 0312	**55743**	VDA 10 0312	**55797**	VDA 20 0312	**55841**	-	-
21/64	0.3281	VDA 18 0328	**55744**	VDA 10 0328	**55798**	VDA 20 0328	**55842**	-	-
11/32	0.3438	VDA 18 0344	**55745**	VDA 10 0344	**55799**	VDA 20 0344	**55843**	-	-
23/64	0.3594	VDA 18 0359	**55746**	VDA 10 0359	**55800**	VDA 20 0359	**55844**	-	-
3/8	0.3750	VDA 18 0375	**55747**	VDA 10 0375	**55801**	VDA 20 0375	**55845**	-	-
25/64	0.3906	VDA 18 0391	**55748**	VDA 10 0391	**55802**	-	-	-	-
13/32	0.4062	VDA 18 0406	**55749**	VDA 10 0406	**55803**	-	-	-	-
27/64	0.4219	VDA 18 0422	**55750**	VDA 10 0422	**55804**	-	-	-	-
7/16	0.4375	VDA 18 0437	**55751**	VDA 10 0437	**55805**	-	-	-	-
29/64	0.4531	VDA 18 0453	**55752**	VDA 10 0453	**55806**	-	-	-	-
15/32	0.4688	VDA 18 0469	**55753**	VDA 10 0469	**55807**	-	-	-	-
31/64	0.4844	VDA 18 0484	**55754**	VDA 10 0484	**55808**	-	-	-	-
1/2	0.5000	VDA 18 0500	**55755**	VDA 10 0500	**55809**	-	-	-	-
33/64	0.5156	VDA 18 0516	**55756**	VDA 10 0516	**55810**	-	-	-	-
17/32	0.4312	VDA 18 0531	**55757**	VDA 10 0531	**55811**	-	-	-	-
35/64	0.5469	VDA 18 0547	**55758**	VDA 10 0547	**55812**	-	-	-	-
9/16	0.5625	VDA 18 0562	**55759**	VDA 10 0562	**55813**	-	-	-	-
37/64	0.5731	VDA 18 0578	**55760**	-	-	-	-	-	-
19/32	0.5938	VDA 18 0594	**55761**	-	-	-	-	-	-
39/64	0.6094	VDA 18 0609	**55762**	-	-	-	-	-	-
5/8	0.6250	VDA 18 0625	**55763**	-	-	-	-	-	-
41/64	0.6406	VDA 18 0641	**55764**	-	-	-	-	-	-
21/32	0.6562	VDA 18 0656	**55765**	-	-	-	-	-	-
43/64	0.6719	VDA 18 0672	**55766**	-	-	-	-	-	-
11/16	0.6875	VDA 18 0688	**55767**	-	-	-	-	-	-
45/64	0.7031	VDA 18 0703	**55768**	-	-	-	-	-	-
23/32	0.7188	VDA 18 0719	**55769**	-	-	-	-	-	-
47/64	0.7344	VDA 18 0734	**55770**	-	-	-	-	-	-
3/4	0.7500	VDA 18 0750	**55771**	-	-	-	-	-	-

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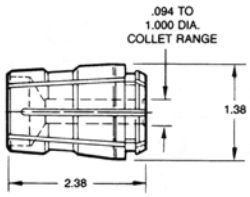
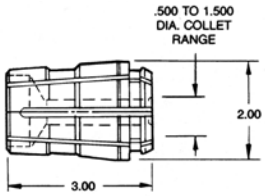
VDF SINGLE ANGLE COLLETS
(TE STYLE)



SERIES 10



SERIES 15

Series 10

Internal Diameter		VDF 10 SERIES COLLET		Internal Diameter		VDF 10 SERIES COLLET	
Fraction	Decimal	Part Number	EDP#	Fraction	Decimal	Part Number	EDP#
3/32	0.094	VDF 10 0094	**55874**	9/16	0.563	VDF 10 0562	**55904**
7/64	0.109	VDF 10 0109	**55875**	37/64	0.578	VDF 10 0578	**55905**
1/8	0.125	VDF 10 0125	**55876**	19/32	0.594	VDF 10 0594	**55906**
9/64	0.141	VDF 10 0141	**55877**	39/64	0.609	VDF 10 0609	**55907**
5/32	0.156	VDF 10 0156	**55878**	5/8	0.625	VDF 10 0625	**55908**
11/64	0.172	VDF 10 0172	**55879**	41/64	0.641	VDF 10 0641	**55909**
3/16	0.188	VDF 10 0187	**55880**	21/32	0.656	VDF 10 0656	**55910**
13/64	0.203	VDF 10 0203	**55881**	43/64	0.672	VDF 10 0672	**55911**
7/32	0.219	VDF 10 0219	**55882**	11/16	0.688	VDF 10 0688	**55912**
15/64	0.234	VDF 10 0234	**55883**	45/64	0.703	VDF 10 0703	**55913**
1/4	0.250	VDF 10 0250	**55884**	23/32	0.719	VDF 10 0719	**55914**
17/64	0.266	VDF 10 0266	**55885**	47/64	0.734	VDF 10 0734	**55915**
9/32	0.281	VDF 10 0281	**55886**	3/4	0.750	VDF 10 0750	**55916**
19/64	0.297	VDF 10 0297	**55887**	49/64	0.766	VDF 10 0765	**55917**
5/16	0.313	VDF 10 0312	**55888**	25/32	0.781	VDF 10 0781	**55918**
21/64	0.328	VDF 10 0328	**55889**	51/64	0.797	VDF 10 0796	**55919**
11/32	0.344	VDF 10 0344	**55890**	13/16	0.813	VDF 10 0812	**55920**
23/64	0.359	VDF 10 0359	**55891**	53/64	0.828	VDF 10 0828	**55921**
3/8	0.375	VDF 10 0375	**55892**	27/32	0.844	VDF 10 0843	**55922**
25/64	0.391	VDF 10 0391	**55893**	55/64	0.859	VDF 10 0859	**55923**
13/32	0.406	VDF 10 0406	**55894**	7/8	0.875	VDF 10 0875	**55924**
27/64	0.422	VDF 10 0422	**55895**	57/64	0.891	VDF 10 0890	**55925**
7/16	0.438	VDF 10 0437	**55896**	29/32	0.906	VDF 10 0906	**55926**
29/64	0.453	VDF 10 0453	**55897**	59/64	0.922	VDF 10 0921	**55927**
15/32	0.469	VDF 10 0469	**55898**	15/16	0.938	VDF 10 0937	**55928**
31/64	0.484	VDF 10 0484	**55899**	61/64	0.953	VDF 10 0953	**55929**
1/2	0.500	VDF 10 0500	**55900**	31/32	0.969	VDF 10 0968	**55930**
33/64	0.516	VDF 10 0516	**55901**	63/64	0.984	VDF 10 0984	**55931**
17/32	0.531	VDF 10 0531	**55902**	1	1.0000	VDF 10 1000	**55932**
35/64	0.547	VDF 10 0547	**55903**				

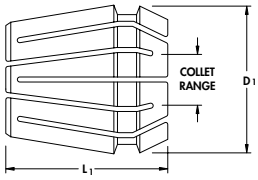
Series 15

• Denotes non-stock standard

Internal Diameter		VDF 15 SERIES COLLET		Internal Diameter		VDF 15 SERIES COLLET	
Fraction	Decimal	Part Number	EDP#	Fraction	Decimal	Part Number	EDP#
1/2	0.500	VDF 15 0500	**55952**	13/16	0.813	VDF 15 0812	•
33/64	0.516	VDF 15 0516	•	53/64	0.828	VDF 15 0828	•
17/32	0.531	VDF 15 0531	•	27/32	0.844	VDF 15 0843	•
35/64	0.547	VDF 15 0547	•	55/64	0.859	VDF 15 0859	•
9/16	0.563	VDF 15 0562	•	7/8	0.875	VDF 15 0875	•
37/64	0.578	VDF 15 0578	•	57/64	0.891	VDF 15 0890	•
19/32	0.594	VDF 15 0594	•	29/32	0.906	VDF 15 0906	•
39/64	0.609	VDF 15 0609	•	59/64	0.922	VDF 15 0921	•
5/8	0.625	VDF 15 0625	**55953**	15/16	0.938	VDF 15 0937	•
41/64	0.641	VDF 15 0641	•	61/64	0.953	VDF 15 0953	•
21/32	0.656	VDF 15 0656	•	31/32	0.969	VDF 15 0968	•
43/64	0.672	VDF 15 0672	•	63/64	0.984	VDF 15 0984	**55957**
11/16	0.688	VDF 15 0688	•	1	1.0000	VDF 15 1000	**55958**
45/64	0.703	VDF 15 0703	•	1 1/8	1.125	VDF 15 1125	**55960**
23/32	0.719	VDF 15 0719	•	1 15/64	1.234	VDF 15 1234	**55976**
47/64	0.734	VDF 15 0734	•	1 1/4	1.250	VDF 15 1250	**55963**
3/4	0.750	VDF 15 0750	•	1 5/16	1.312	VDF 15 1312	**55964**
49/64	0.766	VDF 15 0765	•	1 3/8	1.375	VDF 15 1375	**55965**
25/32	0.781	VDF 15 0781	•	1 1/2	1.500	VDF 15 1500	**55967**
51/64	0.797	VDF 15 0796	•				

VSAC SINGLE ANGLE COLLETS

INCH & METRIC
(ER STYLE)



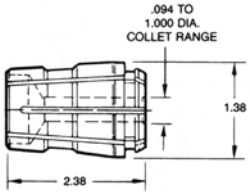
INCH Series 11, 16, 20, 25 & 32

Internal Diameter		VSAC 32 Series		VSAC 25 Series		VSAC 20 Series		VSAC 16 Series		VSAC 11 Series	
Fraction	Decimal	Part Number	EDP#	Part Number	EDP#	Part Number	EDP#	Part Number	EDP#	Part Number	EDP#
1/16	0.0625	NA	**NA**	NA	**NA**	NA	**NA**	VSAC 16 062	**56678**	VSAC 11 062	**56670**
3/32	0.0937	VSAC 32 093	**56726**	VSAC 25 093	**56705**	VSAC 20 093	**56691**	VSAC 16 093	**56679**	VSAC 11 093	**56671**
1/8	0.1250	VSAC 32 125	**56855**	VSAC 25 125	**56706**	VSAC 20 125	**56692**	VSAC 16 125	**56680**	VSAC 11 125	**56672**
5/32	0.1562	VSAC 32 156	**56728**	VSAC 25 156	**56707**	VSAC 20 156	**56693**	VSAC 16 156	**56853**	VSAC 11 156	**56673**
3/16	0.1875	VSAC 32 188	**56730**	VSAC 25 188	**56709**	VSAC 20 188	**56694**	VSAC 16 188	**56682**	VSAC 11 188	**56674**
7/32	0.2188	VSAC 32 218	**56731**	VSAC 25 218	**56710**	VSAC 20 218	**56695**	VSAC 16 219	**56683**	VSAC 11 219	**56676**
1/4	0.2500	VSAC 32 250	**56732**	VSAC 25 250	**56711**	VSAC 20 250	**56696**	VSAC 16 250	**56684**	VSAC 11 250	**56677**
9/32	0.2812	VSAC 32 281	**56734**	VSAC 25 281	**56712**	VSAC 20 281	**56697**	VSAC 16 281	**56685**	-	-
5/16	0.3125	VSAC 32 312	**56735**	VSAC 25 312	**56713**	VSAC 20 312	**56698**	VSAC 16 312	**56686**	-	-
11/32	0.3438	VSAC 32 343	**56736**	VSAC 25 343	**56714**	VSAC 20 343	**56699**	VSAC 16 343	**56688**	-	-
3/8	0.3750	VSAC 32 375	**56737**	VSAC 25 375	**56715**	VSAC 20 375	**56700**	VSAC 16 375	**56689**	-	-
13/32	0.4062	VSAC 32 406	**56738**	VSAC 25 406	**56718**	VSAC 20 406	**56701**	-	-	-	-
7/16	0.4375	VSAC 32 437	**56739**	VSAC 25 437	**56719**	VSAC 20 437	**56702**	-	-	-	-
15/32	0.4688	VSAC 32 468	**56740**	VSAC 25 468	**56720**	VSAC 20 468	**56703**	-	-	-	-
1/2	0.5000	VSAC 32 500	**56741**	VSAC 25 500	**56721**	VSAC 20 500	**56704**	-	-	-	-
17/32	0.5312	VSAC 32 531	**56742**	VSAC 25 531	**56722**	-	-	-	-	-	-
9/16	0.5625	VSAC 32 562	**56743**	VSAC 25 562	**56723**	-	-	-	-	-	-
19/32	0.5938	VSAC 32 593	**56744**	VSAC 25 593	**56724**	-	-	-	-	-	-
5/8	0.6250	VSAC 32 625	**56858**	VSAC 25 625	**56725**	-	-	-	-	-	-
21/32	0.6562	VSAC 32 656	**56745**	-	-	-	-	-	-	-	-
11/16	0.6875	VSAC 32 687	**56746**	-	-	-	-	-	-	-	-
23/32	0.7188	VSAC 32 718	**56747**	-	-	-	-	-	-	-	-
3/4	0.7500	VSAC 32 750	**56748**	-	-	-	-	-	-	-	-

METRIC Series 32 & 16

Range		Metric VSAC 32 Series		Metric VSAC 16 Series	
Metric	Inch	Part Number	EDP#	Part Number	EDP#
0.5 - 1	.019 - .039"	-	-	VSAC 16 01	**55984**
1 - 2	.039 - .079	-	-	VSAC 16 12	**55985**
2 - 3	.079 - .118	VSAC 32 23	**56004**	VSAC 16 23	**55986**
3 - 4	.118 - .157	VSAC 32 34	**56005**	VSAC 16 34	**55987**
4 - 5	.157 - .197	VSAC 32 45	**56006**	VSAC 16 45	**55988**
5 - 6	.197 - .236	VSAC 32 56	**56007**	VSAC 16 56	**55989**
6 - 7	.236 - .276	VSAC 32 67	**56008**	VSAC 16 67	**55990**
7 - 8	.276 - .315	VSAC 32 78	**56009**	VSAC 16 78	**55991**
8 - 9	.315 - .354	VSAC 32 89	**56010**	VSAC 16 89	**55992**
9 - 10	.354 - .394	VSAC 32 910	**56011**	VSAC 16 910	**55993**
10 - 11	.394 - .433	VSAC 32 1011	**55994**	-	-
11 - 12	.433 - .472	VSAC 32 1112	**55995**	-	-
12 - 13	.472 - .512	VSAC 32 1213	**55996**	-	-
13 - 14	.512 - .551	VSAC 32 1314	**55997**	-	-
14 - 15	.551 - .591	VSAC 32 1415	**55998**	-	-
15 - 16	.591 - .630	VSAC 32 1516	**55999**	-	-
16 - 17	.630 - .669	VSAC 32 1617	**56000**	-	-
17 - 18	.669 - .709	VSAC 32 1718	**56001**	-	-
18 - 19	.709 - .748	VSAC 32 1819	**56002**	-	-
19 - 20	.748 - .787	VSAC 32 1920	**56003**	-	-

ValTRU™

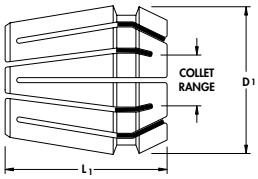


VCSC SINGLE ANGLE COLLETS

COOLANT SEALED (TG STYLE)
1,000 PSI Max.

Range		VCSC 10 Series	
Fraction	Decimal	Part Number	EDP#
3/16	0.1875	VCSC 10 0187 ES	**56584**
13/64	0.2031	VCSC 10 0203 ES	**56585**
7/32	0.2188	VCSC 10 0219 ES	**56586**
15/64	0.2344	VCSC 10 0234 ES	**56587**
1/4	0.2500	VCSC 10 0250 ES	**56588**
17/64	0.2656	VCSC 10 0266 ES	**56589**
9/32	0.2812	VCSC 10 0281 ES	**56590**
19/64	0.2969	VCSC 10 0297 ES	**56591**
5/16	0.3125	VCSC 10 0312 ES	**56592**
21/64	0.3281	VCSC 10 0328 ES	**56593**
11/32	0.3438	VCSC 10 0344 ES	**56597**
23/64	0.3594	VCSC 10 0359 ES	**56598**
3/8	0.3750	VCSC 10 0375 ES	**56599**
25/64	0.3906	VCSC 10 0391 ES	**56600**
13/32	0.4062	VCSC 10 0406 ES	**56601**
27/64	0.4219	VCSC 10 0422 ES	**56602**
7/16	0.4375	VCSC 10 0437 ES	**56603**
29/64	0.4531	VCSC 10 0453 ES	**56604**
15/32	0.4688	VCSC 10 0469 ES	**56605**
31/64	0.4844	VCSC 10 0484 ES	**56606**
1/2	0.5000	VCSC 10 0500 ES	**56607**
33/64	0.5156	VCSC 10 0516 ES	**56608**
17/32	0.5312	VCSC 10 0531 ES	**56609**
35/64	0.5469	VCSC 10 0547 ES	**56610**
9/16	0.5625	VCSC 10 0562 ES	**56611**
37/64	0.5781	VCSC 10 0578 ES	**56612**
19/32	0.5938	VCSC 10 0594 ES	**56613**

Internal Diameter		VCSC 10 Series	
Fraction	Decimal	Part Number	EDP#
39/64	0.6094	VCSC 10 0609 ES	-
5/8	0.6250	VCSC 10 0625 ES	**56614**
41/64	0.6406	VCSC 10 0641 ES	**56615**
21/32	0.6562	VCSC 10 0656 ES	**56616**
43/64	0.6719	VCSC 10 0672 ES	**56617**
11/16	0.6875	VCSC 10 0688 ES	**56618**
45/64	0.7031	VCSC 10 0703 ES	**56620**
23/32	0.7188	VCSC 10 0719 ES	**56621**
47/64	0.7344	VCSC 10 0734 ES	**56622**
3/4	0.7500	VCSC 10 0750 ES	**56623**
49/64	0.7656	VCSC 10 0765 ES	**56624**
25/32	0.7812	VCSC 10 0781 ES	**56625**
51/64	0.7969	VCSC 10 0796 ES	**56626**
13/16	0.8125	VCSC 10 0812 ES	**56627**
53/64	0.8281	VCSC 10 0828 ES	**56628**
27/32	0.8438	VCSC 10 0843 ES	**56629**
55/64	0.8594	VCSC 10 0859 ES	**56630**
7/8	0.8750	VCSC 10 0875 ES	**56631**
57/64	0.8906	VCSC 10 0890 ES	**56632**
29/32	0.9062	VCSC 10 0906 ES	**56633**
59/64	0.9219	VCSC 10 0921 ES	**56634**
15/16	0.9375	VCSC 10 0937 ES	**56635**
61/64	0.9531	VCSC 10 0953 ES	**56636**
31/32	0.9688	VCSC 10 0968 ES	**56637**
63/64	0.9844	VCSC 10 0984 ES	**56638**
1	1.0000	VCSC 10 1000 ES	**56639**



VSAC SINGLE ANGLE COLLETS

COOLANT SEALED SERIES 16, 20, 25 & 32
1,000 PSI Max. (ER STYLE)

Range		Metric VCFC 32 Series		Metric VCFC 25 Series		Metric VCFC 20 Series		Metric VCFC 16 Series	
Metric	Inch	Part Number	EDP#	Part Number	EDP#	Part Number	EDP#	Part Number	EDP#
3 - 4	.118 - .157	VCFC 32 34	**56359**	-	-	VCFC 20 34	**56373**	VCFC 16 34	**56342**
4 - 5	.157 - .197	VCFC 32 45	**56360**	VCFC 25 45	**56386**	VCFC 20 45	**56374**	VCFC 16 45	**56343**
5 - 6	.197 - .236	VCFC 32 56	**56361**	VCFC 25 56	**56387**	VCFC 20 56	**56375**	VCFC 16 56	**56344**
6 - 7	.236 - .276	VCFC 32 67	**56362**	VCFC 25 67	**56388**	VCFC 20 67	**56376**	VCFC 16 67	**56345**
7 - 8	.276 - .315	VCFC 32 78	**56363**	VCFC 25 78	**56389**	VCFC 20 78	**56377**	VCFC 16 78	**56346**
8 - 9	.315 - .354	VCFC 32 89	**56364**	VCFC 25 89	**56390**	VCFC 20 89	**56378**	VCFC 16 89	**56347**
9 - 10	.354 - .394	VCFC 32 910	**56365**	VCFC 25 910	**56391**	VCFC 20 910	**56379**	VCFC 16 910	**56348**
10 - 11	.394 - .433	VCFC 32 1011	**56349**	VCFC 25 1011	**56380**	VCFC 20 1011	**56370**	-	-
11 - 12	.433 - .472	VCFC 32 1112	**56350**	VCFC 25 1112	**56381**	VCFC 20 1112	**56371**	-	-
12 - 13	.472 - .512	VCFC 32 1213	**56351**	VCFC 25 1213	**56382**	VCFC 20 1213	**56372**	-	-
13 - 14	.512 - .551	VCFC 32 1314	**56352**	VCFC 25 1314	**56383**	-	-	-	-
14 - 15	.551 - .591	VCFC 32 1415	**56353**	VCFC 25 1415	**56384**	-	-	-	-
15 - 16	.591 - .630	VCFC 32 1516	**56354**	VCFC 25 1516	**56385**	-	-	-	-
16 - 17	.630 - .669	VCFC 32 1617	**56355**	-	-	-	-	-	-
17 - 18	.669 - .709	VCFC 32 1718	**56356**	-	-	-	-	-	-
18 - 19	.709 - .748	VCFC 32 1819	**56357**	-	-	-	-	-	-
19 - 20	.748 - .787	VCFC 32 1920	**56358**	-	-	-	-	-	-

VDF & VSAC COLLET SETS

Collet Set Number	Description	EDP#
VDF 10 015 SET	59 Collets in 1/64 Increments	**56025**
VDF 10 031 SET	30 Collets in 1/32 Increments	**56026**
VDF 10 062 SET	15 Collets in 1/16 Increments	**56027**
VDF 10 125 SET	8 Collets in 1/8 Increments	**56028**
VSAC1613210KIT	ER 16 collet set - INCH 10 colletts	**56681**
VSAC16210KIT	ER 16 collet set - METRIC 8 collets	**97195**
VSAC20212KIT	ER 20 collet set - INCH 12 collets	**56816**
VSAC2516KIT	ER 25 collet set - INCH 16 collets	**56708**
VSAC3218KIT	ER 32 collet set - INCH 18 collets	**56729**
VSAC32220KIT	ER 32 collet set - METRIC 18 collets	**97196**
VSAC11207KIT	ER 11 collet set - INCH 7 collets	**56675**
VCFC16410KIT	COOLIT collet ER 16 set 6 collets	**97199**
VCFC20413KIT	COOLIT collet ER 20 set 9 collets	**97200**
VCFC25416KIT	COOLIT collet ER 25 set 12 collets	**97201**
VCFC32420KIT	COOLIT collet ER 32 set 16 collets	**97202**

VDA COLLET SETS

Collet Set Number	Description	EDP#
VDA 10 015 SET	33 collets in 1/64 increments	**56012**
VDA 18 015 SET	45 collets in 1/64 increments	**56015**
VDA 18 062 SET	12 collets in 1/16 increments	**56017**
VDA 20 015 SET	21 collets in 1/64 increments	**56018**
VDA 20 031 SET	11 collets in 1/32 increments	**56019**
VDA 20 062 SET	6 collets in 1/16 increments	**56020**
VDA 30 015 SET	14 collets in 1/64 increments	**56021**

