COVENTRY TOOLHOLDERS

TOTAL TOOLING SOLUTIONS

TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

2017 – Jan – Issue 2

COVENTRY ENGINEERING GROUP

Coventry Toolholders Ltd, Units 7, 9&11 Paragon Way, Coventry CV7 9QS
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COVENTRY TOOLHOLDERS

TOTAL TOOLING SOLUTIONS

Welcome to Coventry Toolholders

We supply a complete range of standard and bespoke tooling systems to cater for all your toolholding requirements

- Standard Products
- Special Products
- Complete – Consultancy, Design and Manufacturing service on site at Coventry

CONTACT DETAILS

Phone +44 (0) 2476 645999
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Web www.coveng.co.uk

bsi. ISO 9001 Quality Management FM 569421

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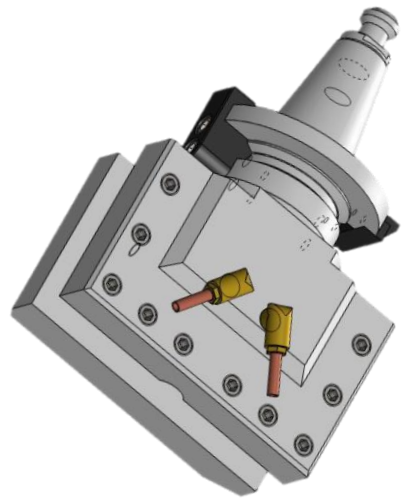
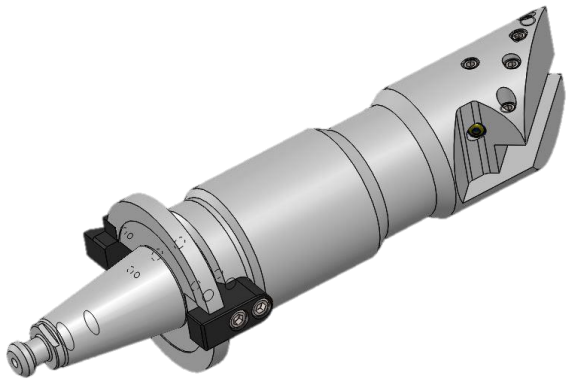
TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES





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TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

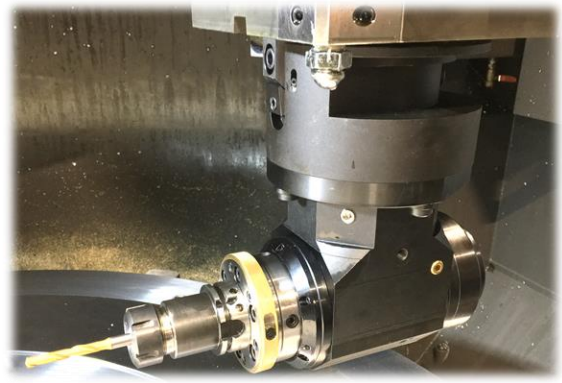
FOR MACHINES WITH STATIC AND ROTATING SPINDLES.

The Coventry Engineering Group offer a complete range of standard and bespoke toolholding systems specifically engineered for your Vertical Turning machine. Design, manufacture and support is centred in our Coventry facility utilising modern CAD/CAM, CNC machining and CNC grinding facilities.

Modular Type

Static Type

- Standard Turning and Boring Toolholders
- Bespoke Turning and Boring Toolholders
- Modular Turning and Boring Toolholders
- Driven Angle Heads
- Face and Taper Contact
- Rotating Toolholders



Driven Heads

COVENTRY TOOLHOLDERS
TOTAL TOOLING SOLUTIONS

INDEX TO SECTIONS

Section 1 - Taper Recognition

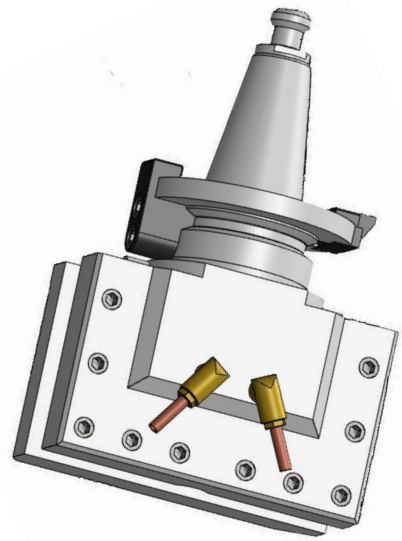
Section 2 - Tools for boring and Turning Operations

