

# CENTAUR

## Precision CNC Tool Holders



## CENTAUR PRECISION CNC TOOL HOLDERS

### TABLE OF CONTENTS

CAT (V-Flange)

#### CAT (V-FLANGE) TOOL HOLDERS

CAT 40 End Mill Holders — Inch Sizes	Page 59
CAT 40 End Mill Holders — Metric Sizes	Page 60
CAT 50 End Mill Holders— Inch Sizes	Page 61
CAT 50 End Mill Holders— Metric Sizes	Page 62
CAT Coolant Through Collet Chucks	Page 63
CAT (V-Flange) Morse Taper Adapters	Page 64
CAT (V-Flange) Jacobs Taper Adapters	Page 64
CAT (V-Flange) Shell Mill Holders	Page 65

BT

#### BT TOOL HOLDERS

BT End Mill Holders — Inch Sizes	Page 66
BT End Mill Holders — Metric Sizes	Page 67
BT Shell Mill Holders	Page 68
BT Morse Taper Adapters	Page 68

Start-up Packages

#### ACCESSORIES & START-UP PACKAGES

Ball Bearing Keyless Chucks	Page 64
Retention Knobs & Tightening Fixtures	Page 69
New Machine Start-Up Packages	Page 70
Notes	Page 71

Power Milling Chuck

#### POWER MILLING CHUCKS

High-Grip Power Milling Chucks & Collets	Pages 72-73
<i>µmatic</i> Precision Chuck System	Pages 74-75
Tool Holding 101	Page 76

*µmatic*

## Precision CNC Tool Holders

Quality tooling from Centaur Precision Tools gives you peak performance and the competitive edge. All toolholders are:

- Precision ground for solid spindle contact
- 100% inspected for quality control
- Value-priced to control your costs

### *On The Fast Track:*

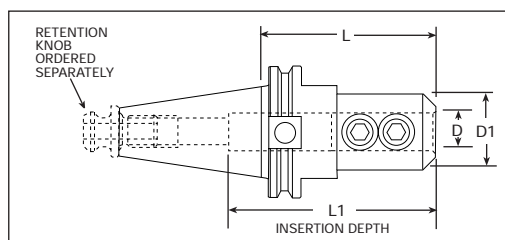
For optimum performance on today's high speed machining centers, balanced toolholders are recommended by most machine tool spindle manufacturers. All Centaur Tool Holders are 16,000 R.P.M., with AT3 or better accuracy on the taper fit and finish — one third of the ANSI specification requirement, and concentric to .0002 TIR or better. All Centaur Tool Holders have fully ground flanges and V-grooves to ensure smooth, accurate handling in automatic tool changers and reduced vibration at high R.P.M. Centaur's commitment to toolholder accuracy provides the best spindle to cutting tool union in the industry and will provide these benefits:

- **Extended tool life =**  
More time in the cut, less downtime for tool replacement.
- **Increased feed rates at higher R.P.M. =**  
Less vibration and better concentricity allow the cutting tool to perform as designed.
- **Increased workpiece accuracy =**  
Lower costs for machine adjustments and inspection.
- **Improved workpiece surface finish =**  
Less secondary finishing.

*Centaur Toolholders =  
finished products with better  
dimensional accuracy at a lower cost...*

*Specifications subject to change without notice.*

## CAT 40 END MILL HOLDERS — INCH SIZES



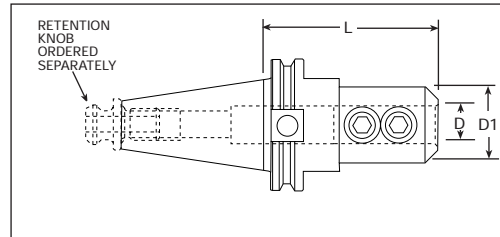
CAT (V-Flange)

	Part No.	D	D1	L	L1	Ret. Knob Thread
<b>CAT 40</b> STUB LENGTH Inch Sizes	SC40SE0500	0.5000	1.75	1.75	3.18	$\frac{5}{8}$ - 11
	SC40SE0625	0.6250	1.75	1.75	3.18	$\frac{5}{8}$ - 11
	SC40SE0750	0.7500	1.75	1.75	2.35	$\frac{5}{8}$ - 11
	SC40SE1000	1.0000	1.75	1.75	2.35	$\frac{5}{8}$ - 11
	SC40SE1250	1.2500	2.25	2.00	2.35	$\frac{5}{8}$ - 11
STANDARD LENGTH Inch Sizes	SC40E0125	0.1250	1.00	3.00	3.60	$\frac{5}{8}$ - 11
	SC40E0187	0.1875	1.00	2.50	3.60	$\frac{5}{8}$ - 11
	SC40E0250	0.2500	1.00	2.50	3.60	$\frac{5}{8}$ - 11
	SC40E0312	0.3125	1.00	2.50	3.60	$\frac{5}{8}$ - 11
	SC40E0375	0.3750	1.00	2.50	3.80	$\frac{5}{8}$ - 11
	SC40E0437	0.4375	1.25	2.62	3.80	$\frac{5}{8}$ - 11
	SC40E0500	0.5000	1.25	2.62	3.80	$\frac{5}{8}$ - 11
	SC40E0625	0.6250	1.50	3.75	3.80	$\frac{5}{8}$ - 11
	SC40E0750	0.7500	1.87	3.75	3.94	$\frac{5}{8}$ - 11
	SC40E0875	0.8750	2.00	4.00	4.25	$\frac{5}{8}$ - 11
	SC40E1000	1.0000	2.00	4.00	4.50	$\frac{5}{8}$ - 11
	SC40E1250	1.2500	2.50	4.25	2.31	$\frac{5}{8}$ - 11
	SC40E1500	1.5000	2.62	4.62	2.50	$\frac{5}{8}$ - 11
EXTENDED LENGTH Inch Sizes	SC40EE0187	0.1875	1.00	6.00	3.80	$\frac{5}{8}$ - 11
	SC40EE0250	0.2500	1.00	6.00	3.80	$\frac{5}{8}$ - 11
	SC40EE0375	0.3750	1.25	6.00	3.80	$\frac{5}{8}$ - 11
	SC40EE0500	0.5000	1.50	6.00	3.80	$\frac{5}{8}$ - 11
	SC40EE0625	0.6250	1.75	6.00	3.80	$\frac{5}{8}$ - 11
	SC40EE0750	0.7500	2.00	6.00	3.80	$\frac{5}{8}$ - 11
	SC40EE0875	0.8750	2.00	6.00	4.25	$\frac{5}{8}$ - 11
	SC40EE1000	1.0000	2.00	6.00	4.50	$\frac{5}{8}$ - 11
	SC40EE1250	1.2500	2.50	6.00	2.31	$\frac{5}{8}$ - 11

NOTE: Holders balanced to 22,000 RPM available upon request

## CAT 40 END MILL HOLDERS — METRIC SIZES

CAT (V-Flange)

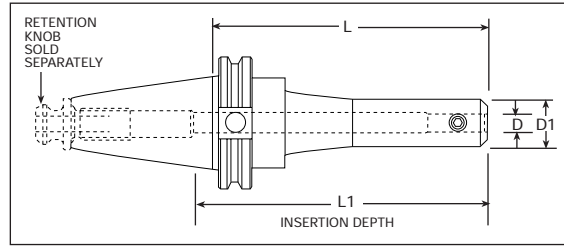


NOTE: Dimensions for Metric tool holders are in Millimeters.

	Part No.	D	D1	L	Ret. Knob Thread
CAT 40 STUB LENGTH METRIC SIZES	SC40SE06MM	6	25	45	$\frac{5}{8}$ - 11
	SC40SE08MM	8	28	45	$\frac{5}{8}$ - 11
	SC40SE10MM	10	35	45	$\frac{5}{8}$ - 11
	SC40SE12MM	12	42	45	$\frac{5}{8}$ - 11
	SC40SE16MM	16	44.5	45	$\frac{5}{8}$ - 11
	SC40SE20MM	20	44.5	45	$\frac{5}{8}$ - 11
	SC40SE25MM	25	44.5	45	$\frac{5}{8}$ - 11
	SC40SE32MM	32	57	50	$\frac{5}{8}$ - 11
STANDARD LENGTH METRIC SIZES	SC40E06MM	6	25	65	$\frac{5}{8}$ - 11
	SC40E08MM	8	28	65	$\frac{5}{8}$ - 11
	SC40E10MM	10	35	65	$\frac{5}{8}$ - 11
	SC40E12MM	12	42	65	$\frac{5}{8}$ - 11
	SC40E16MM	16	48	95	$\frac{5}{8}$ - 11
	SC40E20MM	20	52	95	$\frac{5}{8}$ - 11
	SC40E25MM	25	65	100	$\frac{5}{8}$ - 11
	SC40E32MM	32	72	105	$\frac{5}{8}$ - 11
EXTENDED LENGTH METRIC SIZES	SC40EE06MM	6	25	150	$\frac{5}{8}$ - 11
	SC40EE08MM	8	28	150	$\frac{5}{8}$ - 11
	SC40EE10MM	10	35	150	$\frac{5}{8}$ - 11
	SC40EE12MM	12	42	150	$\frac{5}{8}$ - 11
	SC40EE16MM	16	48	150	$\frac{5}{8}$ - 11
	SC40EE20MM	20	52	150	$\frac{5}{8}$ - 11
	SC40EE25MM	25	65	150	$\frac{5}{8}$ - 11
	SC40EE32MM	32	72	150	$\frac{5}{8}$ - 11
SC40EE40MM	40	80	150	$\frac{5}{8}$ - 11	

NOTE: Holders balanced to 22,000 RPM available upon request

CAT 50 END MILL HOLDERS — INCH SIZES



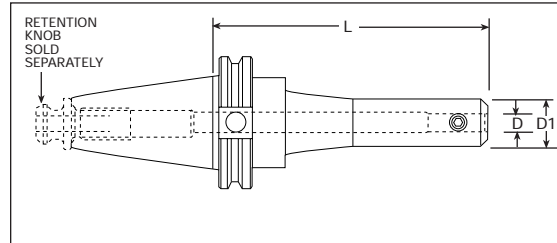
CAT (V-Flange)

	Part No.	D	D1	L	L1	Ret. Knob Thread
CAT 50 STUB LENGTH INCH SIZES	SC50SE0625	0.6250	1.75	2.06	4.500	1" - 8
	SC50SE0750	0.7500	1.75	2.06	4.500	1" - 8
	SC50SE1000	1.0000	2.00	2.25	4.500	1" - 8
	SC50SE1250	1.2500	2.50	2.25	2.750	1" - 8
	SC50SE1500	1.5000	2.62	2.75	2.750	1" - 8
STANDARD LENGTH INCH SIZES	SC50E0187	0.1875	0.68	2.50	3.800	1" - 8
	SC50E0250	0.2500	0.75	2.50	3.800	1" - 8
	SC50E0312	0.3125	0.75	2.50	3.800	1" - 8
	SC50E0375	0.3750	1.00	2.50	4.000	1" - 8
	SC50E0437	0.4375	1.25	2.50	4.000	1" - 8
	SC50E0500	0.5000	1.38	2.62	5.000	1" - 8
	SC50E0625	0.6250	1.50	3.75	6.000	1" - 80
	SC50E0750	0.7500	1.75	3.75	4.000	1" - 8
	SC50E0875	0.8750	2.00	3.75	4.310	1" - 8
	SC50E1000	1.0000	2.00	4.00	4.500	1" - 8
	SC50E1250	1.2500	2.50	4.00	2.750	1" - 8
	SC50E1500	1.5000	2.75	4.00	3.500	1" - 8
	SC50E1750	1.7500	1.32	4.00	3.750	1" - 8
	SC50E2000	2.0000	3.75	5.62	3.500	1" - 8
EXTENDED LENGTH INCH SIZES	SC50EE0187	0.1875	0.68	4.50	7.000	1" - 8
	SC50EE0250	0.2500	0.75	4.50	7.000	1" - 8
	SC50EE0312	0.3125	0.75	4.50	7.000	1" - 8
	SC50EE0375	0.3750	1.00	4.50	7.000	1" - 8
	SC50EE0437	0.4375	1.25	4.50	7.000	1" - 8
	SC50EE0500	0.5000	1.38	4.62	7.000	1" - 8
	SC50EE0625	0.6250	1.50	5.75	8.000	1" - 8
	SC50EE0750	0.7500	1.75	5.75	4.310	1" - 8
	SC50EE0875	0.8750	1.87	5.75	4.310	1" - 8
	SC50EE1000	1.0000	2.00	6.00	4.500	1" - 8
	SC50EE1250	1.2500	2.50	6.00	2.750	1" - 80
	SC50EE1500	1.5000	2.75	6.00	3.500	1" - 8
	SC50EE2000	2.0000	3.75	7.62	3.500	1" - 8

NOTE: Holders balanced to 22,000 RPM available upon request.

## CAT 50 END MILL HOLDERS — METRIC SIZES

CAT (V-Flange)

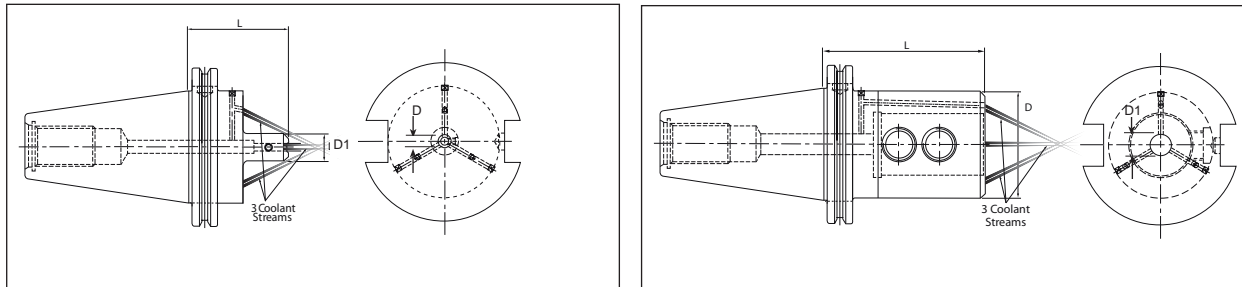


NOTE: Dimensions for Metric tool holders are in Millimeters.

	Part Number	D	D1	L	Ret. Knob Thread
CAT 50 STUB LENGTH METRIC SIZES	SC50SE06MM	6	25	50	1" - 8
	SC50SE08MM	8	28	50	1" - 8
	SC50SE10MM	10	35	50	1" - 8
	SC50SE12MM	12	42	50	1" - 8
	SC50SE16MM	16	48	50	1" - 8
	SC50SE20MM	20	52	50	1" - 8
	SC50SE25MM	25	65	55	1" - 8
	SC50SE32MM	32	70	55	1" - 8
STANDARD LENGTH METRIC SIZES	SC50E06MM	6	2.5	65	1" - 8
	SC50E08MM	8	28	65	1" - 8
	SC50E10MM	10	35	65	1" - 8
	SC50E12MM	12	42	65	1" - 8
	SC50E16MM	16	48	95	1" - 8
	SC50E20MM	20	52	95	1" - 8
	SC50E25MM	25	65	100	1" - 8
	SC50E32MM	32	72	100	1" - 8
	SC50E40MM	40	80	100	1" - 8
SC50E50MM	50	100	140	1" - 8	
EXTENDED LENGTH METRIC SIZES	SC50EE06MM	6	25	115	1" - 8
	SC50EE08MM	8	28	115	1" - 8
	SC50EE10MM	10	35	115	1" - 8
	SC50EE12MM	12	42	115	1" - 8
	SC50EE16MM	16	48	145	1" - 8
	SC50EE20MM	20	52	145	1" - 8
	SC50EE25MM	25	65	150	1" - 8
	SC50EE32MM	32	72	150	1" - 8
	SC50EE40MM	40	80	150	1" - 8
	SC50EE50MM	50	100	195	1" - 8

NOTE: Holders balanced to 22,000 RPM available upon request.

CAT COOLANT THROUGH END MILL HOLDERS



Retention Knobs are sold separately.

CAT (V-Flange)

CAT 40 COOLANT THROUGH END MILL HOLDERS

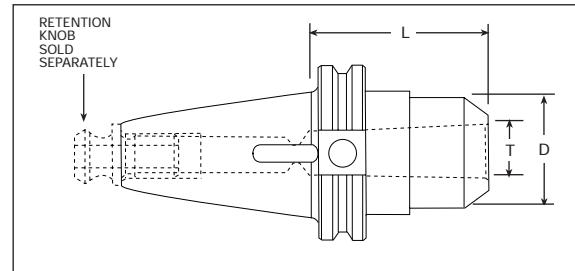
		Part Number	D	D1	L	Ret. Knob Thread
CAT 40	COOLANT THROUGH	SC40EK0187	0.0188	0.68	2.500	5/8 - 11
		SC40EK0250	0.2500	0.75	1.375	5/8 - 11
		SC40EK0312	0.3125	0.75	2.500	5/8 - 11
		SC40EK0375	0.3750	1.00	2.500	5/8 - 11
		SC40EK0437	0.4375	1.25	2.500	5/8 - 11
		SC40EE0500	0.5000	1.25	2.620	5/8 - 11
		SC40EE0625	0.6250	1.50	3.750	5/8 - 11
		SC40EE0750	0.7500	1.75	3.750	5/8 - 11
		SC40EE0875	0.875	2.00	3.750	5/8 - 11
		SC40EE1000	1.0000	2.50	4.000	5/8 - 11
		SC40EE1250	1.2500	2.50	4.000	5/8 - 11
		SC40EE1500	1.5000	2.60	4.000	5/8 - 11

CAT 50 COOLANT THROUGH END MILL HOLDERS

CAT 50	COOLANT THROUGH	SC50EK0187	0.1875	0.68	2.500	1 " - 1/8
		SC50EK0250	0.250	0.75	1.375	1 " - 1/8
		SC50EK0312	0.3125	0.75	2.500	1 " - 1/8
		SC50EK0375	0.3750	1.00	2.500	1 " - 1/8
		SC50EK0437	0.4375	1.25	2.500	1 " - 1/8
		SC50EK0500	0.5000	1.25	2.620	1 " - 1/8
		SC50EK0625	0.6250	1.50	3.750	1 " - 1/8
		SC50EK0750	0.7500	1.75	3.750	1 " - 1/8
		SC50EK0875	0.8750	2.00	3.750	1 " - 1/8
		SC50EK1000	1.0000	2.50	4.000	1 " - 1/8
		SC50EK1250	1.2500	2.50	4.000	1 " - 1/8
		SC50EK1500	1.5000	2.60	4.000	1 " - 1/8

CAT (V-Flange) MORSE TAPER HOLDERS

CAT (V-Flange)



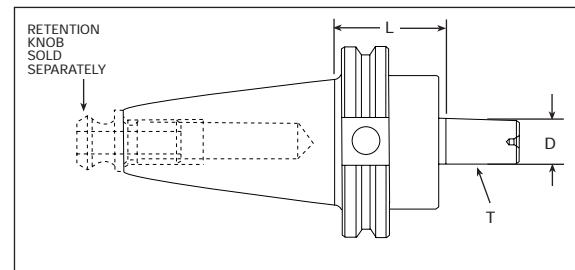
CAT 40

Part No.	T Taper	D	L
C40MT1	1	1.00	1.75
C40MT2	2	1.25	2.44
C40MT3	3	3.00	3.00
C40MT4	4	3.75	3.75

CAT 50

Part No.	T Taper	D	L
C50MT2	2	1.25	2.00
C50MT3	3	1.62	2.50
C50MT4	4	2.20	3.38
C50MT5	5	2.75	3.75

CAT (V-Flange) JACOBS TAPER ADAPTERS



CAT 40

Part No.	T Taper	D	L
C40JT2	2	0.559	1.375
C40JT3	3	0.811	1.375
C40JT4	4	1.120	1.375
C40JT6	6	0.676	1.375
C40JT33	33	0.624	1.375

CAT 50

Part No.	T Taper	D	L
C50JT2	2	0.559	1.375
C50JT3	3	0.811	1.375
C50JT4	4	1.120	1.375
C50JT6	6	0.676	1.375
C50JT33	33	0.624	1.375

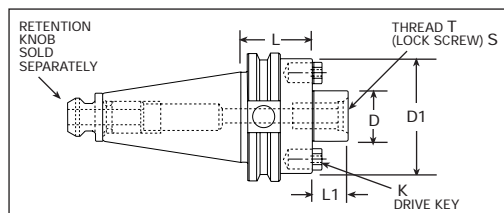
BALL BEARING KEYLESS CHUCKS



Part No.	Clamping Range	Jacobs Mount
JT10250	0 - 1/4	1
JT330500	0 - 1/2	33
JT60500	0 - 1/2	6



CAT (V-FLANGE) SHELL MILL HOLDERS



CAT (V-Flange)

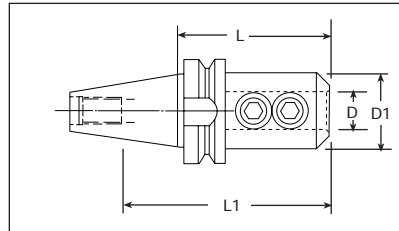
CAT 40

Part No.	D	D1	L	L1	K	T	S
C40SM0750	0.750	1.75	1.375	0.68	0.31	3/8 - 24	C5002
C40SME0750	0.750	1.75	4.000	0.68	0.31	3/8 - 24	C5002
C40SM1000	1.000	2.19	2.062	0.68	0.38	1/2 - 20	C5003
C40SME1000	1.000	2.19	4.000	0.68	0.38	1/2 - 20	C5003
C40SM1250	1.250	2.88	2.125	0.68	0.50	5/8 - 18	C5004
C40SME1250	1.250	2.88	4.000	0.68	0.50	5/8 - 18	C5004
C40SM1500	1.500	3.81	2.406	0.94	0.62	3/4 - 18	C5005
C40SME1500	1.500	3.81	4.000	0.94	0.62	3/4 - 18	C5005

CAT 50

Part No.	D	D1	L	L1	K	T	S
C50SM0750	0.750	1.750	1.50	0.680	0.31	3/8 - 24	C5002
C50SME0750	0.750	1.750	3.50	0.680	0.31	3/8 - 24	C5002
C50SMEX0750	0.750	1.750	5.50	0.680	0.31	3/8 - 24	C5002
C50SM1000	1.000	2.750	2.00	0.680	0.38	1/2 - 20	C5003
C50SME1000	1.000	2.750	4.00	0.680	0.38	1/2 - 20	C5003
C50SMEX1000	1.000	2.750	6.00	0.680	0.38	1/2 - 20	C5003
C50SM1250	1.250	2.880	1.50	0.680	0.50	5/8 - 18	C5004
C50SME1250	1.250	2.880	3.50	0.680	0.50	5/8 - 18	C5004
C50SMEX1250	1.250	2.880	5.50	0.680	0.50	5/8 - 18	C5004
C50SM1500	1.500	3.810	2.40	0.930	0.62	3/4 - 16	C5005
C50SME1500	1.500	3.810	4.00	0.930	0.62	3/4 - 16	C5005
C50SMEX1500	1.500	3.810	6.00	0.930	0.62	3/4 - 16	C5005
C50SM2000	2.000	4.875	2.40	0.930	0.75	1" - 14	C5006
C50SME2000	2.000	4.875	4.00	0.930	0.75	1" - 14	C5006
C50SMEX2000	2.000	4.875	6.00	0.930	0.75	1" - 14	C5006
C50SM2500	2.500	4.875	2.40	1.125	1.00	1" - 14	C5006
C50SME2500	2.500	4.875	4.00	1.125	1.00	1" - 14	C5006
C50SMEX2500	2.500	4.875	6.00	1.125	1.00	1" - 14	C5006

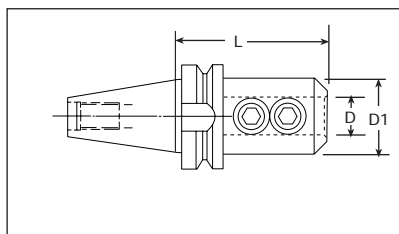
## BT END MILL HOLDERS — INCH SIZES



BT

		Part No.	D	D1	L	L1	Ret. Knob Thread
BT 40	STUB LENGTH INCH SIZES	B40SE0500	0.500	1.75	1.75	3.18	M16 X 2
		B40SE0625	0.625	1.75	1.75	3.18	M16 X 2
		B40SE0750	0.750	1.75	1.75	2.35	M16 X 2
		B40SE1000	1.000	1.75	1.75	2.35	M16 X 2
		B40SE1250	1.250	2.25	2.00	2.35	M16 X 2
	STANDARD LENGTH INCH SIZES	B40E0125	0.1250	0.68	2.50	3.00	M16 X 2
		B40E0187	0.1875	0.68	2.50	3.00	M16 X 2
		B40E0250	0.2500	0.75	2.50	2.62	M16 X 2
		B40E0312	0.3125	0.75	2.50	2.62	M16 X 2
		B40E0375	0.3750	1.00	2.50	2.56	M16 X 2
		B40E0437	0.4375	1.13	2.50	2.56	M16 X 2
		B40E0500	0.5000	1.13	2.62	3.06	M16 X 2
		B40E0625	0.6250	1.50	3.75	4.24	M16 X 2
		B40E0750	0.7500	1.75	3.75	4.00	M16 X 2
		B40E0875	0.8750	2.00	4.00	4.31	M16 X 2
		B40E1000	1.0000	2.00	4.00	4.25	M16 X 2
		B40E1250	1.2500	2.50	4.25	2.31	M16 X 2
		B40E1500	1.5000	2.75	4.62	2.75	M16 X 2
BT 50	STANDARD LENGTH INCH SIZES	B50E0375	0.3750	1.00	3.00	4.00	M 24 X 3
		B50E0500	0.5000	1.25	3.00	4.00	M 24 X 3
		B50E0625	0.6250	1.50	3.00	4.00	M 24 X 3
		B50E0750	0.7500	1.75	3.00	4.00	M 24 X 3
		B50E0875	0.8750	1.88	4.00	4.18	M 24 X 3
		B50E1000	1.0000	2.00	4.00	4.44	M 24 X 3
		B50E1250	1.2500	2.50	4.00	2.75	M 24 X 3
		B50E1500	1.5000	2.62	4.62	3.50	M 24 X 3
		B50E2000	2.0000	3.75	5.25	3.50	M 24 X 3

BT END MILL HOLDERS — METRIC SIZES



NOTE: Dimensions for Metric tool holders are in Millimeters.

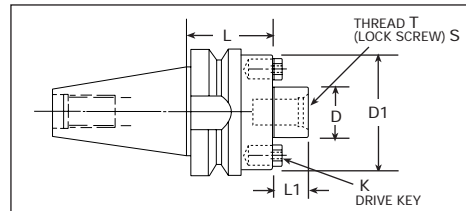
		Part No.	D	D1	L	Ret. Knob Thread
BT 40	STUB LENGTH METRIC SIZES	B40SE16MM	16	48	45	M16 X 2
		B40SE20MM	1.75	1.75	3.18	M16 X 2
		B40SE25MM	1.75	1.75	2.35	M16 X 2

		Part No.	D	D1	L	Ret. Knob Thread
	STANDARD LENGTH METRIC SIZES	B40E06MM	6	25	65	M16 X 2
		B40E08MM	8	28	65	M16 X 2
		B40E10MM	10	35	65	M16 X 2
		B40E12MM	12	42	75	M16 X 2
		B40E16MM	16	48	95	M16 X 2
		B40E20MM	20	52	95	M16 X 2
		B40E25MM	25	65	100	M16 X 2
		B40E32MM	32	72	105	M16 X 2
		B40E40MM	40	80	115	M16 X 2

		Part No.	D	D1	L	Ret. Knob Thread
BT 50	STANDARD LENGTH METRIC SIZES	B50E06MM	6	25	75	M 24 X 3
		B50E08MM	8	28	75	M 24 X 3
		B50E10MM	10	35	75	M 24 X 3
		B50E12MM	12	42	75	M 24 X 3
		B50E16MM	16	48	75	M 24 X 3
		B50E20MM	20	52	75	M 24 X 3
		B50E25MM	25	65	100	M 24 X 3
		B50E32MM	32	72	115	M 24 X 3
		B50E40MM	40	80	3.50	M 24 X 3
		B50E50MM	50	100	1135	M 24 X 3

BT

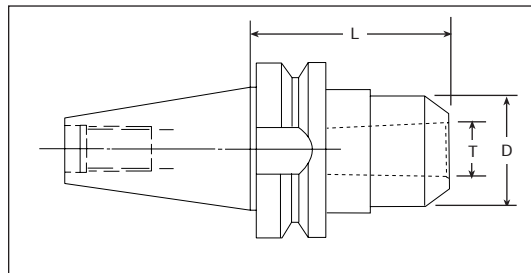
## BT SHELL MILL HOLDERS



BT 40	Part No.	D	D1	L	L1	K	T	S
	B40SM0750	0.75	1.75	1.375	0.68	0.31	$\frac{3}{8}$ - 24	C5002
	B40SM1000	1.00	2.25	2.06	0.68	0.38	$\frac{1}{2}$ - 20	C5003
	B40SM1250	1.25	2.75	2.12	0.68	0.50	$\frac{5}{8}$ - 18	C5004
	B40SM1500	1.50	3.75	2.40	0.94	0.62	$\frac{3}{4}$ - 16	C5005

BT 50	Part No.	D	D1	L	L1	K	T	S
	B50SM0750	0.75	1.75	2.00	0.68	0.31	$\frac{3}{8}$ - 24	C5002
	B50SM1000	1.00	2.25	2.00	0.68	0.38	$\frac{1}{2}$ - 20	C5003
	B50SM1250	1.25	2.75	2.00	0.68	0.50	$\frac{5}{8}$ - 18	C5004
	B50SM1500	1.50	3.75	2.40	0.94	0.62	$\frac{3}{4}$ - 16	C5005
	B50SM2000	2.00	4.88	2.40	0.94	0.75	1" - 14	C5006
	B50SM2500	2.50	4.88	2.40	1.125	1.00	1" - 14	C5007

## BT MORSE TAPER ADAPTERS



BT 40	Part No.	T Taper	D	L
	B40MT2	2	2.38	1.25
	B40MT3	3	3.06	1.62
	B40MT4	4	3.94	2.00

BT 50	Part No.	T Taper	D	L
	B50MT2	2	1.50	1.25
	B50MT3	3	2.31	1.62
	B50MT4	4	3.18	2.00
	B50MT5	5	4.75	2.75

ANSI STANDARD RETENTION KNOBS



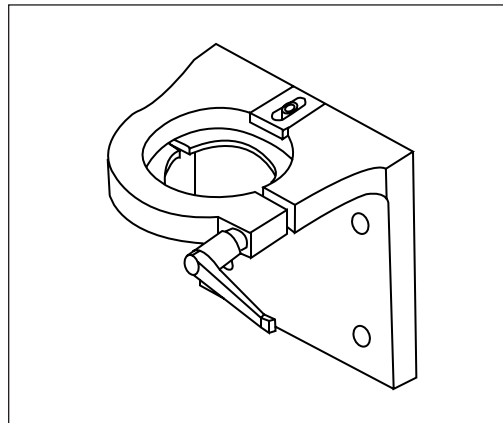
FOR MACHINES WITHOUT COOLANT THROUGH SPINDLES

FOR MACHINES WITH COOLANT THROUGH SPINDLES

Part No.	Taper Size	Thread
C30VR	CAT30	1/2 - 13
C40VR	CAT40	5/8 - 11
C45VR	CAT45	3/4 - 10
C50VR	CAT50	1" - 8
C30VRC	CAT30	1/2 - 13
C40VRC	CAT40	5/8 - 11
C45VRC	CAT45	3/4 - 10
C50VRC	CAT50	1" - 8

NOTE: Retention knobs for most machines available upon request.