COLLET EXTENSIONS

Part Number	COLLET SERIES	SHANK DIAMETER	SHANK LENGTH	DESCRIPTION	EDP#
VE 050 356 11	ER11	.500	5.5 in (140mm)	EXTENSION	**56659**
VE 050 356 16	ER16	.500	5.5 in (140mm)	EXTENSION	**56662**
VE 7560 16	ER16	.750	6.0 in (150mm)	EXTENSION	**55387**
S075 CFC 162520	ER16	.750	2.5 in (64mm)	LATHE EXTENSION	**55333**
VE 075 356 20	ER20	.750	5.5 in (140mm)	EXTENSION	**56664**
VE 100 356 25	ER25	1.000	5.5 in (140mm)	EXTENSION	**56666**
VE 100 356 32	ER32	1.000	5.5 in (140mm)	EXTENSION	**56668**
S100 CFC 324030	ER32	1.000	4.0 in (102mm)	LATHE EXTENSION	**55334**
S125 CFC 324030	ER32	1.250	4.0 in (102mm)	LATHE EXTENSION	**55335**
S150 10SG 630	VDF10	1.500	6.0 in (150mm)	EXTENSION	**57251**
S150 CFC10 4040	VDF10	1.500	4.0 in (102mm)	LATHE EXTENSION	**55336**
S200 15SG 840	VDF15	2.000	8.0 in (204mm)	EXTENSION	**57252**
VE 0500	VDA30	.500	5.5 in (140mm)	EXTENSION	**55383**
VE 0750	VDA20	.750	5.5 in (140mm)	EXTENSION	**55384**
VE 1000	VDA10	1.000	5.5 in (140mm)	EXTENSION	**55385**
VE 1002032	ER32	1.000	2.0 in (51mm)	STUB EXTENSION	**50145**
VE 1250	VDA18	1.250	5.5 in (140mm)	EXTENSION	**55386**

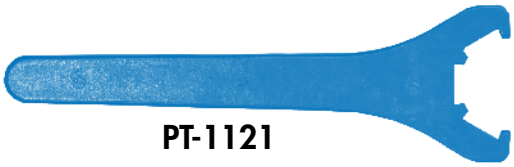
COLLET EXTENSIONS AND KITS WITH COLLETS

Part Number	COLLET SERIES	SHANK DIAMETER	SHANK LENGTH	DESCRIPTION	EDP#
VE 050 356 11KIT	ER11	.500	5.5 in (140mm)	EXTENSION & ER 11 COLLET SET	**56661**
VE 050 356 16KIT	ER16	.500	5.5 in (140mm)	EXTENSION & ER16 COLLET SET	**56663**
VE 75 60SAC 16KIT	ER16	.750	6.0 in (150mm)	EXTENSION & ER 16 COLLET SET	**97193**
VE 075 356 20KIT	ER20	.750	5.5 in (140mm)	EXTENSION & ER20 COLLET SET	**56665**
VE 100 356 25KIT	ER25	1.000	5.5 in (140mm)	EXTENSION & ER 25 COLLET SET	**56667**
VE 100 356 32KIT	ER32	1.000	5.5 in (140mm)	EXTENSION & ER 32 COLLET SET	**56669**

ValTRU™

COLLET NUT WRENCHES

PT-1177

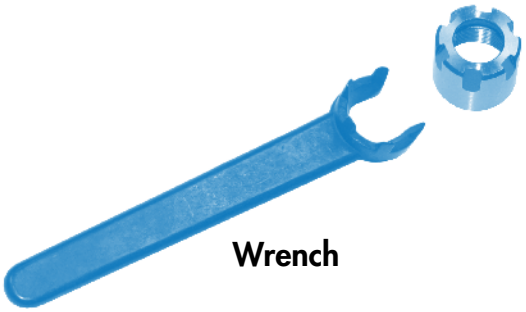


PT-1121

Part Number	Nut Type	Torque ft/lbs	Overall Length	EDP#
PT-1121	ER25 (round nut)	95	8-1/4	**62673**
PT-1177	ER20 (nex nut)	74	6-1/2	**62674**

REPLACEMENT COLLET NUTS & WRENCHES FOR COLLET EXTENSIONS

Extension Assembly

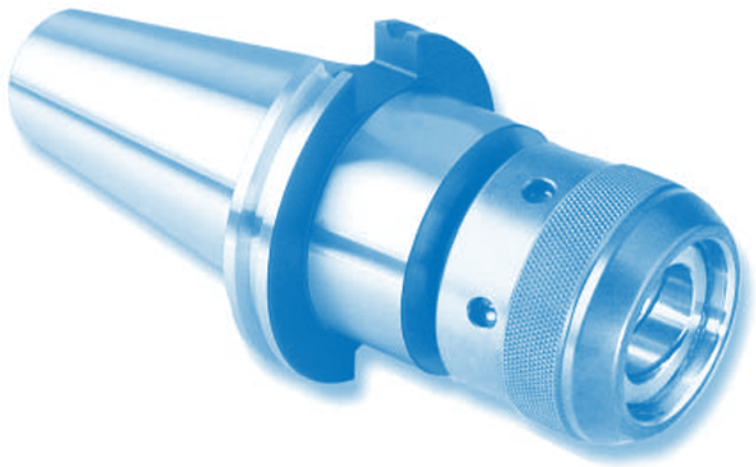


Nut

Wrench

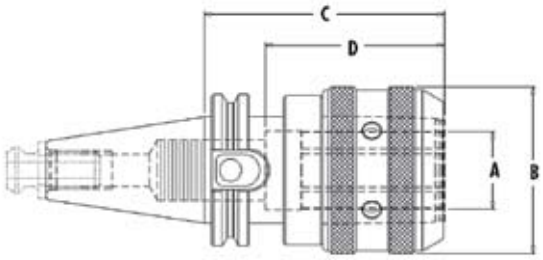
Part Number	Collet Series	Collet Nut	EDP#	Collet Wrench	EDP#
VE 050 356 11KIT VE 050 356 11	ER11	VSAC11CNM	**62753**	PT 1252 ER11	**62749**
VE 050 356 16KIT VE 050 356 16	ER16	VSAC 16CNM	**62754**	PT 1252 ER16	**62750**
VE 075 356 20KIT VE 075 356 20	ER20	VSAC20CNM	**62755**	PT 1252 ER20	**62751**
VE 100 356 25KIT VE 100 356 25	ER25	VSAC25CNM	**62756**	PT 1252 ER25	**62752**

MILL CHUCKS & BUSHINGS



MILLING CHUCKS

ValTRU™



Order retention knob seperately.

- Alloy steel hardened to RC 56 60 for long service life
- End mill socket T.I.R. ≤ .0002"
- Through spindle coolant capability
- Flange entry coolant is available on request

3/4 Inch 75MC Chucks

Part Number	Type	Dimensions				Back Up Screw	EDP#
		A (Dia.)	B (Dia.)	C	D		
BT40 75MC3 364	BT40	.75	2.19	3.64	2.24	BS 09	**62501**
V40CT 75MC3 371	CAT 40	.75	2.19	3.71	2.24	BS 09	**62502**
V50CT 75MC3 396	CAT 50	.75	2.19	3.96	2.24	BS 09	**62503**

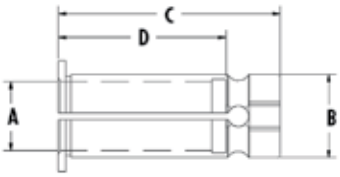
Order Back Up Screws and Sanner Wrench 1OOCNW seperately

1 1/4 Inch 12MC Chucks

Part Number	Type	Dimensions				Back Up Screw	EDP#
		A (Dia.)	B (Dia.)	C	D		
BT40 12MC4 444	BT40	1.25	2.75	4.44	3.00	BS 08	**62504**
V40CT 12MC4 413	CAT 40	1.25	2.75	4.13	3.00	BS 08	**62505**
V50CT 12MC4 413	CAT 50	1.25	2.75	4.13	3.00	BS 08	**62506**
V50CT 1 2MC4 600	CAT 50	1.25	2.75	6.00	3.00	BS 08	**62507**

Order Back Up Screws and Sanner Wrench 1OOCNW seperately

BUSHINGS



Series	Dimensions	
	C	D
75MC	2.00	1.375
12MC	2.75	1.375

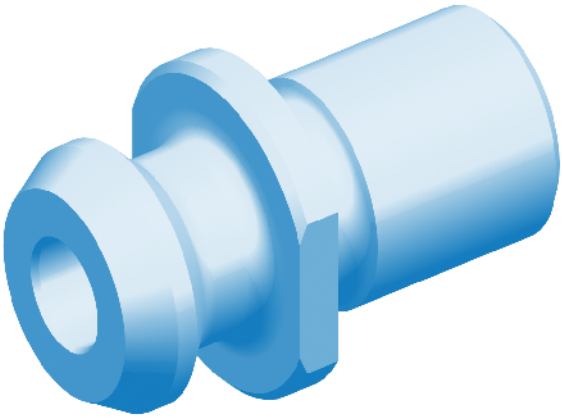
75MC Bushings

Part Number	Dimensions		EDP#
	A	B	
75MCRB 188	.1875	.75	**62508**
75MCRB 250	.2500	.75	**55320**
75MCRB 3 1 3	.3125	.75	**55321**
75MCRB 375	.3750	.75	**55322**
75MCRB 500	.5000	.75	**55323**
75MCRB 625	.6250	.75	**55324**

12MC Bushings

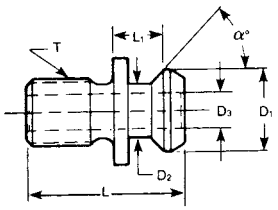
Part Number	Dimensions		EDP#
	A	B	
12MCRB 250	.2500	1.25	**55313**
12MCRB 313	.3125	1.25	**55314**
12MCRB 375	.3750	1.25	**55315**
12MCRB 500	.5000	1.25	**55316**
12MCRB 625	.6250	1.25	**55317**
12MCRB 750	.7500	1.25	**55318**
12MCRB 875	.8750	1.25	**55319**
12MCRB 100	1.0000	1.25	**55312**

RETENTION KNOBS

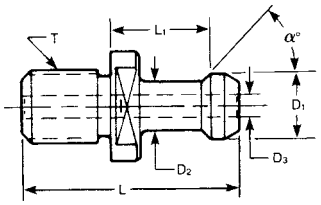


RETENTION KNOBS

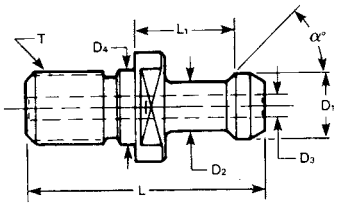
ValTRU™



STYLE 1



STYLE 2



STYLE 3

BT Retention Knobs

Part Number	Taper	Thread	Style	Dimensions						EDP#	Notes
				D1	D2	D4	L	Ll	α		
PT 585 45	BT30	M12	3	.43	.27	.492	1.69	.709	45	**55581**	MAS P30T 1
PT 585 60	BT30	M12	3	.43	.27	.492	1.69	.709	60	**55582**	MAS P30T 1 1
PT 444 45	BT40	M16	3	.59	.39	.669	2.36	1.102	45	**55552**	MAS P40T 1
PT 444 60	BT40	M16	3	.59	.39	.669	2.36	1.102	60	**55553**	MAS P40T 1 1
PT 444 90	BT40	M16	3	.59	.39	.669	2.36	1.102	90	**55554**	MAS P40T 90
PT 532 45	BT40 to V45CT	5/8-11	2	.59	.39		2.25	.990	45	**55564**	BT40 machine convert to 40 CAT
PT 532 60	BT40 to V45CT	5/8-11	2	.59	.39		2.25	.990	60	**55566**	BT40 machine convert to 40 CAT
PT 532 90	BT40 to V45CT	5/8-11	2	.59	.39		2.25	.990		**55567**	BT40 machine convert to 40 CAT
PT 536 45C	BT50 to V50CT	1 - 8	2	.91	.67		3.35	1.386	45	**55571**	BT50 machine convert to 50 CAT
PT 536 60	BT50 to V50CT	1 - 8	2	.91	.67		3.35	1.386	60	**55572**	BT50 machine convert to 50 CAT
PT 536 90	BT50 to V50CT	1 - 8	2	.91	.67		3.35	1.386	90	**55573**	BT50 machine convert to 50 CAT

CAT Retention Knobs

Part Number	Taper	Thread	Style	Dimensions						EDP#	Notes
				D1	D2	D3	L	Ll	α		
PT 475C	V40CT	5/8-11	1	.74	.49	.28	1.49	.440	45	**55560**	CAT Standard
PT 475	V40CT	5/8-11	1	.74	.49		1.49	.440	45	**55559**	CAT Standard
PT 552C	V40CT	5/8-11	2	.59	.40	.16	2.25	1.139	45	**55575**	
PT 552	V40CT	5/8-11	2	.59	.40		2.25	1.139	45	**55574**	
PT 572 45	V40CT	5/8-11	2	.59	.39		2.12	.990	45	**55579**	
PT 275C	V50CT	1 - 8	1	1.14	.39	.47	2.30	.700	45	**55551**	CAT Standard
PT 573	V50CT	1 - 8	1	1.14	.82		2.30	.700	45	**55580**	CAT Standard PT 275 without coolant hole

Note: Caterpillar retention knobs and A.N.S.I. B5.50 1985 retention knobs are interchangeable.

WARNING: Various knob styles are not necessarily interchangeable. To avoid the potential for injury, tooling damage or machine damage, always make sure the proper used for a given adapter and according to machine specifications. Special care should be taken not to interchange metric and inch threaded retention knobs. Use of a metric threaded knob with a non metric threaded adapter shank, or vice versa, could cause inadequate coupling of the adapter to the spindle during machining and a failure of the components. Always use machine guards, protective clothing and safety glasses to prevent burns or other injury to body or eyes from flying objects.

TAP ADAPTERS

Tension/Compression Tap Holders 306

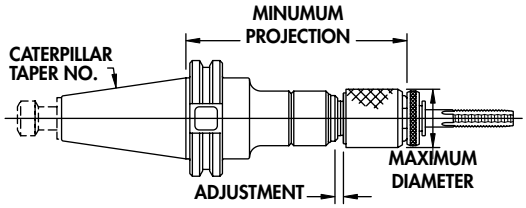
Synchronized Drive Tap Holders 307

BT Synchronized Drive Tap Holders 307

Synchronized & Tension Tap Holders 307

Standard Tap Adapters 308

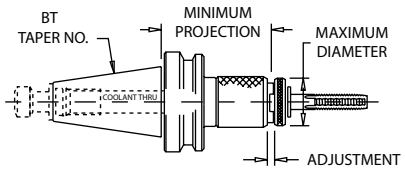
TENSION/COMPRESSION TAP HOLDERS
CAT"V" FLANGE TAPER



**ORDER RETENTION KNOB, TAP,
AND TAP ADAPTOR SEPARATELY.

Part Number	Taper	Tap Adapter Series	Standard Tap Range	NPT	Compression	Maximum Diameter	Minimum Projection	Wt Lbs	EDP
TAP 311 51 40CAT	40	1	0 - 9/16	1/8	0 - .125	1.26	4.67	2.9	**56108**
TAP 311 51 50CAT	50	1	0 - 9/16	1/8	0 - .125	1.26	3.92	7.3	**56111**
TAP 312 52 40CAT	40	2	5/16 - 7/8	1/4 - 1/2	0 - .250	1.96	6.29	5.4	**56113**
TAP 312 52 50CAT	50	2	5/16 - 7/8	1/4 - 1/2	0 - .250	1.96	5.54	9.0	**56116**
TAP 313 53 50CAT	50	3	3/4 - 1 3/8	3/4 - 1	0 - .375	2.91	8.50	16.0	**56118**

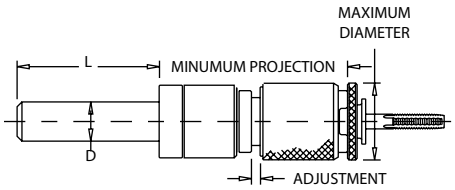
TENSION/COMPRESSION TAP HOLDERS
BT (JMTBA) TAPER



**ORDER RETENTION KNOB, TAP,
AND TAP ADAPTOR SEPARATELY.

Part Number	Taper	Tap Adapter Series	Standard Tap Range	NPT	Compression	Maximum Diameter	Minimum Projection	Wt Lbs	EDP#
TAP 311 51 40BT	40	1	0 - 9/16	1/8	0.125	1.26	4.92	3	**56107**

TENSION/COMPRESSION TAP HOLDERS
STRAIGHT SHANK

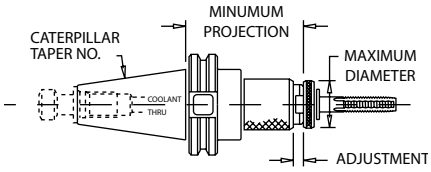


Part Number	Straight Shanked	L	Tap Adapter Series	Standard Tap Range	NPT	Compression	Maximum Diameter	Minimum Projection	Wt Lbs	EDP#
TAP311000SSTC	1.00	3.90	1	0 - 9/16	1/8	0 .125	1.26	2.50	1.3	**56131**
TAP321000SSTC	1.00	3.62	2	5/16 - 11/16	1/4 - 3/8	0 .250	1.96	4.57	2.9	**56132**
TAP321250SSTC	1.25	3.62	2	5/16 - 7/8	1/4 - 3/8	0 .250	1.96	4.57	3.7	**56135**

Notes:
1. Holder set is at full tension, however, operation with less than 1/16" compression is not recommended for most applications except pipe tapping.
2. TAP V Flange and straight shank tools with the GOLD locking shells contain Valenite's new ejector feature.
3. TAP V Flange and straight shank tools are slotted to accept "lug drive" tap holders and Valenite's ball drive tap holders for maximum versatility and economy.
4. Compression stroke changes (as may be required for pipe tapping) are easily accomplished by using a hex wrench through the front of the tool.

ValTRU™

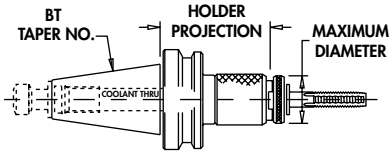
SYNCHRONIZED DRIVE TAP HOLDERS
CAT"V" FLANGE TAPER



**ORDER RETENTION KNOB, TAP,
AND TAP ADAPTOR SEPARATELY.

Part Number	Taper	Tap Adapter Series	Standard Tap Range	NPT	Maximum Diameter	Minimum Projection	Wt. Lbs.	EDP#
TAP 12151 40CATC	40	1	0 - 9/16	1/8	1.26	2.50	2.4	**56098**
TAP 121 51 50CATC	50	1	0 - 9/16	1/8	1.26	3.00	7.0	**56099**
TAP 122 52 40CATC	40	2	5/16 - 7/8	1/4 - 1/2	1.96	3.00	2.7	**56102**
TAP 122 52 50CATC	50	2	5/16 - 7/8	1/4 - 1/2	1.96	3.00	8.4	**56103**

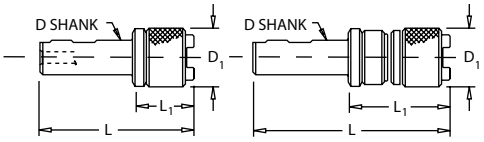
BT SYNCHRONIZED DRIVE TAP HOLDERS
BT (JMTBA) TAPER



**ORDER RETENTION KNOB, TAP,
AND TAP ADAPTOR SEPARATELY.

Part Number	Taper	Tap Adapter Series	Standard Tap Range	NPT	Maximum Diameter	Minimum Projection	Wt. Lbs.	EDP#
TAP1215140BTC	40	1	0 - 9/16	1/8	1.26	2.36	2.5	**56097**

SYNCHRONIZED & TENSION TAP HOLDERS
WELDON STYLE

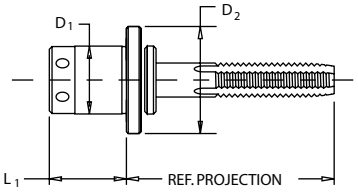


STYLE 1:
SYNCHRONIZED
(SOLID)

STYLE 2:
TENSION ONLY

Part Number	Style	Tap Adapter Series	Standard Tap Range	NPT	Tension Stroke	Dimensions				EDP#
						D	D1	L	L1	
TAP 31 0750 WR	solid	1	0 - 9/16	1/8	NONE	3/4	1.25	3.34	1.25	**56129**
TAP 31 0750 WT	tension	1	0 - 9/16	1/8	0.20	3/4	1.25	4.26	1.00	**56130**
TAP 32 1000 WR	solid	2	5/16 - 7/8	1/4 - 1/2	NONE	1	1.95	4.40	2.09	**56133**
TAP 32 1000 WT	tension	2	5/16 - 7/8	1/4 - 1/2	0.50	1	1.95	5.80	3.49	**56134**

STANDARD TAP ADAPTER
"NO LUG" STYLE



**ORDER TAP SEPARATELY

Part Number	Adapter Size	TAP SIZE	L1 (mm)	D1 (mm)	D2 (mm)	Ref. Projection (inch)	Ref. Projection (mm)	EDP#
TAP 31 MS 06	1	0 - 6	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	1.51	38,4	**56155**
TAP 31 MS 08	1	8	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	1.57	39,9	**56157**
TAP 31 MS 10	1	10	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	1.73	43,9	**56159**
TAP 31 MS12	1	12	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	1.79	45,5	**56161**
TAP 31 0250	1	1/4	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	1.80	45,7	**56138**
TAP 31 0312	1	5/16	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	1.95	49,5	**56140**
TAP 31 0375	1	3/8	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	2.11	53,6	**56142**
TAP 31 0437	1	7/16	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	2.36	59,9	**56144**
TAP 31 0500	1	1/2	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	2.55	64.8	**56146**
TAP 31 0562	1	9/16	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	2.79	70,8	**56148**
TAP 31 NPT 0125	1	1/8 NPT	0.85 (21,6)	0.748 (19,0)	1.18 (30,0)	1.36	34.5	**56163**
TAP 32 0312	2	5/16	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	1.99	50,5	**56175**
TAP 32 0375	2	3/8	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	2.15	54,6	**56177**
TAP 32 0437	2	7/16	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	2.40	61,0	**56179**
TAP 32 0500	2	1/2	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	2.59	65,8	**56181**
TAP 32 0562	2	9/16	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	2.79	70,9	**56183**
TAP 32 0625	2	5/8	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	2.55	64,8	**56185**
TAP 32 0750	2	3/4	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	2.87	72,8	**56189**
TAP 32 0875	2	7/8	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	3.32	84,3	**56193**
TAP 32 NPT 0125	2	1/8 NPT	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	1.40	35,6	**56207**
TAP 32 NPT 0250	2	1/4 NPT	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	1.60	40,6	**56209**
TAP 32 NPT 0375	2	3/8 NPT	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	1.66	42,2	**56211**
TAP 32 NPT 0500	2	1/2 NPT	1.38 (35,1)	1.220 (31,0)	1.88 (47,8)	2.10	53,3	**56213**

PRECISION BORING SYSTEM (VPB)

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Val CONNECT™

VALENITE'S PRECISION BORING SYSTEM

Valenite took a fresh look at today's precision boring operations and introduced a new Precision Boring System to meet your real world needs. The result is a flexible, cost effective, modular system that allows precision boring heads to work on virtually any machining center using industry standard shanks. A system that offers:

- A full line of modular tools you can customize to your part configuration without building special tooling.
- Complete coverage for roughing and finishing applications.
- A broad selection of shank components you can assemble to produce tools of virtually any practical length.
- Simple, easy set up
- Fast, integral micrometer adjustment in 0.001″ increments or 0.02mm for metric tools
- Precision vernier adjustment in 0.0001″ increments or 0.002mm for metric tools
- No movement between lock and unlock to eliminate setting errors
- Fully enclosed tool carrier for safe, rugged operation
- Through bored tool receiver for maximum length adjustment and through the spindle coolant
- Choice of carbide or steel shank small diameter boring bars with coolant holes
- Step or balanced cutting on the twin boring heads for maximum application flexibility

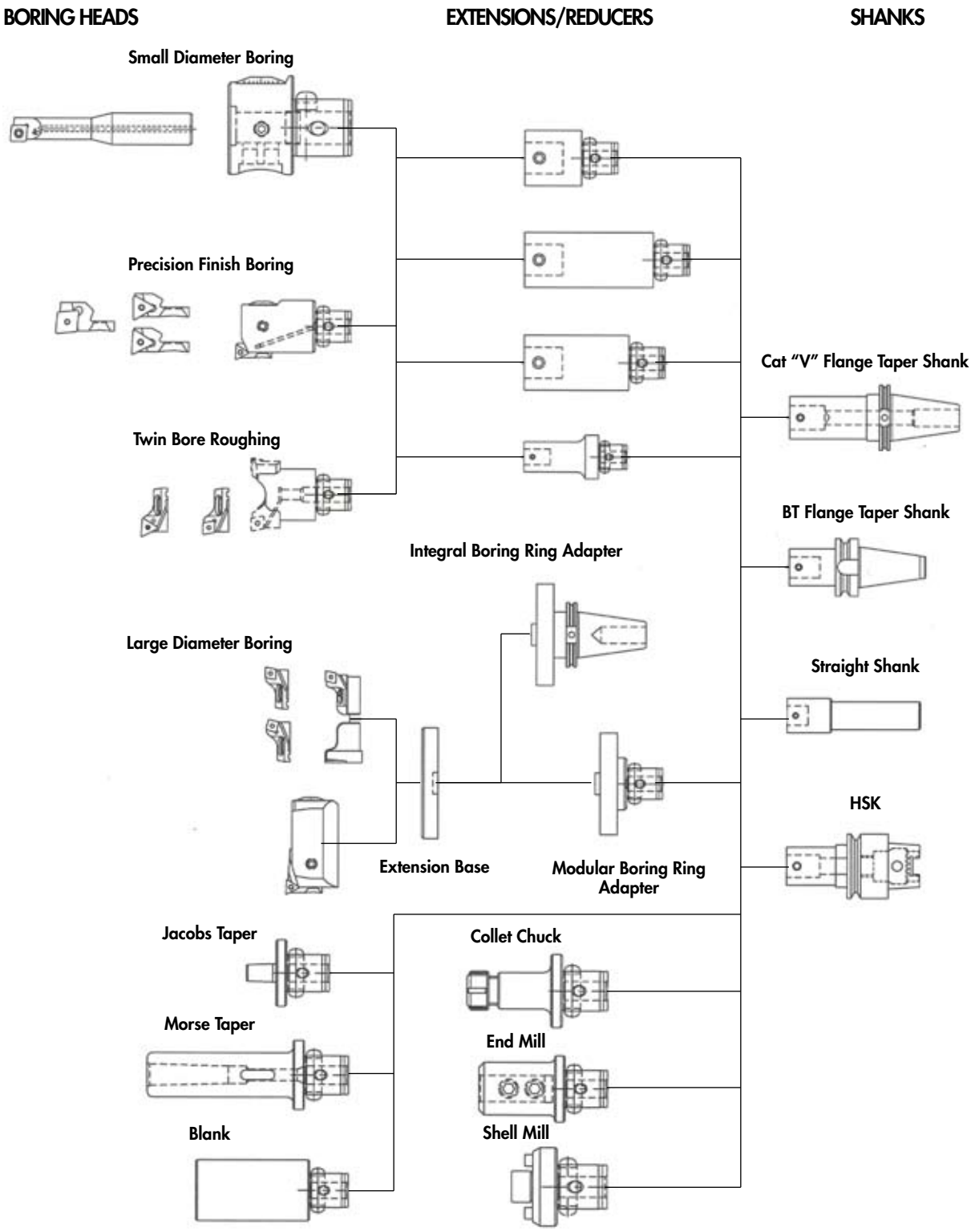
A True Precision Boring System

The Valenite Precision Boring System is available with a full range of tooling to handle:

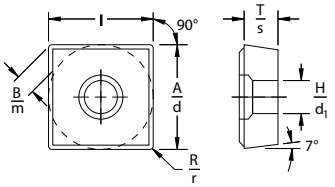
- Smaller diameter precision boring down to 0.230″ diameter
- Precision finish boring for diameters from 0.940″ to 6.00″
- Twin Bore rough boring from 0.95″ to 6.20″
- Large diameter boring from 5.95″ to 21.89″

ValCONNECT™

VPB SYSTEM OVERVIEW

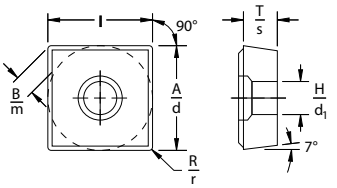


VPB INSERTS - SCGT



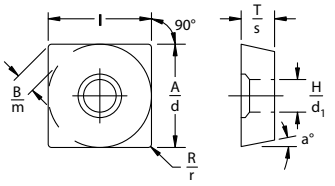
Part Number ISO Number	Dimensions							Available Grades/EDP#					
	X	A (IC)/d	l	T/s	R/r	H/d1	B/m	SV235	SV310	SV315	SV325	VC901	VC929
SCGT 32.51 FH		.375		.156	.015	.173	.071	-	04818	04970	04819	-	-
SCGT 09 T3 04 FH	09	9,525	9,525	3,97	0,4	4,4	1,808						
SCGT 32.52 FH		.375		.156	.031	.173	.065	-	04820	04821	04822	06316	-
SCGT 09 T3 08 FH	09	9,525	9,525	3,97	0,78	4,4	7,643						
SCGT 431 FH		1/2		.187	.015	.217	.097	-	04729	-	04972	06239	-
SCGT 12 04 04 FH	12	12,7	12,7	4,76	0,4	5,5	2,466						
SCGT 432 FH		1/2		.187	.015	.217	.091	-	04823	04824	04825	-	06317
SCGT 12 04 08 FH	12	12,7	12,7	4,76	0,4	5,5	2,30						
SCGT 433 FH		1/2		.187	.046	.217	.084	03610	04826	04973	04827	-	-
SCGT 12 04 12 FH	12	12,7	12,7	4,76	1,2	5,5	2,136						

VPB INSERTS - SCMT



Part Number ISO Number	Dimensions							Available Grades/EDP#		
	X	A(IC)/d	1	T/s	R/s	H/d1	B/m	V1N	VN8	VC29
SCMT 32.51 1A		.375		.156	.015	.173	.071	05632	05633	-
SCMT 09 T3 04 M	09	9,525	9,525	3,96	0,4	4,4	1,808			
SCMT 32.51 2A		.375		.156	.015	.173	.071	05634	-	-
SCMT 09 T3 04 2A	09	9,525	9,525	3,96	0,4	4,4	1,808			
SCMT 32.52 1A		.375		.156	.031	.173	.065	-	05635	-
SCMT 09 T3 08 1A	09	9,525	9,525	3,96	0,79	4,4	1,643			
SCMT 32.52 2A		.375		.156	.031	.173	.065	05636	-	-
SCMT 09 T3 08 2A	09	9,525	9,525	3,96	0,79	4,4	1,643			
SCMT 432 1A		.500		.187	.031	.217	.091	05637	05638	-
SCMT 12 04 08 1A	12	12,7	12,7	4,76	0,79	5,5	2,30			

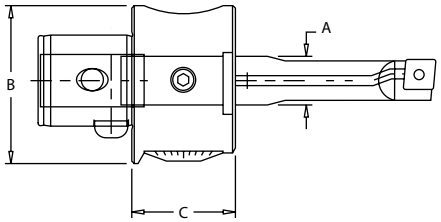
VPB INSERTS - SCMW



Part Number ISO Number	Dimensions							Available Grades / EDP#			
	X	A(IC)/d	l	T/s	R/r	H/d1	B/m	VC610	VC29	V1N	VO1
SCMW 32.52		.375		.156	.031	.173	.065	-	09597	05401	05402
SCMW 09 T3 08	09	9,525	9,525	3,96	0,79	4,4	7,643				
SCMW 432		.500		.187	.031	.217	.091	-	09599	05403	05404
SCMW 120408	12	12,7	12,700	4,76	0,79	5,5	2,30				

Val CONNECT™

Fast, accurate set up and adjustment. Reduced scrap.Eliminates setting errors common to other systems. Tools complete less Boring Bar, (order below).

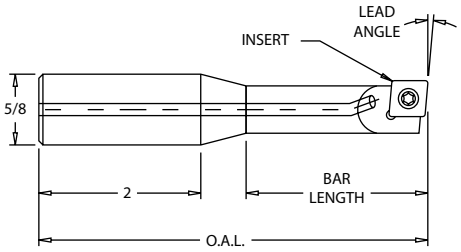


VPB BORING HEADS
PRECISION FINISHING

RANGE 0.230 1.312 (5,84MM 33,32MM)
INCH GRADUATED UNITS
.001" Per Dial Graduation With .0001 Vernier
METRIC GRADUATED UNITS
.02mm Per Dial Graduation With .002mm Vernier.
5,000 RPM Max.

Part Number	Style	Inch Bore		Metric Bore		Connection Size	A(mm)	B(mm)	C(mm)	Adjustment	EDP
		Min.	Max.	Min.	Max.						
VPB PC6 2015	Inch	0.230	1.312	-	-	PC6	.625	2.52	1.65	.312	**52480**
VPB PC6 2005	Metric	-	-	5,84	33,32	PC6	15,88	64	42	7,92	**52481**

Permits through spindle coolant. Standard boring bars of .500 diameter and smaller can be used with VPB boring heads by utilizing the bushings.



VPB BORING HEADS
CARBIDE AND STEEL BORING BARS

RANGE 0.230 - 1.312 (5,84MM - 33,32MM)

Steel

Part Number	Recommended Inch Bore	Inch Bore		Metric Bore		Lead Angle	Bar Dia.	Bar Length	O.A.L.	Radial Rake Angle	Coolant Hole	Insert Note:	EDP
		Min.	Max.	Min.	Max.								
VPB SSCLPR 250	.235 -.305	.230	.855	*5,84*	*21,71*	5°	13/64	11/16	3 7/8	15°	No	CPGT1.51.21	**52697**
VPB SSCLPR 312	.305 - .365	.300	.925	*7,62*	*23,49*	0°	1/4	7/8	4 1/16	11°	No		**52698**
VPB SSCLPR 375	.365 - .450	.360	.985	*9,14*	*25,02*	5°	5/16	1 1/16	4 1/16	12°	Yes	CPGT21.51 CPMT 21.51 CPMW 21.51	**52699**
VPB SSCLPR 500	.450 - .570	.438	1.063	*11,13*	*27,00*	5°	3/8	1 5/16	4 3/16	10"	Yes		**52700**
VPB SSCLPR 625	.570 - .695	.563	1.188	*14,30*	*30,18*	5°	1/2	1 1/2	4 3/16	8°	Yes		**52701**
VPB SSCLPR 750	.695 - 1.312	.688	1.312	*17,48*	*33,32*	5°	5/8		4 1/2	6°	Yes		**52702**

Carbide

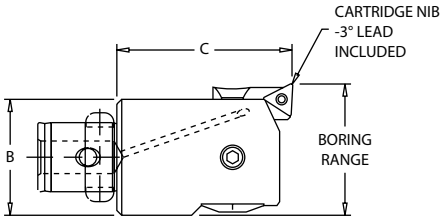
Part Number	Recommended Inch Bore	Inch Bore		Metric Bore		Lead Angle	Bar Dia.	Bar Length	O.A.L.	Radial Rake Angle	Coolant Hole	Insert Note:	EDP
		Min.	Max.	Min.	Max.								
VPB CSCLPR 250	.235 - .305	.230	.855	*5,84*	*21,71*	5°	13/64	1 5/32	4 3/8	15°	No	CPGT 1.51. 21	**52691**
VPB CSCLPR 312	.305 - .365	.300	.925	*7,62*	*23,49*	5°	1/4	1 1/2	4 5/8	11°	No		**52692**
VPB CSCFPR 312	.305 - .365	.300	.925	*7,62*	*23,49*	0°	1/4	1 1/2	4 5/8	11°	No		**52689**
VPB CSCLPR 375	.365 - .450	.360	.985	*9,14*	*25,02*	5°	5/16	1 13/16	4 13/16	12°	Yes	CPGT21.51 CPMT 21.51 CPMW 21.51	**52693**
VPB CSCLPR 500	.450 - .570	.438	1.063	*11,13*	*27,00*	5°	3/8	2 3/16	5 1/16	10°	Yes		**52694**
VPB CSCLPR 625	.570 - .695	.563	1.188	*14,30*	*30,18*	5°	1/2	2 1/2	5 3/16	8°	Yes		**52695**
VPB CSCLPR 750	.695 - 1.312	.688	1.312	*17,48*	*33,32*	5°	5/8		5 15/16	6°	Yes		**52696**
VPB CSCFPR 750	.695 - 1.312	.688	1.312	*17,48*	*33,32*	0°	5/8		5 15/16	6°	Yes		**52690**

Note: Insert CPGT 1.51 uses PT 670T screw , T 6 Torx Wrench. Replacement screws may require modification to clear bore.Insert CPGT 21.51 uses PT 542T screw, T 7 Torx Wrench.

VPB BORING HEAD

PRECISION FINISHING

Range 0.984 - 6.000
(25 mm - 150mm)
INCH GRADUATED UNITS
.001" Per Dial Graduation
with .0001 Vernier
METRIC GRADUATED UNITS
.02mm Per Dial Graduation
with .002mm Vernier



ValCONNECT™

Note: Micrometer dial provides fast, accurate set up and adjustment. Through spindle coolant. True Radial adjustment means length compensations are unnecessary, reducing set up time and scrap. Maximum cutting speed is 1,000 SFM.

Inch Graduated Dial

Part Number	Inch Bore		Metric Bore		Connection Size	Nib Size	B	C	Wt. lbs.	EDP
	Min.	Max.	Min.	Max.						
VPB PC2 2215	.984	1.300	-	-	PC2	2	.925	1.476	N/A	**52468**
VPB PC3 2315	1.240	1.654	-	-	PC3	3	1.201	1.614	0.50	**52471**
VPB PC4 2415	1.614	2.126	-	-	PC4	4	1.496	1.850	0.92	**52474**
VPBPC5 2515	2.087	2.756	-	-	PC5	5	1.929	2.244	1.81	**52477**
VPB PC6 2615	2.677	4.000	-	-	PC6	6	2.480	2.795	3.88	**52482**
VPB PC6 2715	3.937	6.000	-	-	PC6	7	3.740	2.795	N/A	**52484**

Metric Graduated Dial

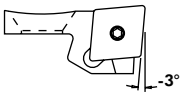
Part Number	Inch Bore		Metric Bore		Connection Size	Nib Size	B	C	Wt. lbs.	EDP
	Min.	Max.	Min.	Max.						
VPB PC2 2205	-	-	25	33	PC2	2	23,5	37,5	N/A	**52467**
VPB PC3 2305	-	-	32	42	PC3	3	30,5	41	0.50	**52470**
VPB PC4 2405	-	-	41	54	PC4	4	38	47	0.92	**52473**
VPB PC5 2505	-	-	53	70	PC5	5	49	57	1.81	**52476**
VPB PC6 2605	-	-	68	100	PC6	6	63	71	3.88	**52481**
VPB PC6 2705	-	-	100	150	PC6	7	95	71	N/A	**52483**

VPB CARTRIDGE NIBS

3° Lead 80° Diamond

Part Number	Nib Size	Insert Type & Size	Insert Screw	Insert Screw Wrench	EDP
VPB 2213 C05	2	CPGT1.81.51	PT 526 T	T7 Torx Wrench	**52521**
VPB 2313 C05	3	CPGT1.81.51	PT 526 T	T7 Torx Wrench	**52522**

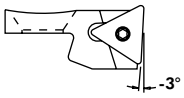
-3 DEG. LEAD CARTRIDGE NIB



3° Lead Triangle

Part Number	Nib Size	Insert Type & Size	Insert Screw	Insert Screw Wrench	EDP
VPB 2313 T11	3	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52523**
VPB 2413 T11	4	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52525**
VPB 2513 T11	5	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52527**
VPB 2613 T11	6	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52529**
VPB 2713 T11	7	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52531**

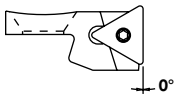
-3 DEG. LEAD CARTRIDGE NIB



0° Lead Triangle

Part Number	Nib Size	Insert Type & Size	Insert Screw	Insert Screw Wrench	EDP
VPB 2410 T11	4	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52524**
VPB 2510 T11	5	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52526**
VPB 2610 T11	6	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52528**
VPB2710 T11	7	TCGT 21 .51	PT 589 T	T7 Torx Wrench	**52530**

0 DEG. LEAD CARTRIDGE NIB



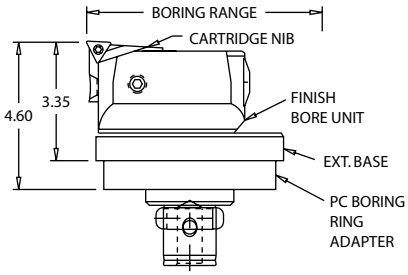
Note: CPMT and CPMW inserts are interchangeable with CPGT inserts of the same size.2) TCMT and TCMW inserts are interchangeable with TCGT inserts of the same size.

Val CONNECT™

VPB FINISH BORING HEADS

RANGE 5.95 - 21.89
(151,13 mm - 556,00 mm)

See page XX for parts.See page XX for Integral Boring Ring Adapter.Maximum cutting speed is 1,000 SFM.



Part Number Extension Base (1 Required)	Finish Bore				EDP#	Part Number/EDP PC Boring Ring Adapter (1 Required)	Part Number/EDP Finish Bore Unit Inch (1 Required)	Part Number/EDP Finish Bore Unit Metric (1 Required)
	Inch Range		Metric Range					
	Min.	Max.	Min.	Max.				
VPB 17BR 7108	5.95	8.27	151,13	210,06	**52495**	VPB PC6 17BR2 **EDP# 52503**	VPB 71 00 2811 **EDP# 52501**	VPB 7100 2801 **EDP# 52500**
VPB 17BR 7110	8.22	10.54	208,79	267,72	**52496**			
VPB 17BR 7112	10.49	12.81	266,45	325,37	**52497**			
VPB 17BR 7115	12.76	15.08	324, 10	383,03	**52498**			
VPB 17BR 7117	15.03	17.35	381,76	440,69	**52499**			
VPB 17BR 7119	17.30	19.62	439,42	498,35	**52504**			
VPB 17BR 7121	19.57	21.89	497,08	556,00	**52505**			

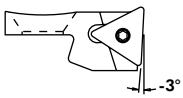
Note: Extension Base VPB 17BR 7108 requires only 2 of the 4 mounting screws. VPB 17BR 7119 and VPB 17BR 7121 are non stock items.

VPB CARTRIDGE NIBS

3° Lead Triangle

Part Number	Nib Size	Insert Type & Size	Insert Screw	Insert Screw Wrench	EDP
VPB 2813 T11	8	TCGT 21 .51	PT 542 T	T7 Torx Wrench	**52533**

-3 DEG. LEAD CARTRIDGE NIB

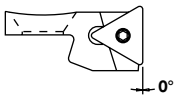


0° Lead Triangle

Part Number	Nib Size	Insert Type & Size	Insert Screw	Insert Screw Wrench	EDP
VPB 2810 T11	8	TCGT 21 .51	PT 542 T	T7 Torx Wrench	**52532**

*TCMT and TCMW inserts are interchangeable with TCGT inserts of the same size. *

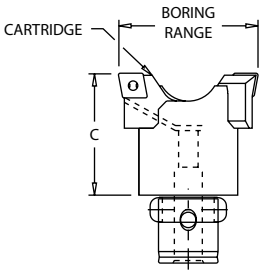
0 DEG. LEAD CARTRIDGE NIB



VPB ROUGH - TWIN BORING HEADS

RANGE 0.95 6.20 (24,1 MM 157 MM)

Val CONNECT™

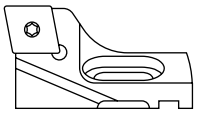


Note: Through spindle coolant capability is standard. Fast, easy set up. Maximum cutting speed is 1,000 SFM.

Boring Head Part Number	Connection Size	Inch Range		Metric Range		Cartridge Part Number (Set of 2) 0° Lead	Cartridge Part Number (Set of 2) 6° Lead	C	Wt. lbs.	EDP
		Min.	Max.	Min.	Max.					
VPB PC2 4215	PC2	.95	1.34	24,1	34,0	VPB 4210 21C06	—	1.39	0.28	**52469**
VPB PC3 4315	PC3	1.26	1.70	32,0	43,2	VPB 4310 31C06	VPB 4316 31S09	1.57	0.56	**52472**
VPB PC4 4415	PC4	1.58	2.17	40,0	55,1	VPB 4410 41C09	VPB 4416 41S09	1.85	0.98	**52475**
VPB PC5 2515	PC5	2.06	2.73	52,4	69,4	VPB 4510 51C12	VPB 4516 51S12	2.24	1.91	**52477**
VPB PC6 4615	PC6	2.61	3.50	66,3	88,9	VPB 4610 61C12	VPB 4616 61S12	2.79	3.97	**52485**
VPB PC6 4615	PC6	3.36	4.20	85,3	106,7	VPB 4610 62C12	VPB 4616 62S12	2.79	4.41	**52485**
VPB PC6 4715	PC6	3.92	4.86	99,6	123,5	VPB 4610 61C12	VPB 4616 61S12	2.79	5.04	**52486**
VPB PC6 4715	PC6	4.68	5.54	119,0	140,0	VPB 4610 62C12	VPB 4616 62S12	2.79	5.48	**52486**
VPB PC6 4715	PC6	5.44	6.20	138,0	157,0	VPB 4710 73C12	VPB 4716 73S12	2.79	5.85	**52486**

Note: Cartridges sold separately as sets.