Section 3 - Modular systems for Capto©, KM©, HSK

Section 4 - Driven Angle Heads

Section 5 - Options

Section 6 - Standard Taper Toolholders

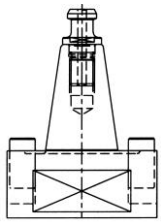


TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

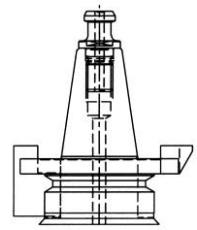
FOR MACHINES WITH STATIC AND ROTATING SPINDLES.

GUIDE TO MACHINE AND TAPER IDENTIFICATION .

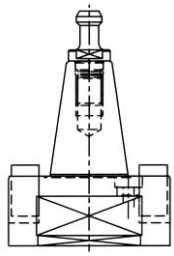
Toshiba AT



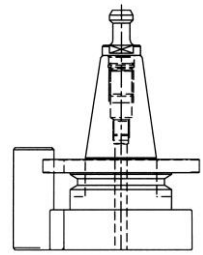
Toshiba AT+C



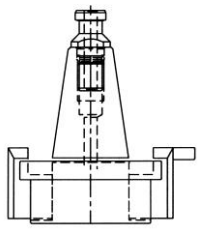
You-Ji AT



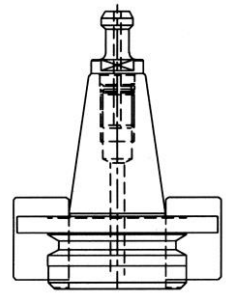
You-Ji AT+C



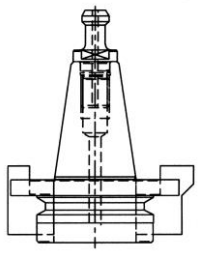
Hankook AT+C



Yu-Shine AT



Massa AT

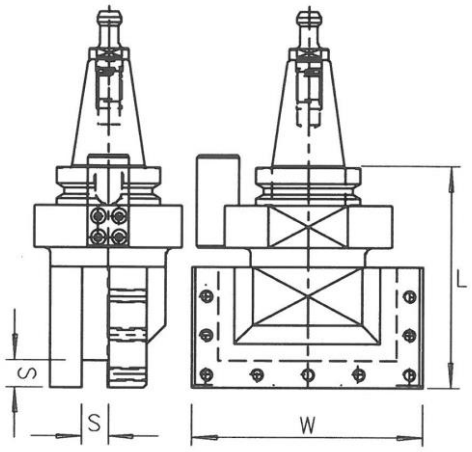


AT – non rotating spindle
AT+C – Rotating Spindle

NOTE – THE ABOVE IS FOR QUOTATION AND GUIDANCE PURPOSES ONLY.
FULL MACHINE DETAILS WILL BE CONFIRMED AT THE DESIGH STAGE

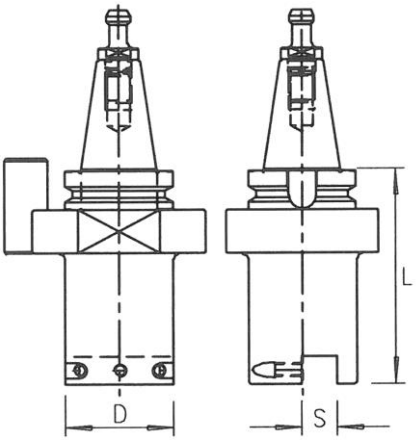
TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

FOR MACHINES WITH STATIC AND ROTATING SPINDLES.