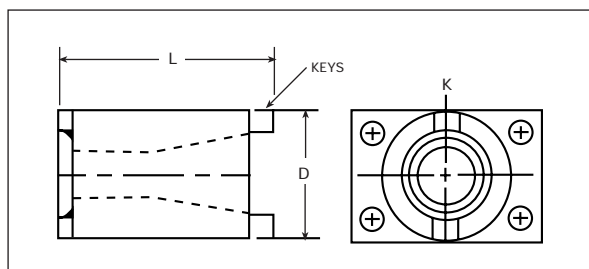
LOCKING TIGHTENING FIXTURES FOR CAT (V-Flange) TOOL HOLDERS



- For use in any position
- Access tool or retention knob
- Bolt down or use in vise

Part No.	Shank Size
C40LTF	CAT40
C50LTF	CAT50

LOCKING FIXTURE FOR ALL TAPERS



- Fit CAT (V-Flange), BT & NMTB tapers
- Bolt down or use in vise

Part No.	Shank	L	D	K
C30TF	30	3.91	3.00	0.62
C40TF	40	4.65	3.00	0.62
C45TF	45	4.90	3.50	0.75
C50TF	50	6.35	4.00	1.00

BT

## NEW MACHINE START-UP PACKAGE

(CAT 40, 45 &amp; 50 AND BT 40 &amp; 50)

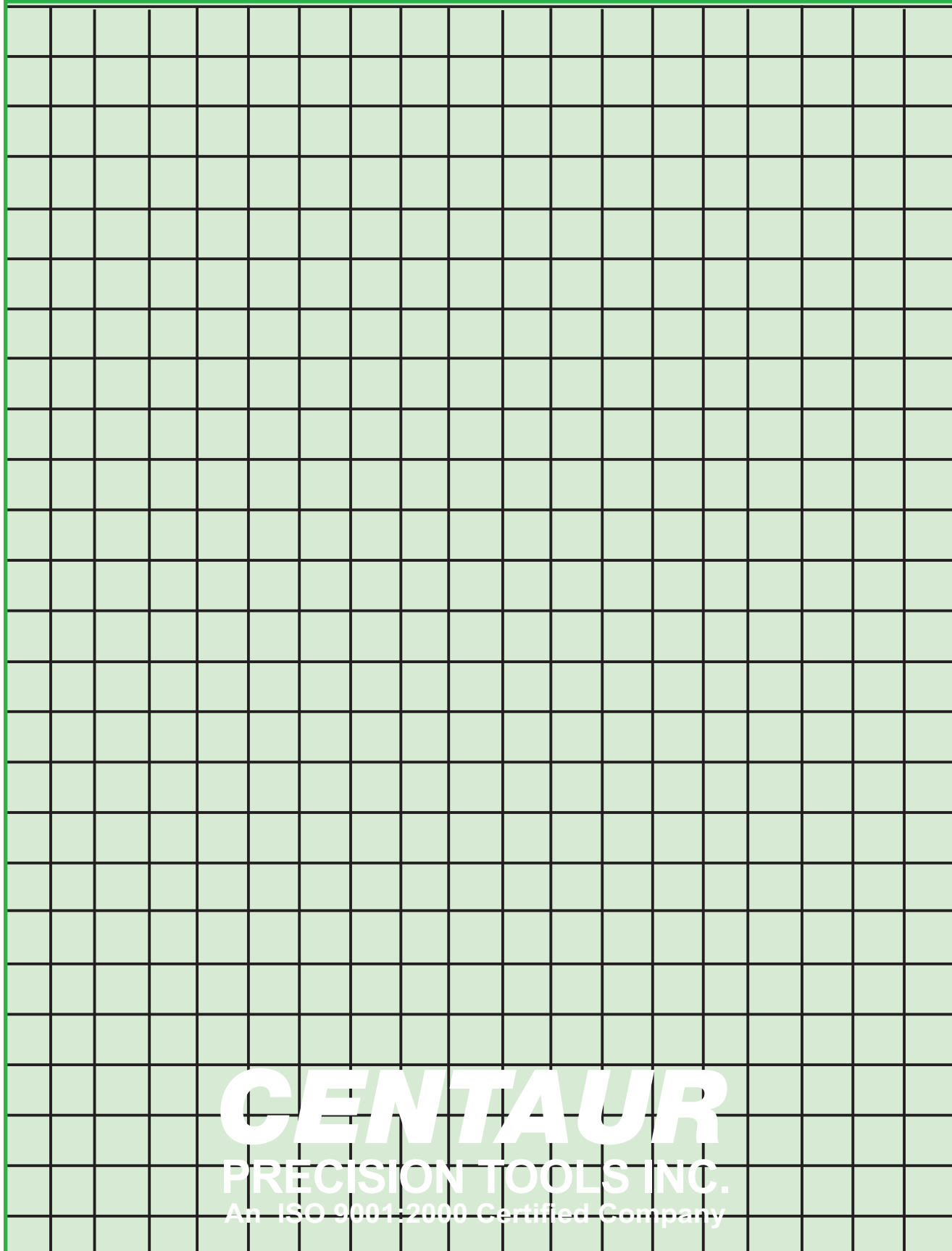
	Sizes	Quantity	Accessories
END MILL HOLDERS	$\frac{1}{4}$ " , $\frac{3}{8}$ " , $\frac{1}{2}$ " , $\frac{5}{8}$ " $\frac{3}{4}$ " , 1" , 1- $\frac{1}{4}$ "	1 ea.	Retention Knobs VR
RD 20 COLLET CHUCKS RD 20 COLLET SET		2 - 4 1	Wrench
RD 32 COLLET CHUCKS RD 32 COLLET SET		2 - 4 1	Wrench
SHELL MILL ADAPTERS	1" , 1- $\frac{1}{4}$ "	1 ea.	
JACOBS TAPER ADAPTERS KEYLESS CHUCKS	#1, #33 $\frac{1}{4}$ " , $\frac{5}{8}$ " Cap.	1 ea. 1 ea.	
RIGID TAP HOLDERS (Synchronous Feed Machines)	#1 (0 - $\frac{9}{16}$ " ) #2 ( $\frac{1}{4}$ - $\frac{7}{8}$ " )	1 ea.	Positive-Drive Tap Adapters
TENSION-COMPRESSION TAP HOLDERS (Non-Synchronous Feed Machines)	#1 (0 - $\frac{9}{16}$ " ) #2 ( $\frac{1}{4}$ - $\frac{7}{8}$ " )	1 ea.	Positive-Drive or Torque Control

## NEW MACHINE START-UP PACKAGE (COOLANT-THROUGH)

(CAT 40, 45 &amp; 50 AND BT 40 &amp; 50)

	Sizes	Quantity	Accessories
END MILL HOLDERS	$\frac{1}{4}$ " , $\frac{3}{8}$ " , $\frac{1}{2}$ " , $\frac{5}{8}$ " $\frac{3}{4}$ " , 1" , 1- $\frac{1}{4}$ "	1 ea.	Retention Knobs VRC
RD 20 COLLET CHUCKS RD 20 SEALED COLLET SET	To Tool Size	2 - 4 1	Wrench
RD 32 COLLET CHUCKS RD 32 SEALED COLLET SET	To Tool Size	2 - 4 1	Wrench
SHELL MILL ADAPTERS	1" , 1- $\frac{1}{4}$ "	1 ea.	
RIGID, COOLANT-THROUGH TAP HOLDERS	#1 (0 - $\frac{9}{16}$ " ) #2 ( $\frac{1}{4}$ - $\frac{7}{8}$ " )	1 ea. 1 ea.	CWE-K Adapters For Blind & Through-Hole Applications  Standard CWE Adapters For Oil Hole Taps

NOTES



Start-up Packages

**CENTAUR**  
PRECISION TOOLS INC.  
An ISO 9001:2000 Certified Company

*Centaur's High-Grip Power Milling chuck provides the strength and precision you need for serious milling jobs.*



### Features:

- **EXTREME GRIP**

Up to five times the gripping power of traditional collet chucks

- **HIGH RIGIDITY**

Vibration-reducing design for outstanding surface finish

- **PEERLESS PRECISION**

Unique clamping system guarantees 0.0004" TIR or less at 4 inches

- **COOLANT-THROUGH**

Compatible with today's high-speed machining centers with coolant-through spindles



HIGH-GRIP POWER MILLING CHUCKS

Part No.	Description
C40PC0750	V40 - 3/4" Diameter
C50PC0750	V50 - 3/4" Diameter
H50APC0750	HSK 50A - 3/4" Diameter
H63APC0750	HSK 63A - 3/4" Diameter
B40PC0750	BT 40 - 3/4" Diameter
B50PC0750	BT 50 - 3/4" Diameter
C40PC1250	V40 - 1-1/4" Diameter
C50PC1250	V50 - 1-1/4" Diameter
H63APC1250	HSK 63A - 1-1/4" Diameter
H100APC1250	HSK 100A - 1-1/4" Diameter
B40PC1250	BT 40 - 1-1/4" Diameter
B50PC1250	BT 50 - 1-1/4" Diameter

COOLANT NOZZLES

For 3/4" Chucks

Part No.	Shank Range
PCN750-2500	1/4 - 3/8"
PCN750-5000	1/2 - 3/4"

For 1-1/4" Chucks

Part No.	Shank Range
PCN1250-2500	1/4 - 3/8"
PCN1250-3750	3/8 - 1/2"
PCN1250-6250	5/8 - 3/4"
PCN1250-1000	7/8 - 1-1/4"

COLLETS FOR MILLING CHUCKS

For 3/4" Chucks

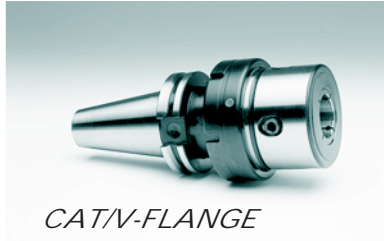
Part No.	Diameter
600-501	1/8
600-502	3/16
600-503	1/4
600-504	5/16
600-505	3/8
600-506	7/16
600-507	1/2
600-508	9/16
600-509	5/8

For 1-1/4" Chucks

Part No.	Diameter
800-501	1/8
800-502	3/16
800-503	1/4
800-504	5/16
800-505	3/8
800-506	7/16
800-507	1/2
800-508	9/16
800-509	5/8
800-510	3/4
800-511	7/8
800-512	1

# ***μmatic***

*Increase Productivity At An Economy Price  
With The Unique Precision Chuck From Centaur*



CAT/V-FLANGE

The *μmatic* high precision chuck is designed specifically to meet the demands of today's new generation of machines and cutting tools. *μmatic*'s powerful clamping force and ability to hold tools within 50 millionths T.I.R. eliminate the need for expensive hydraulic chucks and conventional milling chucks.

Centaur's innovative *μmatic* chuck features clamping surfaces ground directly from the tool holder body. Holding a cutting tool within 0.0002" T.I.R. is achieved with no adjustments.

*μmatic* incorporates truing screws that contact the tool shank directly, permitting rapid adjustments to within 50 millionths — either on a presetter or in the machine spindle.

*μmatic* is ideal for rough milling and finish milling. And because of *μmatic*'s unusually high accuracy, it is perfectly suited for holmaking applications that normally require hydraulic chuck or boring operations.

The *μmatic* high precision chuck ensures greater workpiece accuracy, while delivering increased feed rates and tool life.

The bottom line: ***Increased productivity.***



BT

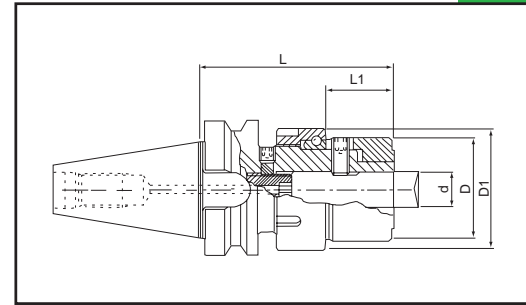
## *Features and Benefits*

- **Patented, vibration-damping structure.** Centaur's *μmatic* interrupts the transmission of helical vibrations to allow increased RPM and feed rates.
- **Guaranteed high accuracies.** Tools clamp within 0.0002" T.I.R. with no adjustment. Truing screws that contact directly to the tool shank can be set easily and quickly to achieve T.I.R. within 50 millionths.
- **Ideal for today's finest machine tools.** *μmatic* is balanced to 22,000 RPM and is sealed for coolant-through applications.
- **Locking screw.** In addition to exerting extremely powerful clamping forces, the *μmatic* high precision chuck is equipped with a Weldon type screw to eliminate tool pullout common with standard heavy duty milling chucks.
- **Delivery from stock.** *μmatic* chucks are shipped directly from Centaur's huge U.S.-based inventory in all standard sizes. CAT/V-Flange, BT and HSK shanks are available.
- **Value pricing.** *μmatic* high precision chucks can replace expensive hydraulic chucks and heavy duty milling chucks, yet are available from Centaur at a fraction of the cost.

## CNC TOOLHOLDERS

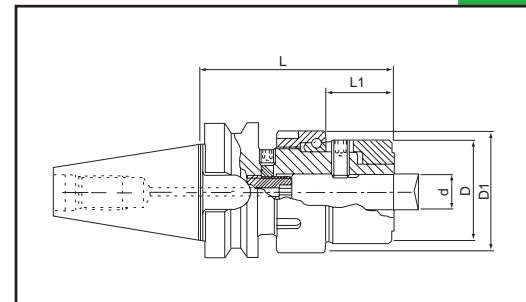
## CAT/V-FLANGE SPECIFICATIONS

Part No.	Shank	d	D		D1		L		L1	
			mm.	in.	mm.	in.	mm.	in.	mm.	in.
C40UM0250	CAT 40	0.250"	28.5	1.122	37.5	1.476	86	3.386	25	0.984
C40UM0312	CAT 40	0.312"	28.5	1.122	37.5	1.476	86	3.386	25	0.984
C40UM0375	CAT 40	0.375"	35.5	1.398	44.5	1.752	96	3.780	31.5	1.240
C40UM0437	CAT 40	0.437"	38	1.496	44.5	1.752	96	3.780	31.5	1.240
C40UM0500	CAT 40	0.500"	38	1.496	44.5	1.752	96	3.780	31.5	1.240
C40UM0625	CAT 40	0.625"	42.5	1.673	49.5	1.949	98	3.858	32.5	1.280
C40UM0750	CAT 40	0.750"	48.5	1.909	54.5	2.146	100	3.937	34.5	1.358
C40UM0875	CAT 40	0.875"	50.5	1.988	56.5	2.224	100	3.937	34.5	1.358
C40UM1000	CAT 40	1.000"	61.5	2.421	68.5	2.697	106	4.173	39	1.535
C40UM1125	CAT 40	1.125"	64	2.520	68.5	2.697	106	4.173	39	1.535
C40UM1250	CAT 40	1.250"	70	2.756	73.5	2.894	114	4.488	43.5	1.713
C50UM0250	CAT 50	0.250"	28.5	1.122	37.5	1.476	86	3.386	25	0.984
C50UM0312	CAT 50	0.312"	28.5	1.122	37.5	1.476	86	3.386	25	0.984
C50UM0375	CAT 50	0.375"	35.5	1.398	44.5	1.752	96	3.780	31.5	1.240
C50UM0500	CAT 50	0.500"	38	1.496	44.5	1.752	96	3.780	31.5	1.240
C50UM0625	CAT 50	0.625"	42.5	1.673	49.5	1.949	98	3.858	32.5	1.280
C50UM0750	CAT 50	0.750"	48.5	1.909	54.5	2.146	100	3.937	34.5	1.358
C50UM0875	CAT 50	0.875"	50.5	1.988	56.5	2.224	100	3.937	34.5	1.358
C50UM1000	CAT 50	1.000"	61.5	2.421	68.5	2.697	106	4.173	39	1.535
C50UM1125	CAT 50	1.125"	64	2.520	68.5	2.697	106	4.173	39	1.535
C50UM1250	CAT 50	1.250"	70	2.756	73.5	2.894	114	4.488	43.5	1.713



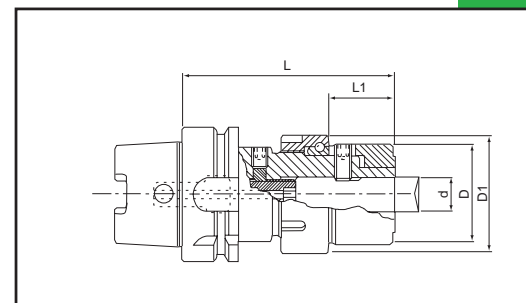
## BT SPECIFICATIONS

Part No.	Shank	d	D		D1		L		L1	
			mm.	in.	mm.	in.	mm.	in.	mm.	in.
B40UM0250	BT 40	0.250"	28.5	1.122	37.5	1.476	78	3.071	25	0.984
B40UM0312	BT 40	0.312"	28.5	1.122	37.5	1.476	78	3.071	25	0.984
B40UM0375	BT 40	0.375"	35.5	1.398	44.5	1.752	88	3.465	31.5	1.240
B40UM0437	BT 40	0.437"	38	1.496	44.5	1.752	88	3.465	31.5	1.240
B40UM0500	BT 40	0.500"	38	1.496	44.5	1.752	88	3.465	31.5	1.240
B40UM0625	BT 40	0.625"	42.5	1.673	49.5	1.949	90	3.543	32.5	1.280
B40UM0750	BT 40	0.750"	48.5	1.909	54.5	2.146	92	3.622	34.5	1.358
B40UM0875	BT 40	0.875"	50.5	1.988	56.5	2.224	92	3.622	34.5	1.358
B40UM1000	BT 40	1.000"	61.5	2.421	68.5	2.697	98	3.858	39	1.535
B40UM1125	BT 40	1.125"	64	2.520	68.5	2.697	98	3.858	39	1.535
B40UM1250	BT 40	1.250"	70	2.757	73.5	2.894	106	4.173	43.5	1.713
B50UM0250	BT 50	0.250"	28.5	1.122	37.5	1.476	89	3.504	25	0.984
B50UM0312	BT 50	0.312"	28.5	1.122	37.5	1.476	89	3.504	25	0.984
B50UM0375	BT 50	0.375"	35.5	1.398	44.5	1.752	99	3.898	31.5	1.240
B50UM0500	BT 50	0.500"	38	1.496	44.5	1.752	99	3.898	31.5	1.240
B50UM0625	BT 50	0.625"	42.5	1.673	49.5	1.949	99	3.898	32.5	1.280
B50UM0750	BT 50	0.750"	48.5	1.909	54.5	2.146	101	3.976	34.5	1.358
B50UM0875	BT 50	0.875"	50.5	1.988	56.5	2.224	101	3.976	34.5	1.358
B50UM1000	BT 50	1.000"	61.5	2.421	68.5	2.697	109	4.291	39	1.535
B50UM1125	BT 50	1.125"	64	2.520	68.5	2.697	109	4.291	39	1.535
B50UM1250	BT 50	1.250"	70	2.756	73.5	2.894	127	5.000	43.5	1.713



## HSK SPECIFICATIONS

Part No.	Shank	d	D		D1		L		L1	
			mm.	in.	mm.	in.	mm.	in.	mm.	in.
H63AUM0250	HSK 63	0.250"	28.5	1.122	37.5	1.476	87	3.425	25	0.984
H63AUM0312	HSK 63	0.312"	28.5	1.122	37.5	1.476	87	3.425	25	0.984
H63AUM0375	HSK 63	0.375"	35.5	1.398	44.5	1.752	97	3.819	31.5	1.240
H63AUM0500	HSK 63	0.500"	38	1.496	44.5	1.752	97	3.819	31.5	1.240
H63AUM0625	HSK 63	0.625"	42.5	1.673	49.5	1.949	99	3.898	32.5	1.280
H63AUM0750	HSK 63	0.750"	48.5	1.909	54.5	2.146	101	3.976	34.5	1.358
H63AUM0875	HSK 63	0.875"	50.5	1.988	56.5	2.224	101	3.976	34.5	1.358
H63AUM1000	HSK 63	1.000"	61.5	2.421	68.5	2.697	114	4.488	39	1.535
H63AUM1125	HSK 63	1.125"	64	2.520	68.5	2.697	114	4.488	39	1.535
H63AUM1250	HSK 63	1.250"	70	2.756	73.5	2.894	124	4.882	43.5	1.713



# TOOL HOLDING 101 FROM **CENTAUR**

## DID YOU KNOW . . .

Click 

TOOL  
HOLDING  
101

Weldon-type end mill tool holders typically push the cutting tool 0.0005" or more off-center! Did you know that **CENTAUR "Green Zone" Collet Chucks, High-Grip™ Milling Chucks** and the unique design high performance **µmatic Chucks** **ALL** centralize the cutting tool! This provides concentricity that increases tool life, enhances feed rates and improves workpiece accuracy and finish.

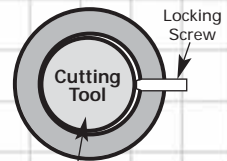
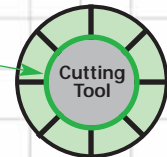
**CENTAUR** is your best choice for precision CNC tool holders for most widely used systems in inch and metric sizes, delivered **FROM STOCK!**

- **CAT (V-FLANGE) 40 & 50:** RD/ER, RDG/TG, RDF/AF, RDA/DA Collet Chucks, End Mill, Morse and Jacobs Taper Adapters,
- **COLLET SYSTEMS:** RD/ER, RDG/TG, RDA/DA and RDA/DA & RD/ER Extension Holders.
- **BT TOOL HOLDERS 40 & 50:** End Mill, Shell Mill Holders and Morse Taper Adapters, RD/ER, RDG/TG, RDA/DA Collet Chucks.
- **HIGH-GRIP™ POWER MILLING CHUCKS** and Collets.
- **µMATIC SYSTEM:** CAT/V FLANGE and BT High Precision Chucks.

**CENTAUR** offers a complete line of Precision Tooling Systems including CNC Tool Holders, VDI Tool Holders and Tapping Systems.

**CENTAUR**  
PRECISION TOOLS INC.  
An ISO 9001:2000 Certified Company

**CENTAUR "Green Zone" chucks** centralize the cutting tool ensuring exact concentricity!



Weldon-type End Mill Holder with off-center Tool

Visit [www.centaurtools.com](http://www.centaurtools.com) and click on the **Tool Holding 101** Button for a comprehensive and informative section on the selection, uses and care of tool holding systems.

13098 SW 133rd Court • Miami, FL 33186  
Toll Free: 1-888-COL-LETS (265-5387) • Fax:(305) 251-0756

Visit [www.centaurtools.com](http://www.centaurtools.com) to view **Tool Holding 101**, a comprehensive program containing CNC Tool Holder technical information..

You can expect the "Green Zone" accuracy of Centaur tool holders to increase feed rates and rpm, work piece accuracy and finish.

And, eliminate unnecessary downtime, reduced tool life, provide more time in the cut and lower the cost per workpiece.

# *FILLED WITH THE TOOLING THAT GIVES YOU THE COMPETITIVE EDGE*

## OUR COMMITMENT TO CUSTOMER SERVICE...

- *Single-Source Ordering Convenience*
- *Reliable Technical Support*
- *Delivery From A Huge  
Available Inventory*
- *Competitive Pricing*
- *Guaranteed Quality*



## ...WORKING FOR YOU IN 2008.



# TABLE OF CONTENTS - 2008



## Precision Collet Systems

- Page 4** RD/ER Collet System Features; Concentricity; Insertion & Release
- Page 5 -19** RD/ER Collet Systems
- Page 20-21** RTX Collet System
- Page 22-23** Straight-Shank Collet Chucks
- Page 24** Master Tooling Sets, Tool Boxes; Trays
- Page 25** BT RD/ER Collet Chucks
- Page 26** CAT (V-Flange) RD/ER Collet Chucks
- Page 27** Short & Rigid CAT & BT Collet Chucks
- Page 28** NMTB, R8 & Morse Taper Collet Chucks
- Page 29** HSK Collet Chucks, Floating Reamer Holders
- Page 30** Clamping Nuts & Wrenches
- Page 31** Retention Knobs; Tightening & Locking Fixtures
- Page 32-37** RDG/TG Collet Systems
- Page 38** CAT V-Flange & BT Collet Chucks; Nuts & Wrenches
- Page 40-42** RDA/DA Collet Systems
- Page 43** CAT (V-Flange), Straight-Shank & BT Collet Chucks
- Page 44-47** RDF/AF Collet Systems
- Page 48-51** RDO Collet Systems
- Page 52** 5C Round Collets — Inch
- Page 53** 5C Round Collets — Metric
- Page 54** 5C Emergency & Step Collets; Adjustable Backstop; Holder Set
- Page 55** R8 Collets
- Page 58** Collets 101



## Precision CNC Tool Holders

- Page 59-62** CAT 40 & 50 Inch & Metric Tool Holders
- Page 63** Coolant Through Tool Holders
- Page 64** CAT (V-Flange) Morse & Jacobs Taper Holders
- Page 65** CAT Shell Mill Holders
- Page 66-68** BT Inch & Metric Tool Holders
- Page 69** Retention Knobs & Tightening Fixtures
- Page 70** Start-Up Tooling Packages
- Page 72-73** High-Grip Power Milling Chucks
- Page 74-75** *umatic* Precision Chuck System



## Precision Tapping Systems

- Page 79** Quick Change Tap Holders
- Page 80** Positive Drive Tap Adapters
- Page 81** Torque Control Tap Adapters
- Page 82** Quick Change Coolant Through Tap Adapters
- Page 82** CWE External Coolant Flow Tap Adapters
- Page 83** CEN-CHRO Tapping Chucks
- Page 84** RD/ER Rigid Tapping Collets
- Page 85** RDG/TG Tapping Collets
- Page 86** RDT Axial Compensating Tap Collets
- Page 87** BF Adapters for RD/ER Collets
- Page 87** Floating Tap Holders
- Page 88** CDSPL All Purpose Tapping Attachment



## Precision VDI Tool Holders

- Page 91** Standard Radial Overhead Tool Holders
- Page 92** Long Radial Overhead Tool Holders
- Page 92** Axial Tool Holders
- Page 94** Boring Bar Holders, Steel Plugs & Morse Taper Adapters
- Page 95** Split Boring Bar Holders & Special Compact Axial Tool Holders
- Page 96** Tapping Holders & Tap Adapters
- Page 97** Collet Chucks RD/ER, RDO/Ortlieb, RDG/TG

# **CENTAUR**



**Precision Collet Systems**

**2008**

# TABLE OF CONTENTS - 2008

## PRECISION COLLET SYSTEMS



### RD/ER

<b>Page 4</b>	RD/ER Collet System Features; Concentricity; Insertion & Release
<b>Page 5</b>	RD/ER 8, 11 & 12 Collet Systems
<b>Page 6-7</b>	RD/ER 16 Collet System
<b>Page 8-9</b>	RD/ER 20 Collet System
<b>Page 10-11</b>	RD/ER 25 Collet System
<b>Page 12-13</b>	RD/ER 32 Collet System
<b>Page 14</b>	RD/ER 32 Internal & External Coolant System
<b>Page 15</b>	NOTES
<b>Page 16 -17</b>	RD/ER 40 Collet System
<b>Page 18</b>	RD/ER 40 Internal & External Coolant System
<b>Page 19</b>	RD/ER 50 Collet System
<b>Page 20-21</b>	RTX Collet System
<b>Page 22-23</b>	Straight-Shank RD/ER Collet Chucks
<b>Page 24</b>	Master Tooling Sets; Tool Trays; Tool Boxes
<b>Page 25</b>	BT RD/ER Collet Chucks
<b>Page 26</b>	CAT (V-Flange) RD/ER Collet Chucks
<b>Page 27</b>	Short & Rigid CAT & BT Collet Chucks
<b>Page 28</b>	NMTB/ISO R8 & Morse Taper Collet Chucks
<b>Page 29</b>	HSK Collet Chucks & Rotating Reamer Holders
<b>Page 30</b>	Clamping Nuts & Wrenches
<b>Page 31</b>	Retention Knobs & Tightening Fixtures\



### RDG/TG

<b>Page 32-33</b>	RDG/TG 75 Collet System
<b>Page 34-35</b>	RDG/TG 100 Collet System
<b>Page 36-37</b>	RDG/TG 150 Collet System
<b>Page 38</b>	CAT (V-Flange) & BT Collet Chucks; Nuts & Wrenches
<b>Page 39</b>	NOTES



### RDA/DA

<b>Page 40</b>	RDA/DA 300 & 200 Collet Systems
<b>Page 41</b>	RDA/DA 100 Collet System
<b>Page 42</b>	RDA/DA 180 Collet System; Nuts & Nosepieces
<b>Page 43</b>	CAT (V-Flange), Straight Shank & BT Collet Chucks



### RDF/AF

<b>Page 44</b>	RDF/AF 25, 38 & 50 Collet Systems
<b>Page 45</b>	RDF/AF 75 & 100 Collet Systems
<b>Page 46</b>	CAT (V-Flange) & BT Collet Chucks
<b>Page 47</b>	Collet Extensions; Nuts & Wrenches





RDO

- Page 48** RDO 16, 20 & 25 Collet Systems
- Page 49** RDO 35 & 44 Collet Systems
- Page 50** TC DIN CAT (V-Flange), BT & NMTB Collet Chucks
- Page 51** Nuts & Wrenches; Master Tooling Sets



5C/R8

- Page 52** 5C Round Collets — Inch
- Page 53** 5C Round Collets — Metric; 5C Hex & Square Collets
- Page 54** 5C Emergency & Step Collets; Adjustable Backstop; Holder Set
- Page 55** R8 Collets
- Page 56** NOTES

RD/ER  
COLLET  
SYSTEM

RDG/TG  
COLLET  
SYSTEM

RDA/DA  
COLLET  
SYSTEM

RDF/AF  
COLLET  
SYSTEM

RDO  
COLLET  
SYSTEM

5C/R8  
COLLET  
SYSTEM

Specifications subject to change without notice.

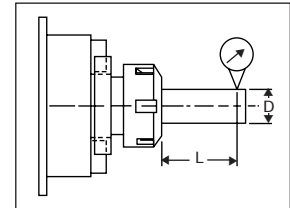


## RD/ER COLLET SYSTEM FEATURES

- **High Accuracy.** 16 slots for rigid clamping and extra concentricity.
- **Wide Clamping Range.** For fewer changes and a low cost per set that covers a continuous range of sizes.
- **Versatility.** Interchangeable with ER and ESX type collets.
- **Ideal for Tool Extensions.** High accuracy for long-reach applications.
- **Multiple Applications.** Same collets can be used for drilling, milling, tapping and reaming.
- **Precision Manufacturing.** High grade spring steel is hardened and precision ground, with 100% quality inspection.
- **Long Life.** Exceeding that of other collet styles.
- **Factory Guarantee.** Fully backed.