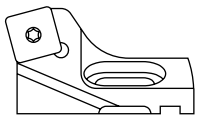
VPB CARTRIDGES



0 DEGREE LEAD CARTRIDGE

0° Lead

Cartridge Set Part Number	Insert Type	Insert Screw	Insert ScrewWrench	EDP
VPB 4210 21C06	CCGT 21.51	PT 464	T 7 Torx Wrench	**52534**
VPB 4310 31C06	CCGT 21.51	PT 464	T 7 Torx Wrench	**52535**
VPB 4410 41C09	CCGT 32.52	PT 559T	T 15 Torx Wrench	**52537**
VPB 4510 51C12	CCGT 432	PT 711T	T 20 Torx Wrench	**52539**
VPB 4610 61C12	CCGT 432	PT 711T	T 20 Torx Wrench	**52541**
VPB 4610 62C12	CCGT 432	PT 711T	T 20 Torx Wrench	**52542**
VPB 4710 73C12	CCGT 432	PT 711T	T 20 Torx Wrench	**52545**



6 DEGREE LEAD CARTRIDGE

6° Lead

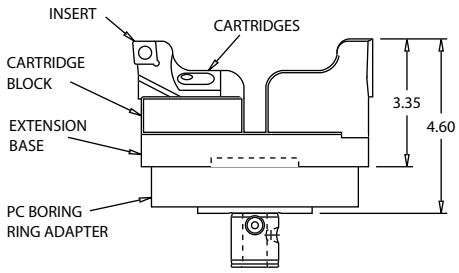
Cartridge Set Part Number	Insert Type	Insert Screw	Insert ScrewWrench	EDP
VPB 4316 31S09	SCGT 32.52	PT 559T	T 15 Torx Wrench	**52536**
VPB 4416 41S09	SCGT 32.52	PT 559T	T 15 Torx Wrench	**52538**
VPB 4516 51S12	SCGT 432	PT 711T	T 20 Torx Wrench	**52540**
VPB 4616 61S12	SCGT 432	PT 711T	T 20 Torx Wrench	**62190**
VPB 4616 62S12	SCGT 432	PT 711T	T 20 Torx Wrench	**52544**
VPB 4716 73S12	SCGT 432	PT 711T	T 20 Torx Wrench	**52546**

Note: CCMT and CCMW inserts are interchangeable with CCGT inserts of the same size.
SCMT and SCMW inserts are interchangeable with SCGT inserts of the same size.

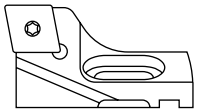
Val CONNECT™

VPB ROUGH - TWIN BORING HEADS

RANGE 5.95 - 14.34
(151,31 MM - 364,24 MM)
Maximum cutting speed is 1,000 SFM.



6 DEGREE LEAD CARTRIDGE


0 DEGREE LEAD CARTRIDGE

Rough Bore				Extension Base (1 Required)		Cartridge Block (1 Set of 2 Req'd)	PC Boring Ring Adapter (1 Req')	Cartridge (1 Set of 2 Required)		Lead Angle	Insert
Inch Range		Metric Range									
Min.	Max.	Min.	Max.	Part Number	EDP#	Part #/EDP#	Part #/EDP#	Part Number	EDP#		
5.95	6.80	151,31	172,72	VPB 17BR 7108	**52495**	VPB 7100 B460 **52502**	VPB PC6 17BR2 **52503**	VPB 4610 61C12	**52541**	0°	C... 4..
								VPB 4616 61S12	**62190**	6°	S... 4..
6.68	7.52	169,67	191,01	VPB 17BR 7108	**52495**			VPB 4610 62C12	**52542**	0°	C... 4..
								VPB4616 62S12	**52544**	6°	S... 4..
7.42	8.27	188,47	210,06	VPB 17BR 7108	**52495**			VPB 4710 73C12	**52545**	0°	C... 4..
								VPB 4716 73S12	**52546**	6°	S... 4..
8.22	9.07	208,79	230,38	VPB 17BR 7110	**52496**			VPB 4610 61C12	**52541**	0°	C... 4..
								VPB 4616 61S12	**62190**	6°	S... 4..
8.95	9.79	227,33	248,67	VPB 17BR 7110	**52496**			VPB 4610 62C12	**52542**	0°	C... 4..
								VPB 4616 62S12	**52544**	6°	S... 4..
9.69	10.54	246, 13	267,72	VPB 17BR 7110	**52496**			VPB 4710 73C12	**52545**	0°	C... 4..
								VPB 4716 73S12	**52546**	6°	S... 4..
10.49	11.34	266,45	288,04	VPB 17BR 7112	**52497**			VPB 4610 61C12	**52541**	0°	C... 4..
								VPB 4616 61S12	**62190**	6°	S... 4..
11.22	12.07	284,99	306,58	VPB 17BR 7112	**52497**			VPB 4610 62C12	**52542**	0°	C... 4..
								VPB 4616 62S12	**52544**	6°	S... 4..
11.96	12.81	303,78	325,37	VPB 17BR 7112	**52497**			VPB 4710 73C12	**52545**	0°	C... 4..
								VPB 4716 73S12	**52546**	6°	S... 4..
12.76	13.61	324,10	345,69	VPB 17BR 7115	**52498**			VPB 4610 61C12	**52541**	0°	C... 4..
								VPB 4616 61S12	**62190**	6°	S... 4..
13.49	14.34	342,65	364,24	VPB 17BR 7115	**52498**			VPB 4610 62C12	**52542**	0°	C... 4..
								VPB 4616 62S12	**52544**	6°	S... 4..

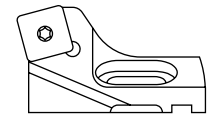
Note: CCMT and CCMW inserts are interchangeable with CCGT inserts of the same size. SCMT and SCMW inserts are interchangeable with SCGT inserts of the same size. CCGT 432 and SCGT 432 inserts use PT 711T screw, T 20 Torx Wrench.

Shipping Weights

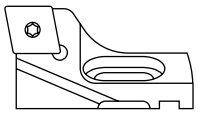
Part Number	Weight Lbs.
VPB17BR 7108	6.19
VPB17BR 7110	8.50
VPB17BR 7112	11.13
VPB17BR 7115	13.75
VPB17BR 7117	16.13
VPB17BR 7119	18.63
VPB17BR 7121	21.00
VPB7100 B460	2.31
VPB PC6 17BR2	7.00

VPB ROUGH - TWIN BORING HEADS

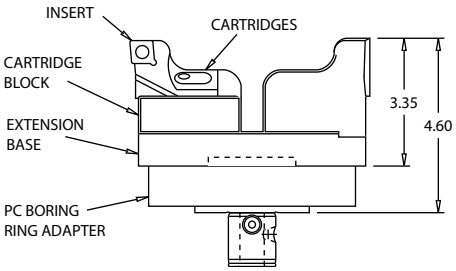
RANGE 14.23 - 21.89
(361,44 MM - 556,01 MM)
Maximum cutting speed is 1,000 SFM.



6 DEGREE LEAD CARTRIDGE



0 DEGREE LEAD CARTRIDGE

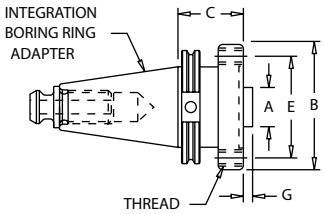


Rough Bore				Extension Base (1 Req'd)		Cartridge Block (1 Set of 2 Req'd)	PC Boring Ring Adapter (1 Req'd)	Cartridge (1 Set of 2 Required)		Lead Angle	Insert
Inch Range		Metric Range									
Min.	Max.	Min.	Max.	Part Number	EDP#	Part #/EDP#	Part #/EDP#	Part Number	EDP#		
14.23	15.08	361,44	383,03	VPB 17BR 7115	**52498**	VPB 7100 B460 **52502**	VPB PC6 17BR2 **52503**	VPB 4710 73C12	**52545**	0°	C... 4..
								VPB 4716 73S12	**52546**	6°	S... 4..
15.03	15.88	381,76	403,35	VPB 17BR 7117	**52499**			VPB 461 0 61C12	**52541**	0°	C... 4..
								VPB 461 6 61S12	**62190**	6°	S... 4..
15.75	16.61	400,05	421,89	VPB 17BR 7117	**52499**			VPB 4610 62C12	**52542**	0°	C... 4..
								VPB 4616 62S12	**52544**	6°	S... 4..
16.50	17.35	419,10	440,69	VPB 17BR 7117	**52499**			VPB 4710 73C12	**52545**	0°	C... 4..
								VPB 4716 73S12	**52546**	6°	S... 4..
17.30	18.15	439,42	461,01	VPB 17BR 7119	**52504**			VPB 4610 61C12	**52541**	0°	C... 4..
								VPB 4616 61S12	**62190**	6°	S... 4..
18.03	18.88	457,96	479,55	VPB 17BR 7119	**52504**			VPB 4610 62C12	**52542**	0°	C... 4..
								VPB 4616 62S12	**52544**	6°	S... 4..
18.77	19.62	476,76	498,35	VPB 17BR 7119	**52504**			VPB 4710 73C12	**52545**	0°	C... 4..
								VPB 4716 73S12	**52546**	6°	S... 4..
19.57	20.42	497,08	518,67	VPB 17BR 7121	**52505**			VPB 4610 61C12	**52541**	0°	C... 4..
								VPB 4616 61S12	**62190**	6°	S... 4..
20.29	21.15	515,37	537,21	VPB 17BR 7121	**52505**			VPB 4610 62C12	**52542**	0°	C... 4..
								VPB4616 62S12	**52544**	6°	S... 4..
21.04	21.89	543,56	556,01	VPB 17BR 7121	**52505**			VPB 4710 73C12	**52545**	0°	C... 4..
								VPB 4716 73S12	**52546**	6°	S... 4..

Note: VPB 17BR 7117 and VPB 17BR 7121 are non stock items. CCMT and CCMW inserts are interchangeable with CCGT inserts of the same size. SCMT and SCMW inserts are interchangeable with SCGT inserts of the same size. See previous page for shipping weights.

VPB INTEGRAL BORING RING ADAPTERS

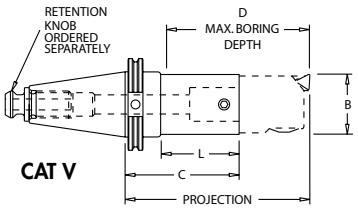
REPLACES PC BORING RING ADAPTER

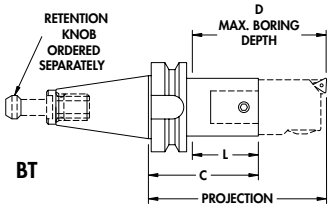


Part Number	Style	A Dia.	B Dia.	C	E	G	EDP#
VPB C50 17BR2	CAT 50	1.750	4.94	2.50	4.00	.250	**52615**
VPB C50 17BR5	CAT 50	1.750	4.94	5.00	4.00	.250	**52616**
VPB N50 17BR2	NMTB 50	1.750	4.94	2.00	4.00	.250	**52641**

ValCONNECT™

VPB MODULAR TOOLING SYSTEMS - CAT "V" FLANGE TAPER SHANK





Note: 'D" and "P" dimensions are slightly shorter for twin bore roughing for sizes PC2 and PC5

40 Taper

Part Number	Connection Size	Dimensions					Wt. lbs.	EDP
		B	C	D	L	P		
VPB C40 PC2 3	PC2	.944	3.327	3.150	1.952	4.803	2.50	**52601**
VPB C40 PC2 4	PC2	.944	4.114	3.937	2.739	5.590	2.63	**52602**
VPB C40 PC3 3	PC3	1.220	3.150	3.600	1.775	4.764	2.63	**52603**
VPB C40 PC3 5	PC3	1.220	5.118	5.570	3.743	6.732	3.25	**52604**
VPB C40 PC4 3	PC4	1.535	2.874	3.150	1.499	4.724	2.72	**52605**
VPB C40 PC4 6	PC4	1.535	6.024	6.300	4.949	7.874	4.25	**52607**
VPB C40 PC5 3	PC5	1.968	2.480	3.150	1.105	4.724	2.72	**52608**
VPB C40 PC5 6	PC5	1.968	5.630	6.300	4.255	7.874	5.53	**52609**
VPB C40 PC6 3	PC6	2.520	2.000	3.221	.625	4.795	N/A	**52610**
VPB C40 PC6 4	PC6	2.520	2.716	3.937	1.341	5.511	3.31	**52612**
VPB C40 PC6 6	PC6	2.520	5.079	6.300	3.704	7.874	6.34	**52614**

50 Taper

Part Number	Connection Size	Dimensions					Wt. lbs.	EDP
		B	C	D	L	P		
VPB C50 PC2 4	PC2	.944	4.114	3.937	2.739	5.590	7.00	**52617**
VPB C50 PC2 5	PC2	.944	5.295	5.118	3.920	6.771	7.25	**52618**
VPB C50 PC3 4	PC3	1.220	3.937	4.393	2.562	5.551	7.38	**52619**
VPB C50 PC3 5	PC3	1.220	5.118	5.570	3.743	6.732	7.72	**52620**
VPB C50 PC3 6	PC3	1.220	6.300	6.125	4.295	7.914	8.09	**52621**
VPB C50 PC4 4	PC4	1.535	3.611	3.937	2.236	5.461	7.59	**52622**
VPB C50 PC4 6	PC4	1.535	6.024	6.300	4.649	7.874	8.69	**52624**
VPB C50 PC4 8	PC4	1.535	7.598	7.875	6.223	9.448	9.50	**52625**
VPB C50 PCS 4	PC5	1.968	3.268	3.937	1.893	5.512	7.84	**52627**
VPB C50 PCS 6	PC5	1.968	5.630	6.300	4.255	7.874	9.72	**52628**
VPB C50 PCS 8	PC5	1.968	7.205	7.875	5.830	9.449	10.94	**52629**
VPB C50 PCS 10	PC5	1.968	9.567	10.236	8.192	11.811	12.75	**52626**
VPB C50 PC6 4	PC6	2.520	2.716	3.937	1.341	5.511	7.66	**52632**
VPB C50 PC6 6	PC6	2.520	5.079	6.300	3.704	7.874	10.78	**52634**
VPB C50 PC6 8	PC6	2.520	6.654	7.875	5.279	9.449	12.84	**52635**
VPB C50 PC6 10	PC6	2.520	9.016	10.236	7.641	11.811	15.94	**52630**
VPB C50 PC6 12	PC6	2.520	11.378	12.598	10.000	14.173	19.09	**52631**

VPD MODULAR TOOLING SYSTEMS - BT FLANGE TAPER SHANK

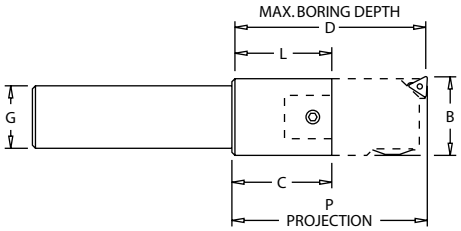
40 Taper

Part Number	Connection Size	Dimensions					Wt. lbs.	EDP#
		B	C	D	L	P		
VPB B40 PC2 4	PC2	.944	3.799	3.937	2.539	5.275	2.53	**52595**
VPB B40 PC3 5	PC3	1.220	4.803	5.118	3.543	6.417	3.16	**52596**
VPB B40 PC4 3	PC4	1.535	2.560	3.150	1.300	4.410	2.75	**52597**
VPB B40 PC5 5	PC5	1.968	4.134	5.118	2.875	6.378	4.22	**52598**
VPB B40 PC6 4	PC6	2.520	2.402	3.937	1.142	5.197	3.13	**52599**

50 Taper

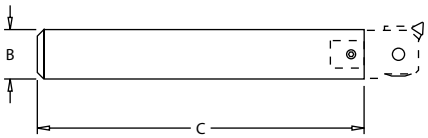
Part Number	Connection Size	Dimensions					Wt. lbs.	EDP#
		B	C	D	L	P		
VPB B50 PC6 4	PC6	2.520	2.835	3.937	1.142	5.630	8.84	**52600**

VPB MODULAR TOOLING SYSTEMS - STRAIGHT SHANK



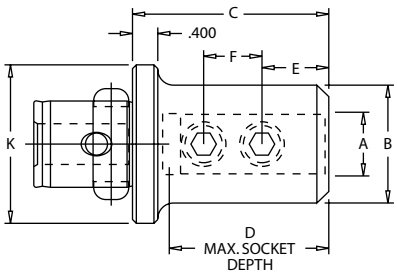
Part Number	Connection Size	Dimensions						Wt. lbs.	EDP#
		B	C	D	G	L	P		
VPB S12 PC4 3	PC4	1.535	2.00	3.75	1.250	1.75	3.850	2.01	**52646**
VPB S12 PC6 4	PC6	2.520	2.00	4.70	1.250	2.70	4.795	3.06	**52647**
VPB S20 PC6 4	PC6	2.520	2.00	4.70	2.000	2.70	4.795	5.19	**52648**

VPB MODULAR TOOLING SYSTEMS - HEAVY METAL BAR



Part Number	Connection Size	Dimensions		Wt. Lbs.	EDP
		B	C		
VPB PC2 094HM11	PC2	.9375	11.420	3.94	**52508**
VPB PC3 125HM14	PC3	1.250	13.780	8.96	**52511**
VPB PC4 150HM15	PC4	1.500	14.750	11.88	**52514**

VPB MODULAR TOOLING SYSTEMS - END MILL HOLDER



Part Number	Conn. Size	Dimensions							Set Screw	Screw Torque (Ft.- Lbs.)	Wt. lbs.	EDP
		A Dia.	B Dia.	C	D	E	F	K				
VPB PC6 18EM1	PC6	.188	.68	1.284	-	.44	-	2.520	1/4 28x1/4WSS	4	1.22	**52563**
VPB PC6 25EM1	PC6	.250	.88	1.284	-	.44	-	2.520	1/4 28X1/4WSS	7	1.26	**52566**
VPB PC6 37EM2	PC6	.375	1.00	1.784	-	.75	-	2.520	3/8 24x5/16WSS	12	1.30	**62195**
VPB PC6 50EM2	PC6	.500	1.25	1.904	-	.88	-	2.520	7/16 20x3/8WSS	17	1.53	**52570**
VPB PC6 62EM3	PC6	.625	1.50	3.034	-	.94	-	2.520	9/16 18X1/2WSS	31	2.13	**62196**
VPB PC6 75EM3	PC6	.750	1.75	3.034	2.75	1.00	-	2.520	5/8 18X1/2WSS	43	2.50	**52572**
VPB PC6 87EM3	PC6	.875	1.88	3.034	2.75	1.00	.81	2.520	5/8 18x1/2WSS	48	2.57	**52574**
VPB PC6 10EM3	PC6	1.000	2.00	3.284	2.88	1.12	1.00	2.520	5/8 18X1/2WSS	69	2.94	**62191**
VPB PC6 12EM3	PC6	1.250	2.52	3.284	3.00	1.12	1.00	2.520	3/4 16x11/16WSS	69	3.94	**62192**

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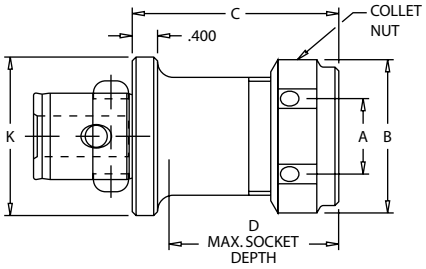
VPB MODULAR TOOLING SYSTEMS - VDF STYLE COLLET CHUCKS

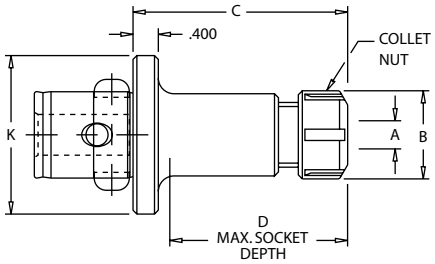
RANGE .093 - 1.500



Part Number	Connection Size	Collet Series	Dimensions					Collet Nut	Nut Torque (Ft.- Lbs.)	Wt. lbs.	EDP#
			A Range	B	C	D	K				
VPB PC6 10SC3	PC6	VDF 10	.093 - 1.000	2.44	3.248	2.72	2.520	VCCNP 10SGF	60	2.73	**52554**
VPB PC6 15SC3	PC6	VDF 15	.500 - 1.500	3.43	3.784	3.30	2.520	VCCNP 15	70	3.97	**52559**

VPB MODULAR TOOLING SYSTEMS - ER STYLE COLLET CHUCKS

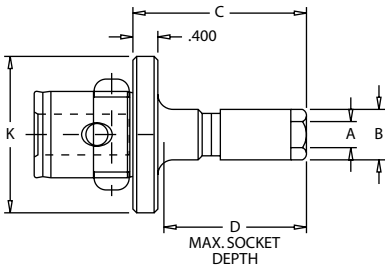
RANGE .019 - .787



Part Number	Connection Size	Collet Series	Dimensions					Collet Nut	Nut Torque (Ft.- Lbs.)	Wt. lbs.	EDP#
			A Range	B	C	D	K				
VPB PC6 16ER3	PC6	ER16	.01 9 .393	1.10	3.284	3.00	2.520	VSAC 16CN25	52	.88	**62193**
VPB PC6 32ER3	PC6	ER32	.078 .787	1.97	3.284	3.00	2.520	VSAC 32CN	95	1.77	**52567**

VPB MODULAR TOOLING SYSTEMS - DOUBLE ANGLE COLLET CHUCKS

RANGE .062 - .750



Part Number	Connection Size	Collet Series	Dimensions					Compression Nut	Nut Torque (Ft.- Lbs.)	Wt. lbs.	EDP#
			A Range	B	C	D	K				
VPB PC6 18DC2	PC6	VDA18	.250 .750	1.44	3.434	3.00	2.520	PT 913 Nut	40	1.53	**52562**
VPB PC6 20DC2	PC6	VDA20	.062 .375	0.81	3.434	3.40	2.520	PT 914Nut	30	1.30	**52564**

VPB MODULAR TOOLING SYSTEMS - REDUCERS

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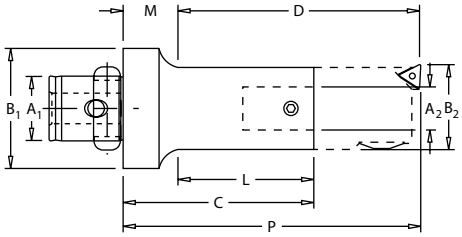
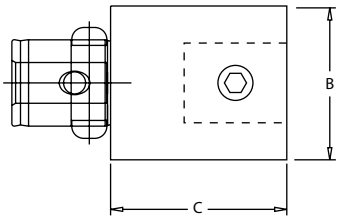


Part Number	A1 Connection	A2 Connection	Dimensions							Wt. lbs.	EDP#
			B1	B2	C	D	L	M	P		
VPB PC3 PC2R1	PC3	PC2	1.220	.945	1.358	2.362	.965	.394	2.834	N/A	**52575**
VPB PC4 PC2R2	PC4	PC2	1.535	.945	2.028	2.953	1.555	.472	3.504	.59	**52576**
VPB PC4 PC3R2	PC4	PC3	1.535	1.220	1.850	2.953	1.378	.472	3.464	1.03	**52577**
VPB PC5 PC2R2	PC5	PC2	1.969	.945	2.028	2.756	1.358	.669	3.504	.75	**52578**
VPB PC5 PC2R3	PC5	PC2	1.969	.945	3.209	3.937	2.539	.669	4.685	1.12	**52579**
VPB PC5 PC3R1	PC5	PC3	1.969	1.220	1.850	2.756	1.181	.669	3.464	.96	**52580**
VPB PC5 PC3R3	PC5	PC3	1.969	1.220	3.031	3.937	2.362	.669	4.645	1.28	**52581**
VPB PC5 PC4R1	PC5	PC4	1.969	1.535	1.575	2.756	.906	.669	3.425	1.06	**52582**
VPB PC5 PC4R2	PC5	PC4	1.969	1.535	2.756	3.937	2.087	.669	4.606	1.59	**52583**
VPB PC6 PC2R2	PC6	PC2	2.520	.945	2.382	3.150	1.752	.630	3.858	1.50	**52584**
VPB PC6 PC2R3	PC6	PC2	2.520	.945	3.760	4.528	3.130	.630	5.236	1.78	**52585**
VPB PC6 PC3R2	PC6	PC3	2.520	1.220	2.205	3.150	1.575	.630	3.819	1.66	**52586**
VPB PC6 PC3R3	PC6	PC3	2.520	1.220	3.583	4.528	2.953	.630	5.197	2.06	**52587**
VPB PC6 PC3R5	PC6	PC3	2.520	1.220	5.354	6.300	4.724	.630	6.968	2.56	**52588**
VPB PC6 PC4R1	PC6	PC4	2.520	1.535	1.929	3.150	1.299	.630	3.779	1.72	**52589**
VPB PC6 PC4R3	PC6	PC4	2.520	1.535	3.307	4.528	2.677	.630	5.157	2.39	**52590**
VPB PC6 PC4R5	PC6	PC4	2.520	1.535	5.079	6.300	4.449	.630	6.929	2.97	**52591**
VPB PC6 PC5R1	PC6	PC5	2.520	1.969	1.535	3.150	.906	.630	3.779	1.75	**52592**
VPB PC6 PC5R3	PC6	PC5	2.520	1.969	2.913	4.528	2.283	.630	5.157	2.89	**52593**
VPB PC6 PC5R4	PC6	PC5	2.520	1.969	4.685	6.300	4.055	.630	6.929	4.06	**52594**

