T.J. DAVIES CO. INC.

THE LEADING MANUFACTURER OF RETENTION KNOBS

Retention Knob Installation and Log

Verify that you are installing the correct retention knob for your machine. Do not assume retention knobs are interchangeable, even if they look similar. Install only the specified knob to avoid damaging the spindle or tool holder and prevent safety hazards.

After confirming you have the correct retention knob, record all details in the retention knob installation log.

Before installing the retention knob, thoroughly clean the spindle. Next, attach the tool holder to the mounting figure and thoroughly clean its internal threads. If there is any dirt or debris in the tool holder, the retention knob may not seat properly.

Apply a small amount of Loctite® 242® thread locker to the tool holder's internal threads. This makes it possible to remove the retention knob with hand tools later. Use a calibrated torque wrench and retention knob socket to tighten the retention knob to the torque listed in the chart or specified by the manufacturer for the machine or toolholder.

Recommended Retention Knob Torque Guide

RETENTION KNOB	DRIVE	TORQUE	SOCKET #
BT 30 Taper	3/8" sq	20-25 ft lbs	RKS BT30
CAT 30 Taper	3/8" sq	20-25 ft lbs	RKS CAT30
BT 40 Taper	1/2" sq	45-55 ft lbs	RKS BTCT40
CAT 40 Taper	1/2" sq	45-55 ft lbs	RKS BTCT40
BT 45 Taper	1/2" sq	45-55 ft lbs	RKS BT45
CAT45 Taper	1/2" sq	45-55 ft lbs	RKS CAT45
BT 50 Taper	1/2" sq	75-90 ft lbs	RKS BT50
CAT 50 Taper	1/2" sq	75-90 ft lbs	RKS CAT50
CAT 60 Taper	1/2" sq	75-90 ft lbs	RKS CAT60

Overtighting can stress the retention knob leading to failure and can cause toolholder swelling and expansion.

Installation Log

Machine: _____

Model: _____

Retention Knob #: _____

Installation Date: _____

Notes: _____

Machine: _____

Model: _____

Retention Knob #: _____

Installation Date: _____

Notes: _____

An electronic log is available, email sales@tjdavies.com

Retention Knobs do have a limited functional lifespan and should be inspected on a regular basis.

- Include retention knob inspection in your monthly preventative maintenance program.
- Regularly inspect retention knobs for any signs of wear. If you notice any signs of wear, replace your retention knob.
- If gripper finger or ball marks are visible on the top of the retention knob, the retention knob should be replaced.
- Change O-rings as part of your preventative maintenance program.

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