## RD/ER COLLET CONCENTRICITY - PER DIN 6499

METRIC				INCHES					
Clamping Range D		L	Maximum T.I.R.		Clamping Range D		L	Maximum T.I.R.	
Min.	Max.		Precision DIN 6499	High Precision DIN 6499	Min.	Max.		Precision DIN 6499	High Precision DIN 6499
1.0	1.6	6	0.015	0.008	0.039	0.063	0.236	0.0006	0.0003
1.6	3.0	10			0.063	0.118	0.394		
3.0	6.0	16			0.118	0.236	0.630		
6.0	10.0	25			0.236	0.394	0.984		
10.0	18.0	40	0.020	0.010	0.394	0.709	1.575	0.0008	0.0004
18.0	26.0	50			0.709	1.024	1.969		
26.0	34.0	60			1.024	1.339	2.362		

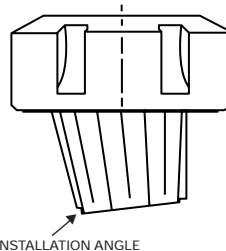


## METHOD OF INSERTION &amp; RELEASE FOR RD/ER COLLETS

## INSERTING

1. Insert collet into nut at angle as shown to engage extraction tongue in groove of collet.
2. Screw nut onto collet holder with collet securely in nut.
3. Insert tool to be gripped and lock nut.

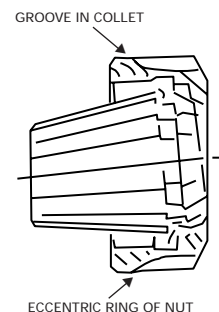
IMPORTANT: Never screw nut onto collet unless collet is properly seated in nut.



INSTALLATION ANGLE

## RELEASING

Hold nut in vertical position and remove nut at an angle. Collet is automatically withdrawn from chuck by eccentric ring of nut when unscrewed.

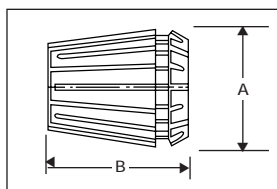


ECCENTRIC RING OF NUT



RD/ER 8 COLLET SYSTEM

Clamping Range		PART NO.	
(mm.)	(in.)	STANDARD PRECISION	HIGH PRECISION
1.0-0.5	0.039-0.019	80-001	80-901
1.5-1.0	0.059-0.039	80-002	80-902
2.0-1.5	0.079-0.059	80-003	80-903
2.5-2.0	0.098-0.079	80-004	80-904
3.0-2.5	0.118-0.098	80-005	80-905
3.5-3.0	0.138-0.118	80-006	80-906
4.0-3.5	0.157-0.138	80-007	80-907
4.5-4.0	0.177-0.157	80-008	80-908
5.0-4.5	0.197-0.177	80-009	80-909
.5 - 5mm 9 Pc. Set		80-010	80-910



**RD/ER 8**  
A = 8.5 mm. (0.34 in.)  
B = 13.5 mm. (0.53 in.)

**RD/ER 11**  
A = 11.5 mm. (0.45 in.)  
B = 18 mm. (0.71 in.)

**RD/ER 12**  
A = 12 mm. (0.47 in.)  
B = 19.5 mm. (0.77 in.)

**RD/ER 8**  
Collapse per collet: 0.5 mm. (0.019 in.)  
Capacity per set: 0.5 - 5 mm. (0.019 - 0.197 in.)  
Precision per DIN 6499

**RD/ER 11**  
Collapse per collet: 0.5 mm. (0.019 in.) Capacity per set: 0.5 - 7 mm. (0.019 - 0.276 in.)  
Precision per DIN 6499 Maximum tightening torque: 20 ft./lbs.

RD/ER 11 COLLET SYSTEM

METRIC SIZES				METRIC SIZES		INCH SIZES		INCH SIZES	
Clamping Range		PART NO.		Dia. (mm)	Part No.	Dia. (in.)	Part No.	Dia. (in.)	Part No.
(mm.)	(in.)	STANDARD PRECISION	HIGH PRECISION						
1.0-0.5	0.039-0.019	110-001	110-901	2.5	1101K2.5	1/8	1101K503	1/16	110-501
1.5-1.0	0.059-0.039	110-002	110-902	3.0	1101K03	5/32	1101K504	3/32	110-502
2.0-1.5	0.079-0.059	110-003	110-903	3.5	1101K3.5	3/16	1101K505	1/8	110-503
2.5-2.0	0.098-0.079	110-004	110-904	4.0	1101K04	7/32	1101K506	5/32	110-504
3.0-2.5	0.118-0.098	110-005	110-905	4.5	1101K4.5	1/4	1101K507	3/16	110-505
3.5-3.0	0.138-0.118	110-006	110-906	5.0	1101K05			7/32	110-506
4.0-3.5	0.157-0.138	110-007	110-907	5.5	1101K5.5			1/4	110-507
4.5-4.0	0.177-0.157	110-008	110-908	6.0	1101K06			7 Pc. Set	110-508
5.0-4.5	0.197-0.177	110-009	110-909	6.5	1101K6.5				
5.5-5.0	0.217-0.197	110-010	110-910	7.0	1101K07				
6.0-5.5	0.236-0.217	110-011	110-911						
6.5-6.0	0.256-0.236	110-012	110-912						
7.0-6.5	0.276-0.256	110-013	110-913						
.5 - 7mm 13 Pc. Set		110-014	110-914						

RD/ER 12 COLLET SYSTEM

NOTE: High precision also available in inch sizes.

RTS 11 RIGID TAPPING COLLETS

ANSI Tap Size	Part No.
0-6	111-141
8	111-168
10	111-194
12	111-220
1/4	111-255

**RD/ER 12**  
Collapse per collet: 0.5 (0.019)  
Capacity per set: 0.5 - 7 mm. (0.019 - 0.276 in.)  
Precision per DIN 6499  
Maximum tightening torque: 20 ft./lbs.

Clamping Range		PART NO.	
(mm.)	(in.)	STANDARD PRECISION	HIGH PRECISION
1.0-0.5	0.039-0.019	120-001	120-901
1.5-1.0	0.059-0.039	120-002	120-902
2.0-1.5	0.079-0.059	120-003	120-903
2.5-2.0	0.098-0.079	120-004	120-904
3.0-2.5	0.118-0.098	120-005	120-905
3.5-3.0	0.138-0.118	120-006	120-906
4.0-3.5	0.157-0.138	120-007	120-907
4.5-4.0	0.177-0.157	120-008	120-908
5.0-4.5	0.197-0.177	120-009	120-909
5.5-5.0	0.217-0.197	120-010	120-910
6.0-5.5	0.236-0.217	120-011	120-911
6.5-6.0	0.256-0.236	120-012	120-912
7.0-6.5	0.276-0.256	120-013	120-913
13Pc. Set		120-014	120-914

Collet Chucks are shown on Pages 22 - 29

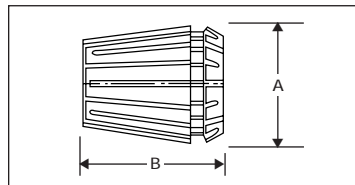
RD/ER





## RD/ER 16 COLLET SYSTEM

RD/ER



A = 17 mm. (0.67 in.)  
B = 27 mm. (1.06 in.)

Collapse per collet: 0.5/1 mm. (0.019/0.039 in.)  
Capacity per set: 0.5 - 10 mm. (0.019 - 0.394 in.)  
Precision per DIN 6499  
Maximum tightening torque: 40 ft./lbs.

## INTERNAL &amp; EXTERNAL COOLANT COLLETS



IK Internal Coolant Collet

Sealed for coolant-through applications, with pressure resistance tested to 1000 p.s.i. Sealed collets are high precision exact size collets and have no collapse range.

Internal Coolant Collets (IK): To direct fluid through the cutting tool.



EK External Coolant Collet

External Coolant Collets (EK): To direct fluid through the collet to the cutting tool tip, allowing the use of standard cutting tools in coolant through applications or to route fluid through the tool and around the tool for higher coolant volume.

## ND COLLETS



Nominal size collets manufactured per DIN 6499 Form A are available in inch and metric sizes by special order, offering maximum 0.0003 in. TIR.

## TAPPING COLLETS

## RTS Rigid Tapping Collets with Square Drive



For synchronous tapping operations using any RD/ER collet chuck. Collet bore is exact tool diameter, with square drive, for accuracy and rigidity.

Available sealed for coolant-through applications, as well as in DIN and JIS standard metric sizes.

## RDT Quick-Change Tapping Collets with Axial Compensation



For use with any RD/ER collet chuck, these tapping collets help prevent tap breakage on machines requiring axial compensation. Friction-free ball-bearing drive. Metric sizes available upon request.



RD/ER 16 COLLETS

RD/ER

Clamping Range (mm.) (in.)		METRIC SIZES			INCH SIZES		INTERNAL COOLANT COLLETS				
		STANDARD PRECISION	HIGH PRECISION	0.5 INCREMENTS	STANDARD PRECISION		METRIC		INCH		
		Part No.	Part No.	Part No.	Dia. (in.)	Part No.	Dia. (mm.)	Part No.	Dia. (in.)	Part No.	
1-0.5	0.039-0.019	160-001	160-901		1/16	160-501	3	160IK03	1/8	160IK501	
1.5-1	0.059-0.039			160-101	3/32	160-502	4	160IK04	5/32	160IK502	
2-1	0.079-0.039	160-002	160-902		1/8	160-503	5	160IK05	3/16	160IK503	
2.5-1.5	0.098-0.059			160-102	5/32	160-504	6	160IK06	7/32	160IK504	
3-2	0.118-0.079	160-003	160-903		3/16	160-505	7	160IK07	1/4	160IK505	
3.5-2.5	0.138-0.098			160-103	7/32	160-506	8	160IK08	9/32	160IK506	
4-3	0.157-0.118	160-004	160-904		1/4	160-507	9	160IK09	5/16	160IK507	
4.5-3.5	0.177-0.138			160-104	9/32	160-508	10	160IK10	11/32	160IK508	
5-4	0.197-0.157	160-005	160-905		5/16	160-509			3/8	160IK509	
5.5-4.5	0.217-0.177			160-105	11/32	160-510					
6-5	0.236-0.197	160-006	160-906		3/8	160-511					
6.5-5.5	0.256-0.217			160-106	13/32	160-512					
7-6	0.276-0.236	160-007	160-907		1/16-13/32 12-Pc. Set 1/8 - 3/8 9 pc. Set	160-513 160-530					
7.5-6.5	0.296-0.256			160-107							
8-7	0.315-0.276	160-008	160-908								
8.5-7.5	0.335-0.296			160-108							
9-8	0.354-0.315	160-009	160-909								
9.5-8.5	0.374-0.335			160-109							
10-9	0.394-0.354	160-010	160-910								
.5 - 10mm 10 Pc. Set		160-011									
3 - 10mm 8 Pc. Set		160-018									

NOTE: High precision also available in inch sizes.

EXTERNAL COOLANT COLLETS			
METRIC		INCH	
Dia. (mm.)	Part No.	Dia. (in.)	Part No.
3	160EK03	1/8	160EK501
4	160EK04	5/32	160EK502
5	160EK05	3/16	160EK503
6	160EK06	7/32	160EK504
7	160EK07	1/4	160EK505
8	160EK08	9/32	160EK506
9	160EK09	5/16	160EK507
10	160EK10	11/32	160EK508
		3/8	160EK509

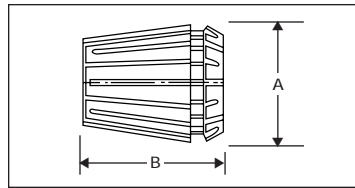
RD/ER 16 TAPPING COLLETS

ANSI Tap Size	RTS RIGID TAPPING COLLETS	RTS INTERNAL COOLANT RIGID TAPPING COLLETS	RDY AXIAL COMPENSATION TAPPING COLLETS
	Part No.	Part No.	Part No.
0-6	161-141	161-141S	160-141
8	161-168	161-168S	160-168
10	161-194	161-194S	160-194
12	161-220	161-220S	
1/4	161-255	161-255S	
5/16	161-318	161-318S	

Collet Chucks are shown on Pages 22 - 29



## RD/ER 20 COLLET SYSTEM



A = 21 mm. (0.83 in.)  
B = 31 mm. (1.22 in.)

Collapse per collet: 1 mm. (0.039 in.)  
Capacity per set: 1 - 13 mm. (0.039 - 0.512 in.)  
Precision per DIN 6499  
Maximum tightening torque: 60 ft./lbs.

## INTERNAL &amp; EXTERNAL COOLANT COLLETS



IK Internal Coolant Collet

Sealed for coolant-through applications, with pressure resistance tested to 1000 p.s.i. Sealed collets are high precision exact size collets and have no collapse range.

Internal Coolant Collets (IK): To direct fluid through the cutting tool.



EK External Coolant Collet

External Coolant Collets (EK): To direct fluid through the collet to the cutting tool tip, allowing the use of standard cutting tools in coolant through applications or to route fluid through the tool and around the tool for higher coolant volume.

## ND COLLETS



Nominal size collets manufactured per DIN 6499 Form A are available in inch and metric sizes by special order, offering maximum 0.0003 in. TIR.

## TAPPING COLLETS



## RTS Rigid Tapping Collets with Square Drive

For synchronous tapping operations using any RD/ER collet chuck. Collet bore is exact tool diameter, with square drive, for accuracy and rigidity.

Available sealed for coolant-through applications, as well as in DIN and JIS standard metric sizes.

## RDT Quick-Change Tapping Collets with Axial Compensation



For use with any RD/ER collet chuck, these tapping collets help prevent tap breakage on machines requiring axial compensation. Friction-free ball-bearing drive. Metric sizes available upon request.



**RD/ER 20 COLLETS**

RD/ER

Clamping Range (mm.) (in.)		METRIC SIZES			INCH SIZES		INTERNAL COOLANT COLLETS			
		STANDARD PRECISION	HIGH PRECISION	0.5 mm. INCREMENTS	STANDARD PRECISION		METRIC		INCH	
Part No.	Part No.	Part No.	Dia. (in.)	Part No.	Dia. (mm.)	Part No.	Dia. (in.)	Part No.		
1-0.5	0.039-0.019		200-100	1/16	200-501	3	200IK03	1/8	200IK501	
1.5-1	0.059-0.039		200-101	3/32	200-502	4	200IK04	5/32	200IK502	
2-1	0.079-0.039	200-001	200-901	1/8	200-503	5	200IK05	3/16	200IK503	
2.5-1.5	0.098-0.059		200-102	5/32	200-504	6	200IK06	7/32	200IK504	
3-2	0.118-0.079	200-002	200-902	3/16	200-505	7	200IK07	1/4	200IK505	
3.5-2.5	0.138-0.098		200-103	7/32	200-506	8	200IK08	9/32	200IK506	
4-3	0.157-0.118	200-003	200-903	1/4	200-507	9	200IK09	5/16	200IK507	
4.5-3.5	0.177-0.138		200-104	9/32	200-508	10	200IK10	11/32	200IK508	
5-4	0.197-0.157	200-004	200-904	5/16	200-509	11	200IK11	3/8	200IK509	
5.5-4.5	0.217-0.177		200-105	11/32	200-510	12	200IK12	13/32	200IK510	
6-5	0.236-0.197	200-005	200-905	3/8	200-511	13	200IK13	7/16	200IK511	
6.5-5.5	0.256-0.217		200-106	13/32	200-512			15/32	200IK512	
7-6	0.276-0.236	200-006	200-906	7/16	200-513			1/2	200IK513	
7.5-6.5	0.296-0.256		200-107	15/32	200-514					
8-7	0.315-0.276	200-007	200-907	1/2	200-515					
8.5-7.5	0.335-0.296		200-108	1/16 - 1/2	15 Pc. Set 200-516					
9-8	0.354-0.315	200-008	200-908							
9.5-8.5	0.374-0.335		200-109							
10-9	0.394-0.354	200-009	200-909							
10.5-9.5	0.414-0.374		200-110							
11-10	0.433-0.394	200-010	200-910							
11.5-10.5	0.453-0.414		200-111							
12-11	0.472-0.433	200-011	200-911							
12.5-11.5	0.493-0.453		200-112							
13-12	0.512-0.472	200-012	200-912							
.5 - 13MM	12 Pc. Set	200-013	200-913							

NOTE: High precision also available in inch sizes.

**RD/ER 20 TAPPING COLLETS**

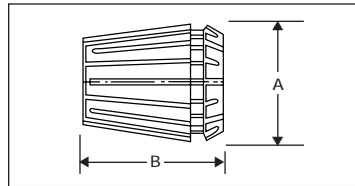
EXTERNAL COOLANT COLLETS			
METRIC		INCH	
Dia. (mm.)	Part No.	Dia. (in.)	Part No.
3	200EK03	1/8	200EK501
4	200EK04	5/32	200EK502
5	200EK05	3/16	200EK503
6	200EK06	7/32	200EK504
7	200EK07	1/4	200EK505
8	200EK08	9/32	200EK506
9	200EK09	5/16	200EK507
10	200EK10	11/32	200EK508
11	200EK11	3/8	200EK509
12	200EK12	13/32	200EK510
13	200EK13	7/16	200EK511
		15/32	200EK512
		1/2	200EK513

ANSI Tap Size	RTS RIGID TAPPING COLLETS		
	Part No.	Part No.	Part No.
0-6	201-141	201-141S	200-141T
8	201-168	201-168S	200-168
10	201-194	201-194S	200-194
12	201-220	201-220S	200-220
1/4	201-255	201-255S	200-255
5/16	201-318	201-318S	
3/8	201-381	201-381S	
7/16	201-323	201-323S	
1/2	201-367	201-367S	

Collet Chucks are shown on Pages 22 - 29



## RD/ER 25 COLLET SYSTEM



A = 26 mm. (1.02 in.)  
B = 35 mm. (1.38 in.)

Collapse per collet: 1 mm. (0.039 in.)  
Capacity per set: 1 - 16 mm. (0.039 - 0.630 in.)  
Precision per DIN 6499  
Maximum tightening torque: 70 ft./lbs.

## INTERNAL &amp; EXTERNAL COOLANT COLLETS



IK Internal Coolant Collet

Sealed for coolant-through applications, with pressure resistance tested to 1000 p.s.i. Sealed collets are high precision exact size collets and have no collapse range.

Internal Coolant Collets (IK): To direct fluid through the cutting tool.



EK External Coolant Collet

External Coolant Collets (EK): To direct fluid through the collet to the cutting tool tip, allowing the use of standard cutting tools in coolant through applications or to route fluid through the tool and around the tool for higher coolant volume.

## ND COLLETS



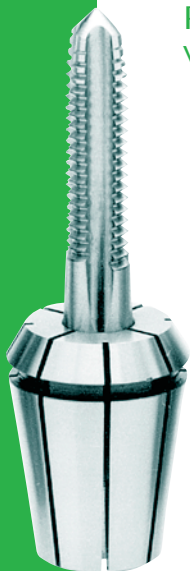
Nominal size collets manufactured per DIN 6499 Form A are available in inch and metric sizes by special order, offering max. 0.0003 in. TIR.

## TAPPING COLLETS

## RTS Rigid Tapping Collets with Square Drive

For synchronous tapping operations using any RD/ER collet chuck. Collet bore is exact tool diameter, with square drive, for accuracy and rigidity.

Available sealed for coolant-through applications, as well as in DIN and JIS standard metric sizes.



## RDT Quick-Change Tapping Collets with Axial Compensation

For use with any RD/ER collet chuck, these tapping collets help prevent tap breakage on machines requiring axial compensation. Friction-free ball-bearing drive. Metric sizes available upon request.







**RD/ER 25 COLLETS**

Clamping Range (mm.) (in.)		METRIC SIZES			INCH SIZES		INTERNAL COOLANT COLLETS			
		STANDARD PRECISION	HIGH PRECISION	0.5 mm. INCREMENTS	STANDARD PRECISION		METRIC		INCH	
Part No.	Part No.	Part No.	Dia. (in.)	Part No.	Dia. (mm.)	Part No.	Dia. (mm.)	Part No.	Dia. (in.)	Part No.
1-0.5	0.039-0.019			250-100	1/16	250-501	3	250IK03	1/8	250IK501
1.5-1	0.059-0.039			250-101	3/32	250-502	4	250IK04	5/32	250IK502
2-1	0.079-0.039	250-001	250-901		1/8	250-503	5	250IK05	3/16	250IK503
2.5-1.5	0.098-0.059			250-102	5/32	250-504	6	250IK06	7/32	250IK504
3-2	0.118-0.079	250-002	250-902		3/16	250-505	7	250IK07	1/4	250IK505
3.5-2.5	0.138-0.098			250-103	7/32	250-506	8	250IK08	9/32	250IK506
4-3	0.157-0.118	250-003	250-903		1/4	250-507	9	250IK09	5/16	250IK507
4.5-3.5	0.177-0.138			250-104	9/32	250-508	10	250IK10	11/32	250IK508
5-4	0.197-0.157	250-004	250-904		5/16	250-509	11	250IK11	3/8	250IK509
5.5-4.5	0.217-0.177			250-105	11/32	250-510	12	250IK12	13/32	250IK510
6-5	0.236-0.197	250-005	250-905		3/8	250-511	13	250IK13	7/16	250IK511
6.5-5.5	0.256-0.217			250-106	13/32	250-512	14	250IK14	15/32	250IK512
7-6	0.276-0.236	250-006	250-906		7/16	250-513	15	250IK15	1/2	250IK513
7.5-6.5	0.296-0.256			250-107	15/32	250-514	16	250IK16	17/32	250IK514
8-7	0.315-0.276	250-007	250-907		1/2	250-515			9/16	250IK515
8.5-7.5	0.335-0.296			250-108	17/32	250-516			19/32	250IK516
9-8	0.354-0.312	250-008	250-908		9/16	250-517			5/8	250IK517
9.5-8.5	0.374-0.335			250-109	19/32	250-518				
10-9	0.394-0.354	250-009	250-909		5/8	250-519				
10.5-9.5	0.414-0.374			250-110	1/16 - 5/8					
11-10	0.433-0.394	250-010	250-910		19 Pc. Set	250-520				
11.5-10.5	0.453-0.414			250-111						
12-11	0.472-0.433	250-011	250-911							
12.5-11.5	0.493-0.453			250-112						
13-12	0.512-0.472	250-012	250-912							
13.5-12.5	0.532-0.493			250-113						
14-13	0.551-0.512	250-013	250-913							
14.5-13.5	0.571-0.532			250-114						
15-14	0.591-0.551	250-014	250-914							
15.5-14.5	0.611-0.571			250-115						
16-15	0.630-0.591	250-015	250-915							
.5 - 16mm	15 Pc. Set	250-016	250-916							

EXTERNAL COOLANT COLLETS			
METRIC		INCH	
Dia. (mm.)	Part No.	Dia. (in.)	Part No.
3	250EK03	1/8	250EK501
4	250EK04	5/32	250EK502
5	250EK05	3/16	250EK503
6	250EK06	7/32	250EK504
7	250EK07	1/4	250EK505
8	250EK08	9/32	250EK506
9	250EK09	5/16	250EK507
10	250EK10	11/32	250EK508
11	250EK11	3/8	250EK509
12	250EK12	13/32	250EK510
13	250EK13	7/16	250EK511
14	250EK14	15/32	250EK512
15	250EK15	1/2	250EK513
16	250EK16	17/32	250EK514
		9/16	250EK515
		19/32	250EK516
		5/8	250EK517

**RD/ER 25 TAPPING COLLETS**

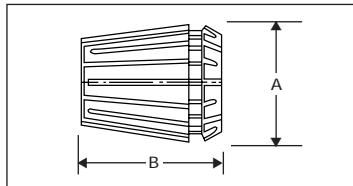
ANSI Tap Size	RTS RIGID TAPPING COLLETS			RTS INTERNAL COOLANT RIGID TAPPING COLLETS			RDT AXIAL COMPENSATION TAPPING COLLETS		
	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.
0-6	251-141	251-141S		251-141					
8	251-168	251-168S		251-168					
10	251-194	251-194S		251-194					
12	251-220	251-220S		251-220					
1/4	251-255	251-255S		251-255					
5/16	251-318	251-318S		251-318					
3/8	251-381	251-381S		251-381					
7/16	251-323	251-323S		251-323					
1/2	251-367	251-367S		251-367					
9/16	251-429	251-429S							
5/8	251-480	251-480S							
1/8 PIPE-SS	251-313	251-313S							
1/8 PIPE-LS	251-437	251-437S							

Collet Chucks are shown on Pages 22 - 29

RD/ER



## RD/ER 32 COLLET SYSTEM



A = 33 mm. (1.23 in.)  
B = 40 mm. (1.58 in.)

Collapse per collet: 1 mm. (0.039 in.)  
Capacity per set: 2 - 20 mm. (0.079 - 0.787 in.)  
Precision per DIN 6499  
Maximum tightening torque: 80 ft./lbs.

## INTERNAL &amp; EXTERNAL COOLANT COLLETS



IK Internal Coolant Collet

Sealed for coolant-through applications, with pressure resistance tested to 1000 p.s.i. Sealed collets are high precision exact size collets and have no collapse range.

Internal Coolant Collets (IK): To direct fluid through the cutting tool.



EK External Coolant Collet

External Coolant Collets (EK): To direct fluid through the collet to the cutting tool tip, allowing the use of standard cutting tools in coolant through applications or to route fluid through the tool and around the tool for higher coolant volume.

## ND COLLETS



Nominal size collets manufactured per DIN 6499 Form A are available in inch and metric sizes by special order, offering maximum 0.0003 in. TIR.

## TAPPING COLLETS

## RTS Rigid Tapping Collets with Square Drive

For synchronous tapping operations using any RD/ER collet chuck. Collet bore is exact tool diameter, with square drive, for accuracy and rigidity.

Available sealed for coolant-through applications, as well as in DIN and JIS standard metric sizes.



## RDT Quick-Change Tapping Collets with Axial Compensation

For use with any RD/ER collet chuck, these tapping collets help prevent tap breakage on machines requiring axial compensation. Friction-free ball-bearing drive. Metric sizes available upon request.





RD/ER 32 COLLETS

		METRIC SIZES			INCH SIZES	
		STANDARD PRECISION	HIGH PRECISION	0.5 mm. INCREMENTS	STANDARD PRECISION	
Clamping Range (mm.)	(in.)	Part No.	Part No.	Part No.	Dia. (in.)	Part No.
3-2	0.118-0.079	320-001	320-901		3/32	320-501
3.5-2.5	0.138-0.098			320-103	1/8	320-502
4-3	0.157-0.118	320-002	320-902		5/32	320-503
4.5-3.5	0.177-0.138			320-104	3/16	320-504
5-4	0.197-0.157	320-003	320-903		7/32	320-505
5.5-4.5	0.217-0.177			320-105	1/4	320-506
6-5	0.236-0.197	320-004	320-904		9/32	320-507
6.5-5.5	0.256-0.217			320-106	5/16	320-508
7-6	0.276-0.236	320-005	320-905		11/32	320-509
7.5-6.5	0.296-0.256			320-107	3/8	320-510
8-7	0.315-0.276	320-006	320-906		13/32	320-511
8.5-7.5	0.335-0.296			320-108	7/16	320-512
9-8	0.354-0.315	320-007	320-907		15/32	320-513
9.5-8.5	0.374-0.335			320-109	1/2	320-514
10-9	0.394-0.354	320-008	320-908		17/32	320-515
10.5-9.5	0.414-0.374			320-110	9/16	320-516
11-10	0.433-0.394	320-009	320-909		19/32	320-517
11.5-10.5	0.453-0.414			320-111	5/8	320-518
12-11	0.472-0.433	320-010	320-910		21/32	320-519
12.5-11.5	0.493-0.453			320-112	11/16	320-520
13-12	0.512-0.472	320-011	320-911		23/32	320-521
13.5-12.5	0.532-0.493			320-113	3/4	320-522
14-13	0.551-0.512	320-012	320-912		3/32 - 3/4	
14.5-13.5	0.571-0.532			320-114	22 Pc. Set	320-523
15-14	0.591-0.551	320-013	320-913		1/4 - 3/4	
15.5-14.5	0.611-0.571			320-115	17 Pc. Set	320-525
16-15	0.630-0.591	320-014	320-914			
16.5-15.5	0.650-0.611			320-116		
17-16	0.669-0.630	320-015	320-915			
17.5-16.5	0.690-0.650			320-117		
18-17	0.709-0.669	320-016	320-916			
18.5-17.5	0.729-0.690			320-118		
19-18	0.748-0.709	320-017	320-917			
19.5-18.5	0.768-0.729			320-119		
20-19	0.787-0.748	320-018	320-918			
2 - 20mm	18 Pc. Set	320-019	320-919			
6 - 20mm	14 Pc. Set	320-020				

RD/ER 32 Internal and External Coolant Collets Listed on Page 14.

RD/ER

RD/ER 32 TAPPING COLLETS

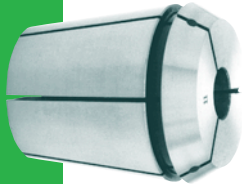
ANSI Tap Size	RTS RIGID TAPPING COLLETS	RTS INTERNAL COOLANT RIGID TAPPING COLLETS	RDT AXIAL COMPENSATION TAPPING COLLETS
	Part No.	Part No.	Part No.
0-6	321-141	321-141S	320-141
8	321-168	321-168S	320-168
10	321-194	321-194S	320-194
12	321-220	321-220S	320-220
1/4	321-255	321-255S	320-255
5/16	321-318	321-318S	320-318
3/8	321-381	321-381S	320-381
7/16	321-323	321-323S	320-323
1/2	321-367	321-367S	320-367
9/16	321-429	321-429S	320-429
5/8	321-480	321-480S	
11/16	321-542	321-542S	
3/4	321-590	321-590S	
13/16	321-652	321-652S	
1/8 PIPE-SS	321-313	321-313S	
1/8 PIPE-LS	321-437	321-437S	320-437
1/4 PIPE	321-562	321-562S	

Collet Chucks are shown on Pages Pages 22 - 29



RD/ER 32 INTERNAL & EXTERNAL COOLANT COLLETS

RD/ER



IK Internal Coolant Collet

Sealed for coolant-through applications, with pressure resistance tested to 1000 p.s.i. Sealed collets are high precision exact size collets and have no collapse range.

Internal Coolant Collets (IK): To direct fluid through the cutting tool.



EK External Coolant Collet

External Coolant Collets (EK): To direct fluid through the collet to the cutting tool tip, allowing the use of standard cutting tools in coolant through applications or to route fluid through the tool and around the tool for higher coolant volume.

