An ISO 9001:2015
Certified Company

tecnicrafts®

Precisely Crafted. To Inspire Trust

- Guide Bushings
- Main Spindle Collets
- Sub - Spindle Collets
- Carbide Lined Collets
- Special Collets
- Bar Feed Collets

High Precision Collets & Guide Bushes

For Swiss Type CNC Automatic Lathes

Version 19.0 1

Machines - Maschinen - Macchine

CITIZEN

Cincom

Miyano

star

TORNOS

NEXTURN
SWISS TURN LEADER

TSUGAMI

Hanwha

DOOSAN

NOMURA

MAIER

INDEX
TRAUB

GILDEMEISTER

KSI

PO LY GIM

MANURHIN KMX

HARDINGE

JINN FA

THE ULTIMATE MACHINING POWER
WOODWAY

Strohm

Petermann

André Bechler SA
Moutier

EWAG

ANCA

ROLLOMATIC

Tecnicrafts Industries

Manufacturers of
Hi-Precision Collets, Carbide Lined Guide Bushes
for Swiss type Automatic Lathes

CITIZEN-CINCOM, TSUGAMI, STAR, TORNOS, TORNOS-DECO, TORNOS-DELTA, GILDEMEISTER, HARDINGE, HANWHA, INDEX, NEXTURN, MAIER, MANURHIN-KMX, MIYANO, NOMURA, POLYGIM, TRAUB, BECHET, BECHLER, PETERMAN, STROHM, GAUTHIER, GOODWAY, JIN-FA.

Collet - Smooth Bore

- Standard upto Ø 7.9mm Bore
- Bigger Bore Sizes also Available in Smooth - on request
- Available in Standard Precision and Extra Precision

Collet - Grooved Bore

- Standard Grooved Bores Available from Ø 8.0mm
- Used Especially in Headstock

Collet - Profile Bore

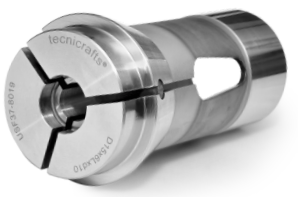
- All profiles like Hexagon, Square, Rectangular, etc.,
- Available in all standard collet models

Collet - Serrated Bore

- Horizontal and Vertical Grooves
- Available from Bore Ø 8.00mm above.

Collets with Carbide Insert

- For long life and endurance.
- All Standard Collets are available with Carbide Insert



Collet - Stepped Bores

- Clamping on Two Different Diameters Possible
- Available for All Collet Types

Collet - Over Gripping

- Suitable for Clearing a shoulder and Gripping on a Smaller Diameter Beyond
- Used on a Pick-off Spindle

Collet Special Profile

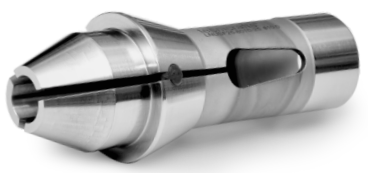
- Suitable for Different Special Profiles and Partial Shapes.

Collets - V Line

- No marks on material while clamping
- Suitable for all profiles like Square, Hexagon, etc.,
- Uniform High Tension
- Easier Cleaning after Operation

Long Nose Collet - Staight Nose

- All Standard Collets available with Long Straight Nose
- Used on a Pick-off Spindle



Long Nose Collet - Tapered Nose

- All Standard Collets available with Long Tapered Nose
- Used on a Pick-off Spindle

Collet with Full Seal (Silicone Seal)

- Slots filled with silicone sealant to prevent chip and dirt debris entering inside the collets
- Mainly used on a Pick-off Spindle

Collet with Key Slot on Cone

- Key Slot on Cone made on request
- Key Slot on Cone is for profile orientation
- Suitable for all profiles like Hexagon, Square, etc..

Collet with Key Slot on Guiding Diameter

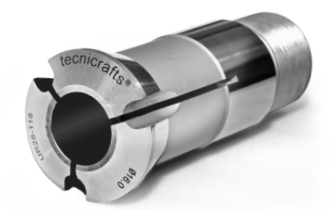
- Key Slot on Guiding Diameter made on request
- Key Slot on Guiding Diameter is for profile orientation
- Suitable for all profiles like Hexagon, Square. etc.,

SW Collet - Standard Nose

- Suitable for Tool Grinding machines and Schaublin Lathes
- Available in Standard Precision and Ultra Precision

SW Collet - Long Nose

- Suitable for Tool Grinding machines
- Available in Standard Precision and Ultra Precision



Guide Bush - Drawn (Adjustable) Type

- Suitable for Swiss type CNC automatic lathes
- Excellent Bore finish
- Bore surface finish - Ra value of 0.4 micron
- Standard Bore Chamfer on the bore edge

Guide Bush - Profile

- All Standard Guide Bushes available with Profiles like Hexagon, Square and Special partial shapes

Guide Bush - Reinforced Shank

- Special Guide Bush for Citizen and Star Swiss type CNC automatic lathes
- Excellent Bore finish
- Bore surface finish - Ra value of 0.4 micron
- Standard Bore Chamfer on the bore edge

Guide Bush - Traub

- Special Guide bush for Traub swiss type CNC automatic lathes
- Excellent Bore finish
- Bore surface finish - Ra value of 0.4 micron
- Standard Bore Chamfer on the bore edge

Guide Bush - Long Nose

- Shifting the Guiding area forward and thereby enhancing the stability of the workpiece
- Excellent Bore finish
- Bore surface finish - Ra value of 0.4 micron
- Standard Bore Chamfer on the bore edge

Guide Bush - U Line

- Slot Designed not to allow chip and dirt debris inside the Guide Bush
- Available only in Ultra Precision
- Suitable for all profiles like Square, Hexagon, etc.,
- Smooth Guiding
- No marks on material while guiding

Bar Feed Collet - External Thread

- Specially processed to obtain uniform tension

Bar Feed Collet - Internal Thread

- Specially processed to obtain uniform tension

Bar Feed Collet - Pin Type

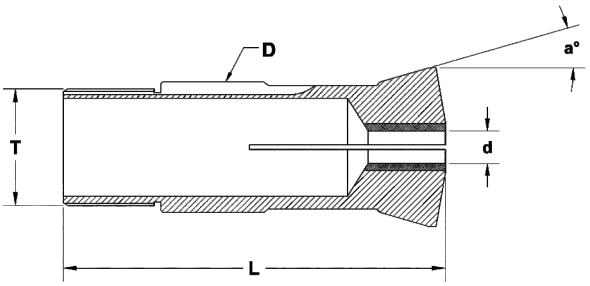
- Specially processed to obtain uniform tension

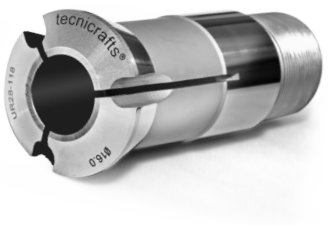
Max Land Guide Bushing

Standard Guide Bush

Guide Bush with Extended Carbide Insert (Max Land Guide Bushing)

- Guiding surface length up to 70mm
- Bore Diameter from 4mm to 42mm
- Guiding surface length will vary depending on bore diameter and guide bush model
- Suitable for components which require long drawing back like chasing a long thread
- High concentricity
- Extended carbide insert ensures improved guidance of component
- Prevents slippage of component from the carbide guide



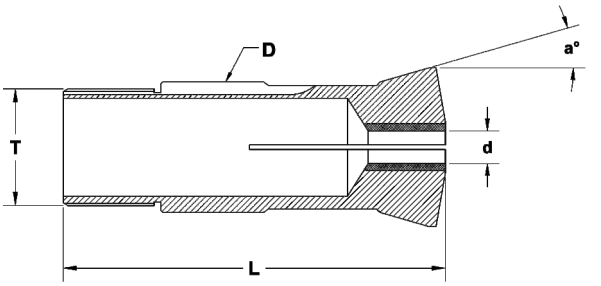


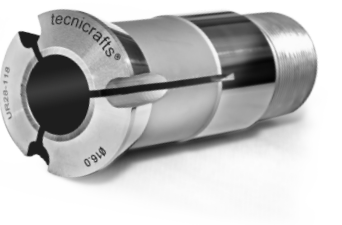
CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