Item	Gauge (L mm)	Tool Shank (S)	Tool Width (W mm)
50-SQB-32-160	160	32	220
50-SQB-32-200	200	32	220
50-SQB-32-250	250	32	220
50-SQB-40-200	200	40	220
50-SQB-40-250	250	40	220

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
EXTERNAL COOLANT NOZZLES
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

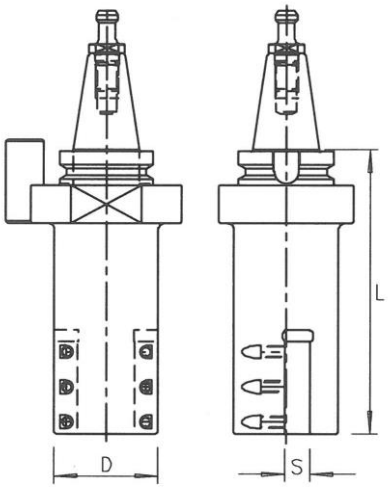


Item	Gauge (L mm)	Tool Shank (S)	Tool Dia (D mm)
50-BBH-20-200	200	20	80
50-BBH-20-250	250	20	80
50-BBH-20-300	300	20	80
50-BBH-20-350	350	20	80
50-BBH-25-200	200	25	110
50-BBH-25-250	250	25	110
50-BBH-25-300	300	25	110
50-BBH-25-350	350	25	110

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
EXTERNAL COOLANT NOZZLES
SPECIFY CLOCKWISE OR ANTI CLOCKWISE CUTTING
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

FOR MACHINES WITH STATIC AND ROTATING SPINDLES.



Item	Gauge (L mm)	Tool Shank (S)	Tool Dia (D mm)
50-BBT-20-200	200	20	80
50-BBT-20-250	250	20	80
50-BBT-20-300	300	20	80
50-BBT-20-350	350	20	80
50-BBT-25-200	200	25	110
50-BBT-25-250	250	25	110
50-BBT-25-300	300	25	110
50-BBT-25-350	350	25	110

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
EXTERNAL COOLANT NOZZLES
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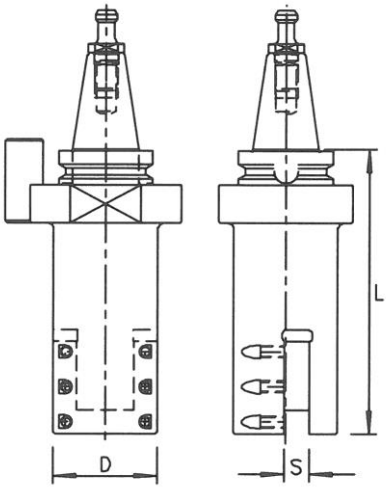
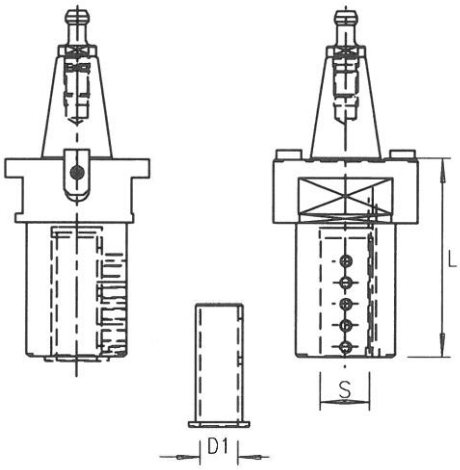


Item	Gauge (L mm)	Tool Shank (S)	Tool Dia (D mm)
50-BBHT-25-200	200	25	100
50-BBHT-25-300	300	25	110
50-BBHT-25-400	400	25	110

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
EXTERNAL COOLANT NOZZLES
SPECIFY CLOCKWISE OR ANTI CLOCKWISE CUTTING
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

FOR MACHINES WITH STATIC AND ROTATING SPINDLES.