INTERNAL COOLANT COLLETS			
METRIC		INCH	
Dia. (mm.)	Part No.	Dia. (in.)	Part No.
4	320IK04	1/8	320IK501
5	320IK05	5/32	320IK502
6	320IK06	3/16	320IK503
7	320IK07	7/32	320IK504
8	320IK08	1/4	320IK505
9	320IK09	9/32	320IK506
10	320IK10	5/16	320IK507
11	320IK11	11/32	320IK508
12	320IK12	3/8	320IK509
13	320IK13	13/32	320IK510
14	320IK14	7/16	320IK511
15	320IK15	15/32	320IK512
16	320IK16	1/2	320IK513
17	320IK17	17/32	320IK514
18	320IK18	9/16	320IK515
19	320IK19	19/32	320IK516
20	320IK20	5/8	320IK517
		21/32	320IK518
		11/16	320IK519
		23/32	320IK520
		3/4	320IK521

EXTERNAL COOLANT COLLETS			
METRIC		INCH	
Dia. (mm.)	Part No.	Dia. (in.)	Part No.
4	320EK04	1/8	320EK501
5	320EK05	5/32	320EK502
6	320EK06	3/16	320EK503
7	320EK07	7/32	320EK504
8	320EK08	1/4	320EK505
9	320EK09	9/32	320EK506
10	320EK10	5/16	320EK507
11	320EK11	11/32	320EK508
12	320EK12	3/8	320EK509
13	320EK13	13/32	320EK510
14	320EK14	7/16	320EK511
15	320EK15	15/32	320EK512
16	320EK16	1/2	320EK513
17	320EK17	17/32	320EK514
18	320EK18	9/16	320EK515
19	320EK19	19/32	320EK516
20	320EK20	5/8	320EK517
		21/32	320EK518
		11/16	320EK519
		23/32	320EK520
		3/4	320EK521

Collet Chucks are shown on Pages 22- 29

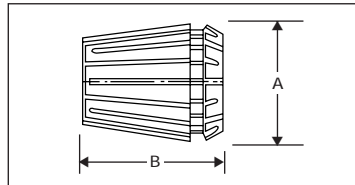
NOTES

RD/ER

**CENTAUR**  
PRECISION TOOLS INC.  
An ISO 9001:2000 Certified Company



## RD/ER 40 COLLET SYSTEM



A = 41 mm. (1.61 in.)  
B = 46 mm. (1.81 in.)

Collapse per collet: 1 mm. (0.039 in.)  
Capacity per set: 3 - 26 mm. (0.018 - 1.024 in.)  
Precision per DIN 6499  
Maximum tightening torque: 90 ft./lbs.

## INTERNAL &amp; EXTERNAL COOLANT COLLETS



IK Internal Coolant Collet

Sealed for coolant-through applications, with pressure resistance tested to 1000 p.s.i. Sealed collets are high precision exact size collets and have no collapse range.

Internal Coolant Collets (IK): To direct fluid through the cutting tool.



EK External Coolant Collet

External Coolant Collets (EK): To direct fluid through the collet to the cutting tool tip, allowing the use of standard cutting tools in coolant through applications or to route fluid through the tool and around the tool for higher coolant volume.

## ND COLLETS



Nominal size collets manufactured per DIN 6499 Form A are available in inch and metric sizes by special order, offering maximum 0.0003 in. TIR.

## TAPPING COLLETS

## RTS Rigid Tapping Collets with Square Drive



For synchronous tapping operations using any RD/ER collet chuck. Collet bore is exact tool diameter, with square drive, for accuracy and rigidity.

Available sealed for coolant-through applications, as well as in DIN and JIS standard metric sizes.

## RDT Quick-Change Tapping Collets with Axial Compensation



For use with any RD/ER collet chuck, these tapping collets help prevent tap breakage on machines requiring axial compensation. Friction-free ball-bearing drive. Metric sizes available upon request.



RD/ER 40 COLLETS

Clamping Range (mm.) (in.)		METRIC SIZES		INCH SIZES	
		STANDARD PRECISION	HIGH PRECISION	STANDARD PRECISION	
Part No.	Part No.	Dia. (in.)	Part No.		
4-3	0.157-0.118	400-001	400-901	1/8	400-501
5-4	0.197-0.157	400-002	400-902	5/32	400-502
6-5	0.236-0.197	400-003	400-903	3/16	400-503
7-6	0.276-0.236	400-004	400-904	7/32	400-504
8-7	0.315-0.276	400-005	400-905	1/4	400-505
9-8	0.354-0.315	400-006	400-906	9/32	400-506
10-9	0.394-0.354	400-007	400-907	5/16	400-507
11-10	0.433-0.394	400-008	400-908	11/32	400-508
12-11	0.472-0.433	400-009	400-909	3/8	400-509
13-12	0.512-0.472	400-010	400-910	13/32	400-510
14-13	0.551-0.512	400-011	400-911	7/16	400-511
15-14	0.591-0.551	400-012	400-912	15/32	400-512
16-15	0.630-0.591	400-013	400-913	1/2	400-513
17-16	0.669-0.630	400-014	400-914	17/32	400-514
18-17	0.709-0.669	400-015	400-915	9/16	400-515
19-18	0.748-0.709	400-016	400-916	19/32	400-516
20-19	0.787-0.748	400-017	400-917	5/8	400-517
21-20	0.827-0.787	400-018	400-918	21/32	400-518
22-21	0.866-0.827	400-019	400-919	11/16	400-519
23-22	0.906-0.866	400-020	400-920	23/32	400-520
24-23	0.945-0.906	400-021	400-921	3/4	400-521
25-24	0.984-0.945	400-022	400-922	25/32	400-522
26-25	1.024-0.984	400-023	400-923	13/16	400-523
3 - 26mm 23 Pc. Set		400-024	400-924	27/32	400-524
9 - 26mm 17 Pc. Set		400-030		7/8	400-525
				29/32	400-526
				15/16	400-527
				31/32	400-528
				1	400-529
				1/8 - 1 in. 25 Pc. Set	400-530
				3/8 - 1 in. 21 Pc. Set	400-031

NOTE: High precision also available in inch sizes.

RD/ER 40 Internal and External Collets Listed on Page 18.

Collet Chucks are shown on Pages 22 - 29

RD/ER 40 TAPPING COLLETS

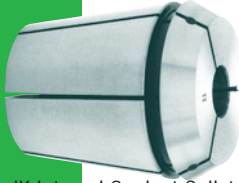
ANSI Tap Size	RTS RIGID TAPPING COLLETS			RTS INTERNAL COOLANT RIGID TAPPING COLLETS			RDT AXIAL COMPENSATION TAPPING COLLETS		
	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	
0-6	401-141		400-141	11/16	401-542	401-542S	400-542		
8	401-168		400-168	3/4	401-590	401-590S			
10	401-194		400-194	13/16	401-652	401-652S			
12	401-220		400-220	7/8	401-697	401-697S			
1/4	401-255	401-255S	400-255	15/16	401-760	401-760S			
5/16	401-318	401-318S	400-318	1	401-800	401-800S			
3/8	401-381	401-381S	400-381	1/8 PIPE-SS	401-313	401-313S			
7/16	401-323	401-323S	400-323	1/8 PIPE-LS	401-437	401-437S	400-437		
1/2	401-367	401-367S	400-367	1/4 PIPE	401-562	401-562S	400-562		
9/16	401-429	401-429S	400-429	3/8 PIPE	401-700	401-700S			
5/8	401-480	401-480S	400-480	1/2 PIPE	401-687	401-687S			

RD/ER



RD/ER

## RD/ER 40 INTERNAL &amp; EXTERNAL COOLANT COLLETS



IK Internal Coolant Collet

Sealed for coolant-through applications, with pressure resistance tested to 1000 p.s.i. Sealed collets are high precision exact size collets and have no collapse range.

Internal Coolant Collets (IK): To direct fluid through the cutting tool.



EK External Coolant Collet

External Coolant Collets (EK): To direct fluid through the collet to the cutting tool tip, allowing the use of standard cutting tools in coolant through applications or to route fluid through the tool and around the tool for higher coolant volume.

INTERNAL COOLANT COLLETS			
METRIC		INCH	
Dia. (mm.)	Part No.	Dia. (in.)	Part No.
4	400IK04	1/8	400IK501
5	400IK05	5/32	400IK502
6	400IK06	3/16	400IK503
7	400IK07	7/32	400IK504
8	400IK08	1/4	400IK505
9	400IK09	9/32	400IK506
10	400IK10	5/16	400IK507
11	400IK11	11/32	400IK508
12	400IK12	3/8	400IK509
13	400IK13	13/32	400IK510
14	400IK14	7/16	400IK511
15	400IK15	15/32	400IK512
16	400IK16	1/2	400IK513
17	400IK17	17/32	400IK514
18	400IK18	9/16	400IK515
19	400IK19	19/32	400IK516
20	400IK20	5/8	400IK517
21	400IK21	21/32	400IK518
22	400IK22	11/16	400IK519
23	400IK23	23/32	400IK520
24	400IK24	3/4	400IK521
25	400IK25	25/32	400IK522
26	400IK26	13/16	400IK523
		27/32	400IK524
		7/8	400IK525
		29/32	400IK526
		15/16	400IK527
		31/32	400IK528
		1	400IK529

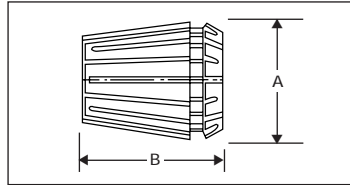
EXTERNAL COOLANT COLLETS			
METRIC		INCH	
Dia. (mm.)	Part No.	Dia. (in.)	Part No.
4	400EK04	1/8	400EK501
5	400EK05	5/32	400EK502
6	400EK06	3/16	400EK503
7	400EK07	7/32	400EK504
8	400EK08	1/4	400EK505
9	400EK09	9/32	400EK506
10	400EK10	5/16	400EK507
11	400EK11	11/32	400EK508
12	400EK12	3/8	400EK509
13	400EK13	13/32	400EK510
14	400EK14	7/16	400EK511
15	400EK15	15/32	400EK512
16	400EK16	1/2	400EK513
17	400EK17	17/32	400EK514
18	400EK18	9/16	400EK515
19	400EK19	19/32	400EK516
20	400EK20	5/8	400EK517
21	400EK21	21/32	400EK518
22	400EK22	11/16	400EK519
23	400EK23	23/32	400EK520
24	400EK24	3/4	400EK521
25	400EK25	25/32	400EK522
26	400EK26	13/16	400EK523
		27/32	400EK524
		7/8	400EK525
		29/32	400EK526
		15/16	400EK527
		31/32	400EK528
		1	400EK529

Collet Chucks are shown  
on Pages 22 - 29





RD/ER 50 COLLET SYSTEM



A = 52 mm. (2.05 in.)  
B = 60 mm. (2.36 in.)

Collapse per collet: 2 mm. (0.079 in.)  
Capacity per set: 10 - 24 mm. (0.394 - 1.339 in.)  
Precision per DIN 6499



RD/ER

RD/ER 50 COLLETS

Clamping Range (mm.) (in.)		METRIC SIZES		INCH SIZES		INCH SIZES	
		STANDARD PRECISION	HIGH PRECISION	STANDARD PRECISION	TAPPING		
Part No.	Part No.	Size Inch	Part No.	Size Inch	Part No.		
12-10	0.472-0.394	500-001	500-901	1/4	500-505	1/4	501-255
14-12	0.551-0.472	500-002	500-902	5/16	500-507	5/16	501-318
16-14	0.630-0.551	500-003	500-903	3/8	500-511	3/8	501-381
18-16	0.709-0.630	500-004	500-904	7/16	500-004	7/16	501-323
20-18	0.787-0.709	500-005	500-905	1/2	500-513	1/2	501-367
22-20	0.866-0.787	500-006	500-906	9/16	500-515	9/16	501-429
24-22	0.945-0.866	500-007	500-907	5/8	500-517	5/8	501-480
26-24	1.024-0.945	500-008	500-908	11/16	500-519	11/16	501-542
28-26	1.102-1.024	500-009	500-909	3/4	500-521	3/4	501-590
30-28	1.181-1.102	500-010	500-910	13/16	500-523	13/16	501-652
32-30	1.260-1.181	500-011	500-911	7/8	500-525	7/8	501-697
34-32	1.339-1.260	500-012	500-912	15/16	500-527	15/16	501-760
12 Pc. Set		500-013	500-913	1"	500-529	1	501-800
				1-1/16	500-531	1-1/8	501-860
				1-1/8	500-533	1-1/4	501-1021
				1-3/16	500-535		
				1-1/4	500-537		
				1-5/16	500-539		
						Pipe Tap Sizes	
						1/8 SS	501-313
						1/8 LS	501-437
						1/4 P	501-562
						3/8 P	501-700
						1/2 P	501-687
						3/4 P	501-906
						1" P	501-1125

NOTE: High precision inch size, coolant and coolant tapping collets are available upon request.

Collet Chucks are shown on Pages 22 - 29

## RTX COLLETS

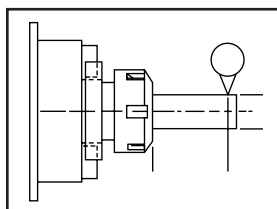
**FEATURES:**

*FOR IMPROVED ACCURACY IN ER COLLET CHUCKS  
OVER THE ENTIRE CLAMPING RANGE*

**FEATURES:**

- *Four times more accurate than conventional RD/ER collet systems*
- *Improved tool life, increased feed rates, and improved workpiece finish and accuracy*
- *Use standard RD/ER collet chucks with RTX clamping nut*
- *RTX collet nut provides better balance for high-speed machining, with easy collet insertion and extraction*
- *True single-angle design for powerful tool holding strength*

Collet Series	Clamping Range D		Maximum TIR
	Minimum	Maximum	
RTX16	0.019	0.394	0.00019
RTX20	0.039	0.512	0.00019
RTX25	0.039	0.630	0.00019
RTX32	0.079	0.787	0.00019
RTX40	0.118	1.024	0.00019



RTX COLLETS

METRIC SIZES					
Clamp. Range	RTX16 Part No.	RTX20 Part No.	RTX25 Part No.	RTX32 Part No.	RTX40 Part No.
1-0.5	162-001				
2-1	162-002	202-001	252-001		
3-2	162-003	202-002	252-002	322-001	
4-3	162-004	202-003	252-003	322-002	402-001
5-4	162-005	202-004	252-004	322-003	402-002
6-5	162-006	202-005	252-005	322-004	402-003
7-6	162-007	202-006	252-006	322-005	402-004
8-7	162-008	202-007	252-007	322-006	402-005
9-8	162-009	202-008	252-008	322-007	402-006
10-9	162-010	202-009	252-009	322-008	402-007
11-10		202-010	252-010	322-009	402-008
12-11		202-011	252-011	322-010	402-009
13-12		202-012	252-012	322-011	402-010
14-13			252-013	322-012	402-011
15-14			252-014	322-013	402-012
16-15			252-015	322-014	402-013
17-16				322-015	402-014
18-17				322-016	402-015
19-18				322-017	402-016
20-19				322-018	402-017
21-20					402-018
22-21					402-019
23-22					402-020
24-23					402-021
25-24					402-022
26-25					403-023

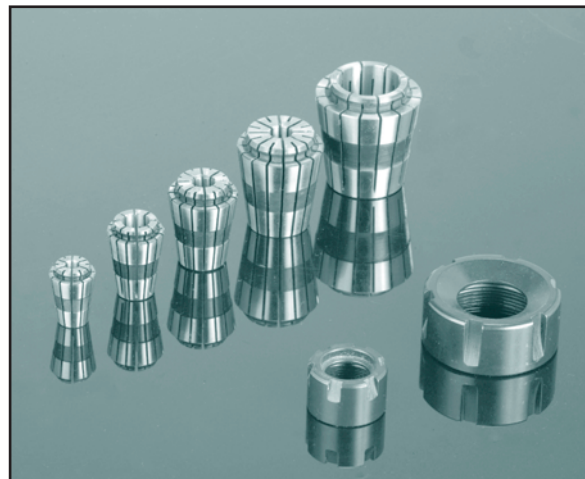
INCH SIZES					
Diameter.	RTX16 Part No.	RTX20 Part No.	RTX25 Part No.	RTX32 Part No.	RTX40 Part No.
1/16	162-501	202-501	252-501		
3/32	162-502	202-502	252-502	322-501	
1/8	162-503	202-503	252-503	322-502	402-501
5/32	162-504	202-504	252-504	322-503	402-502
3/16	162-505	202-505	252-505	322-504	402-503
7/32	162-506	202-506	252-506	322-505	402-504
1/4	162-507	202-507	252-507	322-506	402-505
9/32	162-508	202-508	252-508	322-507	402-506
5/16	162-509	202-509	252-509	322-508	402-507
11/32	162-510	202-510	252-510	322-509	402-508
3/8	162-511	202-511	252-511	322-510	402-509
13/32	162-512	202-512	252-512	322-511	402-510
7/16		202-513	252-513	322-512	402-511
15/32		202-514	252-514	322-513	402-512
1/2		202-515	252-515	322-514	402-513
17/32			252-516	322-515	402-514
9/16			252-517	322-516	402-515
19/32			252-518	322-517	402-516
5/8			252-519	322-518	402-517
21/32				322-519	402-518
11/16				322-520	402-519
23/32				322-521	402-520
3/4				322-522	402-521
25/32					402-522
13/16					403-523
27/32					402-524
7/8					402-525
29/32					402-526
15/16					402-527
31/32					402-528
1					402-529

RTX COLLET SETS

Collet Series	Description	Part No.
RTX16	10 Pc. Metric Set	162-011
RTX16	12 Pc. Inch Set	162-513
RTX20	12 Pc. Metric Set	202-013
RTX20	15 Pc. Inch Set	202-516
RTX25	15 Pc. Metric Set	252-016
RTX25	19 Pc. Inch Set	252-520
RXT32	18 Pc. Metric Set	322-019
RTX32	22 Pc. Inch Set	322-523
RTX40	23 Pc. Metric Set	402-024
RTX40	29 Pc. Inch Set	402-530

RTX COLLET NUTS

Collet Series	Part No.
RTX16	302-116
RTX20	302-220
RTX25	302-225
RTX32	302-232
RTX40	302-240



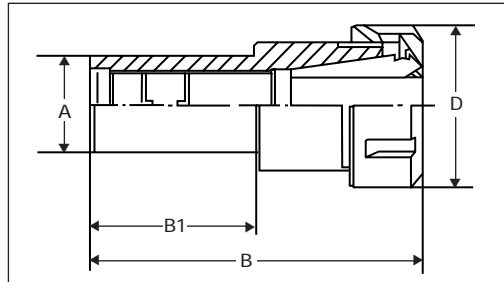
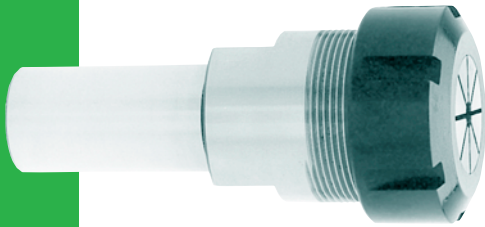
Collet Chucks are shown on Pages 22 - 29

RTX



RD/ER

## STRAIGHT-SHANK RD/ER COLLET CHUCKS (with Step)

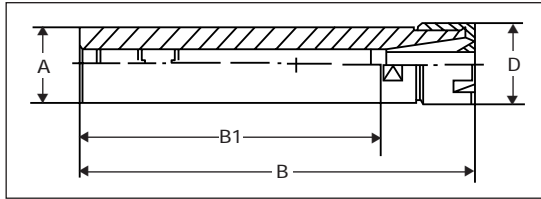


Wrenches are sold separately. See page 30

	Part No.	A		B		B1		D		Nut Style/ Part No.	Wrench
		(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)		
RD 11	71145	7	0.28	58	2.28	45	1.77	16	0.63	M-30011	22011
	81156	8	0.31	70	2.76	56	2.20	16	0.63	M-30011	22011
	141154		1/4	58	2.28	45	1.77	16	0.63	M-30011	22011
RD 16	101644	10	0.39	70	2.76	44	1.73	22	0.87	M-30016	22016
	101660	10	0.39	86	3.39	60	2.36	22	0.87	M-30016	22016
	101680	10	0.39	105	4.72	80	3.15	22	0.87	M-30016	22016
	121680	12	0.47	105	4.13	80	3.15	22	0.87	M-30016	22016
	121681	12	0.47	105	4.13	80	3.15	28	1.10	H-30116	22325
	141630	14	0.55	55	2.17	30	1.18	28	1.10	H-30116	22325
	141660	14	0.55	97	3.82	60	2.36	28	1.10	H-30116	22325
	161660	16	0.63	90	3.55	60	2.36	28	1.10	H-30116	22325
	381644		3/8	70	2.76	44	1.73	22	0.87	M-30016	22016
	121654		1/2	168	6.61	154	6.06	22	0.87	M-30016	22016
	581660		5/8	85	3.35	60	2.36	28	1.10	H-30116	22325
	581680		5/8	105	4.13	80	3.15	28	1.10	H-30116	22325
	341650		3/4	79	3.11	50	1.97	28	1.10	H-30116	22325
	341680		3/4	110	4.33	80	3.15	28	1.10	H-30116	22325
341600		3/4	125	4.92	100	3.94	28	1.10	H-30116	22325	
1141600		1-1/4	85	3.35	60	2.36	28	1.10	H-30116	22325	
RD 20	122000	12	0.47	142	5.60	100	3.94	28	1.10	M-30020	22020
	152000	15	0.59	142	5.60	100	3.94	28	1.10	M-30020	22020
	162000	16	0.63	142	5.60	100	3.94	28	1.10	M-30020	22020
	203020	20	0.79	72	2.17	30	1.18	34	1.34	H-30120	22330
	582000		5/8	142	5.60	100	3.94	28	1.10	H-30120	22330
RD 25	202550	20	0.79	85	3.35	50	1.97	42	1.65	E-30125	22125
	202500	20	0.79	135	5.31	100	3.94	42	1.65	E-30125	22125
	252550	25	0.98	85	3.35	50	1.97	42	1.65	E-30125	22125
	252500	25	0.98	135	5.31	100	3.94	42	1.65	E-30125	22125
	582550		5/8	85	3.35	50	1.97	42	1.65	E-30125	22125
	342550		3/4	85	3.35	50	1.97	42	1.65	E-30125	22125
	342500		3/4	135	5.31	100	3.94	42	1.65	E-30125	22125
RD 32	203235	20	0.79	83	3.27	35	1.38	50	1.97	E-30132	22132
	203250	20	0.79	98	3.85	50	1.97	50	1.97	E-30132	22132
	253250	25	0.98	95	3.74	50	1.97	50	1.97	E-30132	22132
	1003250		1	95	3.74	50	1.97	50	1.97	E-30132	22132
	1143250		1-1/4	98	3.85	50	1.97	50	1.97	E-30132	22132
	1143260		1-1/4	108	4.25	60	2.36	50	1.97	E-30132	22132
RD 40	254050	25	0.98	95	3.74	50	1.97	63	2.48	E-30140	22140
	1004050		1	95	3.74	50	1.97	63	2.48	E-30140	22140
	10040238		1	106	4.17	61	2.38	63	2.48	E-30140	22140
	1144060		1-1/4	105	4.13	60	2.36	63	2.48	E-30140	22140



STRAIGHT-SHANK RD/ER COLLET CHUCKS (Extension Style)



RD/ER

NOTE: Wrenches are sold separately. See page 30

	Part No.	A		B		B1		D		Nut Style/ Part No.	Wrench	
		(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)			
RD 8	80856	8	0.31	70	2.76	56	2.20	12	0.47	M-30008	22008	
	80880	8	0.31	100	3.94	80	3.15	12	0.47	M-30008	22008	
	1008856	10	0.39	70	2.76	56	2.20	12	0.47	M-30008	22008	
	10080	10	0.39	100	3.94	80	3.15	12	0.47	M-30008	22008	
	12080	12	0.47	95	3.74	80	3.15	12	0.47	M-30008	22008	
	50080		1/2	95	3.74	80	3.15	12	0.47	M-30008	22008	
RD 11	201180	20	0.79	100	3.94	80	3.15	16	0.63	M-30011	22011	
	201115	20	0.79	145	5.71	115	4.53	19	0.75	H-30111	22317	
	221100*	22	0.88	130	5.12	100	3.94	19	0.75	H-30111	22317	
	121154		1/2	168	6.61	154	6.06	16	0.63	M-30011	22011	
	121180		1/2	100	3.94	80	3.15	16	0.63	M-30011	22011	
	121181		1/2	100	3.94	80	3.15	19	0.75	H-30111	22317	
	5811140		5/8	155	6.10	140	5.51	19	0.75	H-30111	22317	
	5811200		5/8	64	2.50	51	2.00	16	0.63	M-30011	22011	
	5811300		5/8	90	3.51	76	3.00	16	0.63	M-30011	22011	
	581154		5/8	168	6.61	154	6.06	16	0.63	M-30011	22011	
	581155		5/8	168	6.61	154	6.06	19	0.75	H-30111	22317	
	341185†		3/4	100	3.94	85	3.35	16	0.63	M-30011	22011	
	3420011†		3/4	51	2.00	25	1.00	16	0.63	M-30011	22011	
	34285011†		3/4	72	2.85	49	1.92	16	0.63	M-30011	22011	
		344011		3/4	102	4.00	89	3.50	16	0.63	M-30011	22011
		1001180		1	93	3.66	80	3.15	16	0.63	M-30011	22011
RD 12	141225	14	0.55	38	1.50	25	0.98	19	0.75	H-30112	22317	
	201280	20	0.79	93	3.66	80	3.15	19	0.75	H-30112	22317	
	10012140		1	153	6.02	140	5.51	19	0.75	H-30112	22317	
RD 16	441660	14	0.55	85	3.35	60	2.36	28	1.10	H-30116	22325	
	201630	20	0.79	55	2.17	30	1.18	28	1.10	H-30116	22325	
	201650	20	0.79	79	3.10	50	1.97	28	1.10	H-30116	22325	
	201600	20	0.79	125	4.92	100	3.94	28	1.10	H-30116	22325	
	201601	20	0.79	135	5.31	100	3.94	22	0.87	M-30016	22016	
	221680*	22	0.88	103	4.06	80	3.15	28	1.10	H-30116	22325	
	221634*	22	0.88	160	6.30	134	5.28	28	1.10	H-30116	22325	
	581681		5/8	105	4.13	80	3.15	22	0.87	M-30016	22016	
	581614		5/8	157	6.18	140	5.51	28	1.10	H-30116	22325	
	581654		5/8	179	7.04	154	6.06	22	0.87	M-30016	22016	
	341670†		3/4	116	4.60	70	2.76	22	0.87	M-30016	22016	
	341680		3/4	103	4.05	80	3.15	28	1.10	H-30116	22325	
	341681		3/4	115	4.52	80	3.15	22	0.87	M-30016	22016	
	341690†		3/4	136	5.35	90	3.54	22	0.87	M-30016	22016	
	341610		3/4	135	5.31	100	3.94	22	0.87	M-30016	22016	
	341634		3/4	160	6.40	134	5.28	22	0.87	M-30016	22016	
	341654		3/4	189	7.44	154	6.06	22	0.87	M-30016	22016	
	101600		1	134	5.28	100	3.94	28	1.10	H-30116	22325	
	101614		1	157	6.18	140	5.51	28	1.10	H-30116	22325	
RD 20	202000	20	0.79	142	5.60	100	3.94	28	1.10	M-30020	22020	
	202100	20	0.79	142	5.60	100	3.94	34	1.34	H-30120	22330	
	2220100*	22	0.88	140	5.52	100	3.94	34	1.34	H-30120	22330	
	2220120*	22	0.88	160	6.30	120	4.72	34	1.34	H-30120	22330	
	222080*	22	0.88	120	4.72	80	3.15	34	1.34	H-30120	22330	
	3420100		3/4	142	5.60	100	3.94	28	1.10	M-30020	22020	
	1002034		1	173	6.81	134	5.28	28	1.10	M-30020	22020	
	1002034H		1	173	6.81	134	5.28	34	1.34	H-30120	22330	
RD 25	252500	25	0.98	135	5.31	100	3.94	42	1.65	E-30125	22125	
	1002550		1	85	3.35	50	1.97	42	1.65	E-30125	22125	
	1002500		1	135	5.31	100	3.94	42	1.65	E-30125	22125	
	1002550M		1	85	3.35	50	1.97	35	1.38	M-30025	22025	
	1002500M		1	135	5.31	100	3.94	35	1.38	M-30025	22025	

\*Holders for Star machines.  
†Double-End Style



## MASTER TOOLING SETS

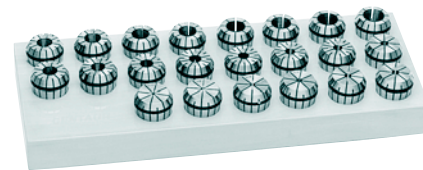


Part No.	Collet Type	No. Of Collets	Range (mm.) (In.)		Chuck	Nut	Wrench
MSO 08080	RD 8	9	0.5 - 5	0.019 - 0.177	Cyl. 8 X 80	RD 8 M	E 8 M
MSO 11154	RD 11	13	0.5 - 7	0.019 - 0.276	Cyl. 5/8 X 154	RD 11 M	E 11 M
MSO 11254	RD 11	13	0.5 - 7	0.019 - 0.276	Cyl. 1/2 X 154	RD 11 M	E 11 M
MSO 16140	RD 16	10	0.5 - 10	0.019 - 0.394	Cyl. 1 X 140	RD 16 H	GS 25
MSO 16134	RD 16	10	0.5 - 10	0.019 - 0.394	Cyl. 3/4 X 134	RD 16 M	E 16 M
MSO 160C40	RD 16	10	0.5 - 10	0.019 - 0.394	CAT 40	RD 16 H	GS 25
MSO 160B40	RD 16	10	0.5 - 10	0.019 - 0.394	BT 40	RD 16 H	GS 25
MSO 20134	RD 20	12	1 - 13	0.039 - 0.512	Cyl. 1 X 134	RD 20 M	E 20 M
MSO 200C40	RD 20	12	1 - 13	0.039 - 0.512	CAT 40	RD 20 H	GS 30
MSO 25100	RD 25	15	1 - 16	0.039 - 0.630	Cyl. 1 X 100	RD 25 E	E 25
MSO 250C40	RD 25	15	1 - 16	0.039 - 0.630	CAT 40	RD 25 E	E 25
MSO 32050	RD 32	18	2 - 20	0.079 - 0.787	Cyl. 1 X 50	RD 32 E	E 32
MSO 32060	RD 32	18	2 - 20	0.079 - 0.787	Cyl. 1-1/4 X 60	RD 32 E	E 32
MSO 32008	RD 32	18	2 - 20	0.079 - 0.787	R8	RD 32 E	E 32
MSO 320C40	RD 32	18	2 - 20	0.079 - 0.787	CAT 40	RD 32 E	E 32
MSO 320C50	RD 32	18	2 - 20	0.079 - 0.787	CAT 50	RD 32 E	E 32
MSO 320B40	RD 32	18	2 - 20	0.079 - 0.787	BT 40	RD 32 E	E 32
MSO 320B50	RD 32	18	2 - 20	0.079 - 0.787	BT 50	RD 32 E	E 32
MSO 40050	RD 40	23	3 - 26	0.118 - 1.024	Cyl. 1 X 50	RD 40 E	E 40
MSO 40008	RD 40	23	3 - 26	0.118 - 1.024	R8	RD 40 E	E 40
MSO 400C40	RD 40	23	3 - 26	0.118 - 1.024	CAT 40	RD 40 E	E 40
MSO 400C50	RD 40	23	3 - 26	0.118 - 1.024	CAT 50	RD 40 E	E 40
MSO 400B40	RD 40	23	3 - 26	0.118 - 1.024	BT 40	RD 40 E	E 40
MSO 400B50	RD 40	23	3 - 26	0.118 - 1.024	BT 50	RD 40 E	E 40

## WOODEN TOOL TRAYS

Part No.	Description	Collet Capacity
TRYRD8	RD 8 Metric	10
TRYRD11	RD 11 Metric	14
TRYRD16	RD 16 Inch	10
TRYRD16I	RD 16 Inch	12
TRYRD20	RD 20 Metric	12
TRYRD20I	RD 20 Inch	16
TRYRD25	RD 25 Metric	15
TRYRD25I	RD 25 Inch	19
TRYRD32	RD 32 Metric	18
TRYRD32I	RD 32 Inch	22
TRYRD40	RD 40 Metric	23

All listed items included in fitted wooden box.