VPB MODULAR TOOLING SYSTEMS - EXTENSIONS



Part Number	Connection Size	Dimensions		Wt. lbs.	EDP#
		B	C		
VPB PC2 PC2E1	PC2	.944	1.181	.25	**52509**
VPB PC2 PC2E2	PC2	.944	1.772	.37	**52510**
VPB PC3 PC3E1	PC3	1.220	1.181	.34	**52512**
VPB PC3 PC3E2	PC3	1.220	1.772	.53	**52513**
VPB PC4 PC4E1	PC4	1.535	1.575	.75	**52515**
VPB PC4 PC4E2	PC4	1.535	2.362	1.13	**52516**
VPB PC5 PC5E2	PC5	1.968	2.362	1.88	**52517**
VPB PC5 PC5E3	PC5	1.968	3.543	2.81	**52518**
VPB PC6 PC6E2	PC6	2.520	2.362	3.00	**52519**
VPB PC6 PC6E4	PC6	2.520	3.937	5.03	**52520**

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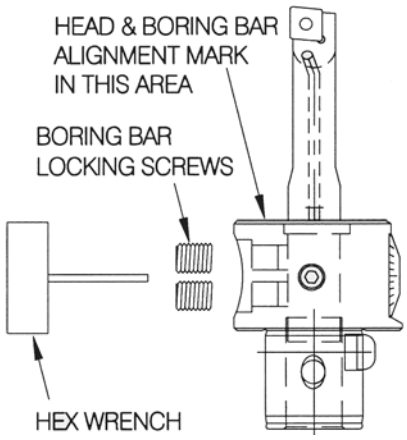
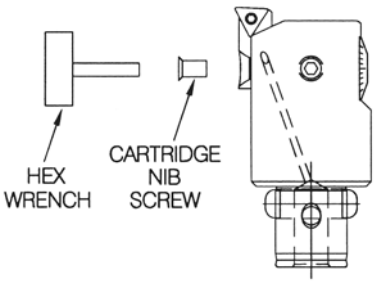
SPARE PARTS & ACCESSORIES



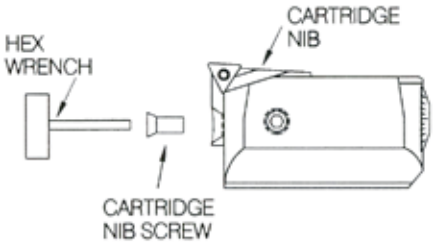
Spare Parts

Boring Unit Part Number	Boring Bar Locking Screws		Hex Wrench	
	Part #	EDP#	Part #	EDP#
VPB PC6-205	PT-91 BBLS		M 5 T Wrench	**55440**
VPB PC6-2015	PT-911 BBLS	**55475**	M 5 T Wrench	**55440**



Spare Parts

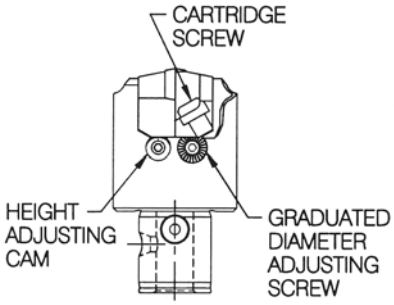
Boring Unit Inch Part Number	Boring Unit Metric Part Number	Cartridge Nib Screw		Hex Wrench	
		Part #	EDP#	Part #	EDP#
VPB PC2-2215	VPB PC2-2205	VPB 2215-01	**52654**	V 2.5 T Wrench	**55436**
VPB PC3-2315	VPB PC3-2305	VPB 2315-01	**52665**	M 3 T Wrench	**55438**
VPB PC4-2415	VPB PC4-2405	VPB 2415-01	**52656**	M 4 T Wrench	**55439**
VPB PC5-2515	VPB PC5-2505	VPB 2515-01	**52657**	M 5 T Wrench	**55440**
VPB PC6-2615	VPB PC6-2605	VPB2615-01	**52654**	M 6 T Wrench	**55441**
VPB PC6-2715	VPB PC6-2705	VPB 2615-01	**52654**	M 6 T Wrench	**55441**



Spare Parts

Boring Unit Part Number	Cartridge Nib Part Number	Cartridge Nib Screw		Hex Wrench	
		Part #	EDP#	Part #	EDP#
VPB 7100-2801	VPB 2813-T11	VPB 2615-01	**52654**	M 6 T Wrench	**55441**
VPB 7100-2811	VPB 2813-T11	VPB 2615-01	**52654**	M 6 T Wrench	**55441**

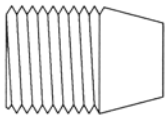
ROUGH BORING UNITS



Spare Parts

Boring Unit Part Number	Diameter Adjustment Screw (Set)		Cartridge Screw (Set)		Height Adjustment Cam (Set)		Wrench Kit		Spare Kit (One Set Each)	
	Part #	EDP#	Part #	EDP#	Part #	EDP#	Part #	EDP#	Part #	EDP#
VPB PC2-4215	VPB 4205-11	**52660**	VPB 4205-12		VPB 4205-13	**52662**	PT-906 Kit	**97269**	VPB 4205-10	**52559**
VPB PC3-4315	VPB 4305-11	**52664**	VPB 4305-12		VPB 4305-13	**52666**	PT-907 Kit	**97167**	VPB 4305-10	**52663**
VPB PC4-4415	VPB 4405-11	**52668**	VPB 4405-12	**52669**	VPB 4405-13	**52670**	PT-908 Kit	**97168**	VPB 4405-10	**52667**
VPB PC5-4515	VPB 4505-11	**52672**	VPB 4505-12	**52673**	VP 4505-13	**52674**	PT-909 Kit	**97169**	VPB 4505-10	**52671**
VPB PC6-4615	VPB 4605-11	**52676**	VPB4605-12	**52677**	VPB 4605-13	**52678**	PT-910 Kit	**97170**	VPB 4605-10	**52675**
VPB PC6-4715	VPB 4605-11	**52676**	VPB4605-12	**52677**	VPB 4605-13	**52678**	PT-910 Kit	**97170**	VPB 4605-10	**52675**
VPB 7100-B460	VPB 4605-11	**52676**	VPB4605-12	**52677**	VPB 4605-13	**52678**	PT-910 Kit	**97170**	VPB 4605-10	**52675**

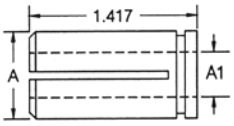
PC STYLE SCREWS



Spare Parts

Connection Size	Screw Part Number		Wrench	
	Part #	EDP#	Part #	EDP#
PC@	VPB 880-002	**52683**	M2.5 T Wrench	**55436**
PC3	VPB 880-003	**52684**	M3 T Wrench	**55438**
PC4	VPB 880-004	**52685**	M4 T Wrench	**55439**
PC4	VPB 880-004	**52685**	M4 T Wrench	**55439**
PC5	VPB 880-005	**52686**	M5 T Wrench	**55440**
PC6	VPB 880-006	**52687**	M6 T Wrench	**55441**
PC7	VPB 880-007	**52688**	M6 T Wrench	**55441**

REDUCTION BUSHINGS



Spare Parts

Part Number	A	A1	EDP#
VPB 62RB-187	.625	.187	52488
VPB 62RB-250	0325	250	52489
VPB 62RB-312	.625	.312	52490
VPB 62RB-375	.625	.375	52491
VPB 62RB-500	.625	.500	52492
VPB 62RB-10MM	.625	10mm	52487
VPB 62RB-12MM	.625	12mm	52493
VPB 62RB 14MM	.625	14mm	52494

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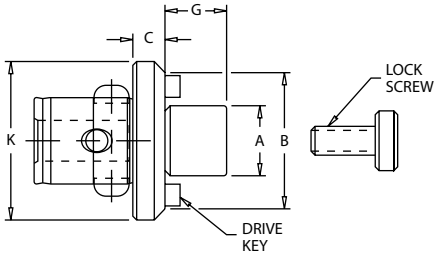
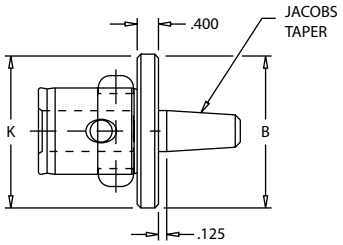
VPB MODULAR TOOLING SYSTEMS - SHELL MILL ADAPTERS



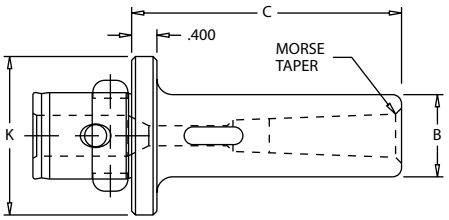
Part Number	Connection Size	Dimensions					Drive Key	Lock Screw	Wt. lbs.	EDP
		A Dia.	B Dia.	C	G	K				
VPB PC6 75SM1	PC6	.750	1.750	.784	.68	2.520	.31	3/4 -16x1 3/4 SHCS	1.63	**62197**
VPB PC6 10SM1	PC6	1.000	2.250	.784	.68	2.520	.38	3/8 - 24 X 1 SHCS	1.84	**52555**
VPB PC6 12SM1	PC6	1.250	2.750	1.034	.68	2.520	.50	5/8 -18 x 1 1/4 SHCS	2.62	**52558**
VPB PC6 15SM2	PC6	1.500	3.750	1.534	.93	2.520	.62	5005 UNIV SCR	5.28	**52560**

VPB MODULAR TOOLING SYSTEMS - JACOBS TAPER ADAPTERS



Part Number	Connection Size	Jacobs Taper	Dimensions		Wt. lbs.	EDP
			B Dia.	K		
VPB PC6 02JT1	PC6	2	2.520	2.520	N/A	**52551**
VPB PC6 33JT1	PC6	33	2.520	2.520	1.19	**52568**

VPB MODULAR TOOLING SYSTEMS - MORSE TAPER ADAPTERS



Part Number	Connection Size	Morse Taper	Dimensions			Wt. lbs.	EDP
			B Dia.	C	K		
VPB PC6 03MT5	PC6	3	1.620	4.78	2.52	2.94	**52552**

TECHNICAL INFORMATION

ValCONNECT™

Small Diameter Precision Boring Head (5,000 RPM Max)

Boring Bar Installation

1. First loosen the boring bar locking screws as shown in Figure 1.
2. Do not use boring bars that have flats on the shank. Boring bar locking screws do not directly contact the bar shank. Damage will result when the boring bar locking screws are positioned over a flatted bar and tightened.
3. Insert the bar and reducing bushing (if necessary) into the boring head.
4. Position the boring bar into the boring head at the minimum overhang length.
5. Now rotate the bar such that the insert cutting edge lines up with the alignment mark on top of the boring head body. See Figure 1 for location of alignment marks. (Valenite VPB bars have alignment marks on the shank).
6. Tighten the boring bar locking screws that were loosened in step 1.

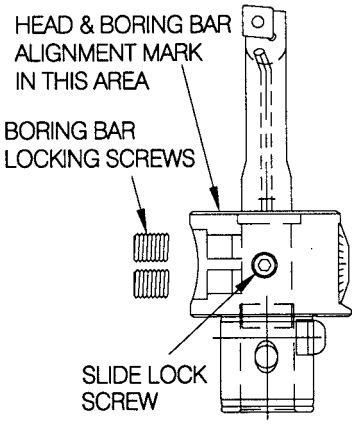


FIGURE 1

Preliminary (Coarse) Adjustment

Initial settings should be made on a tool presetter, or trial cuts can be taken to obtain a hole size suitable for fine adjustment to be made on the dial and vernier.

Using the Dial and Vernier Scale

1. The dial scale is graduated in increments of 0.001″ per graduation. Finer adjustments, (increments of 0.0001″) can be made by utilizing the vernier scale.
2. To use the dial scale, first loosen the slide lock screw shown in Figure 1 with the Torx ® wrench. Use the same wrench to adjust the dial.
3. To make an adjustment, take a reading of the dial's current position in relation to the zero reference line. Rotate the dial in the clockwise direction only for final adjustments. Each line on the dial will make a .001″ adjustment on the diameter. One full rotaion of the dial will make a .040″ adjustment on the diameter.
4. The vernier scale is located across the dial scale as shown in Figure 2.
5. Look at the lines on the dial scale and the vernier scale. Locate where the lines on both the dial and vernier scales match up exactly. For example, in Figure 2, the .0007″ line on the vernier scale lines up with the line on the .002″ line on the dial scale.
6. To make an adjustment in tenths, add the adjustment dimension to the current reading and rotate the dial until the appropriate vernier scale line is aligned with the dial line. For an example, in Figure 2 the zero reference line is between .035″ and .036″ on the dial scale. The .002″ line on the dial scale best matches with the .0007″ line on the vernier scale. Therefore, the actual reading is.0357″. To make a .0004″ adjustment, add .0004″ to .0357″ to get .0361″. Next, rotate the dial scale in a clockwise direction so the reference line on the dial scale is between .036″ and .037″ and the vernier line .0001″ matches up with a line on the dial scale, yielding .0361″. (Figure 3).
7. Before use, tighten the slide lock screw (Figure Note: .

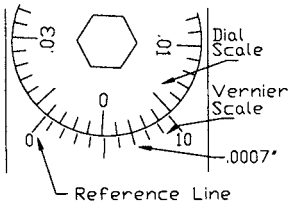


FIGURE 2

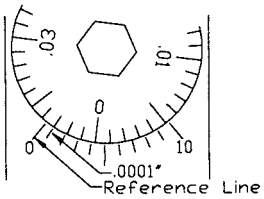


FIGURE 3

REMEMBER...

1. CAUTION: Insure that the bar does not have a "flat" under the clamp screw.
2. Never attempt to use the boring tool without tightening the slide lock screw after adjustments.
3. Always adjust the dial scale in a clockwise direction on the boring head.
4. Never attempt to adjust the dial scale without first loosening the slide lock screw.
5. DO NOT force head beyond mechanical stops!

Maintenance

The Valenite precision boring head is constructed of alloy steel, stainless steel, and a graphite based epoxy resin. The graphite resin is self lubricating and requires no maintenance. To insure long service life, two to four times a year (depending on the severity of conditions) the head should be adjusted to the outward end of travel and light spindle or machine oil applied to the exposed section of the head. This will lubricate the alloy components of the head, and no further maintenance should be required.

	Recommended Torque (in - lbs)	
Finish Head	Slide Lock Screw	Boring Bar Lock Screw
VPB PC6 2015	180	240
VPB PC6 2005	180	240

ValCONNECT™

TECHNICAL INFORMATION

Precision Boring Head (1,000 SFM Max)

Preliminary (Coarse) Adjustment

1. Initial settings should be made on a tool presetter, or trial cuts can be taken to obtain a hole size suitable for fine adjustment to be made on the dial and vernier.
2. To adjust for bore size, loosen the slide lock screw (Figure1).
3. Next, rotate the boring head dial to adjust the cartridge position. A clockwise rotation increases bore size, and a counter clockwise rotation decreases bore size. All final adjustments must be made clockwise.
4. After all necessary adjustments have been made, tighten the slide lock screw to the recommended torque. See chart below.

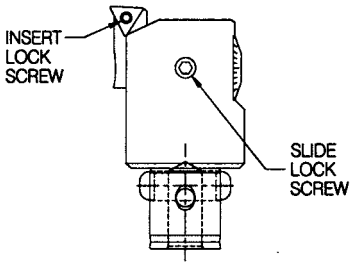


FIGURE 1

Using the Dial and Vernier Scale

1. The dial scale is graduated in increments of 0.001″ per graduation. Finer adjustments, (increments of 0.0001″) can be made by utilizing the vernier scale.
2. To use the dial scale, first loosen the slide lock screw shown in Figure 1 with the Torx ® wrench. Use the same wrench to adjust the dial.
3. Rotate the dial only in the clockwise direction (increasing increments) for final adjustments.
4. The vernier scale is located across the dial scale as shown in Figure 2.
5. Look at the lines on the dial scale and the vernier scale. Locate where the lines on both the dial and vernier scales match up exactly. For example, in Figure 2, the .0007″ line on the vernier scale lines up with the line on the .002″ line on the dial scale.
6. To make an adjustment in tenths, add the adjustment dimension to the current reading and rotate the dial until the appropriate vernier scale line is aligned with the dial line. For an example, in Figure 2 the zero reference line is between .035″ and .036″ on the dial scale. The .002″ line on the dial scale best matches with the .0007″ line on the vernier scale. Therefore, the actual reading is.0357″. To make a .0004″ adjustment, add .0004″ to .0357″ to get .0361″. Next, rotate the dial scale in a clockwise direction so the reference line on the dial scale is between .036″ and .037″ and the vernier line .0001″ matches up with a line on the dial scale, yielding .0361″. (Figure 3).
7. Before use, tighten the slide lock screw (Figure1).

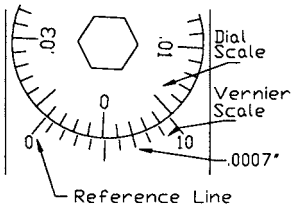


FIGURE 2

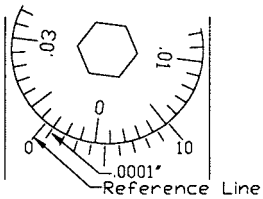


FIGURE 3

Remember

1. Never attempt to adjust the dial scale without first loosening the slide lock screw.
2. Never attempt to use the tool without tightening the slide lock screw after adjustments.
3. Always turn the dial scale in a clockwise direction on the boring head.
4. DO NOT force head beyond mechanical stops!

Maintenance

The Valenite precision boring head is constructed of alloy steel, stainless steel, and a graphite based epoxy resin. The graphite resin is self lubricating and requires no maintenance. To insure long service life, two to four times a year (depending on the severity of conditions) the head should be adjusted to the outward end of travel and light spindle or machine oil applied to the exposed section of the head. This will lubricate the alloy components of the head, and no further maintenance should be required.

	Recommended Torque (in - lbs)		
Finish Head	Side Lock Screw	Cartridge Nib Screw	PC Screw
VPB PC2 2215	36	48	36
VPB PC3 2315	48	60	48
VPB PC4 2415	60	84	72
VPB PC5 2515	120	144	96
VPB PC6 2615	120	144	120
VPB PC6 2715	120	144	120

TECHNICAL INFORMATION

Val CONNECT™

Twin Boring Head (1,000 SFM Max)

Operation

It is recommended that the Series 4 Twin Cutter Units be adjusted on a tool presetter.

Installing Cartridges (Figure 1)

1. Remove the two cartridge lock screws and set them aside.
2. Place the cartridges into the head, making sure that the slot on the bottom of each cartridge engages the head of the diameter adjusting screw.
3. Reinstall the two cartridge locking screws. Adjust for cutting as explained below in the sections "Adjusting for Balanced Cutting" or "Adjusting for Stepped Cutting."

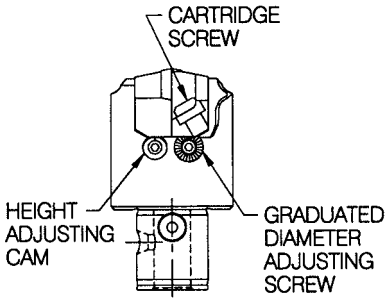


Figure 1

Adjusting For Balanced Cutting

Balanced cutting allows both cutting edges to work simultaneously. A properly balanced twin cutter may be fed at almost four times the rate of a single cutter.

1. Unlock the cartridge lock screw for each cartridge. Make sure the height adjusting cams are located with the reference mark (lowest point) in the vertical position as shown. See Figure 2.
2. Lightly snug each cartridge lock screw just enough to put a slight drag on both cartridges. See Figure 1.
3. Adjust each cartridge to the desired diameter by turning the graduated diameter adjusting screw (Figure Note: . Always adjust in a clockwise direction.
4. Adjust each cartridge to within ±.001 on the diameter.
5. After adjustment and before use, securely tighten both cartridge locking screws.

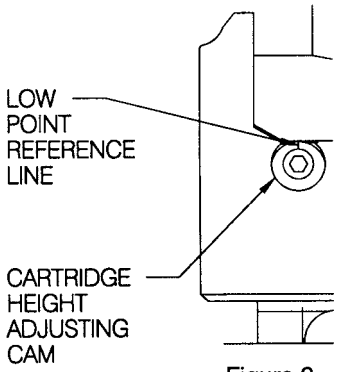


Figure 2

Adjusting For Stepped Cutting

Stepped cutting allows removal of more metal since each insert is set at a different diameter.

1. Unlock the cartridge lock screw for each cartridge. Make sure the height adjusting cams are located with the reference mark (lowest point) in the vertical position as shown Figure 2.
2. Lightly snug each cartridge lock screw just enough to put a slight drag on both cartridges. See Figure 1.
3. Adjust each cartridge to the desired diameter by turning the graduated diameter adjusting screw (Figure Note: . Always adjust in a clockwise direction. Set the diameter of each cartridge to remove approximately one half of the total bore diameter.
4. Using the height adjusting cam, adjust the cartridge with the inner cutting edge, so that it has axial lead over the cartridge with the outer cutting edge. This lead should be a minimum of .002" more than the feed per revolution.

Note: When using stepped cutting, the feed rate must be that of a single cutter.

