

Tightening Fixtures

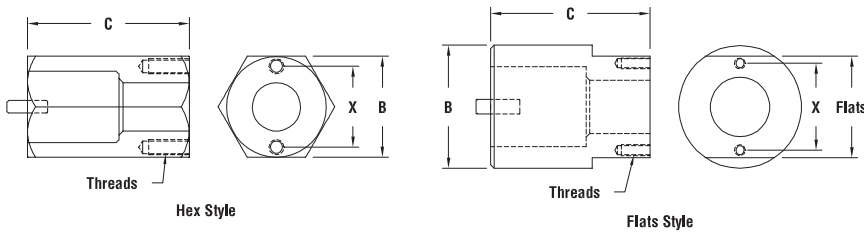
Taper Type & Bench Mount

TAPER TYPE:

- For bench or vise mounting.



Taper Type
Fixture TF40
shown here.



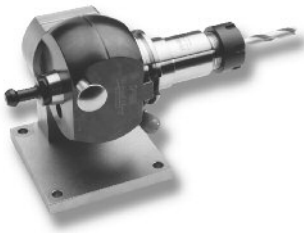
TAPER TYPE

Part Number	Type	B	C	X	Thread	Style
TF30	30	2.50	3.50	2.00	3/8 - 16	Hex
TF40	40	2.50	4.00	2.00	3/8 - 16	Hex
TF50	50	4.25	5.50	3.00	3/8 - 16	Flats - 3.50
TF60	60	4.62	8.50	3.63	3/8 - 16	Flats - 4.62

Part numbers in **bold face** are in-stock items.

BENCH MOUNT SWIVEL:

- For tool locking and retention knob mounting.
- Mounts directly to workbench.



BENCH MOUNT SWIVEL

Part Number	Taper Size
TFBS30	BT 30
TFBS40	CAT 40/BT40
TFBS50	CAT 50/BT50
TFBSH63	HAK63A
TFBSH100	HSK100A

Retention Knobs

Specifications



Retention Knob
DIN50ATRK
shown here.



Retention Knob
40TRK
shown here.



Retention Knob
4001TRK
shown here.

PARLEC STOCKS OVER 100 DIFFERENT STYLES OF RETENTION KNOBS.

- Material, heat treat, and dimensions are to ANSI specifications.
- Manufactured using alloy steel.
- Case hardened to ensure long service life.
- Core is tempered for tough shock resistance.

WARNING:

Machine tool manufacturers have used many various styles and sizes of retention knobs. They often look very similar and appear to be interchangeable. **The use of the incorrect knob, or the incorrect use of a knob, may result in injury or property damage.** We at Parlec try to ensure that we specify the correct knob, but due to the variety, it is the responsibility of the end user to check that the supplied knobs are correct for the machine tool and taper type.

It is very important not to intermix metric retention knobs with inch toolholders. The retention knob will screw in and appear to seat correctly. This is not the case, and damage may occur if used. All standard metric retention knobs have a pilot behind the flange which seats against the nose of the taper. This will assist in identifying a metric knob where both styles are used. However, retention knobs manufactured to a customer's specifications may have a shoulder on an inch knob. Parlec offers metric knobs for most machines to permit the use of metric toolholders.

Be sure to fully tighten the retention knob. Failure to do so may result in the toolholder coming loose during operation.

ORDERING INSTRUCTIONS:

Parlec stocks over one hundred different styles of retention knobs. Please provide a drawing of your knob or supply the information on the retention knob quotation request sheet. Please measure as accurately and completely as possible. If no coolant hole exists, or if, in the case of the DIN style knob, the hole does not go completely through the part, please note. Be sure to include the angle and the thread, or taper size and type.

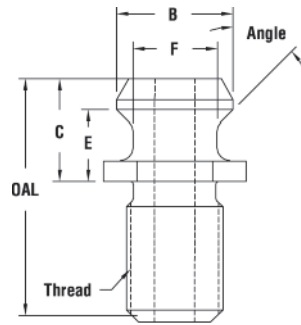
Retention Knobs

ANSI/ISO & DIN

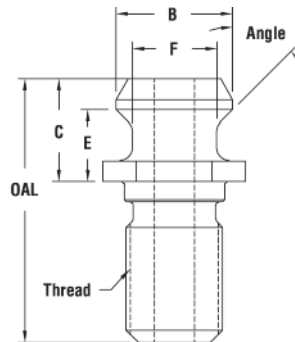
ANSI/ISO:



40TRK shown here.