					Capacity		
Part Nr.	Guiding Dia	Total Length	Thread	Angle	Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R7/02	7	30	M6x0.5	16°	3.5	-	-
R9/01	9	44	M8X0.5	16°	5	4	3
R9/03	9	38.5	M8x0.75	16°	5	4	3
R9/06	9	51	M8x0.8	30°	5	4	3
R9/09	9	44	M8x0.75	16°	5	4	3
R10/03	10	58	M10x0.75	12°	5.5	4	3
R11/02	11	53	M10x0.75	16°	7	5	4
R11/09	11	53	M10x1	16°	7	5	4
R11/10	11	57	M10x0.75	16°	7	5	4
R11/11	11	52.4	M10x0.75	16°	7	5	4
R11/12	11	53	M10x0.80	16°	7	5	4
R12/01	12	52	M12x1	30°	7	6	5
R12/02	12	50	M10x0.75	16°	7	6	5
R12/05	12	50	M10x0.75	16°	7	6	5
R12/07	12	50	M12x1	30°	7.5	6	5
R12/08	12	50	M10x0.5	30°	7	5	4
R12/09	12	50	M12x1	30°	7.5	6	5
R13/01	13	41.5	M12x0.75	15°	8	6	5
R14/02	14	64	M13x0.75	16°	8.5	7	6
R14/03	14	62	M14x1	15°30′	8.5	7	6

* table to be continued



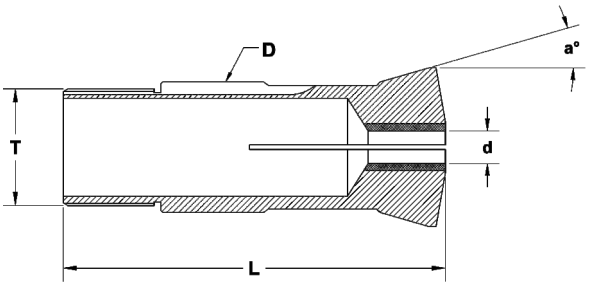


CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Total Length	Thread	Angle	Capacity		
					Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R15/02	15	54	M14x1	16°	10	8	7
R15/03	15	54	M14x0.75	15°	8.5	7	6
R16/01	16	50	M14x1	16°	10	8	7
R16/03	16	60	M14x1	30°	10	8	7
R16/06	16	55	M16x1	30°	10	8	7
R16/07	16	63	M14x1	15°30'	10	8	7
R16/10	16	58	M14x1	16°	10	8	7
R16/12	16	59	M14x1	16°	10	8	7
R16/15	16	59	M15x1	16°	11	9	8
R16/16	16	58.5	M14x1	20°	10	8	7
R16/18	16	63	M14x1	16°30'	10	8	7
R18/01	18	59	M16x1	30°	12	10	8
R18/02	18	60	M18x1	30°	13	10	9
R18/03	18	60	M18x1	30°	13	10	9
R18/06	18	76	M18X1	22°	13	10	9
R18/08	18	60	M18X1	30°	12.5	10	8
R20/01	20	55	M20x1	30°	14	11	9
R20/06	20	55	M20x1	30°	13	11	9
R20/07	20	58	M18x1	15°	13	11	9
R21/03	21	57.5	M18x1	12°	14	11	9

* table to be continued

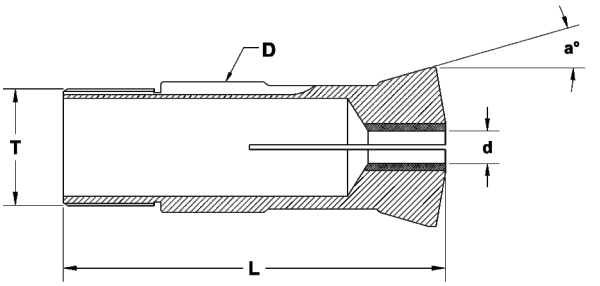


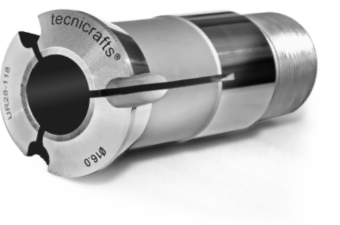
CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

					Capacity		
Part Nr.	Guiding Dia	Total Length	Thread	Angle	Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R22/01	22	68	M19x1	16°	14	12	10
R22/03	22	70	M20x1	15°	15.5	13	11
R22/04	22	68	M19X1	16°	15	12	10
R22/08	22	68	M22x1	16°	16	13	11
R23/01	23	72	M22x1	16°	16.5	14	11
R24/03	24	61	M24x1	30°	16	13	11
R26/02	26	77	M25x1	16°	20	17	14
R26/04	26	71	M24X1.5	15°	18	15	13
R27/03	27	57.5	M24x1	12°	18	15	12
R28/02	28	81	M25x1	30°	20.5	17	14
R28/04	28	82	M25x1	16°	20.5	17	14
R28/05	28	82	M27x1	16°	22	18	15
R30/01	30	70	M28x1	16°	20.5	17	14
R30/02	30	85	M28x1	16°	20.5	17	14
R30/04	30	59	M30x1	15°	22	19	16
R30/05	30	59	M30x1	16°	22	19	16
R30/06	30	68	M30x1	16°	22	19	16
R30/07	30	70	M30x1	16°	22	19	16
R30/08	30	57.5	M30X1	16°	22	19	16
R32/02	32	71	M32x1	30°	23	19	16

* table to be continued





CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

					Capacity		
Part Nr.	Guiding Dia	Total Length	Thread	Angle	Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R32/03	32	74	M32x1	30°	24	21	17
R33/01	33	70	M30x1	16°	26	22	18
R34/02	34	87.5	M34x1	10°	27.5	23	19
R34/03	34	87.5	M34X1	10°	27.5	23	19
R36/02	36	89.5	M36x1	13°	25	21	18
R40/03	40	72	M36x1	30°	29	25	21
R40/05	40	72	M40x1	30°	30	25	21
R41/01	41	54	M38x1	10°	32	27	22
R41/02	41	82	M38x1	10°	32	27	22
R41/03	41	82	M38X1	10°	32	27	22
R41/04	41	54	M38X1	10°	30	26	21
R42/01	42	82	M40x1	16°	33	28	23
R42/02	42	82	M40x1	20°30'	33	28	23
R42/04	42	82	M40x1	20°	33	28	23
R44/01	44	87	M40x1	20°	33	28	23
R45/01	45	82	M42x1	16°	36	30	25
R46/01	46	92	M45x1	16°	38	32	26
R46/02	46	82	M45x1	16°	38	32	26
R48/02	48	81	M48x1.25	30°	38	33	27
R48/04	48	82	M46x1	16°	38	33	27

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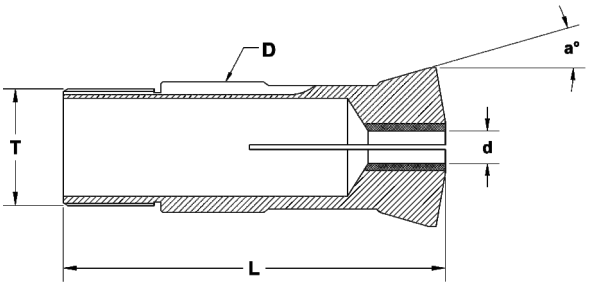
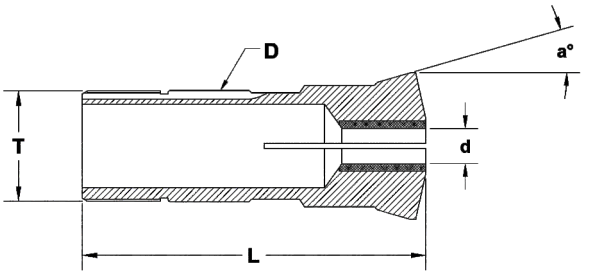
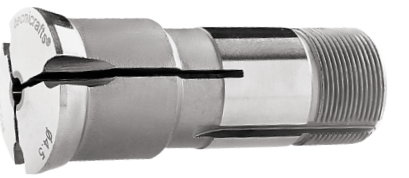


CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

					Capacity		
Part Nr.	Guiding Dia	Total Length	Thread	Angle	Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R48/06	48	81	M46x1	10°	38	33	27
R48/08	48	82	M46X1	16°	38	33	27
R50/02	50	82	M49x1	19°	42	36	29
R52/01	52	99	M48x1.5 LH	10°	40	34	28
R52/02	52	95	M50x1	16°	43	37	30