Item	Gauge (L mm)	Tool Shank (S)
50-BBS-50-154	154	50
50-BBS-50-200	200	50
REDUCING BUSH	Bore Sizes D1 = 40, 32, 25, 20, 16, 12	

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
EXTERNAL COOLANT NOZZLES
FOR NORMAL COOLANT FEED PRESSURE
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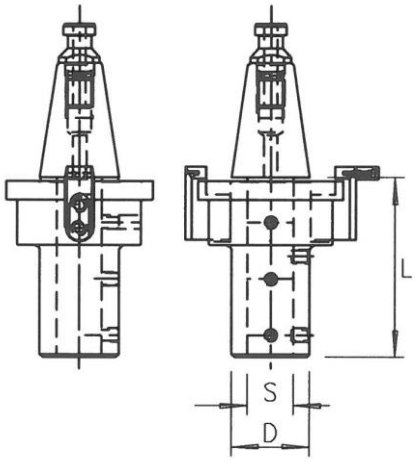


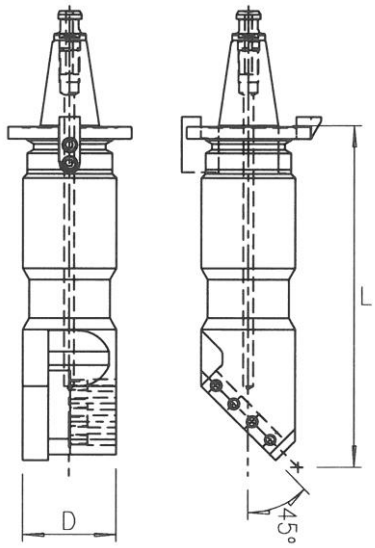
BORING BAR HOLDER

Item	Gauge (L mm)	Tool Shank (S)	Tool Dia (D mm)
50-BB-25-110	110	25	55
50-BB-32-110	110	32	62
50-BB-40-160	160	40	70
50-BB-50-160	160	50	90

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

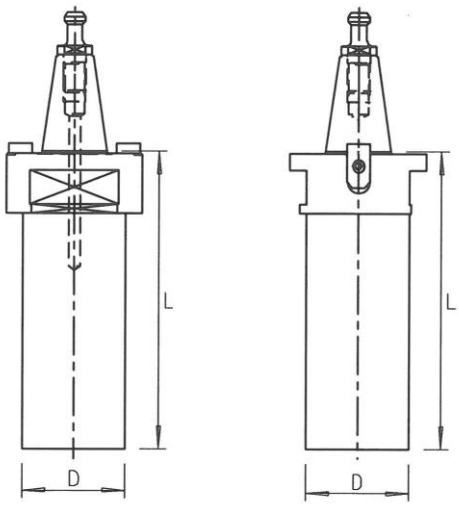
TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

FOR MACHINES WITH STATIC AND ROTATING SPINDLES.



Item	Gauge (L mm)	Tool Dia (D mm)
50-BB45-80-200	200	80
50-BB45-80-250	250	80
50-BB45-80-300	300	80
50-BB45-80-350	350	80
50-BB45-110-200	200	110
50-BB45-110-250	250	110
50-BB45-110-300	300	110
50-BB45-110-350	350	110

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
EXTERNAL COOLANT NOZZLES
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

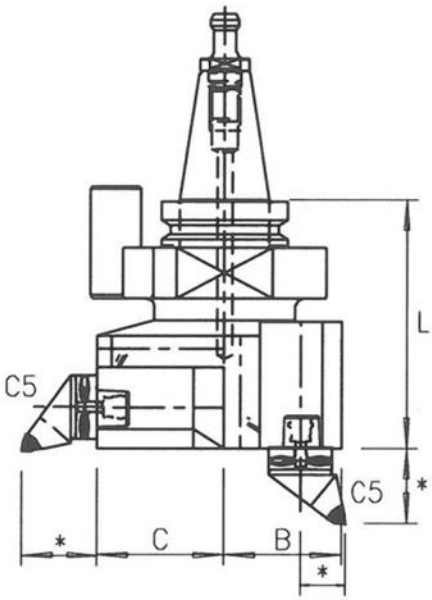


Item	Gauge (L mm)	Tool Dia (D mm)
50-BB-100-150	200	110
50-BB-110-315	300	110
50-BB-110-400	400	110