Style 1



Style 2

ANSI/ISO RETENTION KNOBS

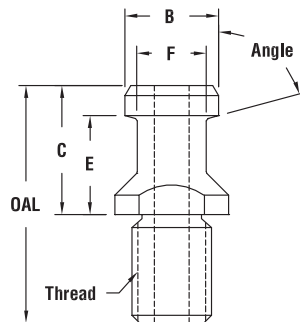
Part Number	Style	Thread	Angle	OAL	B	C	E	F	Coolant Hole	Specification/Feature
30TRK	1	1/2 - 13	45	1.10	.520	.460	.320	.385	.187	ANSI STD
40NTRK	1	5/8 - 11	45	1.50	.740	.640	.440	.490	-	ANSI STD Solid
40TRK	1	5/8 - 11	45	1.50	.740	.640	.440	.490	.281	ANSI STD
45TRK	1	3/4 - 10	45	1.80	.940	.820	.580	.605	.375	ANSI STD
50NTRK	1	1" - 8	45	2.30	1.140	1.000	.700	.820	-	ANSI STD Solid
50TRK	1	1" - 8	45	2.30	1.140	1.000	.700	.820	.468	ANSI STD
50TRK-1	1	1" - 8	45	2.30	1.140	1.000	.700	.820	.500	ANSI .500 Coolant
60TRK	1	1 1/4 - 7	45	3.20	1.460	1.500	1.080	1.045	.500	ANSI STD
60/50TRK	1	1" - 8	45	3.20	1.460	1.500	1.080	1.045	.500	60 to 50 Reducer
A40TRK	2	M16 - 2	45	1.65	.740	.640	.440	.490	.281	ANSI For Metric Shank
A50TRK	2	M24 - 3	45	2.58	1.140	1.000	.700	.820	.468	ANSI For Metric Shank
M50TRK	1	1" - 8	45	2.30	1.140	1.000	.700	.820	.468	MAZAK O-Ring Seal Groove
MM50TRK	2	M24 - 3	45	2.30	1.140	1.000	.700	.820	.468	MAZAK O-Ring Seal Groove

Part numbers in **bold face** are in-stock items.

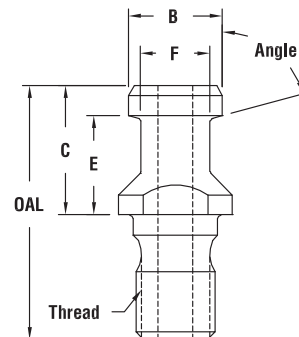
DIN:



DIN50ATRK shown here.



Style 1



Style 2

DIN RETENTION KNOBS

Part Number	Style	Thread	Angle	OAL	B	C	E	F	Coolant Hole	Specification/Feature
4030TRK	1	5/8 - 11	75	1.89	.747	1.020	.788	.550	.281	DIN For Inch Shank
5030TRK	1	1" - 8	75	2.64	1.100	1.345	.990	.827	.468	DIN For Inch Shank
DIN40ATRK	2	M16 - 2	75	2.12	.747	1.024	.788	.549	.276	DIN STD Coolant
DIN40STRK	2	M16 - 2	75	2.12	.747	1.024	.788	.549	-	DIN STD Solid
DIN50ATRK	2	M24 - 3	75	2.91	1.101	1.339	.984	.825	.468	DIN STD Coolant
DIN50STRK	2	M24 - 3	75	2.91	1.101	1.339	.984	.825	-	DIN STD Solid

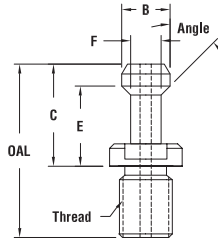
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Retention Knobs

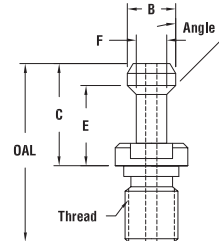
MAS BT



4001TRK shown here.