## WOODEN TOOL BOXES

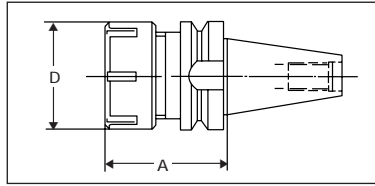
Part No.	Description	Collet Capacity
WBXRD8	RD 8 Box	9
WBXRD11	RD 11 Box	13
WBXRD16	RD 16 Box	10
WBXRD20	RD 20 Box	12
WBXRD25	RD 25 Box	15
WBXRD32	RD 32 Box	18
WBXRD40	RD 40 Box	23



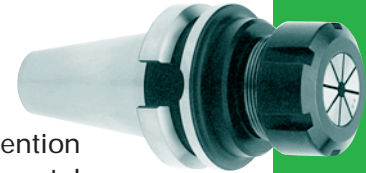


BT RD/ER COLLET CHUCKS

STANDARD LENGTH



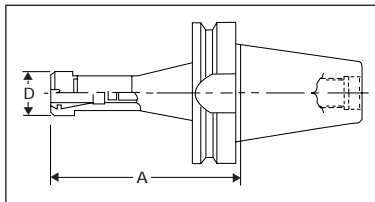
Wrenches and Retention knobs are sold separately. See page 30



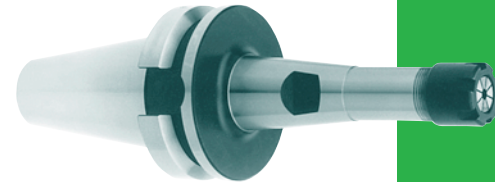
RD/ER

	Part No.	Taper	A		D		Ret. Knob Threading	Nut Style/Part No.	Wrench
			(mm.)	(in.)	(mm.)	(in.)			
RD 16	1614016	BT 30	70	2.76	22	0.87	M12	H-30116	22325
	1624016	BT 35	70	2.76	28	1.10	M12	H-30116	22325
	1634800	BT 40	70	2.76	28	1.10	M16	H-30116	22325
RD 20	1614020	BT 30	70	2.76	34	1.34	M12	H-30120	22330
	1624020	BT 35	70	2.76	34	1.34	M12	H-30120	22330
	1634801	BT 40	70	2.76	34	1.34	M16	H-30120	22330
RD 25	1614025	BT 30	60	2.36	42	1.65	M12	E-30125	22125
	1624025	BT 35	60	2.36	42	1.65	M12	E-30125	22125
	1634025	BT 40	70	2.76	42	1.65	M16	E-30125	22125
RD 32	1614532	BT 30	70	2.76	50	1.97	M12	E-30132	22132
	1624032	BT 35	70	2.76	50	1.97	M12	E-30132	22132
	1634802	BT 40	70	2.76	50	1.97	M16	E-30132	22132
RD 40	1634803	BT 40	80	3.15	63	2.48	M16	E-30140	22140
	1644851	BT 45	80	3.15	63	2.48	M20	E-30140	22140
	1654804	BT 50	80	3.15	63	2.48	M24	E-30140	22140
RD 50	1644852	BT 45	80	3.15	78	3.07	M20	E-30150	22150
	1654852	BT 50	80	3.15	78	3.07	M24	E-30150	22150

EXTENDED LENGTH



Wrenches and Retention knobs are sold separately. See page 30



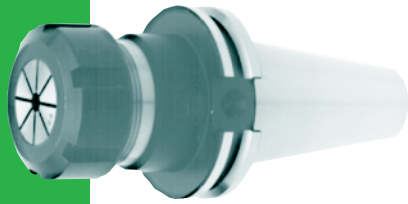
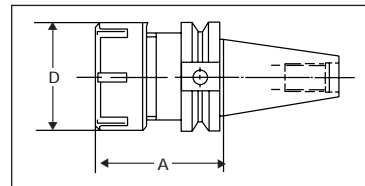
	Part No.	Taper	A		D		Ret. Knob Threading	Nut Style/Part No.	Wrench
			(mm.)	(in.)	(mm.)	(in.)			
RD 16	1614516	BT 30	120	4.73	22	0.87	M12	M-30016	22016
	1624516	BT 35	120	4.73	22	0.87	M12	M-30016	22016
	1634516	BT 40	125	4.93	22	0.87	M16	M-30016	22016
	1644516	BT 45	125	4.93	22	0.87	M20	M-30016	22016
	1654516	BT 50	135	5.32	22	0.87	M24	M-30016	22016
RD 20	1624520	BT 35	135	5.32	28	1.10	M12	M-30020	22020
	1634520	BT 40	135	5.32	28	1.10	M16	M-30020	22020
	1654520	BT 50	135	5.32	28	1.10	M24	M-30020	22020
RD 25	1634425	BT 40	135	2.76	28	1.10	M12	M-30025	22025
	1634525	BT 40	150	5.91	35	1.38	M16	M-30025	22025
RD 32	1624132	BT 35	100	3.94	50	1.97	M12	E-30132	22132
	1634810	BT 40	100	3.94	50	1.97	M16	E-30132	22132
RD 50	1654805	BT 50	100	3.94	78	3.07	M24	E-30150	22150

Balanced to 22,000 RPM upon request.

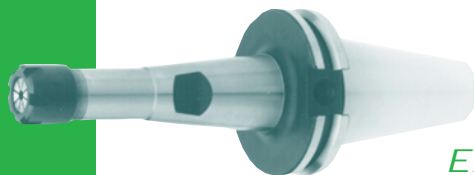
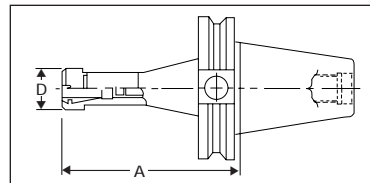


RD/ER

## CAT (V-Flange) RD/ER COLLET CHUCKS

STANDARD  
LENGTHWrenches and  
retention knobs are sold  
separately. See page 30

	Part No.	Taper	A		D		Ret. Knob Threading	Nut Style/ Part No.	Wrench
			(mm.)	(in.)	(mm.)	(in.)			
RD 11	C40RD11	CAT 40	76	3.00	16	0.63	5/8-11	M-30011	22011
RD 16	654016	CAT 40	70	2.76	28	1.10	5/8-11	H-30116	22325
	654016M	CAT 40	70	2.76	22	0.87	5/8-11	M-30016	22325
	C40RD16	CAT 40	64	2.50	32	1.36	5/8-11	E-30126	22116
	C50RD16	CAT 50	102	4.00	32	1.36	1-8	E-30126	22116
RD 20	654020	CAT 40	70	2.76	34	1.34	5/8-11	H-30120	22330
	C40RD20	CAT 40	76	3.00	35	1.38	5/8-11	E-30127	22120
RD 25	654025	CAT 40	70	2.76	42	1.65	5/8-11	E-30125	22125
	C40RD25	CAT 40	64	2.50	42	1.65	5/8-11	E-30125	22125
	664625	CAT 45	70	2.76	42	1.65	3/4-10	E-30125	22125
	674025	CAT 50	90	3.54	42	1.65	1-8	E-30125	22125
	C50RD25	CAT 50	102	4.00	42	1.65	1-8	E-30125	22125
RD 32	654802	CAT 40	70	2.76	50	1.97	5/8-11	E-30132	22132
	C40RD32	CAT 40	76	3.00	50	1.97	5/8-11	E-30132	22132
	674801	CAT 50	100	3.94	50	1.97	1-8	E-30132	22132
RD 40	654803	CAT 40	80	3.15	63	2.48	5/8-11	E-30140	22140
	674803	CAT 50	100	3.94	63	2.48	1-8	E-30140	22140
RD 50	664852	CAT 45	80	3.15	78	3.07	3/4-10	E-30150	22150

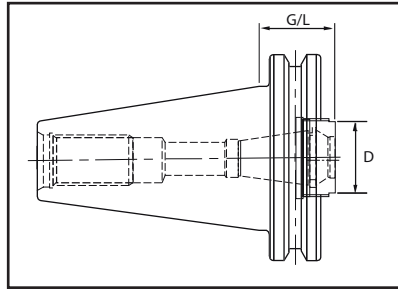
EXTENDED  
LENGTHWrenches and  
retention knobs are sold  
separately. See page 30

	Part No.	Taper	A		D		Ret. Knob Threading	Nut Style/ Part No.	Wrench
			(mm.)	(in.)	(mm.)	(in.)			
RD 16	624516	CAT 30	120	4.73	22	0.87	1/2-13	M-30016	22016
	654516	CAT 40	125	4.93	22	0.87	5/8-11	M-30016	22016
	C40RDE16	CAT 40	127	5.00	32	1.36	5/8-11	E-30126	22116
	664516	CAT 45	125	4.93	22	0.87	3/4-10	M-30016	22016
	674516	CAT 50	125	4.93	22	0.87	1-8	M-30016	22016
	C50RDEX16	CAT 50	178	7.00	32	1.36	1-8	E-30126	22016
RD 20	654520	CAT 40	135	5.32	28	1.10	5/8-11	M-30020	22020
	C40RDE20	CAT 40	102	4.00	35	1.38	5/8-11	E-30127	22120
	C40RDEX20	CAT 40	134	5.25	35	1.38	5/8-11	E-30127	22120
	664520	CAT 45	135	5.32	28	1.10	3/4-10	M-30020	22020
	674520	CAT 50	135	5.32	28	1.10	1-8	M-30020	22020
RD 25	650025	CAT 40	100	3.94	35	1.38	5/8-11	M-30025	22025
	654525	CAT 40	150	5.91	35	1.38	5/8-11	M-30025	22025
	C40RDE25	CAT 40	102	4.00	42	1.65	5/8-11	E-30125	22125
	C40RDEX25	CAT 40	153	6.00	42	1.65	5/8-11	E-30125	22125
	664525	CAT 45	150	5.91	35	1.38	3/4-10	M-30025	22025
	C50RDE25	CAT 50	153	6.00	42	1.65	1-8	E-30125	22125
RD 32	C40RDE32	CAT 40	102	4.00	50	1.97	5/8-11	E-30132	22132
	C40RDEX32	CAT 40	153	6.00	50	1.97	5/8-11	E-30132	22132
	674802	CAT 50	160	6.30	50	1.97	1-8	E-30132	22132
RD 40	654804	CAT 40	153	6.00	63	2.48	5/8-11	E-30140	22140
	674804	CAT 50	160	6.30	63	2.48	1-8	E-30140	22140
RD 50	674805	CAT 50	100	3.94	78	3.07	1-8	E-30150	22150

Balanced to 22,000 RPM upon request.



SHORT & RIGID RD/ER CAT V-FLANGE COLLET CHUCKS



Shortest possible gage length by design for maximum tool rigidity.

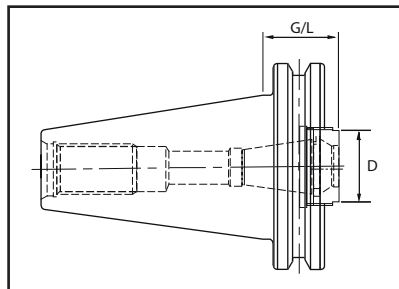
Wrenches and retention knobs are sold separately. See page 30



RD/ER

	Part Number	Taper	G/L mm/inch	D mm/inch	RKT	Nut	Wrench
C40	C40RDSR16	V40	23.5/ .93	24/ .95	5/8-11	35216	35443
	C40RDSR20	V40	24.2/ .95	28/ 1.1	5/8-11	35220	35443
	C40RDSR25	V40	24.2/ .95	32/ 1.26	5/8-11	35225	35444
	C40RDSR32	V40	25.4/ 1	40/ 1.58	5/8-11	35232	35444
C50	C50RDSR16	V50	23.5/ .93	24/ .95	1"- 8	35216	35443
	C50RDSR20	V50	24.2/ .95	28/ 1.1	1"- 8	35220	35443
	C50RDSR25	V50	24.2/ .95	32/ 1.26	1"- 8	35225	35444
	C50RDSR32	V50	25.4/ 1"	40/ 1.58	1"- 8	35232	35444
	C50RDSR40	V50	26.6/ 1.05	50/ 1.97	1"- 8	35240	35444

SHORT AND RIGID BT COLLET CHUCKS



Shortest possible gage length by design for maximum tool rigidity.

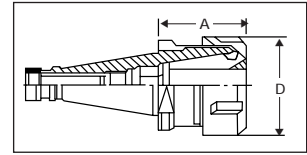
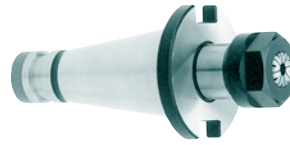
Wrenches and retention knobs are sold separately. See page 30



	Part Number	Taper	G/L mm/inch	D mm/inch	RKT	Nut	Wrench
B40	B40RDSR16	BT40	31/ 1.22	24/ .95	M16	35216	35443
	B40RDSR20	BT40	32/ 1.26	28/ 1.1	M16	35220	35443
	B40RDSR25	BT40	32/ 1.26	32/ 1.26	M16	35225	35444
	B40RDSR32	BT40	33.5/ 1.32	40/ 1.58	M16	35232	35444
B50	B50RDSR16	BT50	42/ 1.65	24/ .95	M24	35216	35443
	B50RDSR20	BT50	43/ 1.69	28/ 1.1	M24	35220	35443
	B50RDSR25	BT50	43/ 1.69	32/ 1.26	M24	35225	35444
	B50RDSR32	BT50	40/ 1.57	40/ 1.58	M24	35232	35444
	B50RDSR40	BT50	50/ 1.97	50/ 1.97	M24	35240	35444



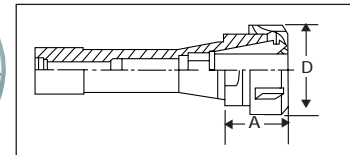
## NMTB/ISO RD/ER COLLET CHUCKS



	Part No.	Taper	A		D		Ret. Knob Threading	Nut Style/Part No.	Wrench
			(mm.)	(in.)	(mm.)	(in.)			
RD 16	604816	NMT 40	50	1.97	28	1.10	5/8-11	H-30116	22016
RD 20	604820	NMT 40	50	1.97	34	1.34	5/8-11	H-30120	22330
RD 32	604801	NMT 30	50	1.97	50	1.97	1/2-13	E-30132	22132
	604802	NMT 40	50	1.97	50	1.97	5/8-11	E-30132	22132
RD 40	604803	NMT 40	50	1.97	63	2.48	5/8-11	E-30140	22140
	604804	NMT 50	60	2.36	63	2.48	1-8	E-30140	22140
	3604040	ISO 40	50	1.97	63	2.43	M16	E-30140	22140
RD 50	604805	NMT 50	65	2.56	78	3.07	1-8	E-30150	22150
	3605050	ISO 50	65	2.56	78	3.07	M24	E-30150	22150

Wrenches are sold separately. See page 30

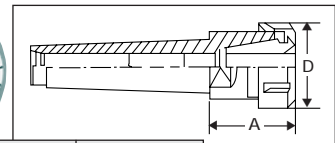
## R8 RD/ER COLLET CHUCKS



	Part No.	Taper	A		D		Ret. Knob Threading	Nut Style/Part No.	Wrench
			(mm.)	(in.)	(mm.)	(in.)			
RD 16	MSOR816	R8	32	1.26	28	1.10	7/16-20	H-30116	22325
RD 32	MSOR832	R8	35	1.38	50	1.97	7/16-20	E-30132	22132
RD 40	MSOR840	R8	70	2.76	63	2.48	7/16-20	E-30140	22140

Wrenches are sold separately. See page 30

## MORSE TAPER RD/ER COLLET CHUCKS



	Part No.	Taper	A		D		Tang Threading	Nut Style/Part No.	Wrench
			(mm.)	(in.)	(mm.)	(in.)			
RD 16	516-113	MT 2	32	1.26	28	1.10	M10	H-30116	22325
RD 20	520-113	MT 2	43	1.69	34	1.34	M10	H-30120	22330
RD 25	525-116	MT 2	47	1.85	42	1.65	M10	E-30125	22125
RD 32	532-123	MT 3	64	2.52	50	1.97	M12	E-30132	22132
	532-124	MT 4	54	2.13	50	1.97	M16	E-30132	22132
RD 40	540-123	MT 3	64	2.52	63	2.48	M12	E-30140	22140
	540-124	MT 4	75	2.96	63	2.48	M16	E-30140	22140

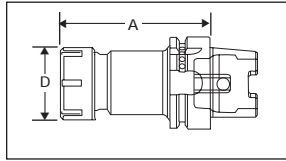
Wrenches are sold separately. See page 30

TANGS FOR  
MORSE TAPER  
COLLET CHUCKS  
SOLD SEPARATELY

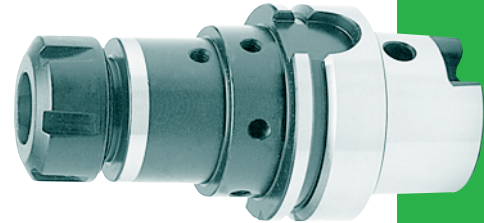
Part No.	Taper	Threading
4220010	MT 2	M10
4230012	MT 3	M12
4240016	MT 4	M16



RD/ER HSK COLLET CHUCKS



NOTE: HSK Endmill and Shellmill holders are available upon request.

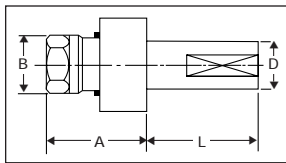


RD/ER

Part No.	D		A		Nut Style/ Part No.	Wrench
	(mm.)	(in.)	(mm.)	(in.)		
HSK63ARD16	22	0.87	100	3.94	M-30016	22016
HSK63ARD20	35	1.38	100	3.94	E-30127	22120
HSK63ARD25	42	1.65	100	3.94	E-30125	22125
HSK63ARD32	50	1.97	100	3.94	E-30132	22132
HSK63ARD40	63	2.48	120	4.73	E-30140	22140

Wrenches are sold separately. See page 30

RD/ER FLOATING REAMER HOLDERS



STRAIGHT-SHANK

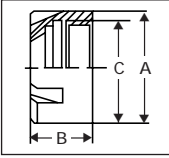
	Part No.	D		L		A		B		Float		Nut Style/ Part No.	Wrench
		(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)		
RD 11	160011	16	.63	46	1.81	40	1.57	22	0.86	1	0.04	H-30111	22317
	580011	16	5/8	46	1.81	40	1.57	22	0.86	1	0.04	H-30111	22317
	340011		3/4	46	1.81	40	1.57	22	0.86	1	0.04	H-30111	22317
RD 16	160016	16	0.63	35	1.38	33	1.30	28	1.00	1	0.04	H-30116	22325
	340016		3/4	35	1.38	33	1.30	28	1.00	1	0.04	H-30116	22325
	100016		1	35	1.38	33	1.30	28	1.10	1	0.04	H-30116	22325
RD 20	200020	20	0.79	46	1.81	48	1.89	34	1.34	1	0.04	H-30120	22330
	250020	25	0.98	50	1.97	48	1.89	34	1.34	1	0.04	H-30120	22330
	340020		3/4	50	1.97	48	1.89	34	1.34	1	0.04	H-30120	22330
	1000020		1	50	1.97	48	1.89	34	1.34	1	0.04	H-30120	22330
RD 25	250025	25	0.98	50	1.97	58	2.28	42	1.65	1	0.04	E-30125	22125
	320025	32	1.26	50	1.97	58	2.28	42	1.65	1	0.04	E-30125	22125
	1000025		1	50	1.97	58	2.28	42	1.65	1	0.04	E-30125	22125
	1140025		1-1/4	50	1.97	58	2.28	42	1.65	1	0.04	E-30125	22125
RD 32	250032	25	0.98	50	1.97	58	2.28	50	1.97	1	0.04	E-30132	22132
	300032	30	1.18	50	1.97	58	2.28	50	1.97	1	0.04	E-30132	22132
	320032	32	1.26	50	1.97	58	2.28	50	1.97	1	0.04	E-30132	22132
	400032	40	1.57	50	1.97	58	2.28	50	1.97	1	0.04	E-30132	22132
	100032		1	50	1.97	58	2.28	50	1.97	1	0.04	E-30132	22132
	1140032		1-1/4	50	1.97	58	2.28	50	1.97	1	0.04	E-30132	22132

Wrenches are sold separately. See page 30



## CLAMPING NUTS &amp; WRENCHES

## MINI NUTS



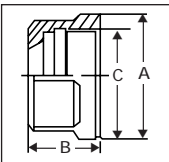
Part No.	Type	A		B		C
		(mm.)	(in.)	(mm.)	(in.)	
30008	RD 8 M	12	0.47	10.8	0.42	M10 X 0.75
30011	RD 11 M	16	0.63	11.3	0.44	M13 X 0.75
30016	RD 16 M	22	0.87	17	0.67	M19 X 1
30020	RD 20 M	28	1.10	19	0.75	M24 X 1
30025	RD 25 M	35	1.38	20	0.79	M30 X 1

## MINI WRENCH



Part No.	Type
22008	E 8 M
22011	E 11 M
22016	E 16 M
22020	E 20 M
22025	E 25 M

## HEX NUTS



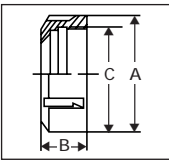
Part No.	Type	A		B		C
		(mm.)	(in.)	(mm.)	(in.)	
30111	UM/RD 11	19	0.75	11.3	0.44	M14 X 0.75
30112	UM/RD 12	19	0.75	12.5	0.49	M14 X 0.75
30116	UM/RD 16	28	1.10	17	0.67	M22 X 1.5
30120	UM/RD 20	34	1.34	19	0.75	M25 X 1.5

## HEX WRENCH



Part No.	Type
22317	GS 17
22317	GS 17
22325	GS 25
22330	GS 30

## "E" NUT



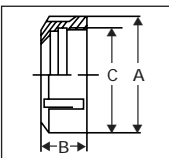
Part No.	Type	A		B		C
		(mm.)	(in.)	(mm.)	(in.)	
30126	UX/RD 16	32	1.26	17.5	0.69	M22 X 1.5
30127	UX/RD 20	35	1.38	18.5	0.73	M25 X 1.5
30125	UM/RD 25	42	1.65	20	0.79	M32 X 1.5
30132	UM/RD 32	50	1.97	22	0.87	M40 X 1.5
30140	UM/RD 40	63	2.48	25	0.98	M50 X 1.5
30150	UM/RD 50	78	2.07	35	1.38	M64 X 2

## "E" WRENCH



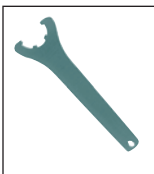
Part No.	Type
22116	E 16
22120	E 20
22125	E 25
22132	E 32
22140	E 40
22150	E 50

## BALL-BEARING NUTS



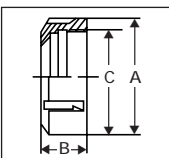
Part No.	Type	A		B		C
		(mm.)	(in.)	(mm.)	(in.)	
30216	KM/RD 16	29	1.14	17.5	0.69	M22 X 1.5
30220	KM/RD 20	34	1.34	18.5	0.73	M25 X 1.5
30225	KM/RD 25	42	1.65	20	0.79	M32 X 1.5
30232	KM/RD 32	50	1.97	22	0.87	M40 X 1.5
30240	KM/RD 40	63	2.48	25	0.98	M50 X 1.5
30250	KM/RD 50	78	3.07	35	1.38	M64 X 2

## "E" WRENCH



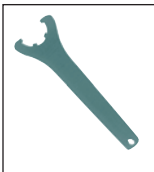
Part No.	Type
22125	E 25
22132	E 32
22140	E 40
22150	E 50

## HIGH-SPEED NUTS



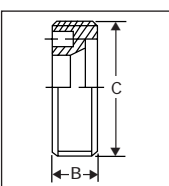
Part No.	Type	A		B		C
		(mm.)	(in.)	(mm.)	(in.)	
30716	HS/RD 16	30	1.18	17	0.67	M22 X 1.5
30720	HS/RD 20	34	1.34	19	0.75	M25 X 1.5
30725	HS/RD 25	42	1.65	20	0.79	M32 X 1.5
30732	HS/RD 32	50	1.97	22.3	0.87	M40 X 1.5
30740	HS/RD 40	63	2.48	25.3	1.00	M50 X 1.5

## "E" WRENCH



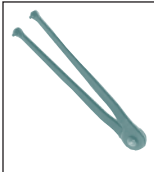
Part No.	Type
22125	E 25
22132	E 32
22140	E 40

## INTERNAL FIT NUTS



Part No.	Type	A		B		C
		(mm.)	(in.)	(mm.)	(in.)	
0035211	RD 11 A	—	—	8	0.32	M18 X 1
0035216	RD 16 A	—	—	8	0.32	M24 X 1
0035220	RD 20 A	—	—	11	0.43	M28 X 1.5
0035225	RD 25 A	—	—	12.5	0.49	M32 X 1.5
0035232	RD 32 A	—	—	14	0.55	M40 X 1.5
0035240	RD 40 A	—	—	20	0.79	M50 X 1.5

## IF WRENCH



Part No.	Type
35443	RD 11 A
35443	RD 16 A
35443	RD 20 A
35444	RD 25 A
35444	RD 32 A
35444	RD 40 A

ANSI STANDARD RETENTION KNOBS

FOR MACHINES WITHOUT COOLANT THROUGH SPINDLES

Part No.	Taper Size	Thread
C30VR	CAT30	1/2 - 13
C40VR	CAT40	5/8 - 11
C45VR	CAT45	3/4 - 10
C50VR	CAT50	1" - 8

FOR MACHINES WITH COOLANT THROUGH SPINDLES

C30VRC	CAT30	1/2 - 13
C40VRC	CAT40	5/8 - 11
C45VRC	CAT45	3/4 - 10
C50VRC	CAT50	1" - 8

NOTE: Retention knobs for most machines available upon request.

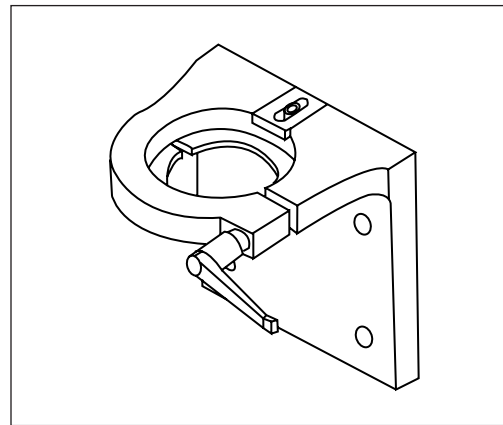


RD/ER

LOCKING TIGHTENING FIXTURES FOR CAT (V-Flange) TOOLHOLDERS

- For use in any position
- Access tool or retention knob
- Bolt down or use in vise

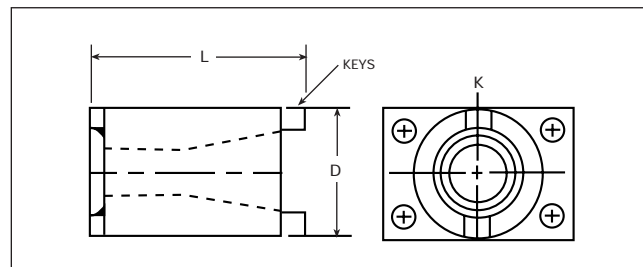
Part No.	Shank Size
C40LTF	CAT40
C50LTF	CAT50



LOCKING FIXTURE FOR ALL TAPERS

- Fit CAT (V-Flange), BT & NMTB tapers
- Bolt down or use in vise

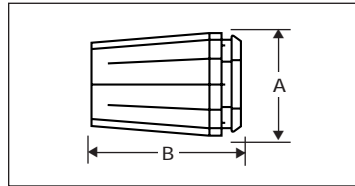
Part No.	Shank	L	D	K
C30TF	30	3.91	3.00	0.62
C40TF	40	4.65	3.00	0.62
C45TF	45	4.90	3.50	0.75
C50TF	50	6.35	4.00	1.00



NOTE: HSK Endmill and Shellmill holders available on request.



## RDG/TG 75 COLLET SYSTEM



A = 1.06 in.  
B = 1.84 in.

Collapse per collet: 1/64 in.  
Capacity per set: 3/32 - 3/4 in.  
Precision per DIN 6341 (0.0005 in. T.I.R.)  
Maximum tightening torque: 80 ft./lbs.

RDG/TG

## INTERNAL COOLANT COLLETS



Sealed for coolant-through applications, with pressure resistance tested to 1,000 p.s.i.

Sealed collets are exact size collets and have no collapse range.

## TAPPING COLLETS



## Rigid Tapping Collets with Square Drive

For synchronous tapping operations using any RDG/TG collet chuck. Collet bore is exact tool diameter, with square drive, for accuracy and rigidity.

ANSI Tap Size	Part No.
0-6	52001
8	52002
10	52003
12	52004
1/4	52005
5/16	52007
3/8	52008
7/16	52009
1/2	52010
9/16	52011
5/8	52013
11/16	52014
3/4	52015
1/8 PIPE-SS	52006
1/8 PIPE-LS	52012
1/4 PIPE	52016



RDG/TG 75 COLLETS

INCH SIZES		
	STANDARD COLLETS	INTERNAL COOLANT COLLETS
(in.)	Part No.	Part No.
3/32	50001	
7/64	50002	
1/8	50003	50103
9/64	50004	50104
5/32	50005	50105
11/64	50006	50106
3/16	50007	50107
13/64	50008	50108
7/32	50009	50109
15/64	50010	50110
1/4	50011	50111
17/64	50012	50112
9/32	50013	50113
19/64	50014	50114
5/16	50015	50115
21/64	50016	50116
11/32	50017	50117
23/64	50018	50118
3/8	50019	50119
25/64	50020	50120
13/32	50021	50121
27/64	50022	50122
7/16	50023	50123
29/64	50024	50124
15/32	50025	50125
31/64	50026	50126
1/2	50027	50127
33/64	50028	50128
17/32	50029	50129
35/64	50030	50130
9/16	50031	50131
37/64	50032	50132
19/32	50033	50133
39/64	50034	50134
5/8	50035	50135
41/64	50036	50136
21/32	50037	50137
43/64	50038	50138
11/16	50039	50139
45/64	50040	50140
23/32	50041	50141
47/64	50042	50142
3/4	50043	50143

METRIC SIZES		
	STANDARD COLLETS	INTERNAL COOLANT COLLETS
(mm.)	Part No.	Part No.
2.5	51000	
3	51001	
3.5	51002	50202
4	51003	50203
4.5	51004	50204
5	51005	50205
5.5	51006	50206
6	51007	50207
6.5	51008	50208
7	51009	50209
7.5	51010	50210
8	51011	50211
8.5	51012	50212
9	51013	50213
9.5	51014	50214
10	51015	50215
10.5	51016	50216
11	51017	50217
11.5	51018	50218
12	51019	50219
12.5	51020	50220
13	51021	50221
13.5	51022	50222
14	51023	50223
14.5	51024	50224
15	51025	50225
15.5	51026	50226
16	51027	50227
16.5	51028	50228
17	51029	50229
17.5	51030	50230
18	51031	50231
18.5	51032	50232
19	51033	50233
19.5	51034	50234
20	51035	50235

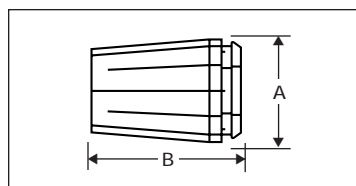
RDG/TG

Standard Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
50044	43	3/32-3/4	1/64
50056	41	1/8-3/4	1/64
50055	33	1/4-3/4	1/64
50045	25	3/8-3/4	1/64
50046	22	3/32-3/4	1/32
50047	13	3/8-3/4	1/32
50048	11	1/8-3/4	1/16



## RDG/TG 100 COLLET SYSTEM



Collapse per collet: 1/64 in.  
Capacity per set: 3/32 - 1 in.  
Precision per DIN 6341 (0.0005 in. T.I.R.)  
Maximum tightening torque: 90 ft./lbs.