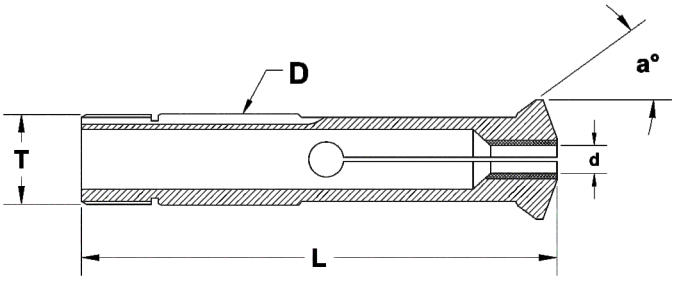




CARBIDE LINED GUIDE BUSH - WITH REINFORCED SHANK

All Dimension are in mm - Unless Otherwise Specified

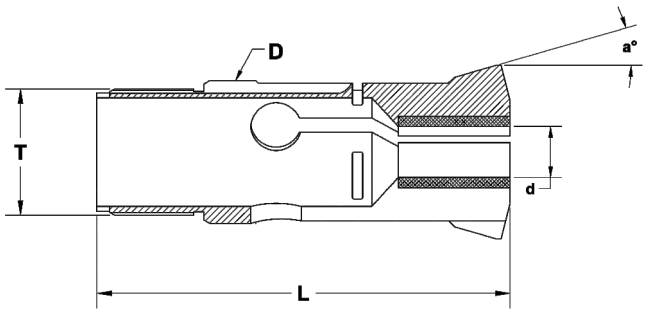
Part Nr.	Guiding Dia	Total Length	Thread	Angle	Capacity		
					Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R22/05	22	68	M22x1	16°	16	13	11
R34/06	34	150	M32x1.50	20°	27	22	19



CARBIDE LINED GUIDE BUSH - MAGIC TYPE

All Dimension are in mm - Unless Otherwise Specified

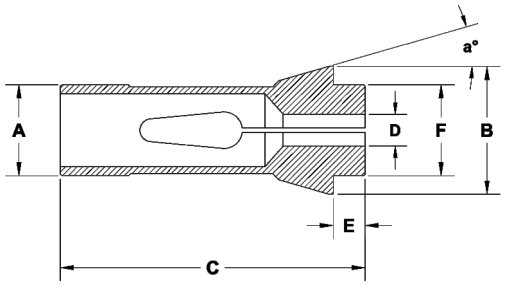
Part Nr.	Guiding Dia	Total Length	Thread	Angle	Capacity		
					Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R10/02	10	58	M10x1	36°	5.5	4	3
R13/02	13	68	M13x1	36°	8	6	5
R18/05	18	68	M18x1	36°	13	10	9



CARBIDE LINED GUIDE BUSH - TRAUB

All Dimension are in mm - Unless Otherwise Specified

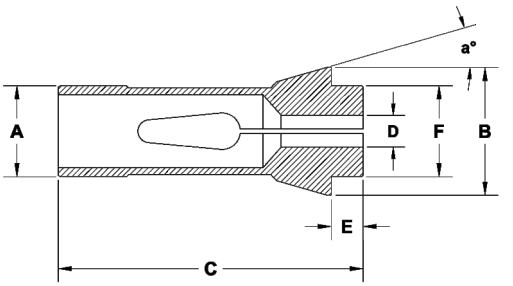
Part Nr.	Guiding Dia	Total Length	Thread	Angle	Capacity		
					Round	Hexagon	Square
	ØD	L	T	a°	●	⬢	■
R21/07	21	65.5	M18x1	12°	13.5	11	9
R27/01	27	67.5	M24x1	12°	18	15	13
R28/06	28	81.2	M25x1	16°	21	18	15
R42/07	42	81	M40x1	16°	33	28	23



COLLETS - OVER GRIPPING

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle
	ØA	ØB	C	E	ØF	a°
SF25/9089	25	35	77	10	24	48°
SF37/9112	37	44	91	6	36	16°

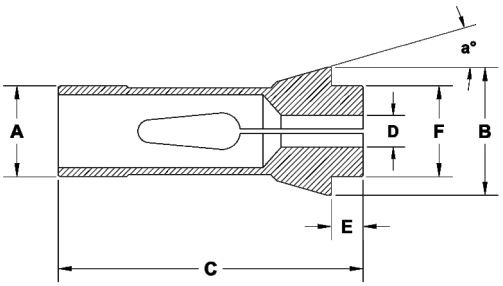


F - TYPE WITH STRAIGHT SHOULDER

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity		
							Round	Hexagon	Square
	ØA	ØB	C	E	ØF	a°	●	⬢	■
SF7/66	7	10.7	26	2.9	7	15°	4.5	3	3
SF7/206	7	10.5	26	3	7	15°	4.5	3	3
SF8/577	8	12	42	4.5	8	16°	5.5	4	3
SF8/1079	8	12	41	3.5	8	16°	4.5	3	3
SF10/86	10	15.5	47.5	5.5	10	20°	7	5	4
SF10/1178	10	16	46	4	10	20°	7	5	4
SF10/9054	10	16	47	5	10	20°	7	6	5
SF10/9096	10	15	43	5	10	15°	6.5	5	4
SF12/78	12	18.1	44.5	4.3	12	15°	8	6	5
SF12/578	12	18	64	6	12	16°	8	6	5
SF13/357	13	19	64	6	13	16°	10	8	7
SF14/98	14	18	46	4	14	13°	10	8	7
SF15/358	15	22	47	5	15	20°	10.5	9	7
SF15/580	15	21	64	6	15	16°	11	9	8
SF15/9005	15	20	45.5	2.5	15	15°	10	8	7
SF15/9012	15	21	64	6	17.5	16°	11.5	9	8
SF16/104	16	22	55	5	16	15°	12	10	8
SF16/1076	16	21	64	6	16	16°	12	10	8
SF16/9070	16	21	62	4	16	16°	12	10	8
SF16/9098	16	21	62	4	16	16°	12	10	8

* table to be continued

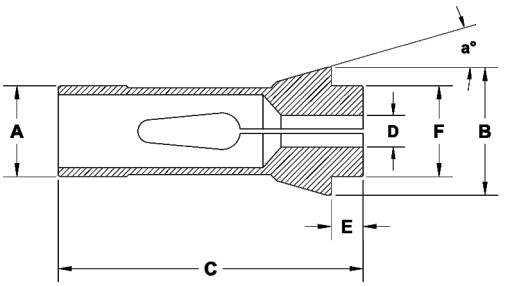


F - TYPE WITH STRAIGHT SHOULDER

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity Round	Capacity Hexagon	Capacity Square
	ØA	ØB	C	E	ØF	a°	●	⬢	■
SF18/85	18	25	67	7	19.5	15°	14	11	9
SF20/87	20	28	67	7	21	16°	16	13	11
SF 20/102	20	27.5	60	5	20	15°	16	13	11
SF 20/201	20	26	54	5	19	15°	16	13	11
SF 20/9026	20	26	67	3	19	16°	16	13	11
SF 22/727	22	32	66	7	25	16°	17	15	12
SF 23.8/9020	23.8	28	62	7	22	15°	18	15	12
SF24/9003	24	28	62	7	22	15°	17	15	12
SF25/64	25	35	77	10	27	16°	20	17	14
SF 25/91	25	34	65	6	25	15°	20	17	14
SF25/9015	25	35	85	18	27	16°	20	17	14
SF25/9091	25	35	72	5	27	16°	20	17	14
SF26/90	26	32	67	7	27.5	13°	20.5	17	14
SF26/9021	26	36	67	7	28	15°	20.5	17	14
SF27/22	27	38	72.7	8	30	15°	23	19	16
SF28/93	28	38	70	7	28	15°	23	19	16
SF28/9004	28	35	77	10	27.5	16°	22.5	19	16
SF30/63	30	42	80	10	34	16°	25	21	17
SF30/101	30	38	65	6	32	15°	25	21	17
SF30/9044	30	42	80	12	32	16°	25	22	18

