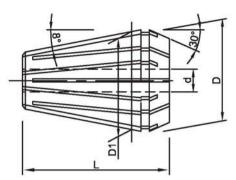




COLLET ER TYPE

DIN 6499 FORM B



Collet Designation	В	ore Ra Ød	ange	Total pieces/set		capacity set	Each collet collapse by	D	Gauge plane dia	L
	From	То	In Steps		From	То			D1	_
ER8	1	5	0.5	9	0.5	5	0.5	8.5	8	13.5
ER11	1	7	0.5	13	0.5	7	0.5	11.5	11	18
ER16	1	10	1	10	0.5	10	1	17	16	27
ER20	2	13	1	12	1	13	1	21	20	31
ER25	2	16	1	15	1	16	1	26	25	35
ER32	3	20	1	18	2	20	1	33	32	40
ER40	4	26	1	23	3	26	1	41	40	46
ER50	12	34	2	12	10	34	2	52	50	60

METHOD OF INSERTION & RELEASE FOR ER COLLET

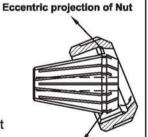
 Insert collet into nut at an angle as shown to engage eccentric projection of Nut with groove of collet.
Screw nut onto collet chuck with collet securely in nut.

3.Insert tool to be gripped and lock nut. IMPORTANT:Never screw nut on to collet chuck unless collet is properly seated in nut.

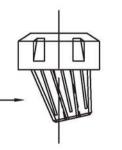
RELEASING

As shown in the fig

 Unscrew the nut from collet chuck
The collet is withdrawn from collet chuck automatically by the eccentric projection in the nut.
Hold the nut in one hand and remove collet at an angle by the other hand.



Groove in the collet





TOTAL INDICATOR READING

ER COLLET RUN-OUT

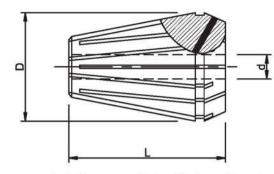
d						
Above	upto	L	12120-000-000-000-000	High Precision		
1	1.5	6		12		
1.5	3	10	0.015	0.010		
3	6	16	0.015			
6	10	25				
10	18	40				
18	26	50	0.020	0.015		
26	34	60	1			



COLLET ERNC TYPE

FOR COOLANT THROUGH APPLICATION

DIN 6499 FORM A



- These are nominal diameter collets with bore diameter 3mm and above
- Suitable for coolant through applications

Collet Designation	Bo	Ød	ange	Total		set	D	Gauge	L	
	From	То	In steps	pieces/set	From	То		plane dia		
ERNC11	3	7	0.5	13	3	7	11.5	11	18	
ERNC16	3	10	1	10	3	10	17	16	27	
ERNC20	3	13	1	12	3	13	21	20	31	
ERNC25	3	16	1	15	3	16	26	25	35	
ERNC32	3	20	1	18	3	20	33	32	40	
ERNC40	4	26	1	23	4	26	41	40	46	
ERNC50	12	34	2	12	12	34	52	50	60	

METHOD OF INSERTION & RELEASE FOR ER COLLET

: 1.Insert collet into nut at an angle as shown to engage eccentric projection of Nut with groove of collet.

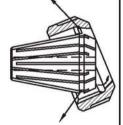
2.Screw nut onto collet chuck with collet securely in nut.

3.Insert tool to be gripped and lock nut. IMPORTANT:Never screw nut on to collet chuck unless collet is properly seated in nut.

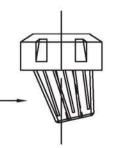
RELEASING

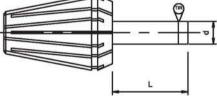
1.Unscrew the nut from collet chuck 2.The collet is withdrawn from collet chuck automatically by the eccentric projection in the nut.

3.Hold the nut in one hand and remove collet at an angle by the other hand. As shown in the fig Eccentric projection of Nut



Groove in the collet

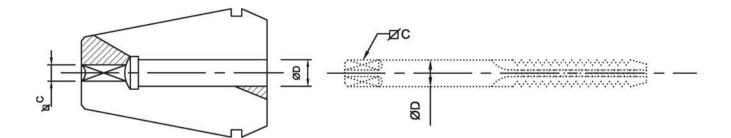




Clampi	ng range	Е.	Run Out (TIR			
Above	upto	-				
3	6	16	0.01			
6	10	25	0.01			
10	18	40				
18	26	50	0.015			
26	34	60				

TOTAL INDICATOR READING





Nowadays there are a number of CNC turning and machining centers equipped with rigid tapping feature,we took advantage of this and developed a new collet type ERT.These new ERT collets are designed with internal square that matches the tap.Present holders designed for ER collets as per DIN6499 can be used along with this collet.

For clamping taps use of ball bearing nuts is recommended. While placing an order always indicate item description as shown below and verify if the tap on DIN or ANSI standard matches the shank diameter and the square.