A = 1.38 in.  
B = 2.38 in.

RDG/TG

## INTERNAL COOLANT COLLETS



Sealed for coolant-through applications,  
with pressure resistance tested to  
1,000 p.s.i.

Sealed collets are exact size collets  
and have no collapse range.

## TAPPING COLLETS

Rigid Tapping Collets  
with Square Drive

For synchronous tapping operations using  
any RDG/TG collet chuck. Collet bore is  
exact tool diameter, with square drive,  
for accuracy and rigidity.

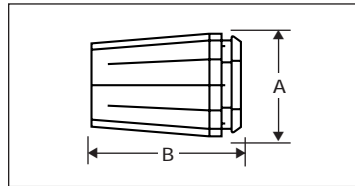
ANSI Tap Size	Part No.
0-6	72001
8	72002
10	72003
12	72004
1/4	72005
5/16	72007
3/8	72010
7/16	72008
1/2	72009
9/16	72011
5/8	72013
11/16	72014
3/4	72016
13/16	72017
7/8	72019
15/16	72021
1	72022
1/8 PIPE-SS	72006
1/8 PIPE-LS	72012
1/4 PIPE	72015
3/8 PIPE	72020
1/2 PIPE	72018







## RDG/TG 150 COLLET SYSTEM



Collapse per collet: 1/64 in.  
Capacity per set: 1/2 - 1-1/2 in.  
Precision per DIN 6341 (0.0005 in. T.I.R.)

A = 2.00 in.  
B = 3.00 in.

RDG/TG

## INTERNAL COOLANT COLLETS



Sealed for coolant-through applications,  
with pressure resistance tested to  
1,000 p.s.i.

Sealed collets are exact size collets  
and have no collapse range.

## TAPPING COLLETS

Rigid Tapping Collets  
with Square Drive

For synchronous tapping operations using  
any RDG/TG collet chuck. Collet bore is  
exact tool diameter, with square drive,  
for accuracy and rigidity.

ANSI Tap Size	Part No.
5/8	92001
3/4	92002
7/8	92003
1	92004
1-1/8	92005
1-1/4	92006
1-3/8	92007
1-1/2	92008
1/4 PIPE	92009
3/8 PIPE	92010
1/2 PIPE	92012
3/4 PIPE	92013
1 PIPE	92014
1-1/4 PIPE	92015



RDG/TG 150 COLLETS

(in.)	INCH SIZES	
	STANDARD COLLETS	INTERNAL COOLANT COLLETS
Part No.	Part No.	
1/2	90001	90101
33/64	90002	90102
17/32	90003	90103
35/64	90004	90104
9/16	90005	90105
37/64	90006	90106
19/32	90007	90107
39/64	90008	90108
5/8	90009	90109
41/64	90010	90110
21/32	90011	90111
43/64	90012	90112
11/16	90013	90113
45/64	90014	90114
23/32	90015	90115
47/64	90016	90116
3/4	90017	90117
49/64	90018	90118
25/32	90019	90119
51/64	90020	90120
13/16	90021	90121
53/64	90022	90122
27/32	90023	90123
55/64	90024	90124
7/8	90025	90125
57/64	90026	90126
29/32	90027	90127
59/64	90028	90128
15/16	90029	90129
61/64	90030	90130
31/32	90031	90131
63/64	90032	90132
1	90033	90133

(in.)	INCH SIZES	
	STANDARD COLLETS	INTERNAL COOLANT COLLETS
Part No.	Part No.	
1-1/64	90034	90134
1-1/32	90035	90135
1-3/64	90036	90136
1-1/16	90037	90137
1-5/64	90038	90138
1-3/32	90039	90139
1-7/64	90040	90140
1-1/8	90041	90141
1-9/64	90042	90142
1-5/32	90043	90143
1-11/64	90044	90144
1-3/16	90045	90145
1-13/64	90046	90146
1-7/32	90047	90147
1-15/64	90048	90148
1-1/4	90049	90149
1-17/64	90050	90150
1-9/32	90051	90151
1-19/64	90052	90152
1-5/16	90053	90153
1-21/64	90054	90154
1-11/32	90055	90155
1-23/64	90056	90156
1-3/8	90057	90157
1-25/64	90058	90158
1-13/32	90059	90159
1-27/64	90060	90160
1-7/16	90061	90161
1-29/64	90062	90162
1-15/32	90063	90163
1-31/64	90064	90164
1-1/2	90065	90165

(mm.)	METRIC SIZES	
	STANDARD COLLETS	INTERNAL COOLANT COLLETS
Part No.	Part No.	
12	91001	90201
12.5	91002	90202
13	91003	90203
13.5	91004	90204
14	91005	90205
14.5	91006	90206
15	91007	90207
15.5	91008	90208
16	91009	90209
16.5	91010	90210
17	91011	90212
17.5	91012	90212
18	91013	90213
18.5	91014	90214
19	91015	90215
19.5	91016	90216
20	91017	90217
20.5	91018	90218
21	91019	90219
21.5	91020	90220
22	91021	90221
22.5	91022	90222
23	91023	90223
23.5	91024	90224
24	91025	90225
24.5	91026	90226
25	91027	90227
25.5	91028	90228
26	91029	90229
26.5	91030	90230
27	91031	90231
27.5	91032	90232
28	91033	90233
28.5	91034	90234
29	91035	90235
29.5	91036	90236
30	91037	90237
30.5	91038	90238
31	91039	90239
31.5	91040	90240
32	91041	90241
32.5	91042	90242
33	91043	90243
33.5	91044	90244
34	91045	90245
34.5	91046	90246
35	91047	90247
35.5	91048	90248
36	91049	90249
36.5	91050	90250
37	91051	90251
37.5	91052	90252
38	91053	90253

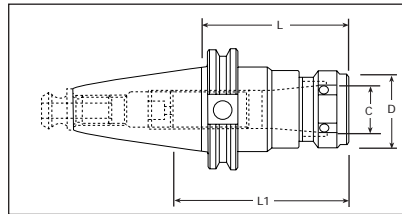
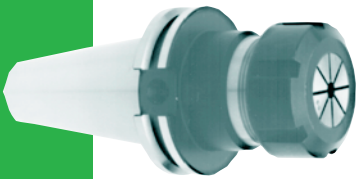
Standard Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
90066	65	1/2-1-1/2	1/64
90067	33	1/2-1-1/2	1/32
90068	17	1/2-1-1/2	1/16

RDG/TG



CAT (V-flange) RDG/TG COLLETS



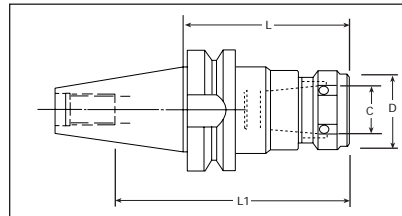
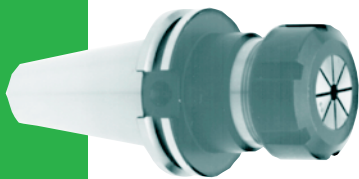
Retention knobs sold separately.

Wrenches are sold separately. See page 30

RDG/TG

	Part No.	Collet Series	C Capacity	D	L	L1	Nut Style/ Part No.
CAT 40	C40RDG075	RDG75	3/4"	1.97	2.75	3.31	E-30476
	C40RDG100	RDG100	1"	2.44	3.00	3.68	E-30400
	C40RDG150	RDG150	1-1/2"	3.25	4.88	5.56	S-30480
	C40RDGEX100	RDG100	1"	2.44	4.00	4.68	E-30400
	C40RDGEEEX100	RDG100	1"	2.44	5.50	5.68	E-30400
	C40RDGEEEX100	RDG100	1"	2.44	6.50	7.18	E-30400
CAT 45	C45RDG100	RDG100	1"	2.44	3.00	4.00	E-30400
	C45RDGEX100	RDG100	1"	2.44	5.00	6.00	E-30400
	C45RDGEEEX100	RDG100	1"	2.44	7.00	7.00	E-30400
	C45RDG150	RDG150	1-1/2"	3.43	3.00	4.00	S-30480
	C45RDGEX150	RDG150	1-1/2"	3.43	5.00	6.00	S-30480
CAT 50	C50RDG100	RDG100	1"	2.44	3.00	4.50	E-30400
	C50RDGEX100	RDG100	1"	2.44	5.50	7.00	E-30400
	C50RDGEEEX100	RDG100	1"	2.44	7.50	9.00	E-30400
	C50RDG150	RDG150	1-1/2"	3.43	3.00	4.50	S-30480

BT RDG/TG COLLET CHUCKS



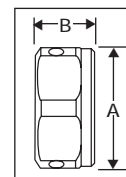
Retention knobs sold separately.

Wrenches are sold separately. See page 30

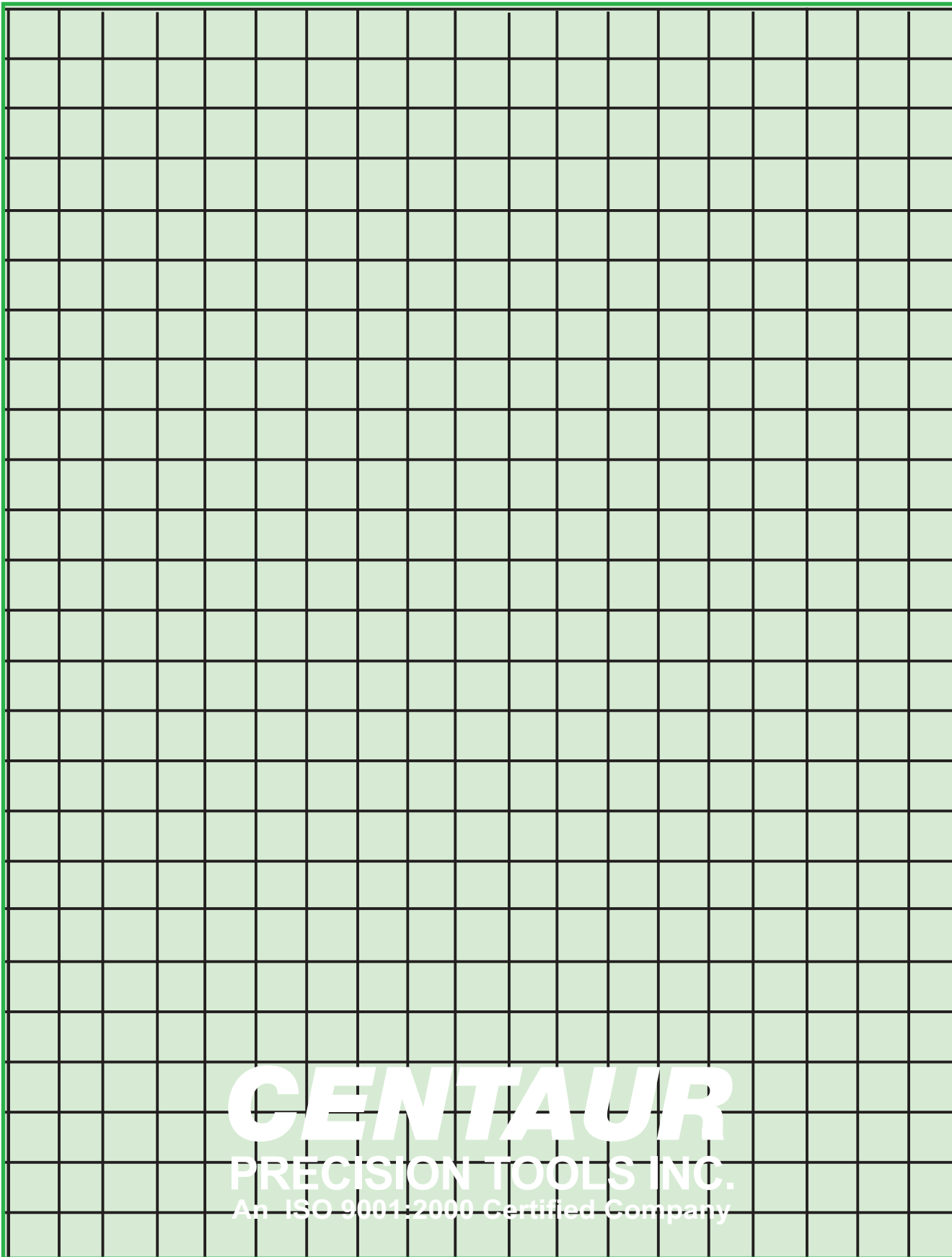
	Part No.	Collet Series	C Capacity	D	L	L1	Nut Style/ Part No.
BT 40	B40RDG075	RDG75	3/4"	2.10	2.75	3.31	E-30476
	B40RDG100	RDG100	1"	2.44	3.00	3.68	E-30400
	B40RDGE100	RDG100	1"	2.44	5.00	5.68	E-30400
BT 50	B50RDG100	RDG100	1"	2.44	3.00	4.75	E-30400
	B50RDG150	RDG150	1-1/2"	3.43	3.00	4.50	S-30480

RDG/TG NUTS & WRENCHES

Part No.	Collet Series	A (in.)	B (in.)	Wrench Type	Wrench Part No.
30476	RDG 75	1.97	0.87	E	22132
30400	RDG 100	2.48	1.29	E	22140
30480	RDG 150	3.25	1.75	SPANNER	RDG 150 SW



NOTES



**CENTAUR**  
PRECISION TOOLS INC.  
An ISO 9001:2000 Certified Company

RDG/TG

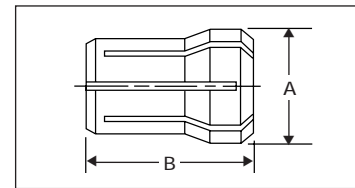


RDA/DA 300 COLLETS



INCH SIZES	
(in.)	Part No.
1/32	300-031
3/64	300-047
1/16	300-062
5/64	300-078
3/32	300-094
7/64	300-109
1/8	300-125
9/64	300-141
5/32	300-156
11/64	300-172
3/16	300-188
13/64	300-203
7/32	300-219
15/64	300-234
1/4	300-250

METRIC SIZES	
(mm.)	Part No.
1	300-1.0MM
1.5	300-1.5MM
2	300-2.0MM
2.5	300-2.5MM
3	300-3.0MM
3.5	300-3.5MM
4	300-4.0MM
4.5	300-4.5MM
5	300-5.0MM
5.5	300-5.5MM
6	300-6.0MM
6.5	300-6.5MM



A = 0.38 in.

B = 1.08 in.

Collapse per collet: 1/64 in.  
Maximum tightening torque: 20 ft./lbs.

RDA 300 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
300-014	14	3/64-1/4	1/64
300-009	9	1/8-1/4	1/64
300-007	7	1/16-1/4	1/32
300-005	5	1/8-1/4	1/32

RDA/DA

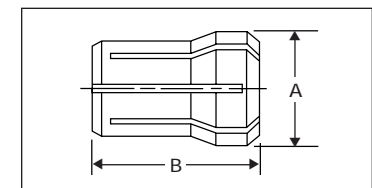
RDA/DA 200 COLLETS



INCH SIZES	
(in.)	Part No.
1/32	200-031
3/64	200-047
1/16	200-062
5/64	200-078
3/32	200-094
7/64	200-119
1/8	200-125
9/64	200-141
5/32	200-156
11/64	200-172
3/16	200-188
13/64	200-203

INCH SIZES	
(in.)	Part No.
7/32	200-219
15/64	200-234
1/4	200-250
17/64	200-266
9/32	200-281
19/64	200-297
5/16	200-312
21/64	200-328
11/32	200-344
23/64	200-359
3/8	200-375
25/64	200-391

METRIC SIZES	
(mm.)	Part No.
1	200-1.0MM
1.5	200-1.5MM
2	200-2.0MM
2.5	200-2.5MM
3	200-3.0MM
3.5	200-3.5MM
4	200-4.0MM
4.5	200-4.5MM
5	200-5.0MM
5.5	200-5.5MM
6	200-6.0MM
6.5	200-6.5MM
7	200-7.0MM
7.5	200-7.5MM
8	200-8.0MM
8.5	200-8.5MM
9	200-9.0MM
9.5	200-9.5MM



A = 0.54 in.

B = 1.18 in.

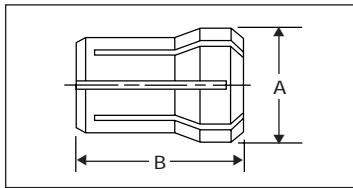
Collapse per collet: 1/64 in.  
Maximum tightening torque: 20 ft./lbs.

RDA 200 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
200-021	21	1/16-3/8	1/64
200-017	17	1/8-3/8	1/64
200-009S	9	1/8-3/8	1/32



RDA/DA 100 COLLETS



A = 0.77 in.

B = 1.44 in.

Collapse per collet: 1/64 in.

Maximum tightening torque: 35 ft./lbs.



INCH SIZES	
(in.)	Part No.
3/64	100-047
1/16	100-062
5/64	100-078
3/32	100-094
7/64	100-109
1/8	100-125
9/64	100-141
5/32	100-156
11/64	100-172
3/16	100-188
13/64	100-203
7/32	100-219
15/64	100-234
1/4	100-250
17/64	100-266
9/32	100-281
19/64	100-297
5/16	100-312
21/64	100-328
11/32	100-344
23/64	100-359
3/8	100-375
25/64	100-391
13/32	100-406
27/64	100-422
7/16	100-438
29/64	100-453
15/32	100-469
31/64	100-484
1/2	100-500
33/64	100-516
17/32	100-531
35/64	100-547
9/16	100-562

METRIC SIZES	
(mm.)	Part No.
1	100-1.0MM
1.5	100-1.5MM
2	100-2.0MM
2.5	100-2.5MM
3	100-3.0MM
3.5	100-3.5MM
4	100-4.0MM
4.5	100-4.5MM
5	100-5.0MM
5.5	100-5.5MM
6	100-6.0MM
6.5	100-6.5MM
7	100-7.0MM
7.5	100-7.5MM
8	100-8.0MM
8.5	100-8.5MM
9	100-9.0MM
9.5	100-9.5MM
10	100-10.0MM
10.5	100-10.5MM
11	100-11.0MM
11.5	100-11.5MM
12	100-12.0MM
12.5	100-12.5MM
13	100-13.0MM
13.5	100-13.5MM
14	100-14.0MM
14.5	100-14.5MM
15	100-15.0MM

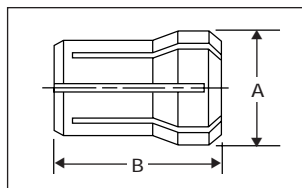
RDA 100 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
100-033	33	1/16-9/16	1/64
100-029	29	1/8-9/16	1/64
100-021	21	1/4-9/16	1/64
100-017	17	1/16-9/16	1/32
100-015	15	1/8-9/16	1/32
100-011	11	1/4-9/16	1/32
100-009	9	1/16-9/16	1/16

RDA/DA



RDA/DA 180 COLLETS



A = 1.04 in.  
B = 1.62 in.

Collapse per collet: 1/64 in.  
Maximum tightening torque: 45 ft./lbs.

RDA 180 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
180-045	45	1/16-3/4	1/64
180-041	41	1/8-3/4	1/64
180-033	33	1/4-3/4	1/64
180-023	23	1/16-3/4	1/32
180-021	21	1/18-3/4	1/32
180-017	17	1/4-3/4	1/32
180-012	12	1/16-3/4	1/16

INCH SIZES	
(in.)	Part No.
3/64	180-047
1/16	180-062
5/64	180-078
3/32	180-094
7/64	180-109
1/8	180-125
9/64	180-141
5/32	180-156
11/64	180-172
3/16	180-188
13/64	180-203
7/32	180-219
15/64	180-234
1/4	180-250
17/64	180-266
9/32	180-281
19/64	180-297
5/16	180-312
21/64	180-328
11/32	180-344
23/64	180-359
3/8	180-375
25/64	180-391
13/32	180-406

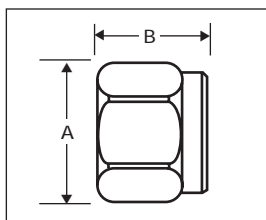
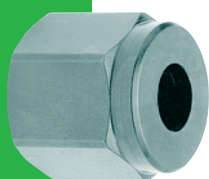
INCH SIZES	
(in.)	Part No.
27/64	180-422
7/16	180-438
29/64	180-453
15/32	180-469
31/64	180-484
1/2	180-500
33/64	180-516
17/32	180-531
35/64	180-547
9/16	180-562
37/64	180-578
19/32	180-594
39/64	180-609
5/8	180-625
41/64	180-641
21/32	180-656
43/64	180-672
11/16	180-688
45/64	180-703
23/32	180-719
47/64	180-734
3/4	180-750
49/64	180-765

METRIC SIZES	
(mm.)	Part No.
1	180-1.0MM
1.5	180-1.5MM
2	180-2.0MM
2.5	180-2.5MM
3	180-3.0MM
3.5	180-3.5MM
4	180-4.0MM
4.5	180-4.5MM
5	180-5.0MM
5.5	180-5.5MM
6	180-6.0MM
6.5	180-6.5MM
7	180-7.0MM
7.5	180-7.5MM
8	180-8.0MM
8.5	180-8.5MM
9	180-9.0MM
9.5	180-9.5MM
10	180-10.0MM
10.5	180-10.5MM

METRIC SIZES	
(mm.)	Part No.
11	180-11.0MM
11.5	180-11.5MM
12	180-12.0MM
12.5	180-12.5MM
13	180-13.0MM
13.5	180-13.5MM
14	180-14.0MM
14.5	180-14.5MM
15	180-15.0MM
15.5	180-15.5MM
16	180-16.0MM
16.5	180-16.5MM
17	180-17.0MM
17.5	180-17.5MM
18	180-18.0MM
18.5	180-18.5MM
19	180-19.0MM
19.5	180-19.5MM
20	180-20.0MM

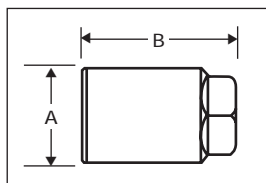
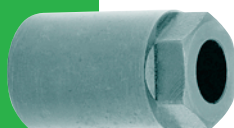
RDADA

COLLET NUT



Part No.	Collet	A (in.)	B (in.)
20300	RDA 300	0.86	0.700
20200	RDA 200	1.125	0.875
20100	RDA 100	1.39	0.910
20180	RDA 180	1.70	0.875

NOSEPIECE

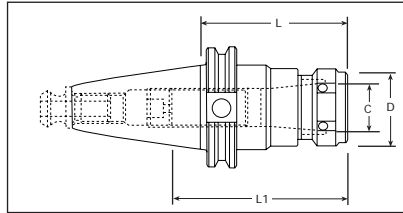


Part No.	Collet	A (in.)	B (in.)
RDAN 300	RDA 300	0.56	1.00
RDAN 200	RDA 200	0.81	1.35
RDAN 100	RDA 100	1.06	1.50
RDAN 180	RDA 180	1.44	1.60





CAT (V-flange) RDA/DA COLLET CHUCKS



Retention knobs sold separately.

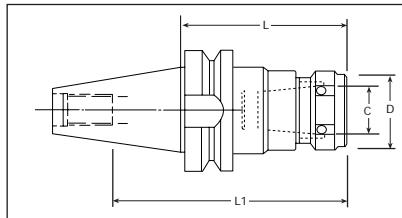
Wrenches are sold separately. See page 30



	Part No.	Collet Series	C Capacity	D	L	L1	Nut
CAT 40	C40RDA100	RDA100	9/16"	1.39	3.00	3.00	20100
	C40RDA180	RDA180	3/4"	1.70	3.00	2.75	20180
	C40RDAE180	RDA180	3/4"	1.70	5.00	2.75	20180
	C40RDA200	RDA200	3/8"	1.30	3.00	3.00	20200
	C40RDAE200	RDA200	3/8"	1.30	5.00	3.00	20200
	C40RDA300	RDA300	1/4"	0.86	3.00	3.82	20300
CAT 50	C50RDA100	RDA100	9/16"	1.39	3.00	3.00	20100
	C50RDAE100	RDA100	9/16"	1.39	6.00	3.00	20100
	C50RDA180	RDA180	3/4"	1.70	3.00	4.04	20180
	C50RDAE180	RDA180	3/4"	1.70	6.00	4.04	20180

Wrenches are sold separately. See page 30

BT RDA/DA COLLET CHUCKS



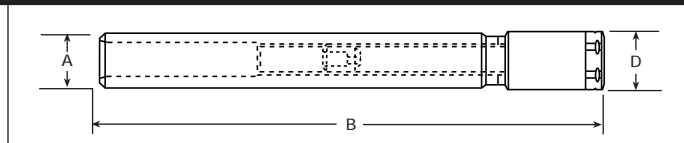
Retention knobs sold separately.

Wrenches are sold separately. See page 30



	Part No.	Collet Series	C Capacity	D	L	L1	Nut
BT 40	B40RDA200	RDA200	3/8"	1.30	3.00	3.00	20200
	B40RDA180	RDA180	3/4"	1.70	3.00	2.75	20180
	B40RDA100	RDA100	9/16"	1.39	3.00	3.00	20100

STRAIGHT-SHANK RDA/DA COLLET CHUCKS



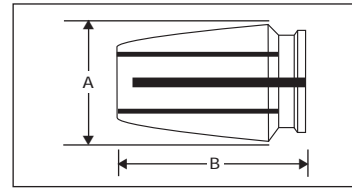
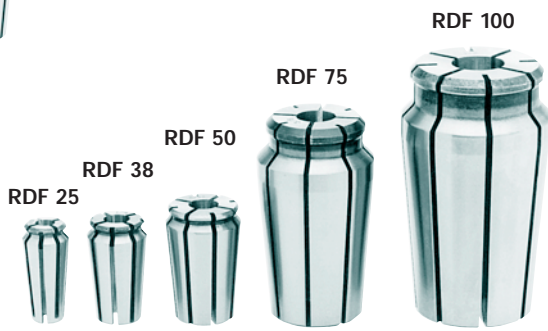
Wrenches are sold separately. See page 30

Part No.	Collet Series	Collet Range	A	B	D	Nut
RDA012300	DA300	0.047 - 0.250	0.50	6.88	0.562	RDAN300
RDA034200	DA200	0.062 - 0.375	0.75	7.23	0.812	RDAN200
RDA100100	DA100	0.062 - 0.562	1.00	7.50	1.062	RDAN100
RDA125180	DA180	0.062 - 0.750	1.25	7.41	1.437	RDAN180

RDA/DA



## RDF/AF COLLET SYSTEMS



	A	B
RDF 25	0.44	1.00
RDF 38	0.56	1.03
RDF 50	0.72	1.16
RDF 75	1.13	2.02
RDF 100	1.45	2.50

Interchangeable with Universal Acura-Flex style collets.  
Acura-Flex is a registered trademark of Universal Engineering.

Collapse per collet: 1/64 in.

NOTE: RDF 50, 75 & 100 available sealed for coolant-through applications.

### RDF/AF 25 COLLETS

INCH SIZES	
(in.)	Part No.
1/32	RDF0
3/64	RDF00
1/16	RDF000
5/64	RDF001
3/32	RDF002
7/64	RDF003
1/8	RDF005
9/64	RDF006

INCH SIZES	
(in.)	Part No.
5/32	RDF007
11/64	RDF008
3/16	RDF009
13/64	RDF011
7/32	RDF012
15/64	RDF013
1/4	RDF014

METRIC SIZES	
(mm.)	Part No.
3	RDF004
5	RDF010

Other metric sizes available on request.

#### RDF 25 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
RDF015	12	1/16-1/4	1/64

### RDF/AF 38 COLLETS

INCH SIZES	
(in.)	Part No.
1/16	RDF020
5/64	RDF021
3/32	RDF022
7/64	RDF023
1/8	RDF025
9/64	RDF026
5/32	RDF027
11/64	RDF028
3/16	RDF029
13/64	RDF031
7/32	RDF032

INCH SIZES	
(in.)	Part No.
15/64	RDF033
1/4	RDF034
17/64	RDF035
9/32	RDF037
19/64	RDF038
5/16	RDF039
21/64	RDF040
11/32	RDF041
23/64	RDF043
3/8	RDF044

METRIC SIZES	
(mm.)	Part No.
3	RDF024
5	RDF030
7	RDF036
9	RDF042

Other metric sizes available on request.

#### RDF 38 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
RDF045	21	1/16-3/8	1/64

### RDF/AF 50 COLLETS

INCH SIZES	
(in.)	Part No.
7/64	RDF054
1/8	RDF055
9/64	RDF056
5/32	RDF057
11/64	RDF058
3/16	RDF059
13/64	RDF061
7/32	RDF062
15/64	RDF063
1/4	RDF064
17/64	RDF065
9/32	RDF067
19/64	RDF068

INCH SIZES	
(in.)	Part No.
5/16	RDF069
21/64	RDF070
11/32	RDF071
23/64	RDF073
3/8	RDF074
25/64	RDF075
13/32	RDF076
27/64	RDF077
7/16	RDF078
29/64	RDF079
15/32	RDF080
31/64	RDF081
1/2	RDF082

METRIC SIZES	
(mm.)	Part No.
5	RDF060
7	RDF066
9	RDF072

Other metric sizes available on request.