PULL STUD INCLUDED
FRONT IS LEFT SOFT FOR CUSTOMER SPECIFIC APPLICATIONS

TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

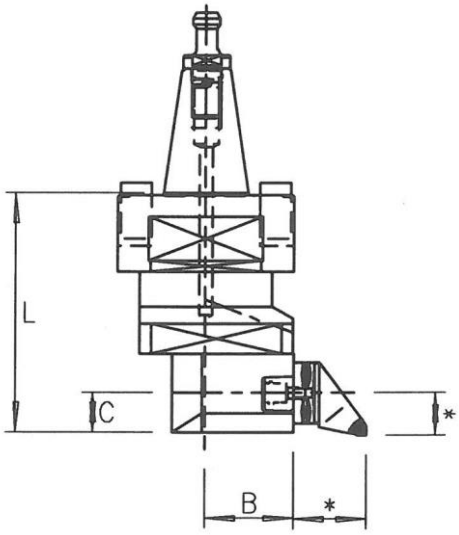
FOR MACHINES WITH STATIC AND ROTATING SPINDLES.
MODULAR TYPE FOR CAPTO SYSTEMS (KM and HSK also available



Item	Gauge (L mm)	Capto Fitting	B (mm)	C (mm)
50-C5(2)-196XR	196	C5	92	100
50-C6(2)-218XR	218	C6	102	122

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
NO EXTERNAL COOLANT NOZZLES
PULL BACK MECHANISM INCLUDED IN CAPTO ADAPTER
- DIMENSION DEPENDENT ON CAPTO TOOL TYPE

SPECIFY CLOCKWISE OR ANTI CLOCKWISE CUTTING
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS



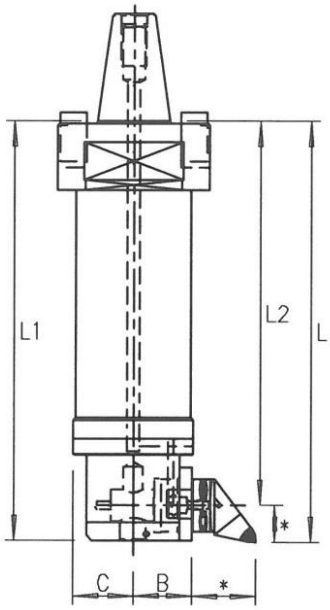
Item	Gauge (L mm)	Capto Fitting	B (mm)	C (mm)
50-C5(1)-196XR	196	C5	100.5	32
50-C6(1)-216XR	216	C6	122	42
50-C8(1)-232XR	232	C8	146	50

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
NO EXTERNAL COOLANT NOZZLES
PULL BACK MECHANISM INCLUDED IN CAPTO ADAPTER
- DIMENSION DEPENDENT ON CAPTO TOOL TYPE

SPECIFY CLOCKWISE OR ANTI CLOCKWISE CUTTING
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

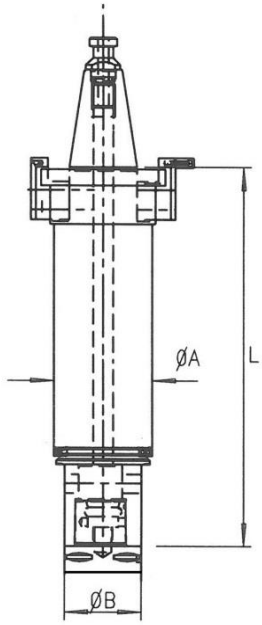
FOR MACHINES WITH STATIC AND ROTATING SPINDLES.
MODULAR TYPE FOR CAPTO SYSTEMS (KM and HSK also available)



Item	Length (L1 mm)	Capto Fitting	B (mm)	C (mm)
50-C5(1)SLIM-400	400	C5	57	57

PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
NO EXTERNAL COOLANT NOZZLES
PULL BACK MECHANISM INCLUDED IN CAPTO ADAPTER
- DIMENSION DEPENDENT ON CAPTO TOOL TYPE