ODERING INSTRUCTION

COLLET TYPE SQUARE SIZE



COLLET ERT TYPE

Standards			Collet	Item Art.Nr Ref						
DIN 374/376	DIN 352/2181	DIN 371	ØD	ØC	ER 16T	ER 20T	ER 25T	ER 32T	ER 40T	ER 501
M5	М3	M3	3.5	2.7	1	1	1		×	-
M5.5	M3.5	M3.5	4	3	1	1	1	-	-	
M6	M4	M4	4.5	3.4	1	1	1	1	-	-
M7	878		5.5	4.3	*	1	1	~	-	-
M8	M4.5-M8	M4.5-M8	6	4.9	1	*	4	~	*	4
M9+M10	M9+M10	M7	7	5.5	1	1	1	~	*	
M11	M11	M8	8	6.2	-	~	1	~	~	1
M12	M12	M9	9	7	-	1	1	~	1	1
	(40	M10	10	8	-	1	4	~	1	1
M13+M14	M13+M14		11	9	-		1	1	*	1
M15-M17	M15-M17		12	9	-	-	1	1	4	1
M18+M19	M18+M19		14	11	-	-	-	~	4	1
M20+M21	M20+M21		16	12	-	Ξ.	-	~	*	~
M22-M26	M22-M26		18	14.5	-		-	-	1	1
M27+M28	M27+M28	12	20	16	-	-	-	4	4	1
M29+-M32	M29+-M32	4	22	18	-	:#:	-	-	-	~
M33	M33	-	25	20	-		-	-	•	1
M34-M38	M34-M38	-	28	22	-	-	-	-	-	1
M39-M42	M39-M42		32	24	-	-			-	~

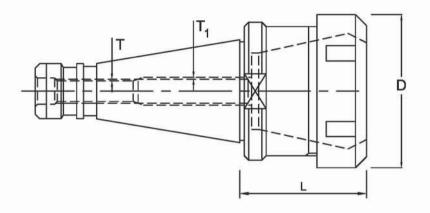
ERT Collets for Tap Holding without compensation as per DIN Standard

ERT Collets for Tap Holding without compensation as per US standard

	U.S.A Standards Tap -Sizes		item Art.Nr Ref	Item Art.Nr Rei					
Inch	Metric	ØD	ØC	ER 16T	ER 20T	ER 25T	ER 32T	ER 40T	ER 50T
1/8"	M3	0.141"	0.110"	1	1	~	-	-	
5/32"	M4	0.168"	0.131"	1	1	~	-	-	
3/16"	M4.5+M5	0.191"	0.152"	1	1	1	1	-	•
7/32*		0.220"	0.165"	1	1	1	~	-	
1/4"	M6+M6.5	0.255"	0.191"	1	1	1	~	-	
5/16"	M7+M8	0.318"	0.238"	-	1	1	~	~	
7/16"	-	0.323"	0.242"	-	1	1	1	1	-
3/8"	M10	0.367"	0.275"	-	1	~	~	~	
1/2"	M12+12.5	0.381"	0.288"	-	1	~	1	1	-
9/16"	M14	0.429"	0.322"	-	-	1	1	1	-
5/8"	M16	0.480"	0.360"	-	-	1	~	1	1
11/16"	M18	0.542"	0.406"	-	-	-	~	~	1
3/4"		0.590"	0.442"	-		-	4	4	1
13/16"	M20	0.652"	0.489"	-) ÷		1	1	~
7/8"	M22	0.697"	0.523"	-	-	-	-	~	4
15/16"	M24	0.760"	0.570"	-	-			~	~
1"	M25	0.840"	0.600"	-	-	-	-	1	1

COLLET CHUCK ISO SHANK

DIN 2080



Model	Capacity	Collet	L	D	T1	T Draw Bar	Weight (Kg)
ISO 30-ER16A-60	0.5~10.0	ER16	60	28	M10*1.5P		0.5
ISO 30-ER20A-60	1.0~13.0	ER20	60	34	M12*1.75P		0.6
ISO 30-ER25A-60	1.0~16.0	ER25	60	42	M16*2.0P	M12*1.75P	0.65
ISO 30-ER32A-60	2.0~20.0	ER32	60	50	M16*2.0P		0.8
ISO 30-ER40A-70	3.0~26.0	ER40	70	63	M16*2.0P		0.9
ISO 40-ER16A-70	0.5~10.0	ER16	70	28	M10*1.5P		0.95
ISO 40-ER20A-70	1.0~13.0	ER20	70	34	M12*1.75P		1.2
ISO 40-ER25A-70	1.0~16.0	ER25	70	42	M16*2.0P	MACKO OD	1.25
ISO 40-ER32A-70	2.0~20.0	ER32	70	50	M16*2.0P	M16*2.0P	1.3
ISO 40-ER40A-70	3.0~26.0	ER40	70	63	M20*2.0P		1.35
ISO 40-ER50A-80	3.0~34.0	ER50	80	78	M24*2.0P		2
ISO 50-ER32A-80	2.0~20.0	ER32	80	50	M16*2.0P		3.2
ISO 50-ER40A-80	3.0~26.0	ER40	80	63	M20*2.0P	M24*3.0P	3.4
ISO 50-ER50A-80	3.0~34.0	ER50	80	78	M24*2.0P		3.7