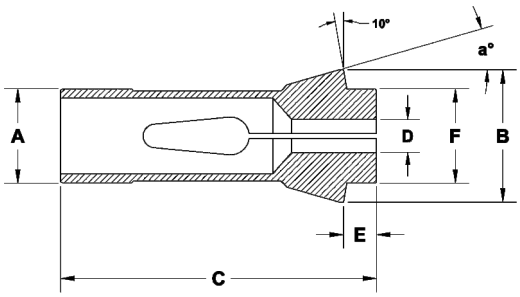
* table to be continued

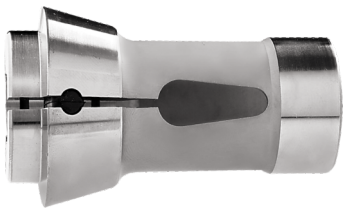


F - TYPE WITH STRAIGHT SHOULDER

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity		
							Round	Hexagon	Square
	ØA	ØB	C	E	ØF	a°	●	⬢	■
SF30/9066	30	42	78	10	32	16°	25	22	18
SF32/1023	32	40	65	6	34	15°	26	22	18
SF33/9043	33	40	80	12	32	16°	28	24	20
SF37/740	37	47	92	10	40	16°	32	27	22
SF40/9074	40	50	92	10	43	16°	35	30	24
SF44/9082	44	52	92	10	44	16°30'	38	32	27
SF44.4/9061	44.4	54.5	64	8.5	42	15°	37	31	26





F - TYPE WITH TAPERED SHOULDER

All Dimension are in mm - Unless Otherwise Specified

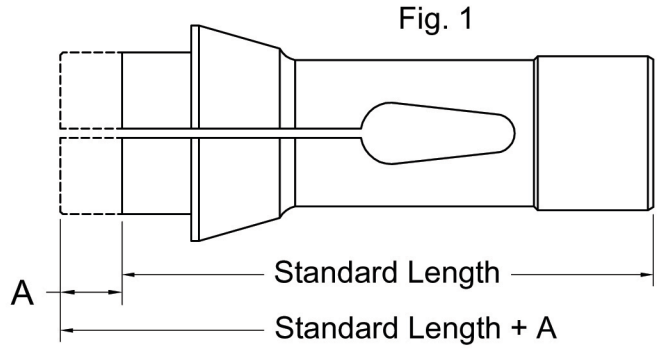
Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity		
							Round	Hexagon	Square
	ØA	ØB	C	E	ØF	a°	●	⬢	■
SF17.46/79	17.46	22	51	5	16	15°	13.5	11	9
SF22/71	22	30	55	6	21	15°	16.5	14	11
SF32/221	32	45	75	8	34	15°	26	22	18
SF35/94	35	48	80	8	38	15°	30	25	21
SF37/9087	37	44	91	5.7	38	16°	32	27	22
SF38/72	38.08	49	107.5	9	38	15°	32	27	22
SF42/99	42	55	94	9	42	15°	36	30	25
SF43/37	43	53	92	10	46	16°	38	33	27
SF43/9078	43	53	92	10	42	15°	35	30	25
SF48/38	48	54	100	10	44	15°	39	34	28
SF48/81	48	60	94	9	50	15°	42	36	29
SF48/9079	48	54	100	10	44	15°	41	35	29
SF58/355	58	70	94	9	60	15°	51	44	36
SF58/9046	58	70	94	9	60	15°	51	44	36
SF66/359	66	84	110	9	73	15°	59	48	39

Ordering Information for Extended Nose Collets / Guide Bush

Machine Make & Model	
Collet Part Number	

Collets - Extended Nose

Fig. 1

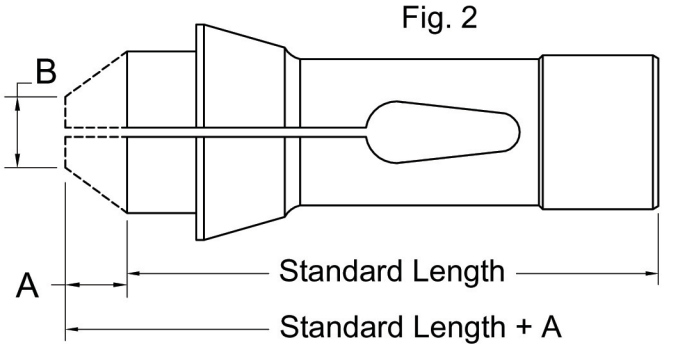


Straight Nose
Extended Nose Collet

A : _____

Bore Dia : _____

Fig. 2



Tapered Nose
Extended Nose Collet

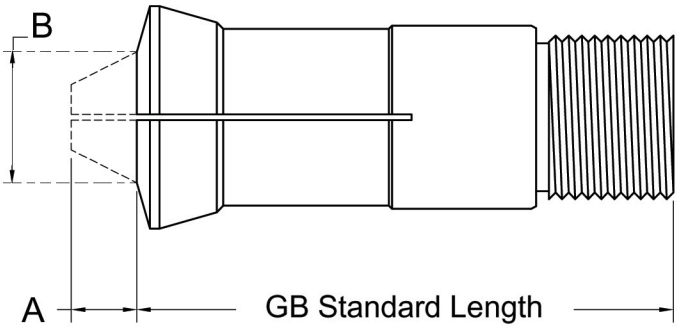
A : _____

B : _____

Bore Dia : _____

Guide Bush - Extended Nose

Fig. 3

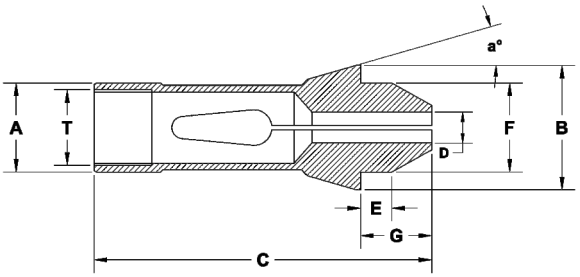


Extended Nose Guide Bush

A : _____

B : _____

Bore Dia : _____

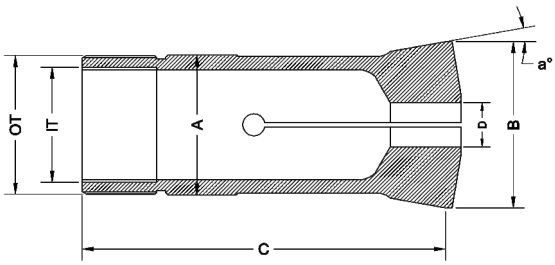


LONG NOSE COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Total Nose Length	Std Nose Length	Nose Dia	Angle	Thread	Capacity Round	Capacity Hexagon	Capacity Square
	ØA	ØB	C	G	E	ØF	a°	T	●	⬢	■
SF13/2014	13	19	70	12	6	13	16°	M11x0.75	9.5	8	6
SF16/830	16	21	66	8	6	16	16°	M14x0.75	12.5	10	8
SF16/2015	16	21	71	13	6	16	16°	M14x0.75	12.5	10	8
SF20/2016	20	26	62	13	5	19	15°	M18x1	15.5	13	11
SF25/2018	25	35	85	18	9	27	16°	M22x1	20	17	14

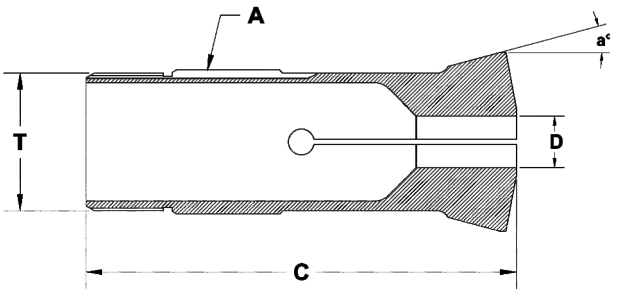
5C / 16C Collets



SPECIAL COLLETS - 5C / 16C COLLETS

All Dimension are in mm - Unless Otherwise Specified

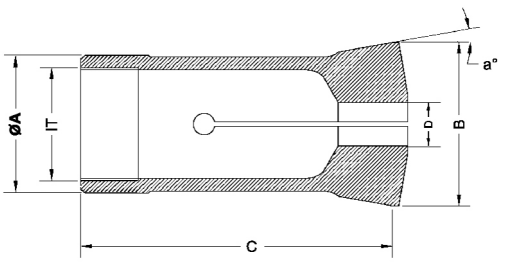
Part Nr.	Guiding Dia	Major Dia	Total Length	OD Thread	ID Thread	Angle	Capacity Round	Capacity Hexagon	Capacity Square
	ØA	ØB	C	OT	IT	a°	●	⬢	■
5C	1.25"(31.75)	1.484"(37.70)	3.268"(83.0)	1.238"x20TPI	1.041"x24TPI	10°	25	21	17
16C	1.889"(48.0)	2.260"(57.40)	4.291"(109.5)	1.870"x1.75	1.687"x20TPI	10°	41	35	29