Style 1



Style 2

MAS BT RETENTION KNOBS

Part Number	Style	Thread	Angle	OAL	B	C	E	F	Coolant		Specification/Feature
									Hole		
3001TRK	1	1/2-13	45	1.42	.393	.787	.630	.236	-	-	CHIRON INCH SHANK
3002TRK	2	M12-1.75	45	1.42	.393	.787	.630	.236	-	-	CHIRON INCH SHANK
3003TRK	2	M12-1.75	45	1.70	.430	.908	.710	.273	-	-	MAS BT 45 DEG
3004TRK	2	M12-1.75	60	1.70	.430	.908	.710	.273	-	-	MAS BT 60 DEG
3502TRK	2	M12-1.75	90	1.77	.550	.908	.710	.312	-	-	-
3504TRK	2	M12-1.75	60	1.97	.540	1.110	.880	.348	-	-	-
4001TRK	1	5/8-11	90	2.13	.588	1.275	.988	.393	-	-	-
4001TRKC	1	5/8-11	90	2.13	.588	1.275	.988	.393	.197	-	-
4002TRK	2	M16-2	90	2.36	.588	1.376	1.102	.393	-	-	MAS BT 90 DEG
4003TRK	2	M16-2	45	2.36	.588	1.376	1.102	.393	-	-	MAS BT 45 DEG
4003TRKC	2	M16-2	45	2.36	.588	1.376	1.102	.393	.197	-	-
4004TRK	2	M16-2	60	2.36	.588	1.376	1.102	.393	-	-	MAS BT 60 DEG
4005TRK	1	5/8-11	45	2.13	.588	1.268	.988	.393	-	-	-
4005TRKC	1	5/8-11	45	2.13	.588	1.268	.988	.393	.157	-	-
4008TRK	1	5/8-11	75	1.88	.744	1.024	.787	.549	-	-	-
4008TRKC	1	5/8-11	75	1.88	.744	1.024	.787	.549	.276	-	-
4009TRK	1	5/8-11	45	2.12	.588	1.264	.990	.393	-	-	-
4009TRKC	1	5/8-11	45	2.12	.588	1.264	.990	.393	.197	-	-
4010TRK	2	5/8-11	75	2.13	.748	1.142	.906	.551	.276	-	-
4014TRK	1	5/8-11	60	2.13	.588	1.268	.990	.393	-	-	-
4014TRKC	1	5/8-11	60	2.13	.588	1.268	.990	.393	.138	-	-
4020TRK	2	M16-2	15	2.26	.748	1.142	.905	.550	.276	-	-
4504TRK	2	M20-2.5	60	2.75	.748	1.575	1.220	.549	-	-	MAS BT 60 DEG
4506TRK	2	3/4-10	45	2.94	.746	1.594	1.388	.509	-	-	-
5001TRK	1	1"-8	90	3.07	.904	1.770	1.378	.667	-	-	-
5001TRKC	1	1"-8	90	3.07	.904	1.770	1.378	.667	.250	-	-
5002TRK	2	M24-3	90	3.34	.904	1.770	1.378	.667	-	-	MAS BT 90 DEG
5003TRK	2	M24-3	45	3.34	.904	1.770	1.378	.667	-	-	MAS BT 45 DEG
5003TRKC	2	M24-3	45	3.34	.904	1.770	1.378	.667	.250	-	-
5004TRK	2	M24-3	60	3.34	.904	1.770	1.378	.667	-	-	MAS BT 60 DEG
5005TRK	1	1"-8	45	3.09	.904	1.791	1.378	.667	-	-	-
5005TRKC	1	1"-8	45	3.09	.904	1.791	1.378	.667	.250	-	-
5014TRK	1	1"-8	60	3.07	.904	1.770	1.378	.667	-	-	-
5014TRKC	1	1"-8	60	3.07	.904	1.770	1.378	.667	.250	-	-
5021TRK	1	1"-8	90	2.53	.940	1.234	.907	.708	-	-	-
C400TRK	1	5/8-11	45	2.30	.588	1.436	1.137	.406	-	-	-
C400TRKC	1	5/8-11	45	2.30	.588	1.436	1.137	.404	.157	-	-
F40TRK	2	M16-2	45	1.85	.740	.752	.552	.490	-	-	FADAL BT40
M400TRK	1	5/8-11	90	1.91	.588	1.053	.777	.393	-	-	-
MAK050TRK	2	1"-8	45	3.14	.904	1.780	1.386	.667	.236	-	MAKINO
MH40TRK	1	M16-2	45	2.26	.588	1.265	1.000	.393	-	-	-
MH500TRK	1	1"-8	90	3.08	.904	1.780	1.386	.667	-	-	-
MSS034TRK	1	1"-8	90	2.52	.940	1.218	.903	.706	.315	-	-
MZ40TRK	2	M16-2	45	1.85	.740	.752	.552	.490	.281	-	FADAL BT40