

September 2019

VELOCITY **PULL STUDS**

OKUMA CERTIFIED PULL STUDS

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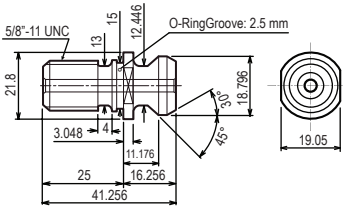

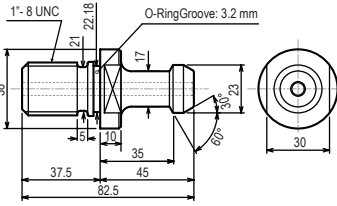

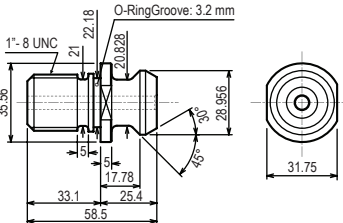
OKUMA Certified
Hardened
Coolant Through
Pull Studs

VELOCITY OKUMA CERTIFIED PULL STUDS

VELOCITY PULL STUDS

TECHNICAL SPECIFICATIONS

Velocity OKUMA Certified pull studs are specifically designed for OKUMA spindles. The tolerances and surface finish to which Velocity pull studs are machined results in increased tool life and better part surface finishes. Velocity OKUMA Certified pull studs are machined from SNCM 420 (JIS)/4320 (ASTM) alloy steel, hardened to HRC 52 - 58. All Velocity pull studs are coolant through. Contact Velocity at 256-258-5549 or sales@velocityproducts.com.

CAT 40	PART NUMBER	DRAWING	MACHINES
	CAT 40 611-2032-05-02 (Internal Coolant)		OKUMA CAT 40 Machines with Internal Coolant Spindles
	CAT 50 613-2032-08-01 (Internal Coolant)		OKUMA CAT 50 Machines with IC Spindles. Also for 1000Nm High Torque Spindles. Confirm part # with Okuma.
	CAT 50 HIGH TORQUE 613-2032-07 (Internal Coolant)		OKUMA CAT 50 MA12500 and MU10000 Geared Headstock Machines. (3000 RPM & 4500 RPM)



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VELOCITY OKUMA CERTIFIED CAT 40 PULL STUDS

CAT 40 Pull Studs

The o-ring supplied with a Velocity OKUMA Certified CAT 40 pull stud is 1.5mm x 15mm. The Velocity pull stud with a 1.5mm x 15mm o-ring is for use on CAT 40 toolholders with a **small chamfer**. Toolholders with a **large chamfer** require a 2.0mm x 15mm o-ring which is also included with Velocity CAT 40 pull studs.



PULL STUD INSTALLATION INSTRUCTIONS

The following instructions are **recommendations only**. Every manufacturer of toolholders has their own torque specifications for installing pull studs.

- Mount the toolholder in a bench fixture when installing the pull stud.
- Clean/degrease the threads on both the pull stud and the toolholder.
- Inspect the chamfer on the toolholder, and select the correct o-ring per above.
- Apply Loctite 242 (blue) thread locker to the internal threads of the **toolholder** - this will correctly push the Loctite forward as the pull stud is installed.
- Always use a calibrated torque wrench, with the proper socket to install pull studs.
- Use the **LOWEST** torque value possible to tighten the pull stud. For a CAT-40 pull stud, a torque value of 30 - 40 ft.lbs. is recommended.



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