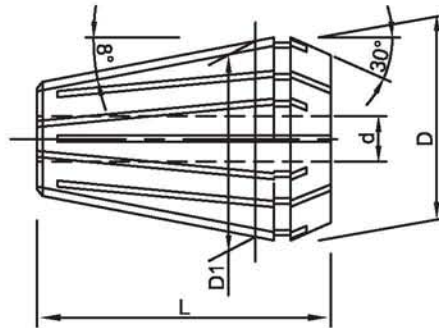


DIN 6499 FORM B



Collet Designation	Bore Range $\varnothing d$			Total pieces/set	Clamping capacity per set		Each collet collapse by	D	Gauge plane dia D1	L
	From	To	In Steps		From	To				
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

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.

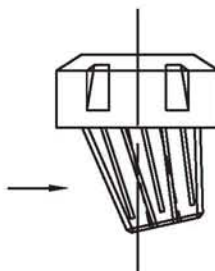
Eccentric projection of Nut



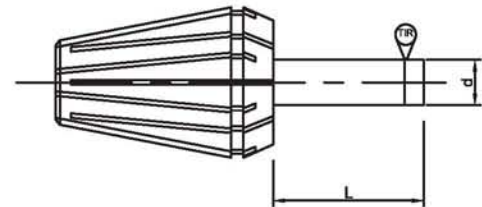
Groove in the collet

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 The collet is withdrawn from collet chuck automatically by the eccentric projection in the nut.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



TOTAL INDICATOR READING

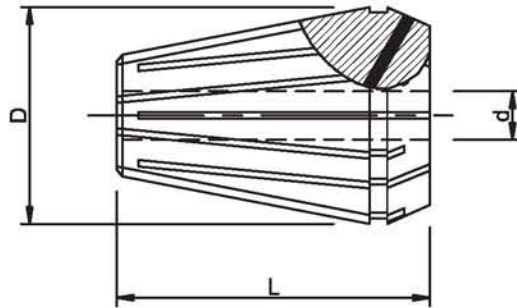


ER COLLET RUN-OUT

d		L	Run Out (TIR)	
Above	upto		Normal Precision	High Precision
1	1.5	6	0.015	0.010
1.5	3	10		
3	6	16		
6	10	25	0.020	0.015
10	18	40		
18	26	50		
26	34	60		

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	Bore Range $\varnothing d$			Total pieces/set	Clamping capacity per set		D	Gauge plane dia	L
	From	To	In steps		From	To			
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

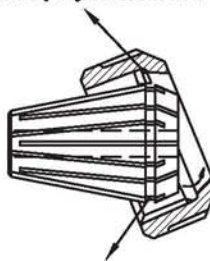
METHOD OF INSERTION & RELEASE FOR ER COLLET

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.

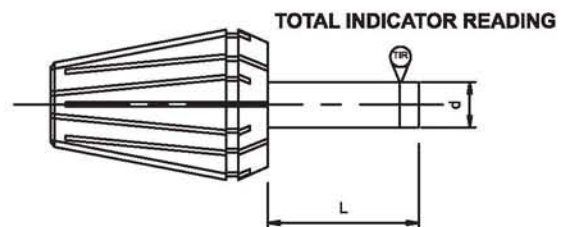
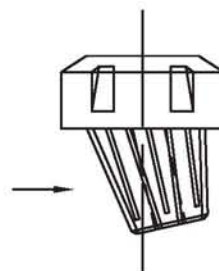
RELEASING

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



Clamping range		L	Run Out (TIR)
Above	upto		
3	6	16	0.01
6	10	25	
10	18	40	0.015
18	26	50	
26	34	60	



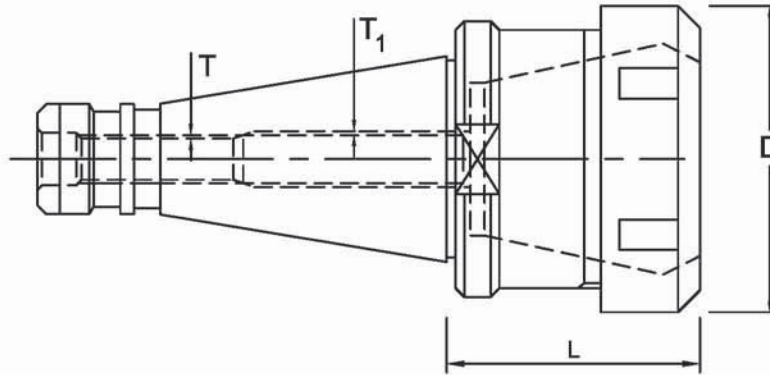
ERT Collets for Tap Holding without compensation as per DIN Standard

Standards			Collet	Item Art.Nr Ref	Item Art.Nr Ref	Item Art.Nr Ref	Item Art.Nr Ref	Item Art.Nr Ref	Item Art.Nr Ref	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 50T
M5	M3	M3	3.5	2.7	✓	✓	✓	-	-	-
M5.5	M3.5	M3.5	4	3	✓	✓	✓	-	-	-
M6	M4	M4	4.5	3.4	✓	✓	✓	✓	-	-
M7	-	-	5.5	4.3	✓	✓	✓	✓	-	-
M8	M4.5-M8	M4.5-M8	6	4.9	✓	✓	✓	✓	✓	-
M9+M10	M9+M10	M7	7	5.5	✓	✓	✓	✓	✓	-
M11	M11	M8	8	6.2	-	✓	✓	✓	✓	✓
M12	M12	M9	9	7	-	✓	✓	✓	✓	✓
-	-	M10	10	8	-	✓	✓	✓	✓	✓
M13+M14	M13+M14	-	11	9	-	-	✓	✓	✓	✓
M15-M17	M15-M17	-	12	9	-	-	✓	✓	✓	✓
M18+M19	M18+M19	-	14	11	-	-	-	✓	✓	✓
M20+M21	M20+M21	-	16	12	-	-	-	✓	✓	✓
M22-M26	M22-M26	-	18	14.5	-	-	-	-	✓	✓
M27+M28	M27+M28	-	20	16	-	-	-	-	✓	✓
M29+-M32	M29+-M32	-	22	18	-	-	-	-	-	✓
M33	M33	-	25	20	-	-	-	-	-	✓
M34-M38	M34-M38	-	28	22	-	-	-	-	-	✓
M39-M42	M39-M42	-	32	24	-	-	-	-	-	✓

ERT Collets for Tap Holding without compensation as per US standard

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

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	M12*1.75P	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		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	M16*2.0P	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		1.25
ISO 40-ER32A-70	2.0~20.0	ER32	70	50	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	M24*3.0P	3.2
ISO 50-ER40A-80	3.0~26.0	ER40	80	63	M20*2.0P		3.4
ISO 50-ER50A-80	3.0~34.0	ER50	80	78	M24*2.0P		3.7