

Tools cut smoother, faster, & safer when you tighten collets, nuts, and retention knobs to correct specifications.

Recommended Collet & Retention Knob Tightening Torque

Collet	Nut Type	Collets I.D. Over 1/16" (2mm)	Collets I.D. Under 1/16" (2mm)	Order Torque Wrench Adapter
ER 16	slotted	42 ft/lbs	30 ft/lbs	04580-16
ER 16	hex	42 ft/lbs	30 ft/lbs	04601-16
ER 20	slotted	59 ft/lbs	24 ft/lbs	04580-20
ER 20	hex	59 ft/lbs	24 ft/lbs	04602-20
ER 25	slotted	77 ft/lbs	77 ft/lbs	04503-25
ER 25	mini nut	25 ft/lbs	25 ft/lbs	04587
ER 32	slotted	100 ft/lbs	100 ft/lbs	04604-32
ER 40	slotted	130 ft/lbs	130 ft/lbs	04605-40
SYOZ 25	hook	90 ft/lbs	90 ft/lbs	03690-25
TG 75	hook	90 ft/lbs	90 ft/lbs	04018-TWA
TG 100	hook	90 ft/lbs	90 ft/lbs	03690-25

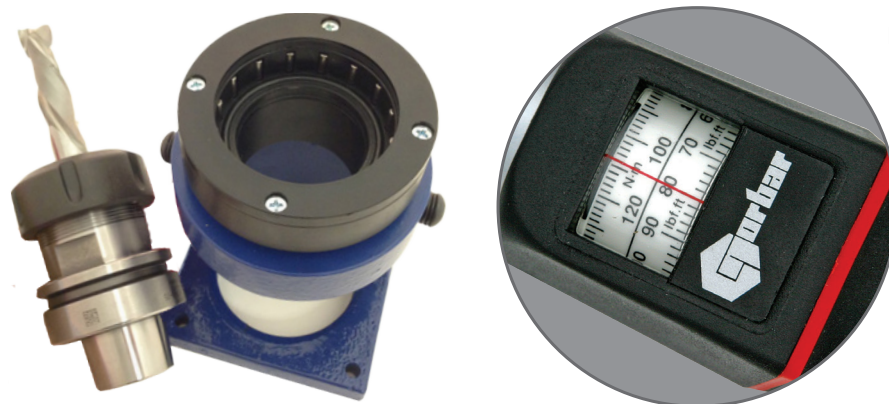
Retention Knobs	Wrench Flats	Drive	Torque	Order Socket
BT 30 Taper	0.535"	1/4"	36 ft/lbs	PSS-30BT
ISO 30 Taper	0.535"	3/8"	36 ft/lbs	PSS-30ISO
Any 40 Taper	0.750"	3/8"	76 ft/lbs	PSS-40
BT 50 Taper	1.187"	1/2"	99 ft/lbs	PSS-50
CAT 50 Taper	1.250"	1/2"	99 ft/lbs	PSSC-50

Directions

1. Snap collet into nut.
2. Insert cutter into collet. Collets without counter bore require shank to extend to the bottom of the collet.
3. Hand tighten collet nut assembly into tool holder.
4. Insert tool holder assembly into tightening fixture and secure it.
5. Tighten collet nut to recommended torque using a torque wrench and adapter.



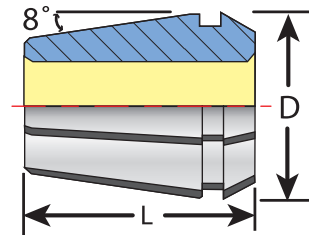
Use a tightening fixture and torque wrench to make sure tools are properly tightened. Incorrect torque can cause cracked collets, poor cutting performance, and possibly cause tools to come loose during operation, causing a very dangerous work environment.



North America's largest carbide & diamond cutting tool manufacturer.

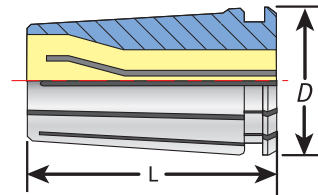
Use the guide below for selecting replacement collets. The best way to tell what type of collet you have is to measure the length of the collet. ER, TG, and SYOZ collets all have unique measurements. For best results always tighten the collet nut its to proper specifications using an accurate torque wrench.

ER Collet	L	D	Torque Spec
ER8	13mm (.51")	8.5mm (.33")	-
ER11	18mm (.708")	11.5mm (.45")	17 ft/lbs
ER16	27.5mm (1.08")	17mm (.67")	42 ft/lbs
ER20	31.5mm (1.24")	21mm (.83")	59 ft/lbs
ER25	34mm (1.34")	26mm (1.02")	77 ft/lbs
ER32	40mm (1.57")	33mm (1.3")	100 ft/lbs
ER40	46mm (1.81")	41mm (1.61")	130 ft/lbs
ER50	60mm (2.36")	52mm (2.05")	130 ft/lbs



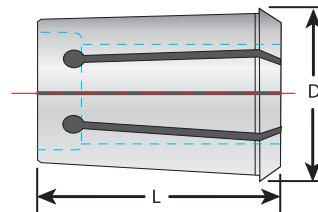
ER Collet Style

TG Collet	L	D	Torque Spec
TG75	47mm (1.85")	27mm (1.06")	90 ft/lbs
TG100	60mm (2.36")	35mm (1.38")	90 ft/lbs
TG150	76mm (3")	51mm (2")	110 ft/lbs



TG Collet Style

SYOZ / EOC Collet	L	D
EOC8	26mm (1.026")	14.4mm (.567")
SYOZ20	34mm (1.34")	20mm (.78")
RDO 20	34mm (1.34")	20mm (.78")
407E	34mm (1.34")	20mm (.78")
EOC 12	34mm (1.34")	20mm (.78")
SYOZ25	52mm (2.06")	35mm (1.38")
RDO 35	52mm (2.06")	35mm (1.38")
462E / SYOZ25	52mm (2.06")	35mm (1.38")
EOC 32	60mm (2.36")	43.7mm (1.72")



SYOZ Collet Style

Special Order Collets:

Length _____ Diameter _____ Other Markings _____

Length _____ Diameter _____ Other Markings _____

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