#### RDF 50 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
RDF083	25	7/64-1/2	1/64



RDF/AF 75 COLLETS

INCH SIZES	
(in.)	Part No.
7/64	RDF094
1/8	RDF095
9/64	RDF096
5/32	RDF097
11/64	RDF098
3/16	RDF099
13/64	RDF101
7/32	RDF102
15/64	RDF103
1/4	RDF104
17/64	RDF105
9/32	RDF107
19/64	RDF108
5/16	RDF109
21/64	RDF110
11/32	RDF111
23/64	RDF113
3/8	RDF114
25/64	RDF115
13/32	RDF116
27/64	RDF117
7/16	RDF118

INCH SIZES	
(in.)	Part No.
29/64	RDF119
15/32	RDF120
31/64	RDF121
1/2	RDF122
33/64	RDF123
17/32	RDF124
35/64	RDF125
9/16	RDF126
37/64	RDF127
19/32	RDF128
39/64	RDF129
5/8	RDF130
41/64	RDF131
21/32	RDF132
43/64	RDF133
11/16	RDF134
45/64	RDF135
23/32	RDF136
47/64	RDF137
3/4	RDF138
49/64	RDF139
25/32	RDF140

METRIC SIZES	
(mm.)	Part No.
5	RDF100
7	RDF106
9	RDF112

Other metric sizes available on request.

RDF 75 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
RDF141	42	7/64-3/4	1/64
RDF142	21	1/8-3/4	1/32
RDF143	11	1/8-3/4	1/16

RDF/AF 100 COLLETS

INCH SIZES	
(in.)	Part No.
13/64	RDF160
7/32	RDF161
15/64	RDF162
1/4	RDF163
17/64	RDF164
9/32	RDF166
19/64	RDF167
5/16	RDF168
21/64	RDF169
11/32	RDF170
23/64	RDF172
3/8	RDF173
25/64	RDF174
13/32	RDF175
27/64	RDF176
7/16	RDF177
29/64	RDF178
15/32	RDF179

INCH SIZES	
(in.)	Part No.
31/64	RDF180
1/2	RDF181
33/64	RDF182
17/32	RDF183
35/64	RDF184
9/16	RDF185
37/64	RDF186
19/32	RDF187
39/64	RDF188
5/8	RDF189
41/64	RDF190
21/32	RDF191
43/64	RDF192
11/16	RDF193
45/64	RDF194
23/32	RDF195
47/64	RDF196

INCH SIZES	
(in.)	Part No.
3/4	RDF197
49/64	RDF198
25/32	RDF199
51/64	RDF200
13/16	RDF201
53/64	RDF202
27/32	RDF203
55/64	RDF204
7/8	RDF205
57/64	RDF206
29/32	RDF207
59/64	RDF208
15/16	RDF209
61/64	RDF210
31/32	RDF211
63/64	RDF212
1	RDF213

METRIC SIZES	
(mm.)	Part No.
7	RDF165
9	RDF171

Other metric sizes available on request.

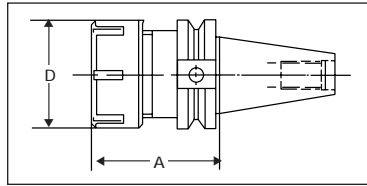
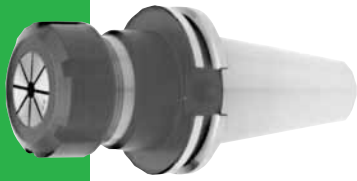
RDF 100 Collet Sets

Part No.	No. of Pcs.	Range (in.)	Increment
RDF215	51	7/32-1	1/64
RDF218	41	3/8-1	1/64
RDF216	26	7/32-1	1/32
RDF217	13	1/4-1	1/16

RDF/AF



## CAT (V-flange) RDF/AF COLLET CHUCKS

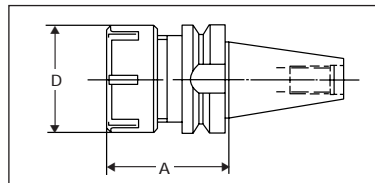
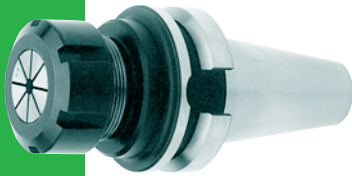


Wrenches are sold separately. See page 30

	Part No.	Collet Type	A (in.)	D (in.)	Ret. Knob Threading	Nut	Wrench
CAT 40	C40RDF038	RDF 38	2.72	1.06	5/8-11	C9400002	—
	C40RDFE038	RDF 38	3.75	1.06	5/8-11	C9400002	—
	C40RDF050	RDF 50	2.72	1.34	5/8-11	C9400020	—
	C40RDF075	RDF 075	2.72	1.94	5/8-11	C9400005	22132
	C40RDFE075	RDF 075	6.00	1.94	5/8-11	C9400005	22132
	C40RDF100	RDF 100	3.00	2.48	5/8-11	C940021	22140
	C40RDFE100	RDF 100	6.00	6.00	5/8-11	C940021	22140
CAT 45	C45RDF100	RDF 100	3.88	2.48	3/4- 10	C940021	22140
	C45RDFE100	RDF 100	6.00	2.48	3/4- 10	C940021	22140
CAT 50	C50RDF100	RDF 100	3.00	2.48	1 - 8	C940021	22140
	C50RDFE100	RDF 100	6.00	2.48	1 - 8	C940021	22140

## BT RDF/AF COLLET CHUCKS

RDF/AF

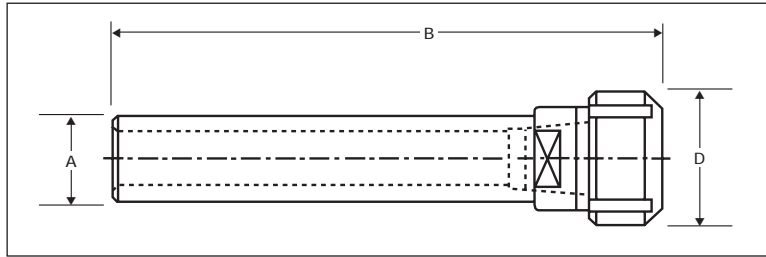


Wrenches are sold separately. See page 30

	Part No.	Collet Type	A (in.)	D (in.)	Ret. Knob Threading	Nut	Wrench
BT 40	B40RDF075	RDF 75	3.12	1.94	M16	C9400005	22132
	B40RDF100	RDF 100	3.25	2.48	M16	C940021	22140

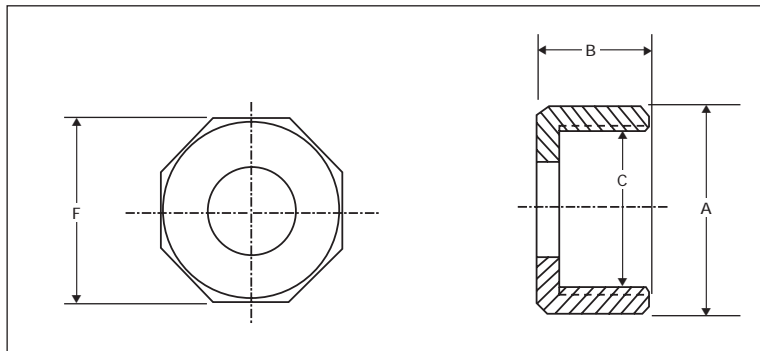


RDF/AF COLLET EXTENSIONS

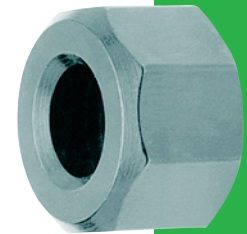


Part No.	Collet Type	A (in.)	B (in.)	D (in.)	Nut	Wrench
RDF90525	RDF 25	0.50	7.00	0.73	C9400022	
RDF90538	RDF 38	0.75	7.00	1.08	C9400002	
RDF90750	RDF 50	0.75	7.50	1.34	C9400020	
RDF90375	RDF 75	1.00	7.00	1.96	C9400005	22132

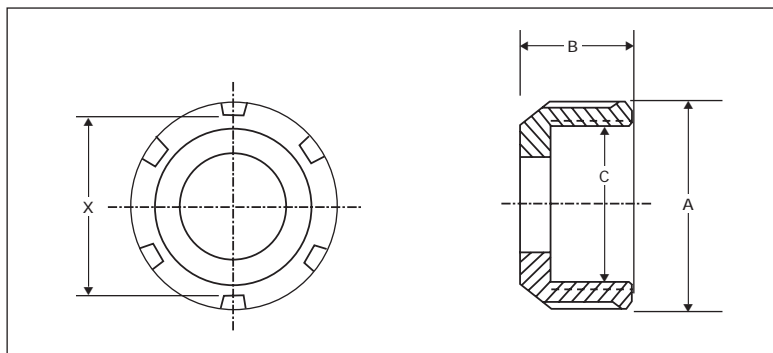
RDF/AF NUTS & WRENCHES



Part No.	Collet Type	A (in.)	B (in.)	C (Thread)	F (Flat)
C9400022	RDF 25	0.73	0.54	9/16-28	0.68
C9400002	RDF 38	1.06	0.62	13/16-12	0.99
C9400020	RDF 50	1.34	0.69	1-12	1.24



RDF/AF



Part No.	Collet Type	A (in.)	B (in.)	C (Thread)	X (Spanner)	Wrench
C9400005	RDF 75	1.96	1.06	1-1/2-12	1.74	22132
C9400021	RDF 100	2.48	1.19	2-12	2.23	22140

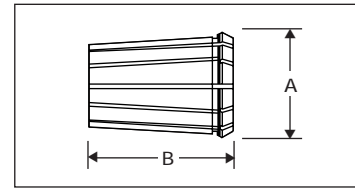




RDO COLLET SYSTEMS



Collapse per collet: 0.5 mm (0.019 in.)  
Precision per DIN 6388B \*Form A



	A		B	
	mm.	in.	mm.	in.
RDO 16	14.5	0.57	26.0	1.03
RDO 20	20.0	0.78	34.0	1.33
RDO 25	25.5	1.00	40.0	1.57
RDO 35	35.3	1.39	52.0	2.05
RDO 44	44.0	1.73	60.0	2.36

RDO 16 COLLETS

INCH SIZES	
(in.)	Part No.
1/8	413001
3/16	413002
1/4	413003
5/16	413004
3/8	413005

NOTE: Form A style

RDO 20 COLLETS

METRIC SIZES	
(mm)	Part No.
2	414102
3	414103
4	414104
5	414105
6	414106
7	414107
8	414108
9	414109
10	414110
11	414111
12	414112
13	414113

INCH SIZES	
(in.)	Part No.
1/8	414001
3/16	414002
1/4	414003
5/16	414004
3/8	414005
7/16	414006
1/2	414007

RDO 25 COLLETS

METRIC SIZES	
(mm.)	Part No.
2	4150001
2.5	4150002
3	4150003
3.5	4150004
4	4150005
4.5	4150006
5	4150007
5.5	4150008
6	4150009
6.5	4150010
7	4150011
7.5	4150012
8	4150013
8.5	4150014
9	4150015

METRIC SIZES	
(mm.)	Part No.
9.5	4150016
10	4150017
10.5	4150018
11	4150019
11.5	4150020
12	4150021
12.5	4150022
13	4150023
13.5	4150024
14	4150025
14.5	4150026
15	4150027
15.5	4150028
16	4150029

INCH SIZES	
(in.)	Part No.
1/16	4151001
5/64	4151002
3/32	4151003
7/64	4151004
1/8	4151005
9/64	4151006
5/32	4151007
11/64	4151008
3/16	4151009
13/64	4151010
7/32	4151011
15/64	4151012
1/4	4151013
17/64	4151014
9/32	4151015
19/64	4151016
5/16	4151017
21/64	4151018
11/32	4151019

INCH SIZES	
(in.)	Part No.
23/64	4151020
3/8	4151021
25/64	4151022
13/32	4151023
27/64	4151024
7/16	4151025
29/64	4151026
15/32	4151027
31/64	4151028
1/2	4151029
33/64	4151030
17/32	4151031
35/64	4151032
9/16	4151033
37/64	4151034
19/32	4151035
39/64	4151036
5/8	4151037

RDO 25 Collet Sets

Part No.	No. of Pcs.	Range	Increment
4150030	29	2-16 mm.	0.5 mm.
4151038	36	1/16-5/8 in.	1/64 in.
4151110	9	1/8-5/8 in.	1/16 in.

NOTE: Sealed collets available for coolant-through applications.

RDO



RDO 35 COLLETS

METRIC SIZES		METRIC SIZES		INCH SIZES	
(mm.)	Part No.	(mm.)	Part No.	(in.)	Part No.
2	4620001	14	4620025	1/8	4621001
2.5	4620002	14.5	4620026	3/16	4621002
3	4620003	15	4620027	1/4	4621003
3.5	4620004	15.5	4620028	5/16	4621004
4	4620005	16	4620029	3/8	4621005
4.5	4620006	16.5	4620030	7/16	4621006
5	4620007	17	4620031	1/2	4621007
5.5	4620008	17.5	4620032	9/16	4621008
6	4620009	18	4620033	5/8	4621009
6.5	4620010	18.5	4620034	11/16	4621010
7	4620011	19	4620035	3/4	4621011
7.5	4620012	19.5	4620036	13/16	4621012
8	4620013	20	4620037	7/8	4621013
8.5	4620014	20.5	4620038	15/16	4621014
9	4620015	21	4620039	1	4621015
9.5	4620016	21.5	4620040		
10	4620017	22	4620041		
10.5	4620018	22.5	4620042		
11	4620019	23	4620043		
11.5	4620020	23.5	4620044		
12	4620021	24	4620045		
12.5	4620022	24.5	4620046		
13	4620023	25	4620047		
13.5	4620024				

NOTE: Sealed collets available for coolant through applications.

RDO 35 Collet Sets

Part No.	No. of Pcs.	Range	Increment
4620048	47	2-25 mm.	0.5 mm.
4621016	15	1/8-1 in.	1/16 in.

RDO 44 COLLETS

METRIC SIZES		METRIC SIZES		METRIC SIZES		INCH SIZES	
(mm.)	Part No.	(mm.)	Part No.	(mm.)	Part No.	(in.)	Part No.
4	4670001	13.5	4670020	23	4670039	1/8	4671001
4.5	4670002	14	4670021	23.5	4670040	3/16	4671002
5	4670003	14.5	4670022	24	4670041	1/4	4671003
5.5	4670004	15	4670023	24.5	4670042	5/16	4671004
6	4670005	15.5	4670024	25	4670043	3/8	4671005
6.5	4670006	16	4670025	25.5	4670044	7/16	4671006
7	4670007	16.5	4670026	26	4670045	1/2	4671007
7.5	4670008	17	4670027	26.5	4670046	9/16	4671008
8	4670009	17.5	4670028	27	4670047	5/8	4671009
8.5	4670010	18	4670029	27.5	4670048	11/16	4671010
9	4670011	18.5	4670030	28	4670049	3/4	4671011
9.5	4670012	19	4670031	28.5	4670050	13/16	4671012
10	4670013	19.5	4670032	29	4670051	7/8	4671013
10.5	4670014	20	4670033	29.5	4670052	15/16	4671014
11	4670015	20.5	4670034	30	4670053	1	4671015
11.5	4670016	21	4670035	30.5	4670054	1-1/16	4671016
12	4670017	21.5	4670036	31	4670055	1-1/8	4671017
12.5	4670018	22	4670037	31.5	4670056	1-3/16	4671018
13	4670019	22.5	4670038	32	4670057	1-1/4	4671019

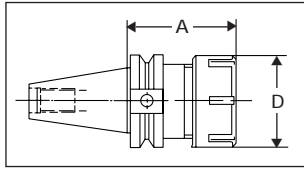
RDO 44 Collet Sets

Part No.	No. of Pcs.	Range	Increment
4670058	57	4-32 mm.	0.5 mm.
4671020	19	1/8-1-1/4 in.	1/16 in.

RDO



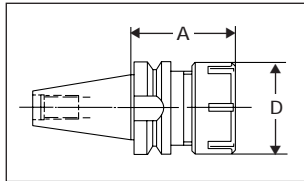
## TC DIN RDO COLLET CHUCKS



Wrenches are sold separately. See page 30

Part No.	Description	A		D		Ret. Knob Threading	Nut	Wrench
		(mm.)	(In.)	(mm.)	(In.)			
655224	TC 40/RDO 25	50	1.97	43	1.69	M16	KM/RDO 25	HSO 25
655425	TC 40/RDO 25	100	3.94	43	1.69	M16	KM/RDO 25	HSO 25
655426	TC 40/RDO 35	80	3.15	60	2.36	M16	KM/RDO 35	HSO 35
655436	TC 45/RDO 35	70	2.76	60	2.36	M20	KM/RDO 35	HSO 35
675447	TC 50/RDO 35	80	3.15	60	2.36	M24	KM/RDO 35	HSO 35
655427	TC 40/RDO 44	80	3.15	72	2.83	M16	KM/RDO 44	HSO 44
655437	TC 45/RDO 44	70	2.76	72	2.83	M20	KM/RDO 44	HSO 44
675448	TC 50/RDO 44	80	3.15	72	2.83	M24	KM/RDO 44	HSO 44

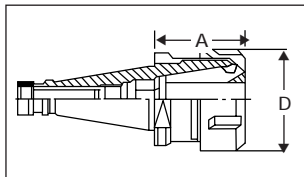
## BT RDO COLLET CHUCKS



Wrenches are sold separately. See page 30

Part No.	Description	A		D		Ret. Knob Threading	Nut	Wrench
		(mm.)	(In.)	(mm.)	(In.)			
1635424	BT40/RDO 25	60	2.36	43	1.69	M16	KM/RDO 25	HSO 25
1635425	BT40/RDO 35	80	3.15	60	2.36	M16	KM/RDO 35	HSO 35
1655447	BT50/RDO 35	90	3.54	60	2.36	M24	KM/RDO 35	HSO 35
1635427	BT40/RDO 44	90	3.54	72	2.83	M16	KM/RDO 44	HSO 44
1655448	BT50/RDO 44	100	3.94	72	2.83	M24	KM/RDO 44	HSO 44

## NMTB RDO COLLET CHUCKS



Wrenches are sold separately. See page 30

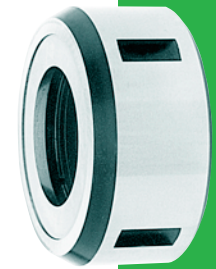
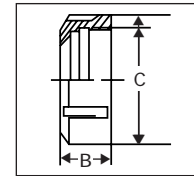
Part No.	Description	A		D		Ret. Knob Threading	Nut	Wrench
		(mm.)	(In.)	(mm.)	(In.)			
2635425	NMT40/RDO 35	80	3.15	60	2.36	5/8-11	KM/RDO 35	HSO 35
2635426	NMT50/RDO 35	80	3.15	60	2.36	1-8	KM/RDO 35	HSO 35
2635427	NMT40/RDO 44	80	3.15	72	2.83	5/8-11	KM/RDO 44	HSO 44
2635428	NMT50/RDO 44	80	3.15	72	2.83	1-8	KM/RDO 44	HSO 44





RDO CLAMPING NUTS (Ball-Bearing)

Part No.	Collet	D		B		C
		(mm.)	(In.)	(mm.)	(In.)	
30320	RDO 20	35	1.38	20	0.79	M27 X 1.5
30325	KM/RDO 25	43	1.69	24	0.94	M33 X 1.5
30335	KM/RDO 35	60	2.36	30	1.18	M48 X 2.0
30344	KM/RDO 44	72	2.83	34	1.33	M68 X 2.5



RDO WRENCH

Part No.	Type
22220	HSO 20
22225	HSO 25
22235	HSO 35
22244	HSO 44



RDO MASTER TOOLING SETS

Complete precision milling system in fitted wooden box. Sets include collets, collet chuck and wrench.



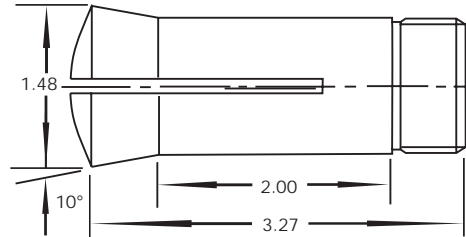
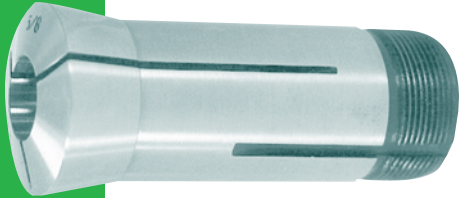
RDO

Part No.	Collet Type	Collets Per Set	Range	Chuck	Nut	Wrench
MSO46216	RDO 35	15	1/8 - 1 in.	NMTB40	KM/RDO 35	HSO 35
MSO46217	RDO 35	15	1/8 - 1 in.	NMTB50	KM/RDO 35	HSO 35
MSO46721	RDO 44	19	1/8 - 1 in.	NMTB40	KM/RDO 44	HSO 44
MSO46722	RDO 44	19	1/8 - 1 in.	NMTB50	KM/RDO 44	HSO 44



## 5C ROUND COLLETS — INCH SIZES

- Hardened and ground
- External thread = 1.234 x 20 RH
- Internal thread = 1.047 x 24 RH



Part No.	Size	Part No.	Size	Part No.	Size	Part No.	Size
5CR04	1/16"	5CR21	21/64"	5CR37	37/64"	5CR53	53/64"
5CR05	5/64"	5CR22	11/32"	5CR38	19/32"	5CR54	27/32"
5CR06	3/32"	5CR23	23/64"	5CR39	39/64"	5CR55	55/64"
5CR07	7/64"	5CR24	3/8"	5CR40	5/8"	5CR56	7/8"
5CR08	1/8"	5CR25	25/64"	5CR41	41/64"	5CR57	57/64"
5CR09	9/64"	5CR26	13/32"	5CR42	21/32"	5CR58	29/32"
5CR10	5/32"	5CR27	27/64"	5CR43	43/64"	5CR59	59/64"
5CR11	11/64"	5CR28	7/16"	5CR44	11/16"	5CR60	15/16"
5CR12	3/16"	5CR29	29/64"	5CR45	45/64"	5CR61	61/64"
5CR13	13/64"	5CR30	15/32"	5CR46	23/32"	5CR62	31/32"
5CR14	7/32"	5CR31	31/64"	5CR47	47/64"	5CR63	63/64"
5CR15	15/64"	5CR32	1/2"	5CR48	3/4"	5CR64	1"
5CR16	1/4"	5CR33	33/64"	5CR49	49/64"	5CR65	1-1/64"
5CR17	17/64"	5CR34	17/32"	5CR50	25/32"	5CR66	1-1/32"
5CR18	9/32"	5CR35	35/64"	5CR51	51/64"	5CR67	1-3/64"
5CR19	19/64"	5CR36	9/16"	5CR52	13/16"	5CR68	1-1/16"
5CR20	5/16"						

## 5C COLLET SETS — INCH SIZES

Part No.	Description	Part No.	Description
5CRS07	7 Pc. Set — 1/4 - 1" in 1/8" Incr.	5CRS33	33 Pc. Set — 1/16 - 1-1/16" in 1/32" Incr.
5CRS15	15 Pc. Set — 1/8 - 1" in 1/16" Incr.	5CRS65	65 Pc. Set — 1/16 - 1-1/16" in 1/64" Incr.
5CRS17	17 Pc. Set — 1/16 - 1-1/16" in 1/16" Incr.		



## 5C ROUND COLLETS — METRIC SIZES

Part No.	Size	Part No.	Size	Part No.	Size	Part No.	Size
5CRM03	3mm	5CRM09	9mm	5CRM15	15mm	5CRM21	21mm
5CRM04	4mm	5CRM10	10mm	5CRM16	16mm	5CRM22	22mm
5CRM05	5mm	5CRM11	11mm	5CRM17	17mm	5CRM23	23mm
5CRM06	6mm	5CRM12	12mm	5CRM18	18mm	5CRM24	24mm
5CRM07	7mm	5CRM13	13mm	5CRM19	19mm	5CRM25	25mm
5CRM08	8mm	5CRM14	14mm	5CRM20	20mm	5CRM26	26mm

## 5C HEX COLLETS

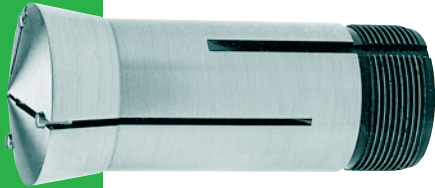
Part No.	Size	Part No.	Size	Part No.	Size	Part No.	Size
5CH08	1/8"	5CH24	3/8"	5CH36	9/16"	5CH48	3/4"
5CH12	3/16"	5CH28	7/16"	5CH40	5/8"	5CH52	13/16"
5CH16	1/4"	5CH32	1/2"	5CH44	11/16"	5CH56	7/8"
5CH20	5/16"						

## 5C SQUARE COLLETS

Part No.	Size	Part No.	Size	Part No.	Size	Part No.	Size
5CS08	1/8"	5CS20	5/16"	5CS32	1/2"	5CS40	5/8"
5CS12	3/16"	5CS24	3/8"	5CS36	9/16"	5CS44	11/16"
5CS16	1/4"	5CS28	7/16"				



## 5C EMERGENCY COLLET



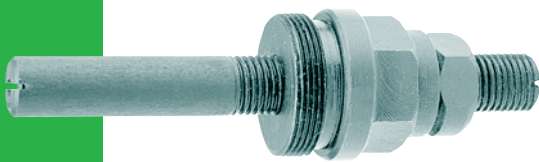
Part No.	Description
5CEM	5C Emergency Collet With Pins

## 5C STEP COLLET



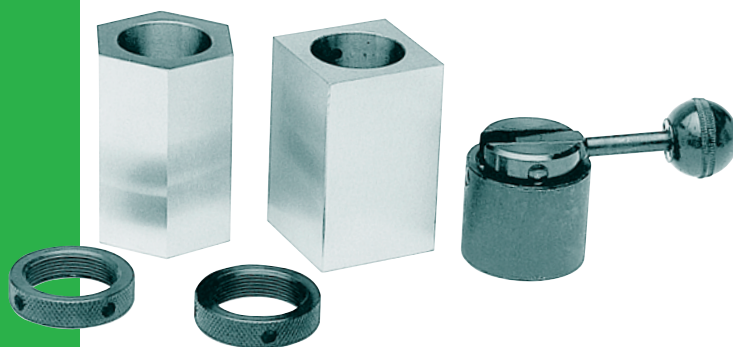
Part No.	Description
5CST2	2" 5C Step Collet
5CST3	3" 5C Step Collet
5CST4	4" 5C Step Collet
5CST5	5" 5C Step Collet
5CST6	6" 5C Step Collet

## 5C COLLET ADJUSTABLE BACKSTOP



Part No.	Description
5CABS	Adjustable Backstop For 5C Collets

## 5C COLLET HOLDER SET

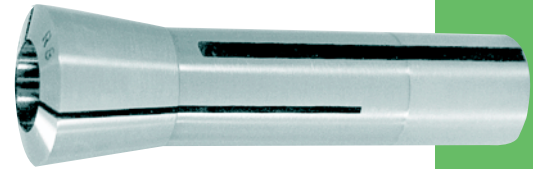
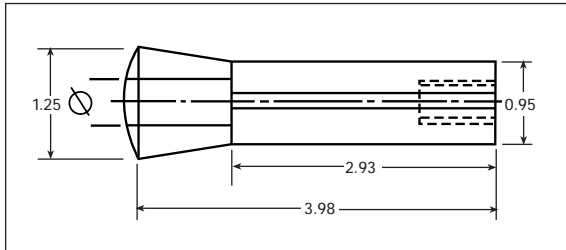


Part No.	Description
5CCHSET	5C Collet Holder Set With Hex, Square and Lever
5CHCH	Hex 5C Collet Holder
5CSCH	Square 5C Collet Holder
5CQAL	Quick-Action Lever For 5C Collet Holders

5C/R8



R8 COLLETS — INCH SIZES



Part No.	Size	Part No.	Size	Part No.	Size	Part No.	Size
R802	1/16"	R808	1/4"	R814	7/16"	R820	5/8"
R803	3/32"	R809	9/32"	R815	15/32"	R821	21/32"
R804	1/8"	R810	5/16"	R816	1/2"	R822	11/16"
R805	5/32"	R811	11/32"	R817	17/32"	R823	23/32"
R806	3/16"	R812	3/8"	R818	9/16"	R824	3/4"
R807	7/32"	R813	13/32"	R819	19/32"	R826	13/16"
						R828	7/8"

R8 COLLET SETS — INCH SIZES

Part No.	Description	Part No.	Description
R8S06	6 Pc. Set — 1/8 - 3/4" in 1/8" Incr.	R8S23	23 Pc. Set — 1/16 - 3/4" in 1/32" Incr.
R8S11	11 Pc. Set — 1/8 - 3/4" in 1/16" Incr.		

R8 COLLETS — METRIC SIZES

Part No.	Size	Part No.	Size	Part No.	Size	Part No.	Size
R8M03	3mm	R8M08	8mm	R8M13	13mm	R8M18	18mm
R8M04	4mm	R8M09	9mm	R8M14	14mm	R8M19	19mm
R8M05	5mm	R8M10	10mm	R8M15	15mm	R8M20	20mm
R8M06	6mm	R8M11	11mm	R8M16	16mm	R8M21	21mm
R8M07	7mm	R8M12	12mm	R8M17	17mm	R8M22	22mm

5C/R8

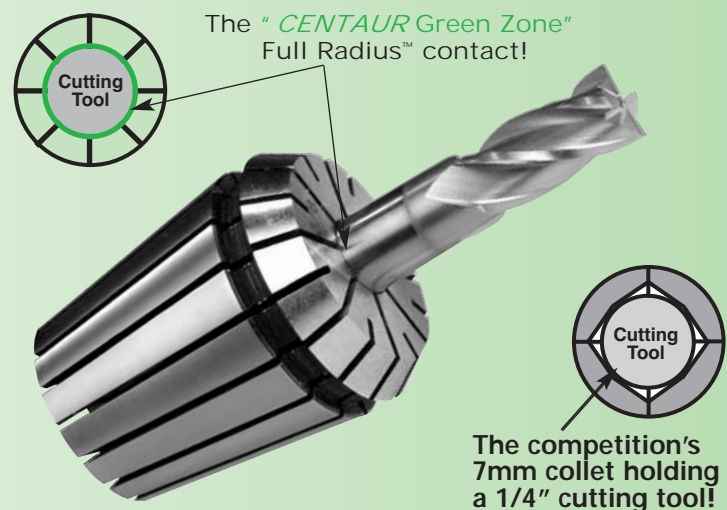
## COLLETS 101 FROM **CENTAUR**



Visit [www.centaurools.com](http://www.centaurools.com) to view **COLLETS 101**, a comprehensive program containing collet selection criteria.

The precision and strength of a tool holding collet largely depends on the amount of surface contact maintained on the cutting tool! Did you know that **CENTAUR** is the collet manufacturer that offers the widest variety of exact size collets that maintain "**Full Radius™**" contact with the cutting tool!