COLLETS WITH EXTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

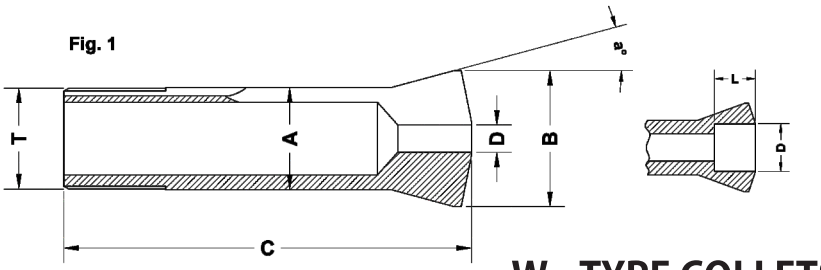
Part Nr.	Guiding Dia	Total Length	OD Thread	Angle	Capacity		
					Round	Hexagon	Square
	ØA	C	T	a°	●	⬢	■
SF19/9018	19.05	77	M18.3 x 1.2	15°	13.5	11	9
SF33/9017	33	100	M32 x 1.5	15°	27.0	23	19
359E	23	93.8	Tr 23 x 1.5	20°	18.0	15	12
363E	25	89	M23 x 1	16°	18.0	15	12
366E	28	106.5	Tr 27 x 20TPI	18°30'	21.0	17	14
367E	28	104.4	Tr 28 x 1.5	20°	22.0	19	15
386E	32	115	Tr 32 x 1.5	20°	27.0	23	19
390E	47	115	Tr 47 x 1.5	20°	38.0	32	26



COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	ID Thread	Angle	Capacity		
						Round	Hexagon	Square
	ØA	ØB	C	IT	a°	●	⬢	■
SF30/9019	30	38	75	M25X1.5	15°	22.5	19	16
TI-58/01	58	70	105	M50X1.5	15°	41	35	29

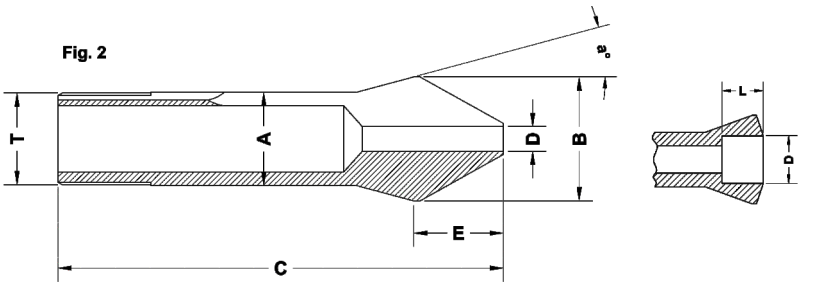


W - TYPE COLLETS

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Thread	Nose Length	Angle	Figure	Length	Capacity D Min - Max
	ØA	ØB	C	T	E	a°		L	
SW10/001	10	14	43.6	Ø9.83x0.833 <) 45°/5°	-	15°	1	-	1.00...6.70
								15	6.71…8.00
								6	8.01…8.50
								5	8.51…9.00
								4	9.01…9.50
								3	9.51…10.00
SW12/002	12	16	46	Ø11.75x1.25 <) 45°/5°	-	15°	1	-	1.00…8.00
								17	8.01…10.00
								6	10.01…10.50
								5	10.51…11.00
								4	11.01…11.50
								3	11.51…12.00
								2	12.01…12.50
SW12/93108	12	16	52	Ø11.75x1.25 <) 45°/5°	8.8	15°	2	-	1.00…8.00
								24	8.01…10.00
SW15/003	15	20.2	58.3	Ø14.75x1.25 <) 45°/5°	-	15°	1	-	1.00…10.70
								22	10.71…12.70
								9.5	12.71…13.00
								8.5	13.01…13.50
								7.5	13.51…14.00
								6.5	14.01…14.50
								5.5	14.51…15.00
								4.5	15.01…15.50
								3.5	15.51…16.00
SW15/93285	15	20.2	67	Ø14.75x1.25 <) 45°/5°	12	15°	2	-	1.00…10.20
								22	10.21…12.70
SW20/004	20	26.3	73	Ø19.7x1.666 <) 45°/5°	-	15°	1	-	1.00…14.50
								28	14.51…16.00
								13.5	16.01…16.50
								13	16.51…17.00
								12.2	17.01…17.50
								11.5	17.51…18.00
								10.7	18.01…18.50
								10	18.51…19.00
								8.7	19.01…19.50

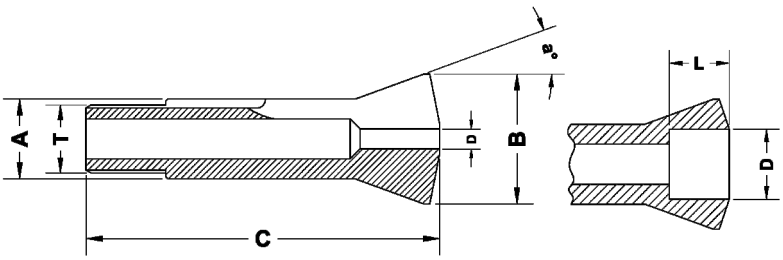
* table to be continued



W - TYPE COLLETS

All Dimension are in mm - Unless Otherwise Specified

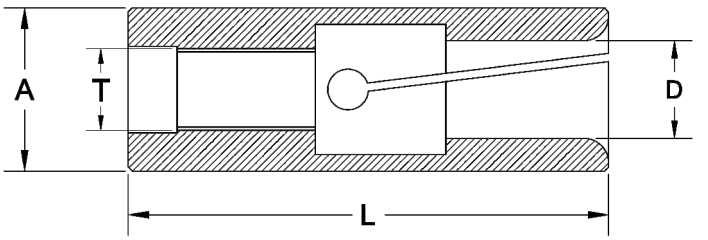
Part Nr.	Guiding Dia	Major Dia	Total Length	Thread	Nose Length	Angle	Figure	Length	Capacity D Min - Max
	ØA	ØB	C	T	E	a°		L	
SW20/004	20	26.3	73	Ø19.7x1.666 <) 45°/5°	-	15°	1	7.5	19.51…20.00
								6.5	20.01…20.50
								5.5	20.51…21.00
								4.7	21.01…21.50
								4	21.51…22.00
								3	22.01…22.50
								2	22.51…23.00
SW20/92744	20	26.3	84.5	Ø19.7x1.666 <) 45°/5°	15.5	15°	2	-	1.00…13.00
								41	13.01…16.00
SW25/005	25	33.7	97.6	Ø24.7x15f" <) 45°/5°	-	15°	1	-	1.00…19.05
								35	19.06…21.00
								16.5	21.01…21.50
								16	21.51…22.00
								15.7	22.01…22.50
								15.5	22.51…23.00
								15	23.01…23.50
								14.5	23.51…24.00
								13.5	24.01…24.50
								12.5	24.51…25.00
								11.5	25.01…25.50
								10.5	25.51…26.00
								9.5	26.01…26.50
								8.5	26.51…27.00
								7.5	27.01…27.50
								6.5	27.51…28.00
								5.5	28.01…28.50
								4.5	28.51…29.00
SW25/92872	25	33.7	112.2	Ø24.7x15f" <) 45°/5°	19.7	15°	2	-	1.00…19.05
								50	19.06…21.00
SW31.75/842	31.75	37.4	87	Ø31.4x20f" <) 60°	-	10° 3'	1	-	1.00…25.19
								40	25.20…27.99
								10	28.00…28.99
								7	29.00…29.99
								4	30.00…31.00