	Recommended Torque (in-lbs)	
Finish Head	Cartridge Screw	PC Screw
VPB PC2 4215	12	36

THERMAL TOOLHOLDING SYSTEM

How It Works 330-331

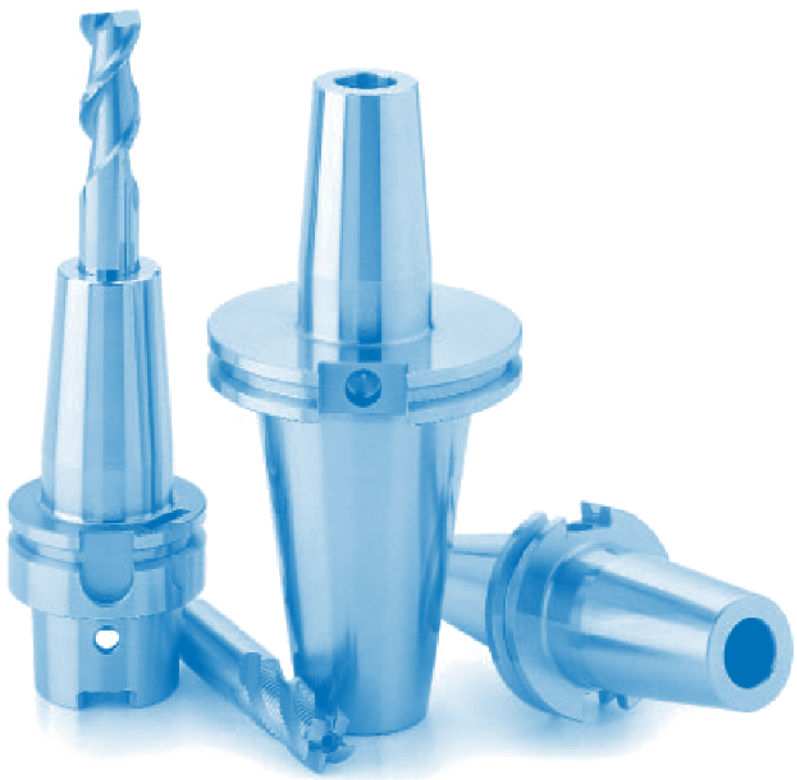
Thermal Toolholder HSK Adapter 332

Thermal Toolholder CAT Adapter 332

Thermal Toolholder Tool Extension 333

Thermal Toolholder Axial Adjusting Gage 333

Technical Section 334



Thermal Tooling - Cold Things Contract Hot Things Expand

ValTRU™

Extreme Precision
The shrink fit process is inherently precise to 3 microns or better, with a uniform 360° clamping force that minimizes runout and tool distortion from unbalanced thermal and mechanical stresses. Tools are easily pre-set during the installation process.

High Clamping Force
Tools and toolholders are connected with a high strength interference fit over the entire length of the tool's shank. The clamping force typically exceeds the shear strength of the cutting tool material.

Inherent Balance
Shrink fit tools are very compact and absolutely symmetrical because there are no flats, keyways, or mechanical components involved. Heat shrinking is the system of choice for high speed metalcutting applications.

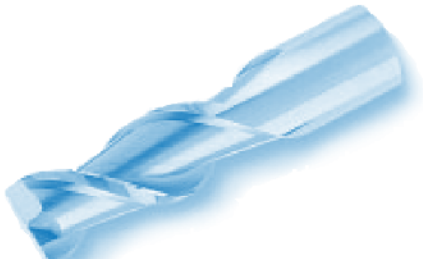
Thru-Coolant Adaptable
The interference fit between the tool and toolholder is self sealing, greatly simplifying the delivery of coolant through the tool. No special screws, mechanical or elastomeric seals are required.

Job Ready
Shrink fit toolholders are available in popular sizes for HSK, CAT V flange and many other spindles for tools with shank diameters up to 50 mm (2.00 in.).

It's all about what you don't need!

The Valenite Thermal Toolholding System lets you minimize your investment and your inventory requirements by allowing both carbide and high speed steel tools to be used in the same toolholder. In addition, you'll make your life easier by eliminating:

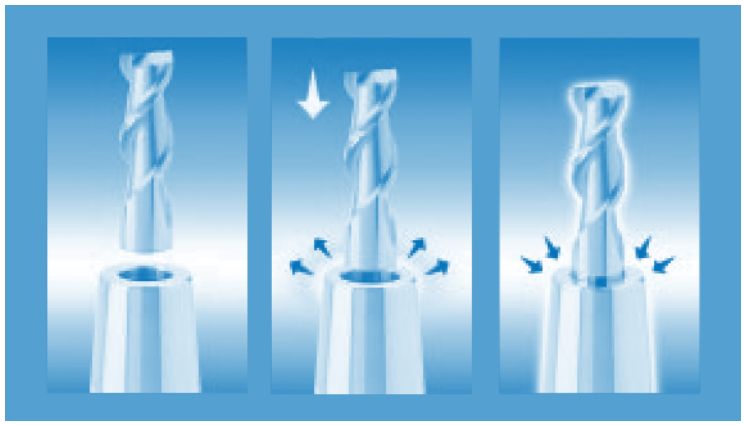
- Collets
- Collet nuts
- Collet seals
- Special locking screws
- Torque wrenches
- Leaking hydraulic fluid



It also provides the precision,performance, strength and durability you expect and require in real world operating conditions. This revolutionary thermal toolholding system uses carefully selected and processed toolholder materials and a precisely controlled heating/cooling cycle. Shrink fit tools are available for most popular HSK and CAT V taper spindles, plus many other standard and special geometries. To improve the precision and performance of your rotary metalcutting operations right now, all you have to do is turn the page.

ValTRU™

Thermal Toolholding How it Works



At the core of the system
Valenite shrink fit toolholders are made from a special, heat resistant tool steel that can be heated and cooled up to 5,000 times without structural damage or loss of geometric precision. This material needs only to be heated between 300° and 340°C (572° 644°F) to handle both steel and carbide tools (Figure 1).

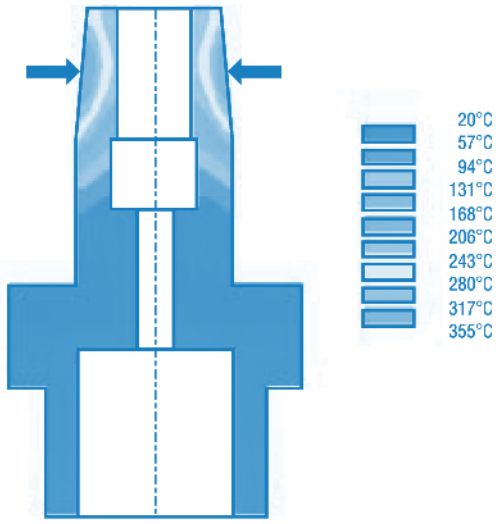


FIG. 1

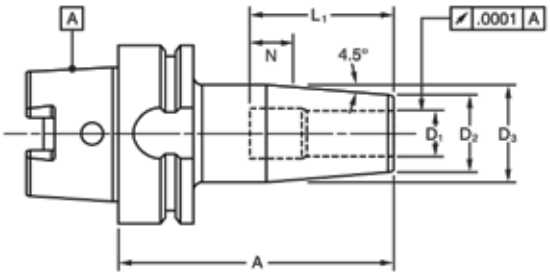
Fast and efficient
With other systems, steel tools are difficult to remove because they have essentially the same coefficient of thermal expansion as the toolholders, and tend to absorb a great deal of thermal energy during the relatively slow heating cycle. The Valenite system overcomes this by raising the temperature of the toolholder very rapidly using an advanced induction heating technology. The toolholder heats so fast that the cutting tool does not have time to expand during the heating cycle of 5 to 10 seconds. In addition, the tool is electro magnetically shielded which helps to keep it cool.

- Recommended for drilling, end milling, reaming, and boring
- Thru-coolant capability
- Carbide and HSS cutting tools can be used
- Axial adjustment
- Less than .0001 runout
- Balanced by design

THERMAL TOOLHOLDING HSK ADAPTER

INCH

- Recommended for drilling, end milling, reaming, and boring.
- Thru-coolant capability
- Carbide and HSS cutting tools can be used
- Axial adjustment
- Less than .0001 runout
- HSK adapters balanced to G2.5@15,000 rpm

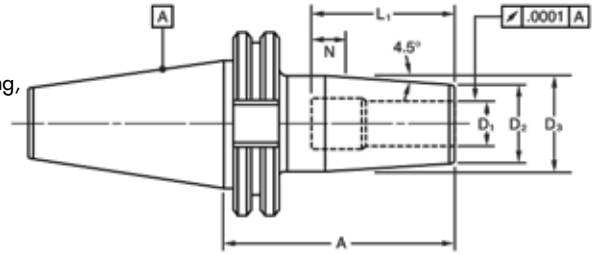


Part Number	Dimensions						EDP#
	D1	D2	D3	A	L1	N	
HSK63A SF025 315	1/4″	20	27	80	36	10	**55615**
HSK63A SF037 335	3/8″	24	32	85	42	10	**55616**
HSK63A SF050 354	1/2″	27	34	90	47	10	**55617**
HSK63A SF062 374	5/8″	27	34	95	50	10	**55618**
HSK63A SF075 394	3/4″	33	42	100	52	10	**55620**
HSK63A SF100 453	1″	44	53	115	58	10	**55621**
HSK63A SF125 472	1 1/4″	44	53	120	58	10	**55654**
HSK100A SF025 335	1/4″	20	27	85	36	10	**55605**
HSK100A SF037 354	3/8″	24	32	90	42	10	**55606**
HSK100A SF050 374	1/2″	27	34	95	47	10	**55607**
HSK100A SF062 394	5/8″	27	34	100	50	10	**55608**
HSK100A SF075 413	3/4″	33	42	105	52	10	**55610**
HSK100A SF100 453	1″	44	53	115	58	10	**55611**
HSK100A SF125 472	1 1/4″	44	53	120	58	10	**55647**

THERMAL TOOLHOLDING CAT ADAPTER

INCH

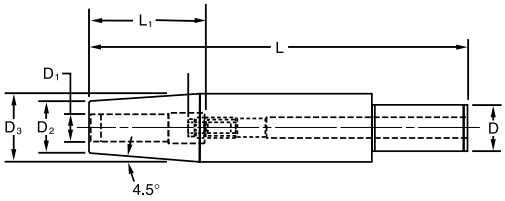
- Recommended for drilling, end milling, reaming, and boring.
- Thru-coolant capability
- Carbide and HSS cutting tools can be used
- Axial adjustment
- Less than .0001 runout
- CAT adapters balanced to G6.3@15,000 rpm



Part Number	Dimensions						EDP#
	D1	D2	D3	A	L1	N	
V40CT SF025 375	1/4″	20	27	95	36	10	**55625**
V40CT SF037 375	3/8″	24	32	95	42	10	**55626**
V40CT SF050 375	1/2″	27	34	95	47	10	**55627**
V40CT SF062 375	5/8″	27	34	95	50	10	**55628**
V40CT SF075 375	3/4″	33	42	95	52	10	**55629**
V40CT SF100 394	1″	44	53	100	58	10	**55632**
V50CT SF025 375	1/4″	20	27	95	36	10	**55635**
V50CT SF037 375	3/8″	24	32	95	42	10	**55636**
V50CT SF050 375	1/2″	27	34	95	47	10	**55637**
V50CT SF062 375	5/8″	27	34	95	50	10	**55638**
V50CT SF075 375	3/4″	33	42	95	52	10	**55640**
V50CT SF100 394	1″	44	53	105	58	10	**55641**
V50CT SF125 412	1 1/4″	44	53	105	58	10	**55643**

ValTRU™

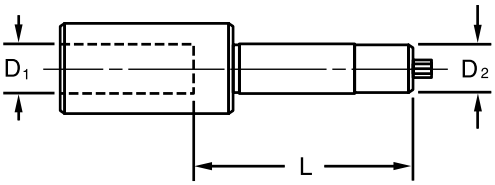
THERMAL TOOLHOLDING TOOL EXTENSION
INCH



Part Number	Dimensions						EDP#
	D	D1	D2	D3	L	L1	
TVS012600	16	1/8″	9	15	110	21	**55725**
TVS018600	16	3/16″	9	15	110	21	•
TVS025600	16	1/4″	15	15	110	23	•
TVS031600	16	5/16″	15	20	110	36	•
TVS038600	16	3/8″	15	20	110	36	•
TVS044600	20	7/16″	20	27	110	42	•
TVS050600	20	1/2″	20	27	110	47	**55726**
TVS062700	25	5/8″	24	32	120	50	**59873**

• Denotes non stock item

THERMAL TOOLHOLDING AXIAL ADJUSTING GAGE



- Allows pre-set of cutting tool before shrinking process

Part Number	Dimensions			EDP#
	D1	D2	L	
T3 025	1/4″	1/4″	80	•
T3 031	5/16″	5/16″	80	•
T3 038	3/8″	3/8″	80	•
T3 044	7/16″	7/16″	80	•
T3 050	1/2″	1/2″	80	•
T3 056	9/16″	9/16″	80	•
T3 062	5/8″	5/8″	80	•
T3 068	11/16″	11/16″	80	•
T3 075	3/4″	3/4″	80	**55688**
T3 088	7/8″	7/8″	80	•
T3 100	1″	1″	80	**55689**
T3 125	1 1/4″	1 1/4″	80	**55690**

• Denotes non stock item

The gage is placed in the adapter with the cutting tool. The length difference of the gage is calculated into the tool assembly. Rotating of the gage moves the axial stop screw and presets the length. Remove the gage and the cutting tool can be shrunk into the adapter.

TECHNICAL SECTION

ValTRU™

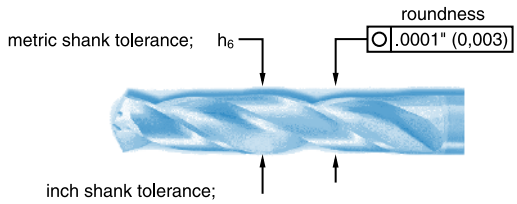
Heating unit features

The standard induction heating unit (Figure 1) has the following features:

- Unit is self contained and light weight, allowing it to be mobile or bench mounted
- Three standard, quick-change induction coils handle tools from 6 to 31mm (0.24 to 1.25 inches)
- Heating process is automatic
- Heating cycle is typically 5 to 10 seconds
- Four micro-processor controlled cooling stations, each with its own cooling fan.
- Placing heated tool on cooling station automatically initiates cooling cycle
- Cooling takes under a minute at which point the tool can be handled by unprotected hands

FIG. 1

Cutting Tool Requirements



1/4 - 9/16 = .0004" under nominal diameter, maximum
3/4 - 1 1/4 = .0005" under nominal diameter, maximum
(EX: 3/4" drill shank tolerance should be between .7500" / .7495")

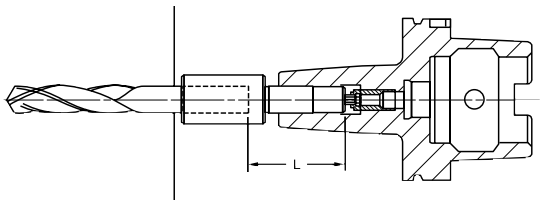


FIG. 2

Pre-set tool lengths

Tool length can be pre-set prior to clamping using a special gage adapter and ordinary shop measuring instruments. The tool is simply placed in the gage and then set into the toolholder. As the gage is rotated, it engages an axial stop screw inside the toolholder which changes the offset depending on the direction of rotation (Figure 2). When the desired length is reached, the gage is simply removed and the tool is inserted into the toolholder after it is heated.

HSK

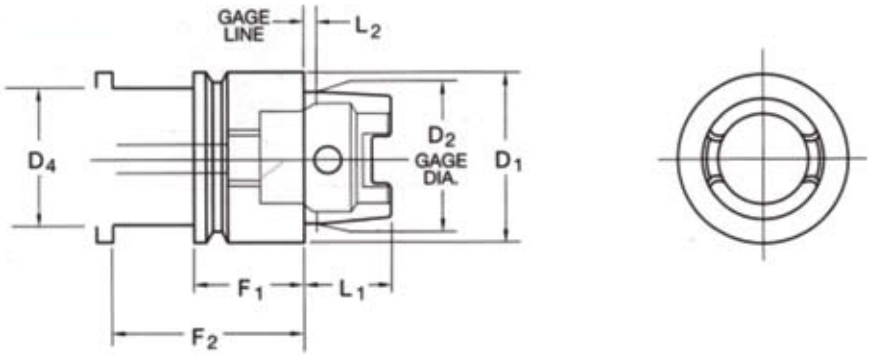
HSK Universal Connections System	336-337
Boring System Adapter	338
End Mill Adapter	338
Shell Mill Adapter	338
Collet Chuck Adapter	339
Collant Tube Wrench	339
Coolant Tube	339

VALENITE'S HSK TOOLING

You've been looking for a way to get things done faster without losing accuracy. Valenite's HSK Tooling is designed to provide the following benefits:

- High stiffness is achieved with full face contact, which improves tool rigidity in the cut.
- Accuracy is improved through the use of axial positioning which delivers better part to part consistency.
- Universal design allows the same tool to be used on both lathes and machining centers, holding down inventory costs.
- The hollow shank design of the HSK tool reduces weight and mass, thus improving high speed operation and reducing wear and tear on machine tool spindles.

DIN 69 893

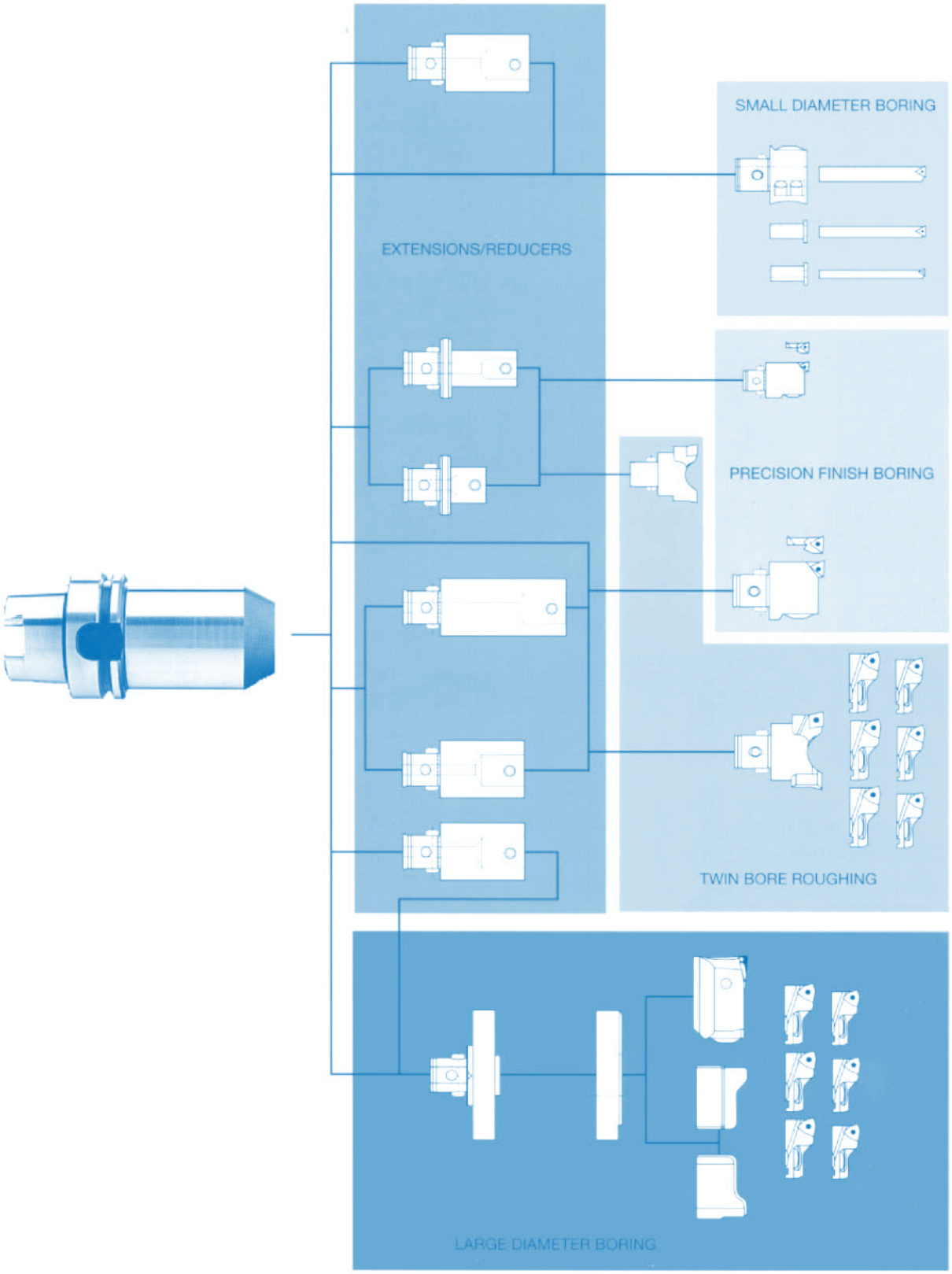


HSK Shank DImensional Information

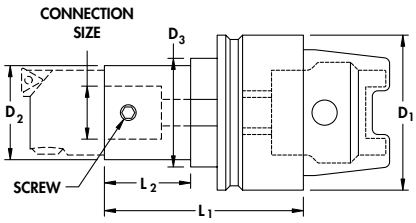
HSK Size	D_1	F_1	F_2	L_1	L_2	D_2	D_4
40 A	1.574	.787	1.38	.787	.1574	1.1811	1.34
50 A	1.968	1.023	1.65	.984	.1968	1.4960	1.65
63 A	2.480	1.023	1.65	1.259	.2480	1.8897	2.09
80 A	3.149	1.023	1.65	1.574	.3149	2.3622	2.64
100 A	3.937	1.141	1.77	1.968	.3937	2.9527	3.35

ValTRU™

HSK UNIVERSAL CONNECTION SYSTEM



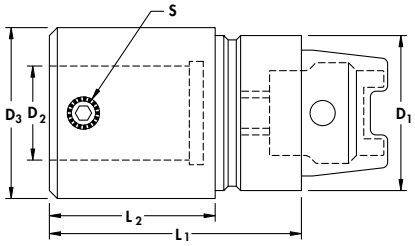
HSK - BORING SYSTEM ADAPTER



Part Number	ConnectionSize	Dimensions					Screw	EDP#
		D1	D2	D3	L1	L2		
HSK63A PC4 02500	PC4	2.480	1.535	2.08	2.500	.85	880 004	**51956**
HSK63A PC6 03250	PC6	2.480	2.520	2.08	3.250	1.60	880 006	**51958**
HSK63A PC6 05125	PC6	2.480	2.520	2.08	5.125	3.47	880 006	**51959**
HSK100A PC6 03250	PC6	3.937	2.520	3.34	3.250	1.48	880 006	**51950**
HSK100A PC6 06687	PC6	3.937	2.520	3.34	6.687	4.92	880 006	**51952**

Adapter supplied less coolant tube

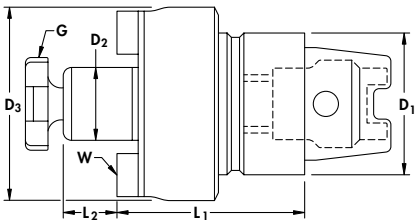
HSK - END MILL ADAPTER



Part Number	Dimensions					Screw	EDP#
	D1	D2	D3	L1	L2		
HSK63A E0500 300	2.480	1/2	1.37	3.000	1.88	7/16-20 x 3/8 WSS(1)	**51920**
HSK63A E1000 437	2.480	1	2.55	4.375	2.58	3/4-16 x 1/2 WSS (2)	**51923**
HSK63A E1250 437	2.480	11/4	2.79	4.375	2.58	3/4-16 x 1-1/16 WSS (2)	**51924**
HSK100A E0500 337	3.937	1/2	1.37	3.375	1.88	7/16-20 x 3/8 WSS (1)	**51915**
HSK100A E1000 437	3.937	1	2.55	4.375	2.58	3/4-16 x1-1/l6 WSS (2)	**51916**

