

- Meets or exceeds DIN69871 specifications and all current standard updates.
- The 7/24 shank cones are produced to the highest industry standards according to ISO-1947. With a taper accuracy of AT3 or better, an optimum fit between the spindle and toolholder is provided.
- Essential surfaces are not black oxide to provide better fitments.
- All non-critical surfaces are black oxide, except for the high-performance toolholders.
- Through-coolant is a standard feature when enabled by the toolholder design.
- Depending on the application and symmetry of toolholder assembly (toolholder, components, retention knob, collets, cutting tools, etc.) DV40 and DV50 toolholders will perform effectively up to 10,000 rpm before the complete toolholder assembly needs to be balanced. At speeds above 10,000 rpm, Kennametal recommends that the toolholder be balanced.

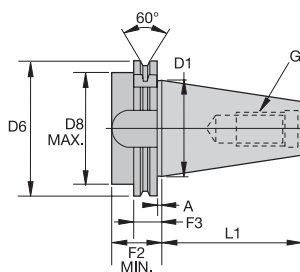
**IMPORTANT!**

- All critical surfaces need to be protected against damage from dents and scratches from cutting edges. Such damage will impair tool accuracy and performance.
- Always assemble only clean components. Never overtighten tools, which can permanently destroy the function and accuracy of the toolholder.

For retention knobs, please see page 764.



**■ DIN 69871  
DV FORM A**

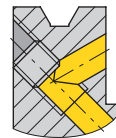


	D1	D6	D8 max.	L1	F2 min.	F3	A	G
30	1.250 (31,75)	1.967 (49,95)	1.772 (45,00)	1.876 (47,65)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M12 thread
40	1.750 (44,45)	2.480 (63,00)	1.969 (50,00)	2.687 (68,25)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M16 thread
45	2.250 (57,15)	3.228 (82,00)	2.480 (63,00)	3.250 (82,55)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M20 thread
50	2.750 (69,85)	3.827 (97,45)	3.150 (80,00)	4.000 (101,60)	1.378 (35,00)	.750 (19,05)	.126 (3,20)	M24 thread

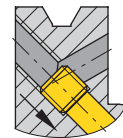


**Form B Coolant**

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

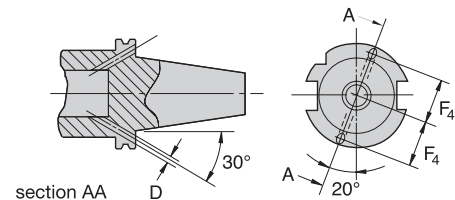


Toolholders are factory set to the form B coolant supply position. When relocating coolant position screws, use of a removable liquid (small screw thread locker) is recommended.



The toolholder can be easily converted to DIN 69871 form AD coolant supply; tightening screws will stop coolant from escaping through the flange.

**■ DIN 69871  
DV FORM B – Flange Coolant Entry Ports**



	D	F4 ±0.004
30	.157 (4,00)	.827 (21,00)
40	.157 (4,00)	1.063 (27,00)
45	.197 (5,00)	1.378 (35,00)
50	.236 (6,00)	1.654 (42,00)