B - TYPE COLLETS

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total length	Thread	Angle	Length	Capacity D Min - Max
	ØA	ØB	C	T	a°	L	ØD
SB6/128	6	10.5	31.3	Ø5x36f" <) 55°	20°	-	1.00…3.00
						12	3.01…4.50
						4.5	4.51…5.00
						4	5.01…5.50
						3.5	5.51…6.00
SB8/137	8	13	35.5	Ø6.82x0.625 <) 55°	20°	-	1.00…4.00
						12.5	4.01…6.50
						6	6.51…7.00
						5	7.01…7.50
						4	7.51…8.00
						3.2	8.01…8.50
						2.5	8.51…9.00
						1.7	9.01…9.50
						1	9.51…10.00
SB15/139	15	21	55	M13 x 1	20°	-	1.00…9.50
						20	9.51…12.50
						8.5	12.51…13.00
						7.7	13.01…13.50
						7	13.51…14.00
						6.5	14.01…14.50
						6	14.51…15.00
SB32/55	32	40	102	M30 x 1.5	15°	-	1.00…24.00
						44	24.01…28.00
						12	28.01…30.00
						8	30.01…32.00
SB32/65	32	40	106	Ø29.7x15f" <) 45°/5°	15°	-	1.00…24.00
						44	24.01…28.00
						12	28.01…30.00
						8	30.01…32.00
SB45/199	45	53	115	M42 x 1.5	15°	-	1.00…36.00
						53	36.01…40.99
						14	41.00…41.99
						12	42.00…42.99
						10	43.00…43.99
						8	44.00…45.00

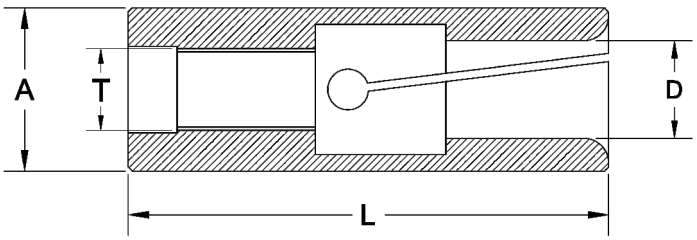


BARFEEDER COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Length	Thread	Capacity Range	
	ØA	L	T	Ø Min	Ø Max
BF05/01	5.15	37	M4x0.7	1	3.5
BF7.5/02	7.5	40	M5x0.50	1	5.5
BF08/02	8	50	M4x0.70	1	6
BF8.5/01	8.5	30	M5x0.80	1	6
BF09/01	9	40	M6x0.75	1	7
BF9.5/02	9.5	45	M5x0.80 LH	1	7.5
BF9.5/03	9.5	45	M5x0.80	1	7.5
BF10/03	10	46	M6x1 LH	1	8
BF10/04	10	42	M6x0.75	1	8
BF10/06	10	50	M5x0.80 LH	1	8
BF10/08	10	50	M5x0.80	1	8
BF12/01	12	42	M7x0.75	1	10
BF12/04	12	40	M6x1 LH	1	10
BF12/06	12	42	M7x0.75	1	10
BF12/07	12	45	M5x0.80 LH	1	10
BF13/01	13	60	M8x1 LH	1	11
BF13/02	13	50	M5x0.80 LH	1	11
BF14/01	14	42	M8x1	3	12
BF14/04	14	42	M7x0.75	3	12
BF15/02	15	42	M8x1	3	13
BF15/03	15	60	M9x1 LH	3	13

* table to be continued

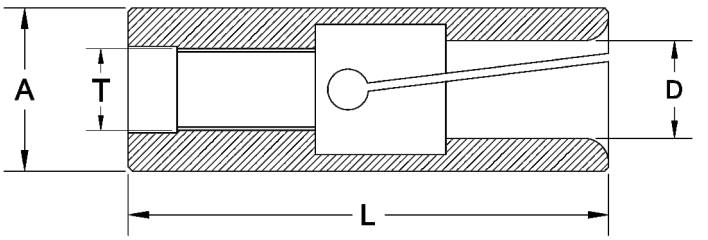


BARFEEDER COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Length	Thread	Capacity Range	
	ØA	L	T	Ø Min	Ø Max
BF15/04	15	60	M10x1 LH	3	13
BF15/07	15	40	M5x0.50	3	13
BF15/09	15	73	M10x1 LH	3	13
BF15/11	15	60	M10x1	3	13
BF15/12	15	60	M8x1	3	13
BF15/14	15	85	M12x1 LH	3	13
BF15/15	15	50	M9x1 LH	3	13
BF15/16	15	16	M8x1 LH	3	13
BF16/01	16	73	M10x1 LH	3	14
BF16/04	16	58	M9x1 LH	3	14
BF16/06	16	42	M8x1	12	14
BF18/03	18	42	M9x1 LH	6	16
BF18/04	18	60	M9x1 LH	13	16
BF18/05	18	59	M10x1 LH	13	16
BF18/06	18	59	M10x1	13	16
BF19/01	19	59	M10x1	13	17
BF19/06	19	60	M9x1 LH	13	17
BF19/08	19	40	M8x1	12	17
BF19/09	19	50	M5x0.80 LH	13	17
BF20/03	20	59	M10x1	4	17
BF20/04	20	60	M10x1 LH	13	17

* table to be continued

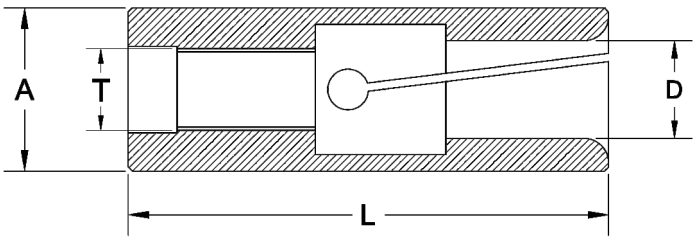


BARFEEDER COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Length	Thread	Capacity Range	
	ØA	L	T	Ø Min	Ø Max
BF20/07	20	60	M10x1	13	17
BF20/08	20	59	M9x1 LH	13	17
BF20/09	20	42	M10x1	8	17
BF20/10	20	59	M9x1	13	17
BF22/01	22	59	M10x1	17	19
BF22/04	22	59	M9X1LH	17	19
BF23/04	23	59	M10x1	17	20
BF23/05	23	60	M9x1 LH	17	20
BF24/01	24	60	M9x1 LH	17	21
BF25/06	25	59	M10x1	17	22
BF25/07	25	59	M10x1 LH	17	22
BF25/08	25	60	M9x1 LH	17	22
BF25/09	25	60	M17x1	13	22
BF26.5/01	26.5	65	M17x1	15	23
BF27/01	27	65	M10x1 LH	15	24
BF27/02	27	65	M10x1	15	24
BF27/03	27	59	M9x1 LH	15	24
BF29/01	29	65	M18x1.5 LH	17	26
BF30/01	30	65	M10x1	24	27
BF30/03	30	65	M18x1.5	17	27
BF30/04	30	65	M18x1.5 LH	17	27

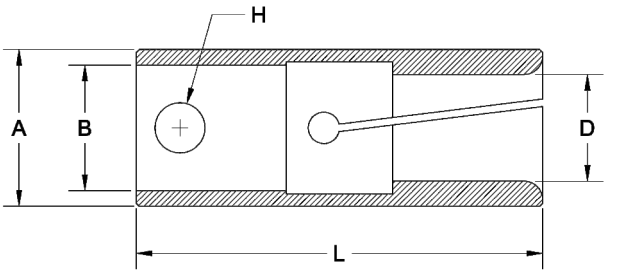
* table to be continued

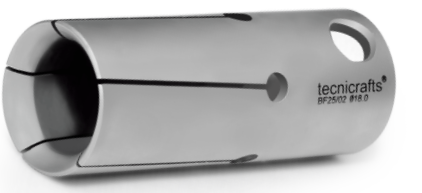


BARFEEDER COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Length	Thread	Capacity Range	
	ØA	L	T	Ø Min	Ø Max
BF30/05	30	65	M10x1 LH	17	27
BF32/01	32	70	M17x1 LH	19	29
BF32/02	32	80	M25x1.5 LH	19	29
BF32/04	32	80	M25x1.5	19	29
BF35/02	35	80	M25x1.5	29	32
BF35/04	35	80	M25x1.5 LH	29	32
BF36/01	36	100	M30x1.5	23	33
BF40/01	40	80	M25x1.5	32	37
BF42/02	42	90	M25x1.5 LH	29	39
BF42/04	42	80	M25x1.5 LH	32	39
BF42/05	42	90	M32x1.5 LH	29	39
BF42/08	42	80	M25x1.5	29	39
BF44/01	44	80	M25x1.5 LH	39	41
BF46/01	46	80	M25x1.5	37	43
BF46/02	46	80	M25x1.5 LH	41	43