Adapter supplied less coolant tube

HSK - SHELL MILL ADAPTER



Spare Parts

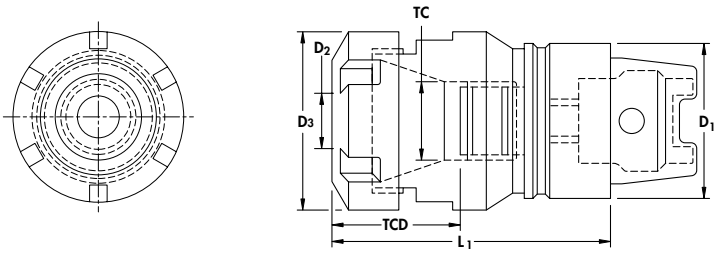
Part Number	W	EDP#
5012 UNIV KEY	0.3	**55406**
501 3 UNIV KEY	0.4	**55407**
5014 UNIV KEY	0.5	**55408**
501 5 UNIV KEY	0.6	**55409**
5017 UNIV KEY	1.0	**55411**

Part Number	Dimensions					W KeySize	Set Screw	EDP#
	D1	D2	D3	L1	L2			
HSK63A SM100 237	2.5	1.0	2.4	2.4	0.7	3/8	1/2-20 x 1-1/4SHCS	**51934**
HSK63A SM125 275	2.5	1.3	2.9	2.8	0.7	1/2	5/8-18 x 1-1/4SHCS	**51935**
HSK63A SM150 287	2.5	1.5	3.5	2.9	0.9	5/8	#5005 UNIV SCR	**51936**
HSK100A SM100 200	3.9	1.0	2.4	2.0	0.7	3/8	1/2-20 x 1-1/4 SHCS	**51929**
HSK100A SM150 225	3.9	1.5	3.5	2.3	0.9	5/8	#5005 UNIV SCR	**51931**
HSK100A SM250 325	3.9	2.5	5.0	3.3	1.1	1		**51932**

Adapter supplied less coolant tube

ValTRU™

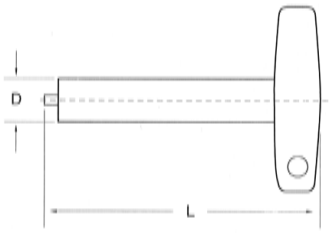
HSK - COLLET CHUCK ADAPTER



Part Number	Dimensions					TCD Screw	Collet Nut	Collet Series	EDP#
	D1	D2	D3	L1	TC				
HSK63A SAC32 450	2.480	0.078 - 0.748	1 .97 Dia	4.500	0.787	1 .79 Min 2. 38 Max	VSAC-32CN	VSAC-32, VCFC-32	**51928**
HSK63A 10SG 506	2.480	0.093 - 1.00	2.50 Dia	5.062	1.00	2.65 Min 2.85 Max	VCCNP-10SGF	VDF-10, VCSC-10, VDFNP-10	**51927**
HSK100A 10SG 525	3.937	0.093 - 1.00	2.50 Dia	5.250	1.00	2.65 Min 2.90 Max	VCCNP 10SGF	VDF 10, VCSC 10,VDFNP 10	**51925**

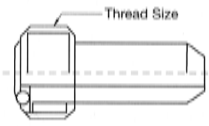
Adapter supplied less coolant tube

HSK - COOLANT TUBE WRENCH



Part Number	HSK SIZE	Dimensions		EDP#
		L	D	
PT885	63	4.8	.65	**52341**
PT 886	100	5.5	.86	**52342**

HSK - COOLANT TUBE

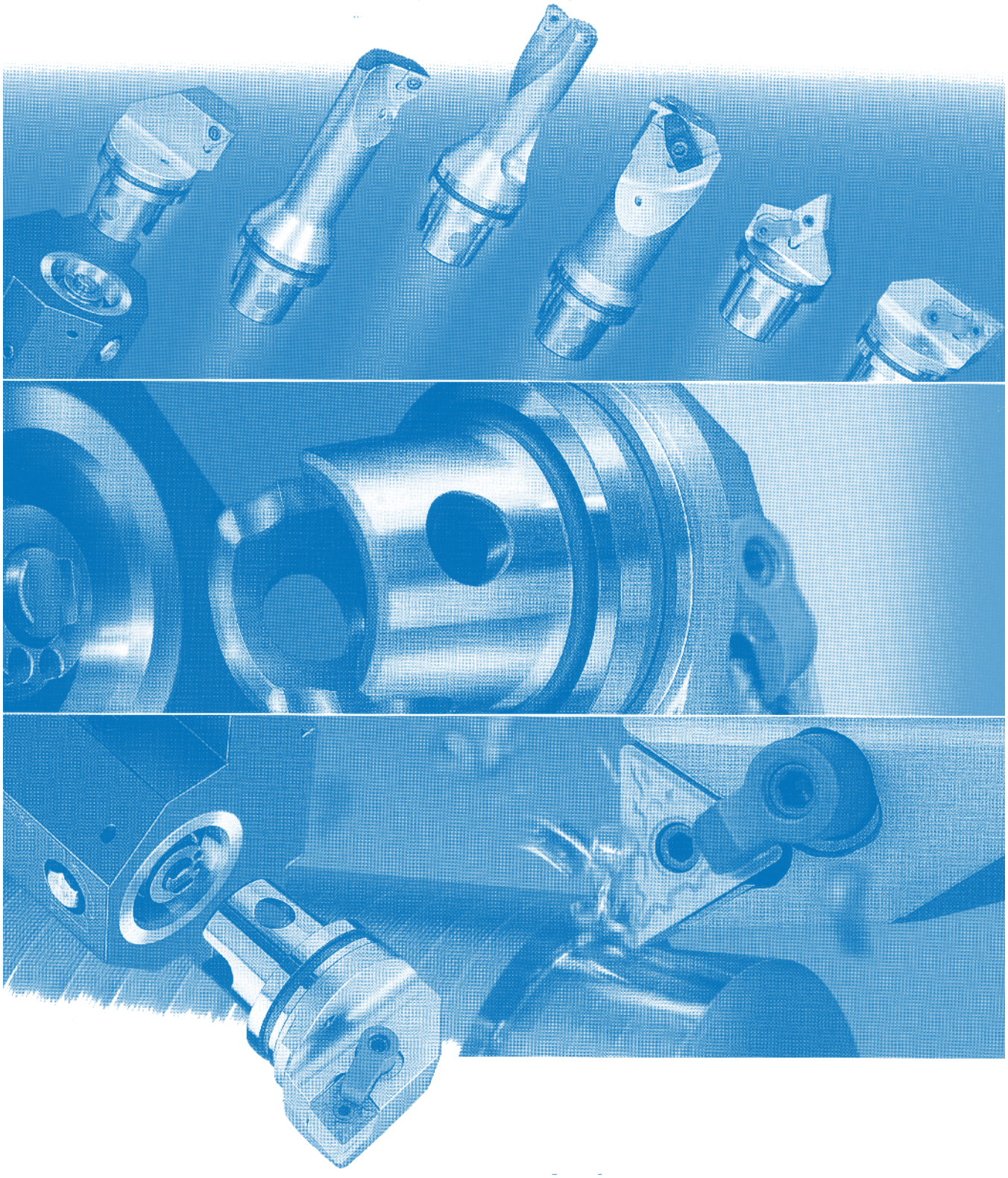


Part Number	HSK Size	Thread	EDP#
PT 881	63	M18X 1	**52337**
PT 883	100	M24X 1,5	**52339**

Includes tube, nut, and o-ring

ValCONNECT™

VM MODULAR QUICK CHANGE TOOLING



VM MODULAR TOOLING

VM - QLN R/L - VD1	343
VM - QFN R/L	343
VM - QLRA R/L - VD1	343
VM - QLSR R/L	344
VM - QLN - SS	344
VM - MCLN R/L	345
VM - MDJN R/L	345
VM - MDQN R/L	345
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VM Modular Quick Change Tooling	355
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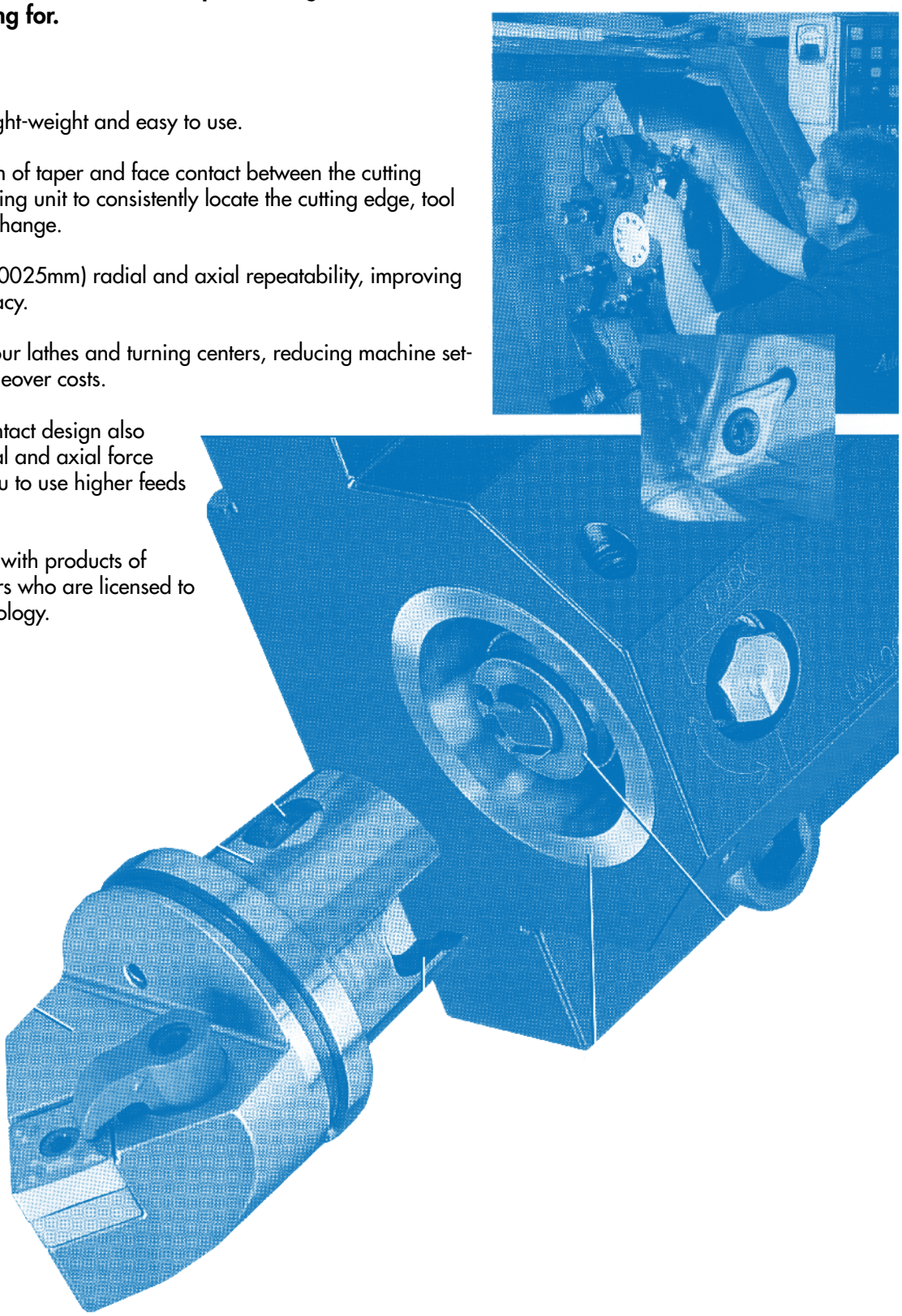
VM MODULAR QUICK CHANGE TOOLING

ValCONNECT™

Here's why the VM Connection is the quick change answer you've been looking for.

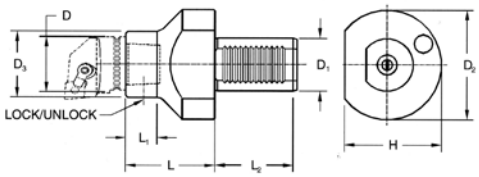
The VM Connection:

- is rigid, precise, light-weight and easy to use.
- uses a combination of taper and face contact between the cutting unit and the clamping unit to consistently locate the cutting edge, tool change after tool change.
- offers 0.0001" (0.0025mm) radial and axial repeatability, improving part-to-part accuracy.
- easily adapts to your lathes and turning centers, reducing machine set-up time and changeover costs.
- taper and face contact design also absorbs high radial and axial force loads, allowing you to use higher feeds and depth of cut.
- is fully compatible with products of other manufacturers who are licensed to produce this technology.



Val CONNECT™

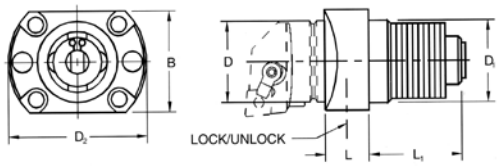
VM - QLN R/L-VDI
CLAMPING UNITS
VDI SHANK



Right Hand Shown

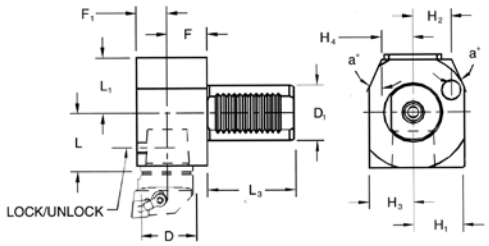
Part Number	Dimensions								EDP#	
	D	D1	D2	D3	L	L1	L2	H	Right Hand	Left Hand
VM40 QLNR/L VDI 4060	1.575	1.575	3.268	1.890	2.362	0.906	2.480	2.913	**57486**	**57747**
VM50 QLNR/L VDI 5070	1.968	1.968	3.858	2.362	2.756	1.181	3.071	3.307	**58021**	**58017**

VM - QLFN R/L
CLAMPING UNITS
FLANGE MOUNT



Part Number	Dimensions						EDP#
	D	D1	D2	L	L1	B	
VM40 QLFN 25	1.575	1.575	2.677	0.984	1.547	1.811	**57485**
VM50 QLFN 32	1.968	1.968	3.543	1.26	1.732	2.283	**57490**

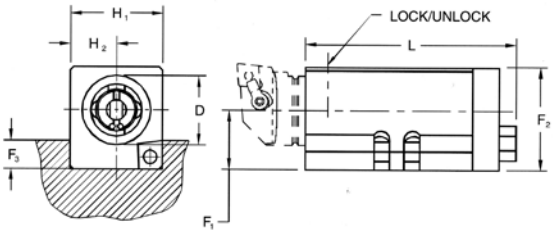
VM - QLRA R/L-VDI
CLAMPING UNITS
RIGHT ANGLE VDI SHANK



Right Hand Shown

Part Number	Dimensions											EDP#	
	D	D1	L	L1	L3	F	F1	H1	H2	H3	H4	Right Hand	Left Hand
VM40 QLRAR/L VDI 4040	1.575	1.575	1.575	1.496	2.480	0.984	0.906	1.575	1.811	1.339	0.945	**57761**	**57757**
VM40 QLRAR/L VDI 4060	1.575	1.575	2.362	1.496	2.480	0.984	0.906	1.575	1.181	1.339	0.945	**57762**	**57758**

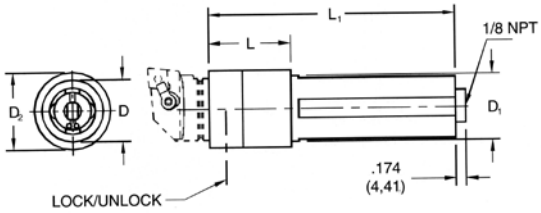
VM - QLSR R/L
CLAMPING UNITS
SQUARE SHANK



Left Hand Shown

Part Number	Dimensions							EDP#	
	D	L	F1	F2	F3	H1	H2	Right Hand	Left Hand
VM40 QLSR/L 1660C	1.575	3.425	1.496	2.441	1.000	1.996	1.000	**57488**	**57765**
VM40 QLSR/L 1660D	1.575	4.425	1.496	2.441	1.000	1.996	1.000	**57489**	**57766**
VM50 QLSR/L 2078	1.968	4.031	1.693	2.874	1.250	2.496	1.250	**58030**	**58028**

VM - QLN-SS
CLAMPING UNITS
STANDARD ROUND SHANK
INCH VERSIONS



Part Number	Dimensions					EDP#
	D	D1	D2	L	L	
VM40 QLN SS 24 236	1.575	1.500	1.890	2.362	5.714	**57487**
VM40 QLN SS 32 236	1.575	2.000	1.890	2.362	5.714	**57754**

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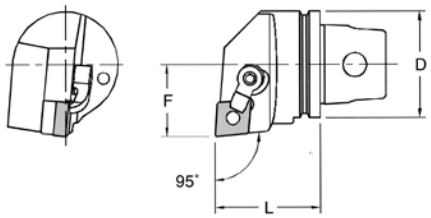


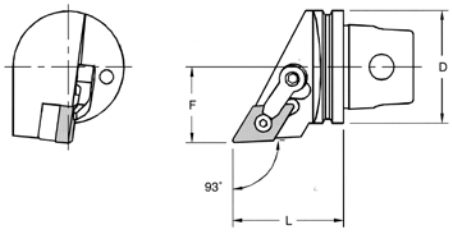
Right Hand Shown

VM - MCLN R/L
CUTTING UNITS
5° RADIAL RAKE
5° AXIAL RAKE

Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 MCLNR/L 4	1.575	1.575	1.063	CNMG432	**51515**	**57421**
VM40 MCLNR/L 5	1.575	1.575	1.063	CNMG543	**57703**	**57702**
VM50 MCLNR/L 5	1.968	1.968	1.378	CNMG432	**57903**	**57970**
VM50 MCLNR/L 6	1.968	1.968	1.378	CNMG643	**57974**	**57971**

Spare Parts

Insert Size	Shim		Pin		Clamp		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#	Part#	EDP#
CNMG432	CSN 433	**09143**	NLC 46	**52967**	CLM20	**59058**	XNSC 0620	**53064**
CNMG543	CSN 533	**09147**	NLC 58	**52970**	CLM20	**59058**	XNSC 0620	**53064**
CNMG643	CSN 633	**09150**	NLC 68	**52971**	CLM12	**59056**	XNSC 0825	**53065**



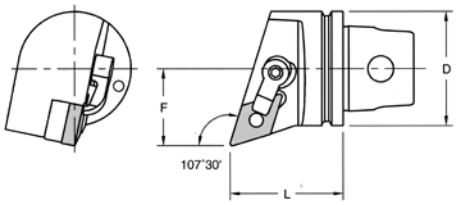
Right Hand Shown

VM - MDJN R/L
CUTTING UNITS
5° RADIAL RAKE
5° AXIAL RAKE

Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 MDJNR/L 4	1.575	1.575	1.063	DNMG432	**57423**	**57422**
VM50 MDJNR/L 4	1.968	1.968	1.378	DNMG432	**57428**	**57427**

Spare Parts

Insert Size	Shim		Pin		Clamp		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#	Part#	EDP#
DNMG432	DSN 443	**09160**	NLC 46L	**59236**	CLM20	**59058**	XNSC 0620	**53064**



Right Hand Shown

VM - MDQN R/L
CUTTING UNITS
5° RADIAL RAKE
5° AXIAL RAKE

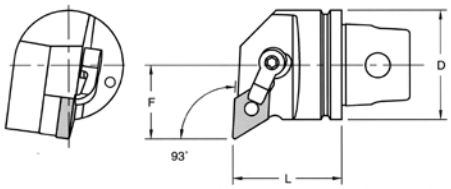
Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 MDQNR/L 4	1.575	1.575	1.063	DNMG432	**57709**	**57708**
VM50 MDQNR/L 4	1.968	1.968	1.378	DNMG432	**57980**	**57979**

Spare Parts

Insert Size	Shim		Pin		Clamp		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#	Part#	EDP#
DNMG432	DSN 443	**09160**	NLC 46L	**59236**	CLM22	**59059**	XNSC 0620	**53064**

VM - MDUN R/L

CUTTING UNITS
7 1/2° RADIAL RAKE
5° AXIAL RAKE



Right Hand Shown

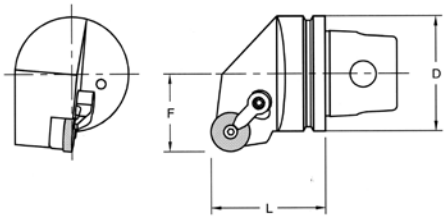
Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM50 MDUNR/L 4	1.968	1.968	1.378	DNMG432	**57982**	**57981**

Spare Parts

Insert Size	Shim		Pin		Clamp		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#	Part#	EDP#
DNMG432	DSN 443	**09160**	NLC 46L	**59236**	CLM22	**59059**	XNSC 0620	**53064**

VM - MRGN R/L

CUTTING UNITS
5° RADIAL RAKE
5° AXIAL RAKE



Right Hand Shown

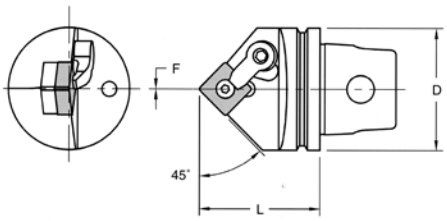
Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 MRGNR/L 4	1.575	1.575	1.063	RNMG43	**57715**	**57713**
VM50 MRGNR/L 4	1.968	1.968	1.378	RNMG43	**57985**	**57983**

Spare Parts

Insert Size	Shim		Pin		Clamp		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#	Part#	EDP#
RNMG43	IRSN 43	**09163**	NLC 46	**52967**	CLM9	**59065**	XNSC 0825	**53065**

ValCONNECT™

VM - MSDN
CUTTING UNITS
NEGATIVE RAKE
0° RADIAL RAKE
8° AXIAL RAKE

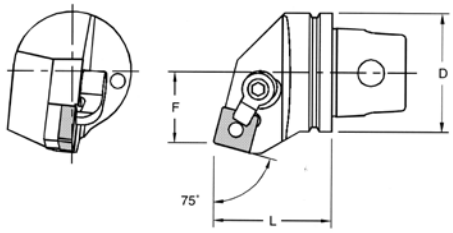


Part Number	Dimensions			Insert	EDP#
	D	L	F		
VM40 MSDNN4	1.575	1.575		SNMG432	**57716**
VM50 MSDNN4	1.968	1.968		SNMG432	**57987**

Spare Parts

Insert Size	Shim		Pin		Clamp		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#	Part#	EDP#
SNMG432	ISSN 433	**09166**	NLC 46	**52967**	CLM20	**59058**	XNSC 0620	**53064**

VM - MSRN
CUTTING UNITS
NEGATIVE RAKE
5° RADIAL RAKE
5° AXIAL RAKE



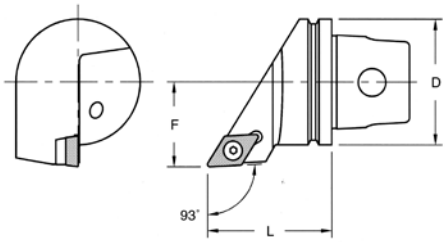
Right Hand Shown

Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 MSRNR/L 4	1.575	1.575	0.945	SNMG432	**57721**	**57719**
VM50 MSRNR/L 6	1.968	1.968	1.810	SNMG633	**57996**	**57994**

Spare Parts

Insert Size	Shim		Pin		Clamp		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#	Part#	EDP#
SNMG432	ISSN 433	**09166**	NLC 46	**52967**	CLM9	**59065**	XNSC 0825	**53065**
SNMG633	ISSN 633	**09169**	NLC 68	**52971**	CLM12	**59056**	XNSC 0825	**53065**
SNMG533	SSN 533	**09263**	NLC 58	**52970**	CLM20	**59058**	XNSC 0620	**53064**