SPECIFY CLOCKWISE OR ANTI CLOCKWISE CUTTING
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

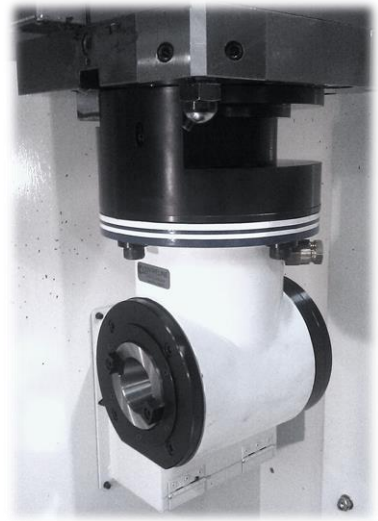


Item	Gauge (L mm)	Capto Fitting	A (mm)	B (mm)
50-C6(1)EXT-220	220	C6	80	63
50-C8(1)EXT-400	400	C8	103	80
50-KM63(1)-220	220	KM63	80	63

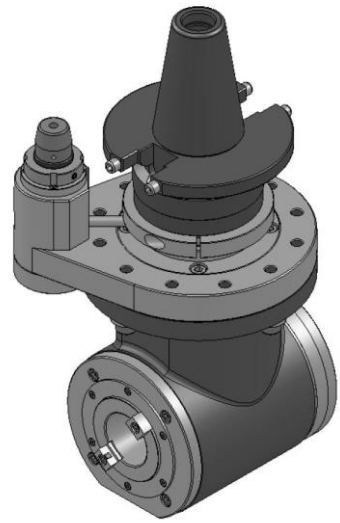
PULL STUD INCLUDED
THROUGH CENTRE COOLANT FEATURE
NO EXTERNAL COOLANT NOZZLES
ONE CLAMPING ADAPTER INCLUDED FOR C8 TOOL
SPECIFY CLOCKWISE OR ANTI CLOCKWISE CUTTING
FOR NORMAL COOLANT FEED PRESSURE
PLEASE CONTACT US FOR HIGH PRESSURE APPLICATIONS

TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

DRIVEN ANGLE HEADS FOR VERTICAL TURNING LATHES:



Eliminates the time and cost of taking components off the machine for second operation work.



- 40ISO, 50ISO or Capto/EPS, KM Output
- Various length options
- Both 90 degree and adjustable angle available.
- Custom fit to machine spindle
- Cowl mount for rigidity
- Auto tool change capability
- Through Coolant option

Full details and technical specifications available on request

TOOLHOLDING SYSTEMS FOR VERTICAL TURNING MACHINES

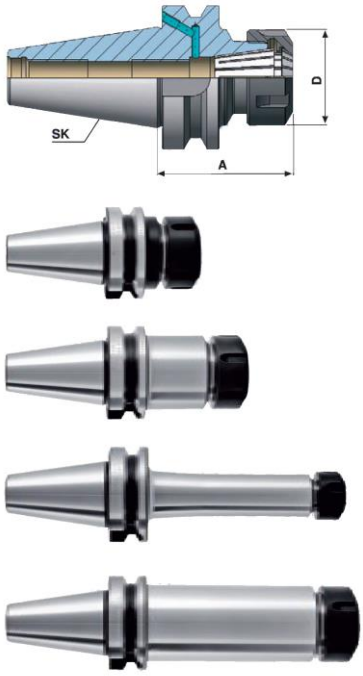
OPTIONAL FEATURES FOR MACHINES WITH STATIC AND ROTATING SPINDLES.

ADDITONAL OPTIONAL FEATURES	
FACE AND TAPER CONTACT	FLANGE FACE GROUND TO GIVE CONTACT WITH THE SPINDLE FACE. PROVIDES ADDITIONAL SUPPORT DURING MACHINING OPERATIONS
HIGH PRESSURE COOLANT	CHANGE ALL COOLANT NOZZLES TO SUIT HIGH PRESSURE COOLANT. NOTE VARIOUS TYPES OF NOZZLE CAN BE SUPPLIED TO GIVE EXTENDED REACH AND ADJUSTABLE COOLANT DIRECTION.

Coventry Toolholders Ltd, Units 7, 9&11 Paragon Way, Coventry CV7 9QS
T: +44 (0) 24 7664 5999 F +44 (0) 24 7664 4081
E: info@coventrytoolholders.com W: www.coveng.co.uk

A comprehensive range of both standard (from stock) and special rotating toolholders are available, along with associated accessories. An extract from the range is detailed below.