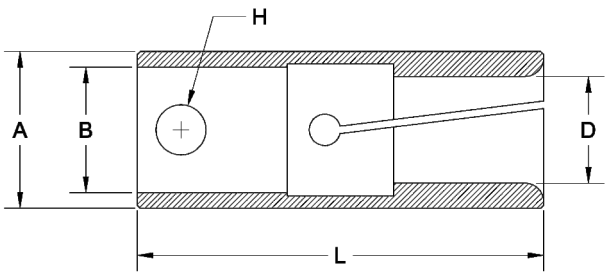


BARFEEDER COLLETS WITH PIN TYPE

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Length	Bore Dia	Hole Dia	Capacity Range	
	ØA	L	ØB	ØH	Ø Min	Ø Max
BF05/02	5	28	3.5	1.5	1	3.5
BF07/04	7	37	5	3	1	5.5
BF07/07	7	28	3.5	1.5	1	5.5
BF10/02	10	40	7	4	1	8
BF12/05	12	40	8	4	1	10
BF15/01	15	55	10	6	3	13
BF15/06	15	40	11	6	3	13
BF15/08	15	50	11	6	3	13
BF15/10	15	55	7	2	3	13
BF16/03	16	65	11	6	3	14
BF16/05	16	40	11	6	3	14
BF17/01	17	55	7	2	13	15
BF17/02	17	45	11	6	5	15
BF18/01	18	40	11	6	3	16
BF19/02	19	57	10	6	3	17
BF19/04	19	57	10	2	3	17
BF19/07	19	40	11	6	13	17
BF20/05	20	56	10	6	13	17
BF20/06	20	65	14	8	3	17
BF22/02	22	65	14	8	18	19

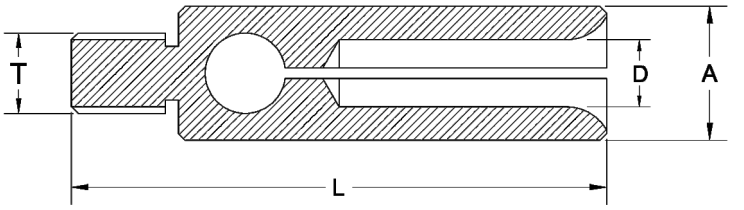
* table to be continued



BARFEEDER COLLETS WITH PIN TYPE

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Length	Bore Dia	Hole Dia	Capacity Range	
	ØA	L	ØB	ØH	Ø Min	Ø Max
BF25/02	25	65	20	8	18	22
BF25/03	25	76	16	8	3	22
BF30/02	30	65	20	8	23	27
BF32/05	32	65	20	8	28	29
BF32/06	32	76	16	8	23	29
BF34/01	34	90	20	8	18	31
BF35/03	35	65	20	8	30	32

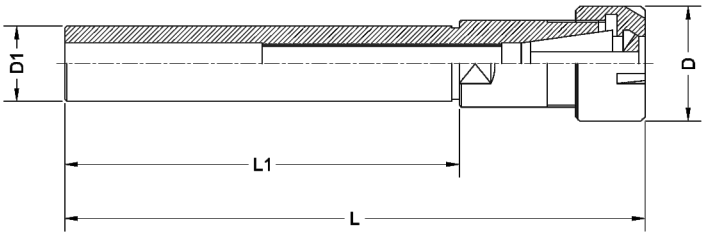


BARFEEDER COLLETS WITH EXTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Length	Thread	Capacity Range	
	ØA	L	T	Ø Min	Ø Max
BF5.5/01	5.5	31	M3	1	4
BF07/02	7	40	M6x1LH	1	5
BF08/01	8	40	M6x1	1	6
BF10/01	10	40	M6x1LH	1	8
BF11.5/01	11.5	40	M6x1	6	10
BF12/02	12	40	M6x1LH	8	10
BF15/13	15	40	M6x1 LH	3	13

- Range of Cylinderical ER Collet Shanks made from high quality special steels under controlled process
- The Shank is made to h6 standards for providing higher accuracy and tool life
- The Run-out is maintained within 0.005mm from shank dia to ERcavity taper
- Used for a vide range of tool holding application in Maching centers, Swiss type automatic lathes for drilling, milling application
- Wide Variety of shanks types - including Round, Round with flat in Single / Double ends offered in both metric and Inch Sizes
- These Cylinderical shanks are supplied with clamping nuts (without ER Collet)
- The shanks can be provided with back-up screw - upon request

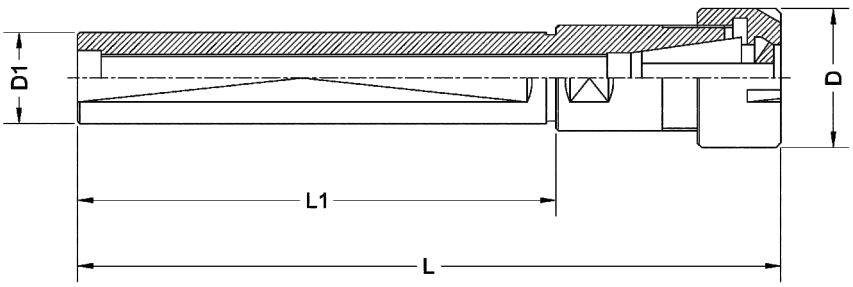


Single End - ER Cylindrical Holders with Mini Nut - Inch series

Part Nr.	ØD mm	ØD1 mm	L mm	L1 mm
ERS/SE-3/8" x 070 / ER 8 M	12	9.52	93.0	70
ERS/SE-1/2" x 140 / ER 11 M	16	12.7	169.5	140
ERS/SE-1/2" x 140 / ER 16 M	22	12.7	177.0	140
ERS/SE-5/8" x 150 / ER 11 M	16	15.87	172.5	150
ERS/SE-3/4" x 155 / ER 16 M	22	19.05	181.5	155
ERS/SE-3/4" x 100 / ER 16 M	35	19.05	147.0	100
ERS/SE-1" x 155 / ER 20 M	28	25.5	181.5	155

Single End - ER Cylindrical Holders with Mini Nut - Metric series

Part Nr.	ØD mm	ØD1 mm	L mm	L1 mm
ERS/SE 06 x 045 / ER 11 M	16	6	71.5	45
ERS/SE 07 x 045 / ER 11 M	16	7	71.5	45
ERS/SE 08 x 080 / ER 8 M	12	8	106.0	80
ERS/SE 08 x 056 / ER 11 M	16	8	82.5	56
ERS/SE 10 x 060 / ER 16 M	22	10	98.5	60
ERS/SE 12 x 080 / ER 8 M	12	12	97.0	80
ERS/SE 12 x 080 / ER 16 M	22	12	118.5	80
ERS/SE 15 x 100 / ER 20 M	28	15	142.5	100
ERS/SE 16 x 150 / ER 11 M	16	16	171.0	150
ERS/SE 16 x 100 / ER 20 M	28	16	142.5	100
ERS/SE 20 x 155 / ER 16 M	22	20	181.5	155
ERS/SE 25 x 155 / ER 20 M	28	25	181.5	155



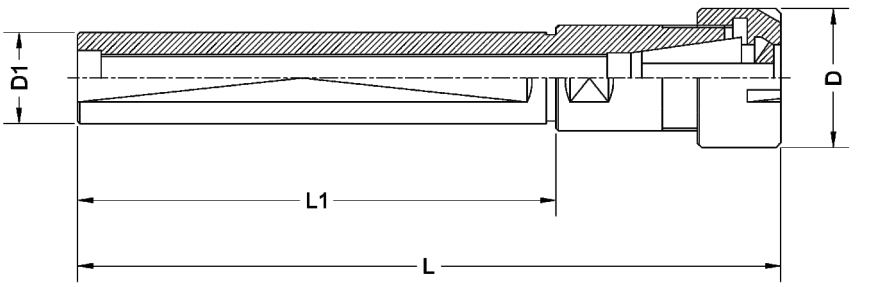
Single End - ER Cylindrical Holders - Flat with Mini Nut - Inch series