VM - SDJC
CUTTING UNITS
POSITIVE RAKE
5° RADIAL RAKE
5° AXIAL RAKE



Right Hand Shown

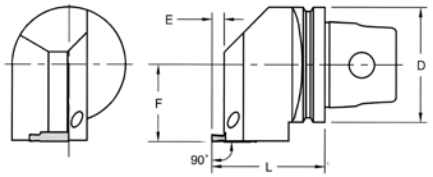
Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 SDJCR/L 11	1.575	1.575	1.063	DCGT32.52	**57875**	**57873**
VM40 SDJCR/L 15	1.575	1.575	1.063	DCGT432	**57876**	**57874**

Spare Parts

Insert Size	Shim		Pin		Screw	
	Part#	EDP#	Part#	EDP#	Part#	EDP#
DCGT32.52	SDCN 3252	**57403**	PT 776	**52325**	PT 781T	**52327**
DCGT432	SDCN 432	**09206**	PT 777	**52326**	PT 782T	**52328**

VM - SDTM R/L

CUTTING UNITS FOR ON-EDGE INSERTS



Right Hand Shown

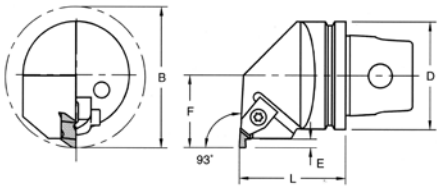
Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 SDTM R/L 3	1.575	1.575	1.063	TNMC32NG...	**57446**	**57886**
VM40 SDTM R/L 4	1.575	1.575	1.063	TNMC43NG...	**57888**	**57887**
VM50 SDTM R/L 4	1.968	1.968	1.378	TNMC43NG...	**58124**	**58122**

Spare Parts

Insert Size	Screw	
	Part#	EDP#
TNMC32NG...	SD 1	**53035**
TNMC43NG...	SD 2	**53036**

VM - VLE R/L

CUTTING UNITS FOR V-LOC INSERTS



Right Hand Shown

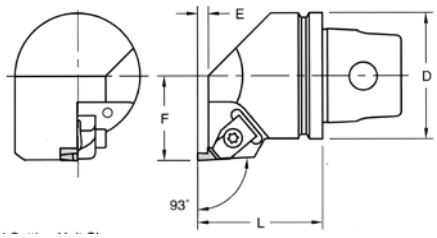
Part Number	Dimensions				Insert	EDP#	
	D	L	F	B		Right Hand	Left Hand
VM40 VLE R/L 4	1.575	1.575	1.063	2.126	VLG4...	**57920**	**57504**
VM50 VLE R/L 3	1.968	1.968	1.378	2.756	VLG3...	**58145**	**57507**

Spare Parts

Insert Size	Clamp		Screw	
	Part#	EDP#	Part#	EDP#
VLG...R	VL 72	58719	10 32X3/4 SHCS	**51991**
VLG...L	VL 73	58720	10 32X3/4 SHCS	**51991**

VM - VLS R/L

VDI SHANK



Right Hand Shown

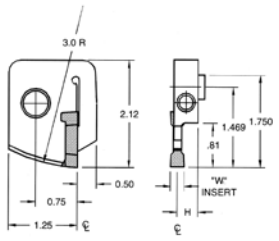
Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 VLS R/L 3	1.575	1.850	1.063	VLG-3R/L	**57506**	**57505**

Spare Parts

Insert Size	Clamp		Screw	
	Part#	EDP#	Part#	EDP#
VLG...R	VL 72	**58719**	10 32X3/4 SHCS	**51991**
VLG...L	VL 73	**58720**	10 32X3/4 SHCS	**51991**

ValCONNECT™

VM - VHDBA R/L
Econ-O-Groove® ANVIL



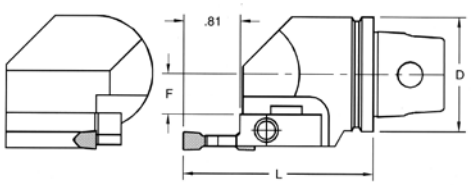
Left Hand Shown

Part Number	Dimensions			Insert	EDP#	
	H	W MIN	W MAX		Right Hand	Left Hand
VHDBA 125 188R/L A	0.457	0.125	0.197	VDB	**61883**	**61882**
VHDBA 188 250R/L A	0.437	0.188	0.250	VDB	**61885**	**61884**

Spare Parts

Holder	Screw	
	Part#	EDP#
All	1/4-28X5/8 SHCS	**52029**

VM - VHDBS R/L



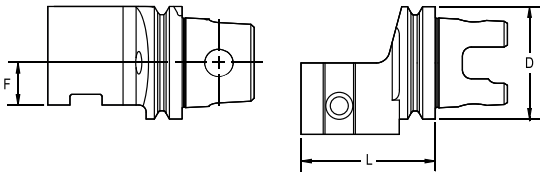
Right Hand Shown

Part Number	Dimensions			Insert	EDP#	
	D	L	F		Right Hand	Left Hand
VM40 VHDBSR/L	1.575	2.554	0.542	VDB	**57502**	**57914**
VM50 VHDBSR/L	1.968	3.150	0.739	VDB	**58141**	**58140**

Spare Parts

Holder	Mounting Screw		Anvil
	Part#	EDP#	Part#
All	PT 527	**53003**	VHDBA...

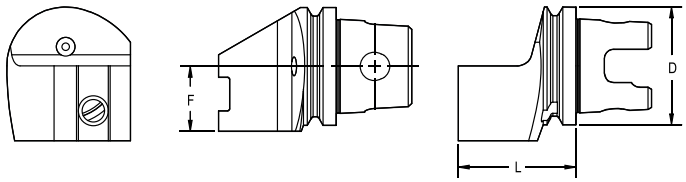
VG120 TOOLHOLDERS
AXIAL VM CONNECTION



VG120 R Hand 40 Size Shown

Part Number	Dimensions			EDP#	
	D	L	F	R Hand	L Hand
VG120 R/L 40	1.575	1.774	0.542	**61937**	**61934**
VG120 R/L 50	1.968	2.35	0.739	**61938**	**61935**

VG122 TOOLHOLDERS
90° VM CONNECTION



VG122 R Hand 40 Size Shown

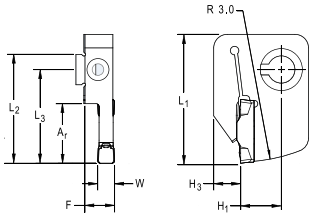
Part Number	Dimensions			EDP#	
	D	L	F	R Hand	L Hand
VG122 R/L 40	1.575	1.500	0.000	**61943**	**61940**
VG122 R/L 50	1.968	1.969	1.083	**61944**	**61941**

Spare Parts for VG120 & VG122

Part Number	Wrench		Screw		Torque(ft lbs)
	Part Number	EDP#	Part Number	EDP#	
All	516 HEXWRENCH	**57330**	PT527	**53003**	32

Val CONNECT™

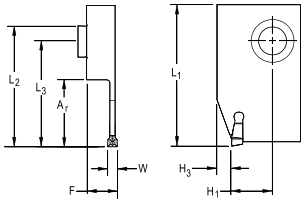
VGSCA TOOLHOLDERS
SCREW CLAMP ANVIL
Ar .875 - 1.100



R Hand Shown

Part Number	Ar	Seat Size	Dimensions							Max Ar	EDP#	
			W	F	H1	H3	L1	L2	L3		R Hand	L Hand
VGSCA R/L 20	0.810	20	0.079	0.506	0.75	0.50	2.09	1.721	1.44	0.748	**58482**	**58475**
VGSCA R/L 25	0.810	25	.098 - .118	0.496	0.75	0.50	2.09	1.721	1.44	0.744	**58483**	**58476**
VGSCA R/L 30	0.810	30	.118 - .125	0.49	0.75	0.50	2.09	1.721	1.44	.740 - .724	**58484**	**58477**
VGSCA R/L 40	1.000	40	.157 - .187	0.47	0.75	0.50	2.28	1.911	1.63	.949 - .921	**58485**	**58478**
VGSCA R/L 50	1.000	50	.197 - .236	0.45	0.75	0.50	2.28	1.911	1.63	.949 .906	**58486**	**58479**
VGSCA R/L 60	1.000	60	.236 - .250	0.43	0.75	0.50	2.28	1.911	1.63	.925 .906	**58487**	**58480**
VGSCA R/L 80	1.100	80	0.315	0.411	0.75	0.50	2.38	2.011	1.73	1.087	**58488**	**58481**

VGWCA TOOLHOLDERS
WEDGE CLAMP ANVIL
Ar .875 - 1.500



R Hand Shown

Part Number	Ar	Seat Size	Dimensions							EDP#	
			W	F	H1	H3	L1	L2	L3	R Hand	L Hand
VGWCA R/L 20	0.875	20	.073 - .088	0.482	0.75	0.25	2.215	1.845	1.564	**58496**	**58489**
VGWCA R/L 25	1.000	25	.098 - .133	0.472	0.75	0.25	2.340	1.970	1.689	**58497**	**58490**
VGWCA R/L 30	1.125	30	.118 - .163	0.464	0.75	0.25	2.465	2.095	1.814	**58498**	**58491**
VGWCA R/L 40	1.250	40	.156 - .203	0.445	0.75	0.25	2.590	2.200	1.939	**58499**	**58492**
VGWCA R/L 50	1.250	50	.197 - .250	0.426	0.75	0.25	2.590	2.200	1.939	**58500**	**58493**
VGWCA R/L 60	1.250	60	.236 - .315	0.406	0.75	0.25	2.590	2.200	1.939	**58501**	**58494**
VGWCA R/L 80	1.500	80	.315 - .394	0.370	0.75	0.25	2.840	2.470	2.189	**58502**	**58495**

VGSCA Spare Parts

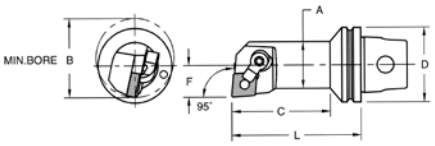
Seat Size	Torx Wrench*		Screw*		Torque (ft lbs)
	Part Number	EDP#	Part Number	EDP#	
20	PT1206T	**62395**	PT1217T	**62403**	3.0
25	PT1206T	**62395**	PT1217T	**62403**	3.0
30	PT1206T	**62395**	PT1217T	**62403**	3.0
40	PT1206T	**62395**	PT1217T	**62403**	3.3
50	PT1206T	**62395**	PT1217T	**62403**	3.7
60	PT1206T	**62395**	PT1217T	**62403**	3.7
80	PT1206T	**62395**	PT1217T	**62403**	4.5

*Advanced Torx Plus® locking mechanism

VGWCA Spare Parts

Seat Size	Insert Key	
	Part Number	EDP#
20	PT1204T	**62393**
25	PT1204T	**62393**
30	PT1205T	**62394**
40	PT1206T	**62395**
50	PT1206T	**62395**
60	PT1206T	**62395**
80	PT1206T	**62395**

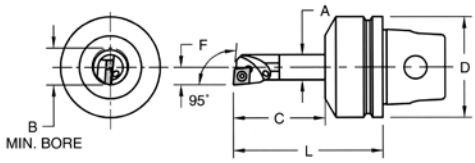
VM - MCLN R/L
CUTTING UNITS
NEGATIVE RAKE



Right Hand Shown

Part Number	Dimensions						Insert	EDP#	
	D	L	F	A	B	C		Right Hand	Left Hand
VM40 S25E MCLNR/L 4	1.575	2.756	0.669	0.984	1.260	2.165	CNMG432	**57453**	**57452**
VM40 S40B MCLNR/L 4	1.575	1.575	1.063	1.575	2.126		CNMG432	**57456**	**57858**
VM50 S25E MCLNR/L 4	1.968	2.756	0.669	0.984	1.260	1.929	CNMG432	**57457**	**58050**
VM50 S32G MCLNR/L 4	1.968	3.543	0.866	1.26	1.575	2.755	CNMG432	**57459**	**51523**
VM50 S40J MCLNR/L 4	1.968	4.331	1.063	1.575	1.968	3.583	CNMG432	**57461**	**57460**
VM50 S40L MCLNR/L 4	1.968	5.512	1.063	1.575	1.968	4.724	CNMG432	**58092**	**58090**
VM50 S50C MCLNR/L 4	1.968	1.968	1.378	1.968	2.756		CNMG432	**57462**	**58104**

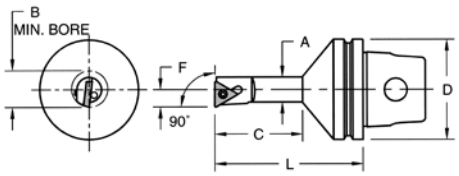
VM - SCLP R/L
CUTTING UNITS
POSITIVE RAKE



Right Hand Shown

Part Number	Dimensions						Insert	EDP#	
	D	L	F	A	B	C		Right Hand	Left Hand
VM40 S16F SCLPR/L 09	1.575	3.150	0.433	0.630	0.787	2.205	CPGT32.52	**57468**	**57782**
VM40 S20G SCLPR/L 09	1.575	3.543	0.512	0.787	0.984	2.756	CPGT32.52	**57792**	**57791**

VM - VHDBA R/L
CUTTING UNITS
POSITIVE RAKE

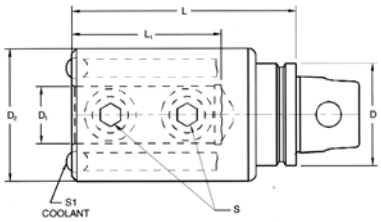


Right Hand Shown

Part Number	Dimensions						Insert	EDP#	
	D	L	F	A	B	C		Right Hand	Left Hand
VM40 S12E STFPR/L 11	1.575	2.756	0.354	0.472	0.630	1.654	TPGT21.51	**57467**	**57779**
VM40 S20G STFPR/L 16	1.575	3.543	0.512	0.787	0.984	2.756	TPGT32.52	**57798**	**57796**
VM40 S32G STFPR/L 16	1.575	3.543	0.866	1.260	1.575	2.953	TPGT32.52	**00000**	**57841**

ValCONNECT™

VM - BAEC
BORING BAR ADAPTER

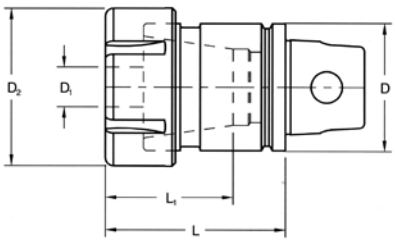


Part Number	Dimensions					EDP#
	D	D1	D2	L	L1	
VM40 BAEC075 276	1.575	0.750	1.968	2.756	2.283	**57675**
VM40 BAEC100 276	1.575	1.000	1.968	2.756	2.283	**57474**

Spare Parts

Holder	Screw
	Part#
VM40...075...	3/8 24 X 1/2 FPSS
VM40...100...	3/8 24 X 3/8 FPSS

VM - SAC
COLLET CHUCK ADAPTER

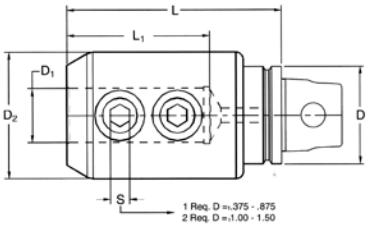


Part Number	Dimensions					EDP#
	D	D1	D2	L	L1	
VM40 SAC32 200	1.57	1/16-3/4	1.968	2.008	1.850	**57482**
VM50 SAC32 200	1.968	1/16-3/4	1.968	2.008	1.850	**58116**

Spare Parts

Holder	Screw	
	Part#	EDP#
All	VSAC32CN	**55535**

VM - EM
END MILL ADAPTER

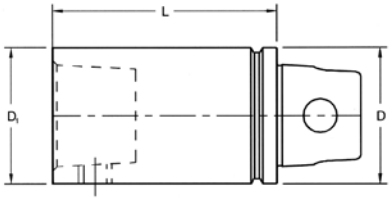


Part Number	Dimensions					EDP#
	D	D1	D2	L	L1	
VM50 EM100 315	1.968	1.000	2.480	3.150	2.283	**57965**
VM50 EM125 335	1.968	1.250	2.835	3.346	2.468	**57966**
VM63 EM062 216	2.480	0.625	1.968	2.165	1.968	•

Spare Parts

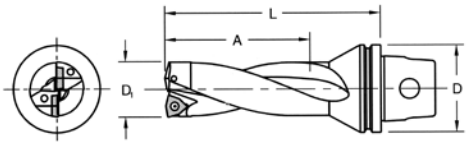
Holder	Screw	
	Part#	EDP#
	3/4-16X11/16WSS	**55395**

VM - S
EXTENSIONS



Part Number	Dimensions			EDP#
	D	D1	L	
VM40 S40 60	1.580	1.580	2.360	**57499**

VM - VWD
INDEXABLE DRILL



Part Number	Dimensions				EDP#	
	D	D1	L	A	Right Hand	Left Hand
VM40 VWDR/L 075 307	1.575	0.750	3.075	1.500	**57935**	**57929**
VM40 VWDR/L 100 357	1.575	1.000	3.575	2.000	**57940**	**57930**
VM40 VWDR/L 125 428	1.575	1.250	4.288	2.500	**57483**	**57932**

Spare Parts

Holder	Screw	
	Part#	EDP#
All	PT 487T	**52280**

ValCONNECT™

VM MODULAR QUICK CHANGE TOOLING FOR:
MAZAK (Integrex 100Y, 200Y, 200SY, 300Y, 400Y Machines) and
MORI SEIKI (MT Series MT-253/1000-1500, MT253S/1000-1500 Machines)

The Clamping System is built into the Mazak and Mori Seiki Tool Spindles. These include:

- Boring Bar Adapter
- Reducing Bushing
- Boring Bar Adapters
- Endmill Adapters
- Turning Tools Adapter

MAZAK MACHINES
INTEGREX 100Y, 200Y, 200SY, 300 Y, 400Y
VM MODULAR QUICK-CHANGE TOOLING

ValCONNECT™

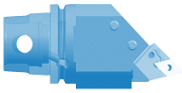
The VM Cutting Units shown are representative of the tools that are available. (Tools must be identified with "XMZ" in the Valenite Part Number to include the tool-changer feature, i.e., VM63XMZ-SM075-102).

Turning Tool Adapter
VM63XMZ-STER-16
VM63XMZ-STEL-16

Accepts 1 x 1 Shank.
Tool not included.

Turning Tool Adapter
VM63XMZ-STAR-16
VM63XMZ-STAL-16

Accepts 1 x 1 Shank.
Tool not included.



Turning Tool Adapter For 100Y machines
VM63XMZ-STICK45-12

Accepts 3/4 x 3/4 Shank.
Tool not included.

Endmill Adapters
VM63XMZ-EM025-216
VM63XMZ-EM031-216
VM63XMZ-EM038-216
VM63XMZ-EM050-216
VM63XMZ-EM062-220
VM63XMZ-EM075-245
VM63XMZ-EM100-330
VM63XMZ-EM125-345
VM63XMZ-EM150-400L

Turning Tool Adapter For 100Y machines
VM63XMZ-STER-12
VM63XMZ-STEL-12

Accepts 3/4 x 3/4 Shank.
Tool not included.

Turning Tool Adapter For 100Y machines
VM63XMZ-STAR-12
VM63XMZ-STAL-12

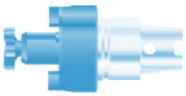
Accepts 3/4 x 3/4 Shank.
Tool not included.

Hydraulic Chuck-Adapter
VM63XMZ-HDY075-475
VM63XMZ-HDY125-475

Extensions
VM63XMZ-S63-90

Boring Bar Adapter
VM63XMZ-BA150-413

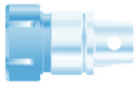
See reducing bushing below



Shell Mill Adapter
VM63XMZ-SM075-102
VM63XMZ-SM100-126
VM63XMZ-SM125-157

Morse Tapper Adapters
VM63XMZ-MT1-95
VM63XMZ- MT2-110
VM63XMZ-MT3-130

Reducers
VM63XMZ-S32-50
VM63XMZ-S40-60
VM63XMZ-S50-80



Collect Chuck Adapter
VM63XMZ-SAC16-200
VM63XMZ-SAC16-472
VM63XMZ-SAC25-200
VM63XMZ-SAC25-472
VM63XMZ-SAC32-220
VM63XMZ-SAC32-354
VM63XMZ-SAC32-472
VM63XMZ-SAC40-354
VM63XMZ-10SG-394

Tap Adapter
VM63XMZ-TAP31 WR
VM63XMZ-TAP32 WR

Reducing Bushing for Boring Bar Adapters			
Part Number	O.D.	I.D.	Length
VEAB 24 20 CS	1.500	1 1/4	2 1/2
VEAB 24 16 CS	1.500	1	2 1/2
VEAB 24 12 CS	1.500	3/4	2 1/2
VEAB 24 10 CS	1.500	5/8	2 1/2
VEAB 24 08 CS	1.500	1/2	2 1/2
VEAB 24 06 CS	1.500	3/8	2 1/2
VEAB 24 05 CS	1.500	5/16	2 1/2

ValCONNECT™

MORI SEIKI MACHINES
MT SERIES MT-253/1000-1500, MT253S/1000-1500
VM MODULAR QUICK-CHANGE LATHE TOOLING

The VM Cutting Units shown are representative of the tools that are available. (Tools must be identified with "MT" in the Valenite Part Number to include the tool-changer feature, i.e., VM63MT-SMD75-102.)

Turning Tool Adapter
VM63MT-STAR-16
VM63MT-STAL-16

Accepts 1 x 1 Shank.
Tool not included.

Turning Tool Adapter
VM63MT-STER-16
VM63MT-STEL-16

Accepts 1 x 1 Shank.
Tool not included.

Hydraulic Chuck Adapter
VM63MT-HDY075-475
VM63MT-HDY125-475

Tap Adapter
VM63MT-TAP31 WR
VM63MT-TAP32 WR

Endmill Adapters
VM63MT-EM-025-216
VM63MT-EM-031-216
VM63MT-EM-038-216
VM63MT-EM-050-216
VM63MT-EM-062-220
VM63MT-EM-075-350
VM63MT-EM-100-400
VM63MT-EM-125-412

Shell Mill Adapter
VM63MT-SM075-102
VM63MT-SM100-126
VM63MT-SM125-215

Collect Chuck Adapter
VM63MT-SAC16-200
VM63MT-SAC16-472
VM63MT-SAC25-200
VM63MT-SAC25-472
VM63MT-SAC32-220
VM63MT-SAC32-354
VM63MT-SAC32-472
VM63MT-SAC40-354
VM63MT-10SG-394

Boring Bar Adapter
VM63XMZ-BAEC-150-413

See reducing bushing below

Reducing Bushing for Boring Bar Adapters			
Part Number	O.D.	I.D.	Length
VEAB 24 20 CS	1.500	1 1/4	2 1/2
VEAB 24 16 CS	1.500	1	2 1/2
VEAB 24 12 CS	1.500	3/4	2 1/2
VEAB 24 10 CS	1.500	5/8	2 1/2
VEAB 24 08 CS	1.500	1/2	2 1/2
VEAB 24 06 CS	1.500	3/8	2 1/2
VEAB 24 05 CS	1.500	5/16	2 1/2

Reducers
VM63MT-S32-50
VM63MT-S40-65
VM63MT-S50-80

Used to adapt standard VM32, VM40 and VM50 tools.

Extension
VM63MT-S63-90

Used to increase length of tools.
Can be used with standard VM tools.