ER – DIN6499 Collet Chucks



ER RANGE	ER16,25,32,40
Clamping Diameters	From 1mm to 26mm
Gauge Lengths (A)	From 70, 100, 160, 200mm as standard
Coolant	Available with through coolant. Sealed collet systems available
Specials	Available on Request

ER – DIN6499 Collets

ER RANGE	ER16,25,32,40
Accuracy	Available as Precision (.010mm) or High Precision (.005mm)
Systems	• Standard • Tapping Collet • Tension Tapping Collet • Sealed or Jet

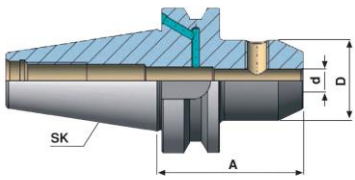
ER Collet Tool Extensions

ER Series

MINI ER Series

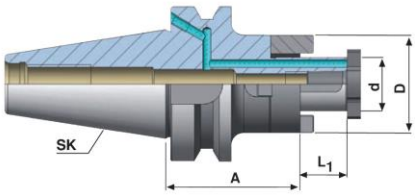
ER RANGE	ER16,25,32,40 and MINI series ER11,16,25
Clamping Diameters	From 1mm to 26mm
Overall Lengths	From 70 - 200mm as standard

End Mill (Weldon) Toolholders

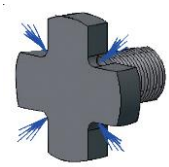


Bore Range (Dia.)	6,8,10,12,14,16,18,20, 25,32,40mm
Gauge Lengths (A)	63 - 200mm as standard
Coolant	Available with through coolant and front coolant channels
Specials	Available on Request

Face Mill, Shell Mill and Combi Shell Mill Toolholders



Spigot Range (d)	22,27,32,40,60mm (40 and 60mm are bolt on type)
Gauge Lengths (A)	55 - 200mm as standard
Coolant	Available with through coolant with optional coolant type clamp screws
Specials	Available on Request

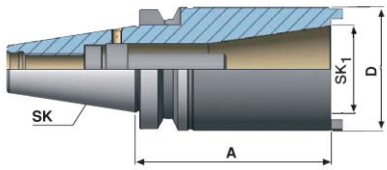


Through Coolant
Type Clamp screw

Pull Studs / Retention Knobs

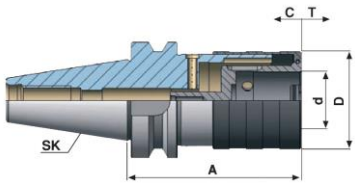
Range	• Solid • Through Coolant • Metric or Imperial • Special Sizes

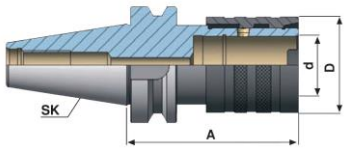
Taper Extensions and Reducers



50 Taper	50 – 50 Extensions A = 120 50 – 40 Reducers A = 70

Tapping Toolholders – Quick Change





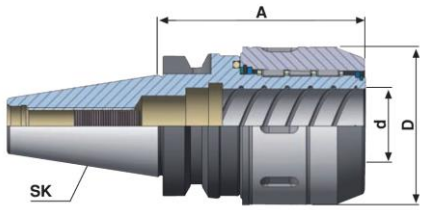
Range	Size 1 – M3-M14 Size 2 – M5-M22 Size 3 – M14-M36
Type	Both Solid Type and Tension and Compression
	Adapters for both DIN and ISO Tap sizes available. Contact us for larger tapping sizes.