Part Nr.	ØD mm	ØD1 mm	L mm	L1 mm
ERS/SE-F- 5/8" x 043 / ER 8 MF	12	15.875	58	43
ERS/SE-F- 3/4" x 115 / ER 11 MF	16	19.05	135	115
ERS/SE-F- 3/4" x 050 / ER 16 MF	22	19.05	78	50
ERS/SE-F- 3/4" x 070 / ER 16 MF	22	19.05	98	70
ERS/SE-F- 3/4" x 120 / ER 16 MF	22	19.05	148	120
ERS/SE-F- 1" x 075 / ER 16 MF	22	25.4	103	75
ERS/SE-F- 1" x 100 / ER 16 MF	22	25.4	128	100
ERS/SE-F- 1" x 100 / ER 20 MF	28	25.4	128	100
ERS/SE-F- 1" x 140 / ER 20 MF	28	25.4	168	140

Single End - ER Cylindrical Holders - Flat with Mini Nut - Metric series

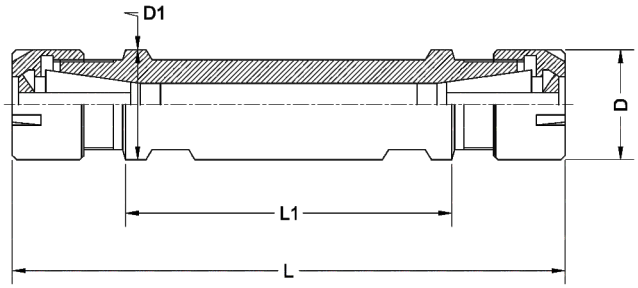
Part Nr.	ØD mm	ØD1 mm	L mm	L1 mm
ERS/SE-F- 16 x 038 / ER 11 MF	16	16	58	38
ERS/SE-F- 16 x 140 / ER 11 MF	16	16	160	140
ERS/SE-F- 20 x 050 / ER 16 MF	22	20	78	50
ERS/SE-F- 20 x 120 / ER 16 MF	22	20	148	120
ERS/SE-F- 20 x 140 / ER 16 MF	22	20	148	140
ERS/SE-F- 22 x 038 / ER 16 MF	22	22	66	38
ERS/SE-F- 22 x 070 / ER 16 MF	22	22	98	70
ERS/SE-F- 22 x 100 / ER 16 MF	22	22	128	100
ERS/SE-F- 22 x 080 / ER 20 MF	28	22	119	80
ERS/SE-F- 22 x 070 / ER 25 MF	35	22	117	70

* table to be continued



Single End - ER Cylindrical Holders - Flat with Mini Nut - Metric series

Part Nr.	ØD mm	ØD1 mm	L mm	L1 mm
ERS/SE-F- 25 x 065 / ER 16 MF	22	25	93	65
ERS/SE-F- 25 x 100 / ER 20 MF	28	25	128	100
ERS/SE-F- 25 x 154 / ER 20 MF	28	25	182	154
ERS/SE-F- 25 x 075 / ER 25 MF	35	25	122	75
ERS/SE-F- 25 x 145 / ER 25 MF	35	25	181	145
ERS/SE-F- 32 x 070 / ER 25 MF	35	32	100	70



Double End - ER Cylindrical Holders - Flat with Mini Nut - Inch series

Part Nr.	ØD mm	ØD1 mm	L mm	L1 mm
ERS/DE-F- 5/8" x 015 / ER 8 MF	12	15.875	45	15
ERS/DE-F- 5/8" x 025 / ER 8 MF	12	15.875	55	25
ERS/DE-F- 3/4" x 040 / ER 11 MF	16	19.05	80	40
ERS/DE-F- 3/4" x 070 / ER 11 MF	16	19.05	110	70
ERS/DE-F- 3/4" x 090 / ER 11 MF	16	19.05	130	90
ERS/DE-F- 3/4" x 055 / ER 16 MF	22	19.05	107	55
ERS/DE-F- 1" x 062 / ER 16 MF	22	25.4	118	62

Double End - ER Cylindrical Holders - Flat with Mini Nut - Metric series

Part Nr.	ØD mm	ØD1 mm	L mm	L1 mm
ERS/DE-F-16 x 050 / ER 11 MF	16	16	90	50
ERS/DE-F-20 x 030 / ER 11 MF	16	20	70	30
ERS/DE-F-20 x 050 / ER 11 MF	16	20	90	50
ERS/DE-F-20 x 055 / ER 16 MF	22	20	107	55
ERS/DE-F-22 x 055 / ER 16 MF	22	22	111	55
ERS/DE-F-22 x 075 / ER 16 MF	22	22	131	75
ERS/DE-F-25 x 062 / ER 16 MF	22	25	118	62
ERS/DE-F-32 x 055 / ER 20 MF	28	32	111	55
ERS/DE-F-32 x 075 / ER 20 MF	28	32	131	75

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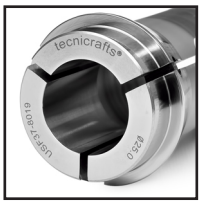
We produce, High Precision Sleeves, Closed Guide Bush, Longnose Guide Bush, Croco Collets, Wave Guide Bushes. The Bore Profile includes Round, Hexagon, Square & Special Profiles etc., Our dedicated manufacturing team can support all your custom work holding needs to meet your "Special" Swiss turning requirements.

Options for collets



Collet - Smooth Bore

Collet - Grooved Bore

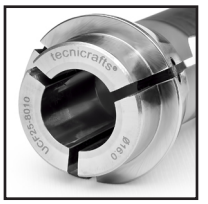
Collet - Serrated Bore

Collet - Stepped Bore

Collet - Square Bore

Collet - Rect., Bore

Collet - Special Bore

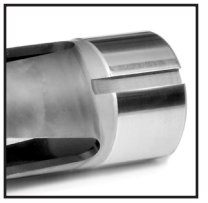


Collet with Carbide Insert

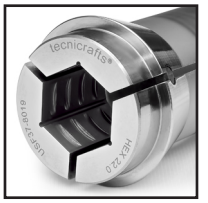
Collet with Silicone Seal

Collet - V - Line

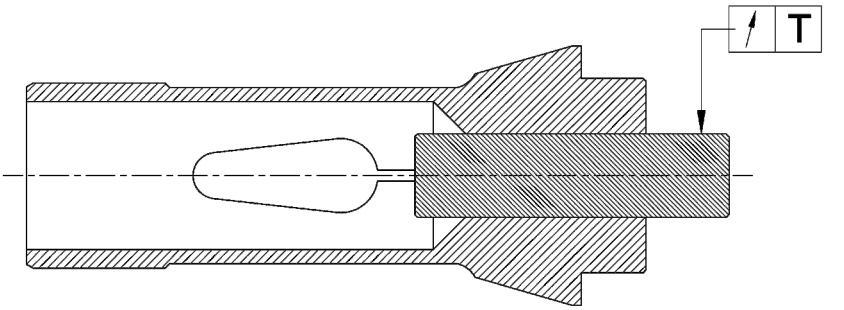
Collet with Key on Cone

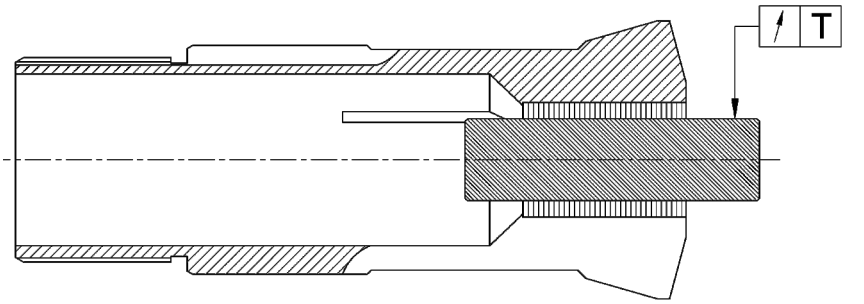


Collet with Key on Guiding Dia



Collet - Hexagon Bore





Run Out Tolerance

All Dimension are in mm - Unless Otherwise Specified

	Round Bores (T Maximum)		Hex. / Sq. Bores (T Maximum)	
Bore Size	**Standard Precision**	**Ultra Precision**	**Standard Precision**	**Ultra Precision**
1.00 - 10.00	0.010	0.005	0.060	0.030
10.01 - 20.00	0.015	0.008	0.060	0.040
20.01 - 30.00	0.020	0.010	0.060	0.040
30.01 - 40.00	0.025	0.012	0.060	0.040

The Specification / Dimension Contained in this catalogue are subject to change without notice.

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