



Why Make The Investment?

We can give you plenty of reasons.

- J&M Machine, with the support of Mitutoyo American Corporation, conducted tests using the leading brands of retention knobs in the leading brands of v-flange tool holders.
- These tests have proven that these wear marks are a result of the expansion of the tool holder shank due to the installation of the standard retention knob.
- The pressure exerted by the 60 degree angle of the threads of the standard retention knob results in growth in diameter of the small end of the tool holder shank.
- Testing performed by J&M Machine has proven that tool holders should be checked for expansion prior to their installation in the machines.
- Use of the Test Fixture guarantees that holders seat properly in the spindle when tool holders are changed.
- Proper seating eliminates the fretting of a second angle at the gage line of the tool holder by eliminating movement caused by cutting force pressure.
- This increases tool life by reducing tool run-out and uneven chip load resulting in better finishes, increased feed rates and closer tolerances.
- Run-out and vibration that can break the fine razor edge on carbide tools prematurely is virtually eliminated.
- Balance of high speed tools after installation of the retention knob is maintained, which in turn, reduces tool life variance from one tool to another in the same cutting operation.

Set Your Course For Quality





J&M MACHINE, INC.

Since 1965



- Longer tool life, less breakage, improved feed rates, and reduced down-times for machine and spindle maintenance, which all add up to more money to the bottom line.
- J&M Machine responded by developing a new, patent pending High Torque retention knob design that produces the ONLY BALANCED RETENTION KNOB AVAILABLE ON THE MARKET.
- High Torque retention knobs can be tightened to the same torque levels as standard retention knobs but with two to ten times LESS toolholder distortion.
- ANSI retention knob designs include a pilot which greatly reduces the chance of breakage.
- Made in the USA of hot rolled 8620H material and black oxidized to guard against rust, these retention knobs provide improved durability, extended life and reduced cracking potential.
- J&M retention knobs are lasered with easy to read markings so choosing the wrong knob isn't an issue.
- Installation of these high Torque retention knobs using J&M manufactured sockets
- Will yield longer tool life, less breakage, consistent feed rates, and reduced down-times for machine and spindle maintenance which all add up to more money to the bottom line.

Order by phone or write us at sales@jmmachineinc.com. To order, simply use the part number from your present knob, and we'll cross match it with the high torque knob. Visit us online at <http://www.jmmachineinc.com>.

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