Solid Type

Clutch Type

Quick Change Tap Adapters

High Grip Milling Chucks



Bore Sizes	32mm and 20mm
Type	High Grip roller bearing type clamping
Reducing Sleeves	32 to 25,20,16,12,10,8,6 20 to 16,12,10,8,6

Reducing Sleeves

Sets also available

FOR ALL YOUR STANDARD AND SPECIAL TOOLHOLDER REQUIREMENTS

CONTACT US ON -

Phone – +44 (0)2476 645999
Fax - +44 (0)2476 644081
E-Mail – info@coventrytoolholders.com
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COVENTRY TOOLHOLDERS

TOTAL TOOLING SOLUTIONS

Notes

COVENTRY ENGINEERING GROUP

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COVENTRY TOOLHOLDERS

COVENTRY TOOLHOLDERS — PRECISION TOOLHOLDING SYSTEMS. A COMPLETE PRODUCT RANGE FROM A SINGLE SOURCE

HSK
Sizes from HSK32 to HSK100
Forms A to F
Standards and Specials

STEEP TAPER
MAS403 BT, DIN69871 DV
CV – CAT ANSI – ISO
Metric and Imperial available

STRAIGHT SHANK
Cylindrical shaft to:
ER - Standard and Mini
DA - Standard, Slim, and Mini
TG – Full range

SPECIAL TOOLHOLDERS
A complete service: Technical Advice – Design – Manufacture – Test. All on one site.

STANDARD HYDRAULIC
Full range of bore sizes on a range of tapers.
Hydraulic system uses patented gel technology

SPECIAL HYDRAULIC
A wide variety of designed to suit both toolholding and workholding applications

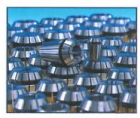
HEAT SHRINK
Full range of Toolholders, Heat Shrink Units and Accessories - Special and extended length toolholders available.

OTHER TOOLHOLDERS
Rotary Coolant Adapters – achieve through coolant supply. Pull Studs – full range available. Spanners / Wipers

VDI STATIC TOOLING
Range of static VDI tooling. Range covers VDI 16mm to VDI 80 shank sizes.

VDI DRIVEN TOOLING
Designed to suit a range of turret configurations. Standard In-Line and Angle types along with special designs.

EASY CHANGE
Quick Change toolholding system for Manual Machines. Achieve tool change in 3 seconds



COLLETS
ER – Standard and High Precision, also rigid and tension tapping collets.
DA – Standard range and Mini
TG – Full range of collets.

TURN – MILL TOOLING
A range of standard toolholders designed for integrated turn / milling machines

TURN - MILL TOOLING
A range of custom designs for high precision and heavy duty cutting requirements.

VERTICAL TURNING – SPECIAL
Specially designed tools for custom applications. Tools shown have Capto® adapters for quick change tooling

VERTICAL TURNING – STANDARD
Square block and boring bar type holders for large capacity vertical turning machines.

CENTRELINE

CENTRELINE — DRIVEN TOOLHOLDING SYSTEMS. A COMPLETE PRODUCT RANGE FROM A SINGLE SOURCE

STANDARD APPLICATIONS

RIGHT ANGLE HEADS
To suit any type of machine

FIXED ANGLE HEADS
The rigid answer to complex angles

UNIVERSAL ANGLE HEADS
Ultimate flexibility

SPEED INCREASERS
Allows the ultimate feedrate

ROTARY COOLANT ADAPTERS
For all types of machine tool

ATC MULTIHEADS
For drilling, tapping, reaming etc.

'CENTINEL' ADJUSTABLE
Multi-drilling & tapping heads

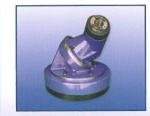
'SET BACK' HEAD
Limited space applications

SPECIAL APPLICATIONS

VERTICAL BORING HEADS
A hydraulically operated A.T.C 900 unit to accept Coromant Capto® Tooling

SPECIAL DRIVEN TOOLS
For all types of turning centres

SPECIAL & EXTENDED APPLICATIONS
To suit any type of prismatic machine



UNIVERSAL ANGLE HEADS
Universal heads can be designed to suit all types of machine

TITAN STEEL WHEEL
3 off 120° angle drives at 90° to the machine axis

EXTENDED REACH FOR SMALL BORES
A solution for small diameter deep milling applications

BESPOKE APPLICATIONS
For confined machining conditions

STANDARD UNITS
Special interfaces to customers machine tools

COVENTRY ENGINEERING SERVICES

Equipped to offer "turnkey" manufacturing solutions with 2D & 3D design and a full range of specialised precision machining services.

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CENTRELINE

ISO 9001 Quality Management
FM 569421