**CENTAUR**  
PRECISION TOOLS INC.  
An ISO 9001:2000 Certified Company



# CENTAUR

## Precision Tapping Systems



2008

*PUT CENTAUR'S COMPLETE LINE OF PRECISION-ENGINEERED TAPPING SYSTEMS TO WORK FOR YOU*

For a wide array of tapping needs, Centaur is your single-source supplier:

- Synchronous-feed or tension-compression, quick release tap holders
- Standard and coolant-through tapping systems
- Quick-change tap adapters interchangeable with the industry standard
- Tapping collets, adapters and floating holders

*AND CENTAUR SUPPORTS YOU WITH RESPONSIVE CUSTOMER SERVICE*



- Reliable Technical Support
- Delivery From A Huge Available Inventory



- Competitive Pricing
- Guaranteed Quality

*Specifications subject to change without notice.*

**CENTAUR PRECISION TOOLS**

**2008**

## TABLE OF CONTENTS

<i>Quick-Change Tap Holders</i>	<i>Page 79</i>
<i>Positive-Drive Tap Adapters</i>	<i>Page 80</i>
<i>Torque Control Tap Adapters</i>	<i>Page 81</i>
<i>Quick-Change Coolant-Through Tap Holders</i>	<i>Page 82</i>
<i>CWE External Coolant Flow Tap Adapters</i>	<i>Page 82</i>
<b>NEW !</b> <i>CEN-CHRO Tapping Chucks</i>	<i>Page 83</i>
<i>RDG/TG Rigid Tapping Collets With Square Drive</i>	<i>Page 84</i>
<i>RD/ER Rigid Tapping Collets With Square Drive</i>	<i>Page 85</i>
<i>RDT Axial Compensating Tap Collets</i>	<i>Page 86</i>
<i>BF Adapters For RD/ER Collets</i>	<i>Page 87</i>
<i>Floating Tap Holders</i>	<i>Page 87</i>
<i>CDSPL All-Purpose Tapping Attachment</i>	<i>Page 88</i>

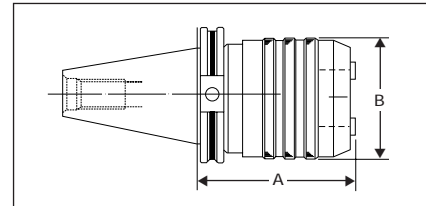
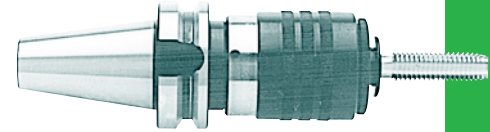
**Toll-Free: 888-COL-LETS**



TAPER-SHANK TAP HOLDERS

RIGID TAP HOLDERS

Part No.	Description	A	B	Adapter
CTR4001	CAT40 / MRT#1	2.95	1.42	CWE 1
CTR4002	CAT40 / MRT#2	3.55	2.05	CWE 2
CTR5001	CAT50 / MRT#1	2.95	1.42	CWE 3
CTR5002	CAT50 / MRT#2	3.55	2.05	CWE 2
CTR5003	CAT50 / MRT#3	4.62	3.07	CWE 3
BTR3000	BT30 / MRT#0	3.38	1.02	CWE 0
BTR3001	BT30 / MRT#1	3.58	1.42	CWE 1
BTR3002	BT30 / MRT#2	4.16	2.05	CWE 2
BTR4001	BT40 / MRT#1	2.63	1.42	CWE 1
BTR4002	BT40 / MRT#2	3.23	2.05	CWE 2
BTR5001	BT50 / MRT#1	3.46	1.42	CWE 1
BTR5002	BT50 / MRT#2	4.05	2.05	CWE 2
BTR5003	BT50 / MRT#3	5.37	3.57	CWE 3



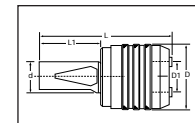
TENSION-COMPRESSION TAP HOLDERS

Part No.	Description	A	B	Compensation		Adapter
				T	C	
CTC4001	CAT40 / MTC#1	2.95	1.42	0.30	0.30	CWE 1
CTC4002	CAT40 / MTC#2	3.85	2.16	0.49	0.49	CWE 2
CTC5001	CAT50 / MTC#1	3.26	1.42	0.30	0.30	CWE 1
CTC5002	CAT50 / MTC#2	3.85	2.16	0.49	0.49	CWE 2
CTC5003	CAT50 / MTC#3	5.79	3.07	0.79	0.79	CWE 3
BTC3001	BT30 / MTC#1	3.57	1.42	0.30	0.30	CWE 1
BTC3002	BT30 / MTC#2	4.48	2.16	0.49	0.49	CWE 2
BTC4001	BT40 / MTC#1	2.63	1.42	0.30	0.30	CWE 1
BTC4002	BT40 / MTC#2	3.54	2.16	0.49	0.49	CWE 2
BTC5002	BT50 / MTC#2	4.35	2.16	0.49	0.49	CWE 2
BTC5003	BT50 / MTC#3	5.61	3.07	0.79	0.79	CWE 3

STRAIGHT-SHANK TAP HOLDERS

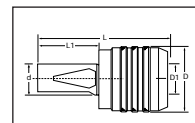
RIGID TAP HOLDERS

Part No.	Description	d	D	D1	L	L1
MRT10000	MRT#0 / 1"	1.00	1.02	0.51	3.38	2.00
MRT07501	MRT#1 / 3/4"	0.75	1.42	0.75	3.15	1.57
MRT07502	MRT#2 / 3/4"	0.75	2.05	1.22	3.74	1.57
MRT10001	MRT#1 / 1"	1.00	1.42	0.75	3.58	2.01
MRT10002	MRT#2 / 1"	1.00	2.05	1.22	4.17	2.01
MRT15003	MRT#3 / 1-1/2"	1.50	3.07	2.36	6.25	3.00
MRT20004	MRT#4 / 2"	2.00	3.73	2.37	6.53	2.51



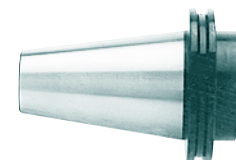
TENSION-COMPRESSION TAP HOLDERS

Part No.	Description	d	D	D1	L	L1	Compensation	
							T	C
MTC07501	MTC#1 / 3/4"	0.75	1.42	0.75	3.15	1.57	0.30	0.30
MTC10001	MTC#1 / 1"	1.00	1.42	0.75	3.58	2.01	0.30	0.30
MTC10002	MTC#2 / 1"	1.00	2.16	1.22	4.49	2.01	0.49	0.49
MTC15003	MTC#3 / 1-1/2"	1.50	3.07	2.36	6.50	3.00	0.79	0.79



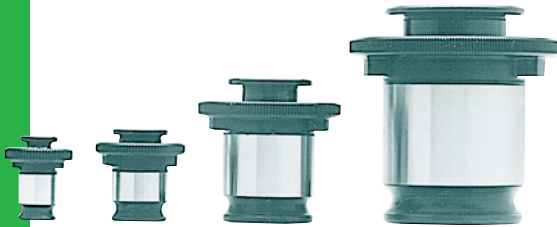
TAP HOLDER SHANKS

Part No.	Description	Taper	Bore	Projection From Gauge Line
CT400100	CAT40 / 1"	CAT-V40	1.00	1.37
CT500100	CAT50 / 1"	CAT-V50	1.00	1.37
CT500150	CAT50 / 1-1/2"	CAT-V5	1.50	1.37
BT300100	BT30 / 1"	BT30	1.00	2.00
BT400100	BT40 / 1"	BT40	1.00	1.40
BT500100	BT50 / 1"	BT50	1.00	1.87
BT500150	BT50 / 1-1/2"	BT50	1.50	1.87



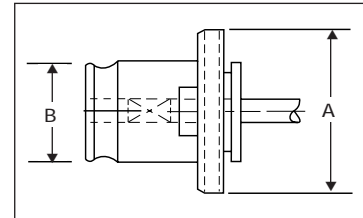
## POSITIVE-DRIVE TAP ADAPTERS

- Fully interchangeable with Bilz and other popular tapping systems
- Engineered for smooth operation and easy release



*TAP ADAPTER  
DIMENSIONS*

	A	B
CWE 0	0.87	0.51
CWE 1	1.18	0.75
CWE 2	1.89	1.22
CWE 3	2.75	1.89
CWE 4	3.62	2.36



Hand Tap Size	Tap Shank Dia.	Part No. CWE 0	Depth Tap Enters	Part No. CWE 1	Depth Tap Enters	Part No. CWE 2	Depth Tap Enters	Part No. CWE 3	Depth Tap Enters	Part No. CWE 4	Depth Tap Enters
0-6	0.141	000006	0.77	100006	0.85	200006	0.85				
#8	0.168	000008	0.84	100008	0.92	200008	0.92				
#10	0.194	000010	0.84	100010	0.92	200010	0.92				
#12	0.220	000012	0.87	100012	0.95	200012	0.95				
1/4	0.255	000250	0.87	100250	0.95	200250	0.95				
5/16	0.318			100312	0.98	200312	1.49				
3/8	0.381			100375	1.05	200375	1.56				
7/16	0.323			100437	1.08	200437	1.59				
1/2	0.367			100500	1.11	200500	1.62				
9/16	0.429			100562	1.17	200562	1.68				
5/8	0.480					200625	1.74				
11/16	0.542					200687	1.81				
3/4	0.590					200750	1.87				
13/16	0.652					200812	1.87	300812	2.42		
7/8	0.697					200875	1.93	300875	2.48		
15/16	0.760							300937	2.48		
1	0.800							301000	2.54	401000	3.60
1 - 1/8	0.896							301125	2.61	401125	3.70
1 - 1/4	1.021							301250	2.73	401250	3.79
1 - 3/8	1.108							301375	2.79	401375	3.86
1 - 1/2	1.233									401500	3.92
1 - 5/8	1.305									401625	3.72
1 - 3/4	1.430									401750	4.04
1 - 7/8	1.519									401875	4.04

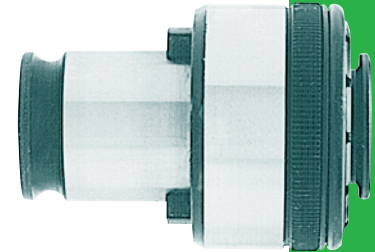
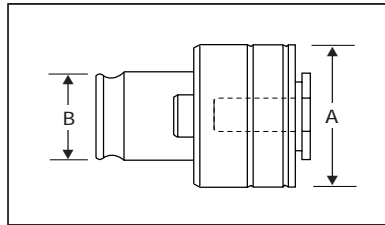
Pipe Tap Size	Tap Shank Dia.	Part No. CWE 1	Depth Tap Enters	Part No. CWE 2	Depth Tap Enters	Part No. CWE 3	Depth Tap Enters	Part No. CWE 4	Depth Tap Enters
1/8 - SS	0.313	105062	1.05	205062	1.05				
1/8 - LS	0.437	105063	1.05	205063	1.05				
1/4P	0.562			205125	1.18				
3/8P	0.700			205375	1.24	305375	1.32		
1/2P	0.687			205500	1.37	305500			
3/4P	0.906					301750	1.55	405750	2.20
1P	1.125					301100	1.68	4051000	2.40
1 1/4P	1.312							4051250	2.60
1 1/2P	1.500							4051500	2.60

NOTE: Metric, DIN and Japanese standard sizes upon special request.

TORQUE CONTROL TAP ADAPTERS

TAP ADAPTER DIMENSIONS

	A	B
CWES 0	0.91	0.51
CWES 1	1.26	0.75
CWES 2	1.97	1.22
CWES 3	2.84	1.89
CWES 4	3.74	2.37



Hand Tap Size	Part No. CWES 0	Part No. CWES 1	Part No. CWES 2	Part No. CWES 3	Part No. CWES 4
0-6	001006	101006			
8	001008	101008			
10	001010	101010			
12	001012	101012			
1/4	001250	101125			
5/16		101312	201312		
3/8		101375	201375		
7/16		101437	201437		
1/2		101500	201500		
9/16		101562	201562		
5/8			201625		
11/16			201687		
3/4			201750		
13/16			201812	310812	
7/8			201875	310875	
15/16				310937	
1				311000	411000
1 - 1/8				311125	411125
1 - 1/4				311250	411250
1 - 3/8				311375	411375
1 - 1/2					411500
1 - 5/8					411625
1 - 3/4					411750
1 - 7/8					411875

Pipe Tap Size	Part No. CWES 1	Part No. CWES 2	Part No. CWES 3	Part No. CWES 4
1/8 - SS	101062			
1/8 - LS	101063			
1/4 P		201126		
3/8 P		201376	311037	
1/2 P		201501	311050	
3/4 P			311075	415750
1" P			311100	4151000
1 1/4 P				4151250
1 1/2 P				4151500

## QUICK-CHANGE COOLANT-THROUGH TAP HOLDERS



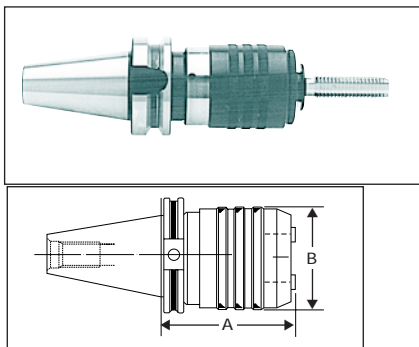
Uses *STANDARD TAP ADAPTERS* for oilhole taps in blind hole applications.



Uses *EXTERNAL COOLANT FLOW ADAPTERS* for standard taps in blind and through-hole applications.

- For use on machines with coolant through the spindle
- Rigid system for synchronous feed tapping
- Improves chip removal and prolongs tool life

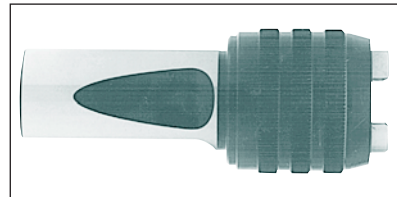
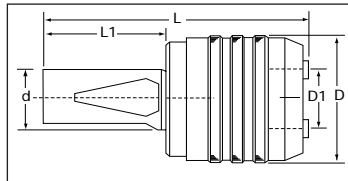
## TAPER SHANKS



Part No.	Description	A	B
CTK4001	CAT40 / MRK#1	2.95	1.42
CTK4002	CAT40 / MRK#2	3.55	2.05
CTK5001	CAT50 / MRK#1	2.95	1.42
CTK5002	CAT50 / MRK#2	3.55	2.05
BTK4001	BT40 / MRK#1	2.63	1.42
BTK4002	BT40 / MRK#2	3.23	2.05
BTK5001	BT50 / MRK#2	4.05	2.05
BTK5002	BT50 / MRK#3	5.37	3.57

## STRAIGHT-SHANK

Part No.	Description	d	D	D1	L	L1
MRK10001	MRK#1 / 1"	1.00	1.42	0.75	3.58	2.01
MRK10002	MRK#2 / 1"	1.00	2.05	1.22	4.17	2.01



## EXTERNAL COOLANT FLOW TAP ADAPTERS

Hand Tap Size	Tap Shank Dia.	Part No. CWEK 1	Part No. CWEK 2
0-6	0.141	107006K	207006K
8	0.168	107008K	207008K
10	0.194	107010K	207010K
12	0.220	107012K	207012K
1/4	0.255	107125	207125K
5/16	0.318	107312	207312K
3/8	0.381	107375	207375K
7/16	0.323	107437	207437K
1/2	0.367	107500	207500K
9/16	0.429	107562	207562K
5/8	0.480		207625K
11/16	0.542		207687K
3/4	0.590		207750K
13/16	0.652		207812K
7/8	0.697		207875K

Pipe Tap Size	Tap Shank Dia.	Part No. CWEK 1	Part No. CWEK 2
1/8 - SS	0.313	175062	275062
1/8 - LS	0.437	175063	275063
1/4	0.562		275125
3/8	0.700		275375
1/2	0.687		275500

NOTE: For standard adapters, see page 82.

**NEW!**

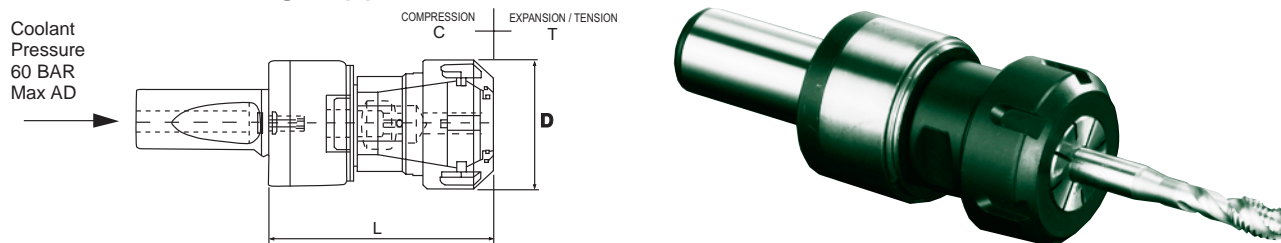
**CEN-CHRO TAPPING CHUCKS**

A new Tapping chuck to maximize efficiency and lower costs in all Rigid Tapping or Synchronous feed Tapping applications.

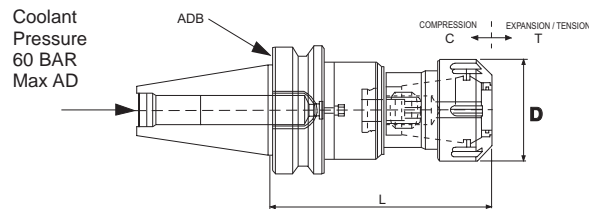
In theory; with a rigid tapping application the machine keeps the relationship between feed rate and rotational forces timed perfectly. Any deviation in the feed rate in relation to the RPM creates unnecessary wear on the tap causing poor tap life and inaccurate tapped holes. The new technology built into the **Cen-Chro Tapping Chucks** compensates for the minute discrepancies between the machines feed rate and RPM throughout the entire tapping cycle. **Cen-Chro Tapping Chucks** have 0.5mm controlled movement in the tension and compression modes to compensate for minute deviations and allow the tap to be influenced only by rotational force, and produce gage perfect threads with depth repeatability.

Increase productivity with the new **Cen-Chro Tapping Chucks** by reducing downtime for tap changes, increased speeds and higher quality tapped holes.

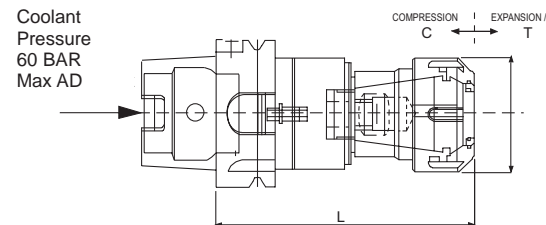
**Cen-Chro Tapping Chucks** use RTS Tapping Collets and RTS Sealed Tapping Collets for coolant through applications.



Style A — Straight Shank



Style B — V-Flange & BT



Style C — HSK

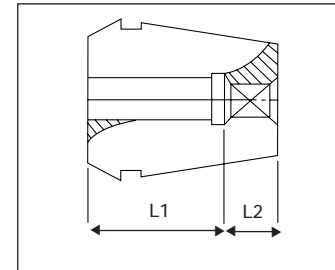
Part Number	Description	Collet Style	Style	G/L	D	Nut	Wrench
MCC1016	RTS 16/1" SS	RTS 16	A	3.4	1.1	30126	22116
MCC1032	RTS 32/1" SS	RTS 32	A	3.4	2.0	30132	22132
MCC1540	RTS 40/1.5 SS	RTS 40	A	4.6	2.5	30140	22140
CCC4016	RTS 16/V40	RTS 16	B	4.4	1.1	30126	22116
CCC4032	RTS 32/V40	RTS 32	B	4.4	2.0	30132	22132
CCC4040	RTS 40/V40	RTS 40	B	5.5	5.5	30140	22140
CCC5016	RTS 16/V50	RTS 16	B	4.2	1.1	30126	22116
CCC5032	RTS 32 V50	RTS 32	B	4.2	2.0	30132	22132
CCC5040	RTS 40/V50	RTS 40	B	4.9	2.5	30140	22140
BCC4016	RTS 16/BT40	RTS 16	B	4.4	1.1	30126	22116
BCC4032	RTS 32/BT40	RTS 32	B	4.4	2.0	30132	22132
BCC4040	RTS 40/BT40	RTS 32	B	5.5	2.5	30140	22140
BCC5016	RTS 16/BT50	RTS 16	B	4.2	1.1	30126	22116
BCC5032	RTS 32/BT50	RTS 32	B	4.2	2.0	30132	22132
BCC5040	RTS 40/BT50	RTS 40	B	5.6	2.5	30140	22140
HCC6316	RTS 16/HSK63A	RTS 16	C	4.4	1.1	30126	22116
HCC6332	RTS 32/HSK63A	RTS 32	C	4.4	2.0	30132	22132
HCC6340	RTS 40/HSK63A	RTS 40	C	5.7	2.5	30140	22140

## RD/ER RIGID TAPPING COLLETS WITH SQUARE DRIVE

- Collet bore is exactly tool diameter for accuracy and rigidity
- Permit synchronous tapping operations using any standard collet chuck
- Available sealed for coolant-through applications

NOTE: Metric, DIN and Japanese standard sizes on request.

Tap Size Range	L1	L2				
		RTS 16	RTS 20	RTS 25	RTS 32	RTS 40
0-6 - 1/4	0.709	0.374	0.531	0.630	0.866	1.102
5/16 - 1/2	0.866		0.374	0.472	0.709	0.945
9/16 - 7/8	0.984			0.374	0.591	0.827
1"	1.102					0.709



Hand Tap Size	Part No. By Collet Series				
	RD 16	RD 20	RD 25	RD 32	RD 40
0-6	161-141	201-141	251-141	321-141	401-141
8	161-168	201-168	251-168	321-168	401-168
10	161-194	201-194	251-194	321-194	401-194
12	161-220	201-220	251-220	321-220	401-220
1/4	161-255	201-255	251-255	321-255	401-255
5/16	161-318	201-318	251-318	321-318	401-318
3/8		201-381	251-381	321-381	401-381
7/16		201-323	251-323	321-323	401-323
1/2		201-367	251-367	321-367	401-367
9/16			251-429	321-429	401-429
5/8			251-480	321-480	401-480
11/16				321-542	401-542
3/4				321-590	401-590
13/16				321-652	401-652
7/8					401-697
15/16					401-760
1					401-800



Pipe Tap Size	Part No. By Collet Series				
	RD 16	RD 20	RD 25	RD 32	RD 40
1/8 PIPE - SS			251-313	321-313	401-313
1/8 PIPE - LS			251-437	321-437	401-437
1/4 PIPE				321-562	401-562
3/8 PIPE					401-700
1/2 PIPE					401-687

**RDG/TG RIGID TAPPING COLLETS WITH SQUARE DRIVE**

- Collet bore is exactly tool diameter for accuracy and rigidity
- Permit synchronous tapping operations using any standard collet chuck
- Available sealed for coolant-through applications

NOTE: Metric, DIN and Japanese standard sizes on request.

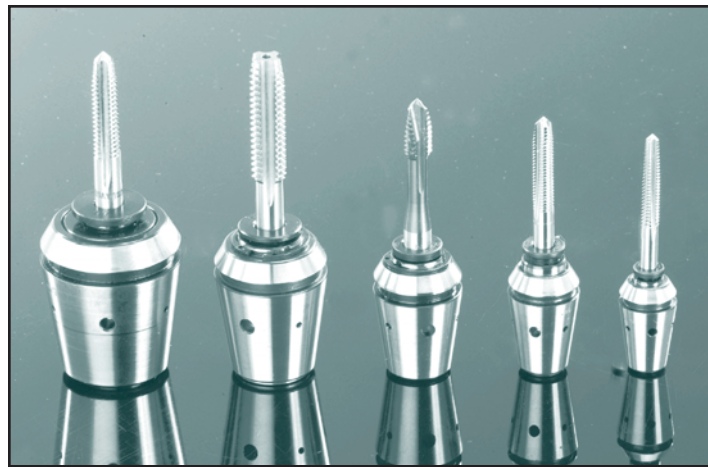


Hand Tap Size	Part No. By Collet Series		
	RDG 75	RDG 100	RDG 150
0-6	52001	72001	
8	52002	72002	
10	52003	72003	
12	52004	72004	
1/4	52005	72005	
5/16	52007	72007	
3/8	52008	72010	
7/16	52009	72008	
1/2	52010	72009	
9/16	52011	72011	
5/8	52013	72013	92001
11/16	52014	72014	
3/4	52015	72016	92002
13/16		72017	
7/8		72019	92003
15/16		72021	
1		72022	92004
1-1/8			92005
1-1/4			92006
1-3/8			92007
1-1/2			92008

Pipe Tap Sizes	Part No. By Collet Series		
	RDG 75	RDG 100	RDG 150
1/8 PIPE-SS	52006	72006	
1/8 PIPE-LS	52012	72012	
1/4 PIPE	52016	72015	92009
3/8 PIPE		72020	92010
1/2 PIPE		72018	92012
3/4 PIPE			92013
1 PIPE			92014
1-1/4 PIPE			92015

## RDT AXIAL COMPENSATING TAPPING COLLETS

- RDT Tapping Collets permit tapping operations using standard RD/ER collet holders
- Quick-change tap removal with solid square drive. Allows tap replacement without removing the tap collet from the chuck, while maintaining consistent tap gage length
- Friction-free ball bearing drive with axial compensation. Helps deter tap breakage on machines with synchronous feed or machines requiring axial compensation



PATENT PENDING

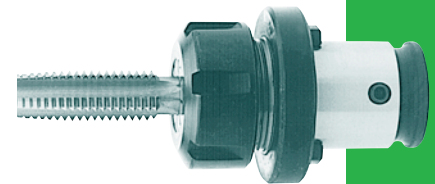
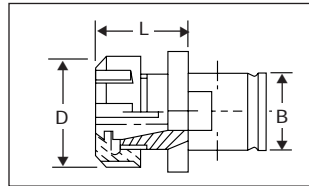
Tap Size	Tap Shank Diameter	Part Number By Collet Series				
		RDT 16	RDT 20	RDT 25	RDT 32	RDT 40
#0-6	0.141	160-141	200-141T	250-141	320-141	400-141
#8	0.168	160-168	200-168	250-168	320-168	400-168
#10	0.194	160-194	200-194	250-194	320-194	400-194
#12	0.220		200-220	250-220	320-220	400-220
1/4"	0.255		200-255	250-255	320-255	400-255
5/16"	0.318			250-318	320-318	400-318
3/8"	0.381			250-381	320-381	400-381
7/16"	0.323			250-323	320-323	400-323
1/2"	0.367			250-367	320-367	400-367
9/16"	0.429				320-429	400-429
5/8"	0.480					400-480
11/16"	0.542					400-542
1/8 PIPE-LS	0.437				320-437	400-437
1/4 PIPE	0.562					400-562

NOTE: Metric, DIN and Japanese sizes available upon request.



**BF ADAPTERS FOR RD/ER COLLETS**

- Quick-change adapters are interchangeable with Bilz and other popular tapping systems
- Collets permit holding ANSI and metric sizes
- Can be used for tapping and drilling

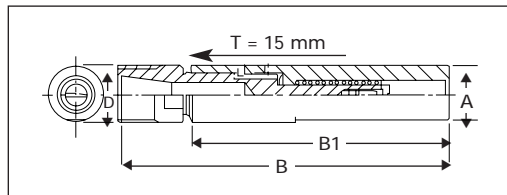


Part No.	Collet Series	Tap Range	B		L		D	
			(mm.)	(In.)	(mm.)	(In.)	(mm.)	(In.)
BF0 1113	RD 11	0-6 - 1/4"	13	0.51	28	1.10	19	0.75
BF1 1619	RD 16	0-6 - 1/2"	19	0.75	25	1.35	28	1.10
BF2 2531	RD 25	0-6 - 3/4"	31	1.22	34	1.34	42	1.65
BF3 3248	RD 32	0-6 - 15/16"	48	1.89	48	1.89	50	1.97
BF3 4048*	RD 40	0-6 - 1-1/8"	48	1.89			63	2.48

\*NOTE: Available upon special request.

**FLOATING TAP HOLDERS**

- Permits tapping using RD/ER 16 collet system
- Ideally suited for applications on Swiss and Japanese automats and lathes

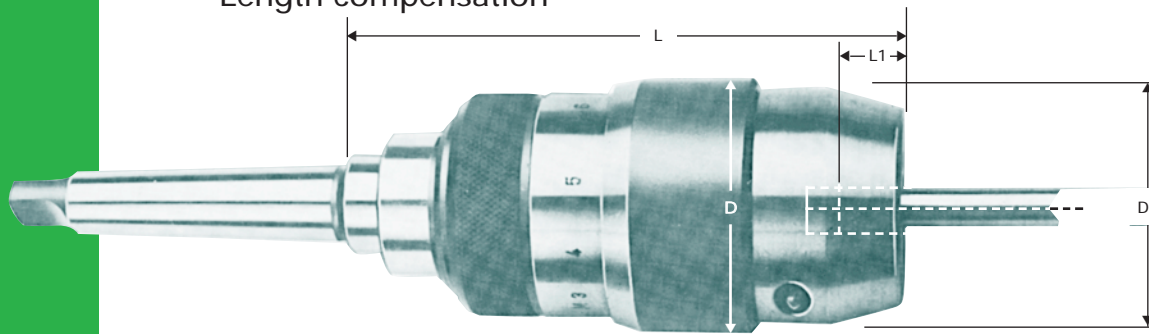


Part No.	A		B		B1		D		Tension		Nut	Wrench
	(mm.)	(In.)	(mm.)	(In.)	(mm.)	(In.)	(mm.)	(In.)	(mm.)	(In.)		
0341660		3/4	136	5.35	60	2.36	28	1.10	15	0.59	RD 16 H	GS 25
0341665		3/4	100	3.94	65	2.56	22	0.87	15	0.59	RD 16 M	E 16 M
0341600T		3/4	176	6.93	100	3.94	28	1.10	15	0.59	RD 16 H	GS 25

## CDSPL ALL-PURPOSE TAPPING ATTACHMENT

For tapping operations on reversible drilling and tapping machines, lathes, mills, and others.

- Double chucking
- Safety chuck
- Radial parallel float
- Length compensation



### PRODUCT FEATURES

The Centaur CDSPL provides a wide-range, twin chucking head for the direct clamping of taps. There is no need for separate collets. An adjustable safety torque clutch helps prevent tap breakage. Radial parallel float compensates for misalignment between hole and tap. Length compensation on compression and tension compensates for the difference between machine feed and tap pitch.

**Chuckling.** High concentricity, firm clamping, safe torque drive and large clamping range. CDSPL can accommodate standard square-ended taps. The tap is clamped by two adjustable sets of jaws. The four jaw set provides positive drive at the tap square. The three jaw set centers the tap perfectly. The two jaw sets move independently of one another, providing proper clamping despite any differential in the relation between the tap round shank and square.

**Safety Torque Clutch.** The safety clutch is infinitely variable to the required tap size torque by simply adjusting to scale. The safety clutch disengages when the preset torque is exceeded. After disengagement, there is virtually no torque on the tap, minimizing clutch wear. This prevents tool breakage. Blind holes can be bottom tapped under full rotation of the spindle. Reversing the spindle, the clutch re-engages and the tap is automatically withdrawn.

**Radial Parallel Float.** This ball-bearing float device guarantees threads to exact tolerance. It also protects misaligned taps against side thrust. It automatically centers after every tapping operation.

**Length Compensation.** Ball-cage length compensation provides smooth axial movement, even in the presence of maximum torque. This free axial movement prevents damage to thread flanks when the feed rate and tap pitch do not match. It also permits cutting small threads on heavy machines. The length compensation positions at zero point and is therefore also suitable for machine feed.

NOTE: CDSPL tapping attachment is suitable for right-hand threads only. For left-hand threads on request.

Part No.	Shank	Tap Range			Float	Length Comp.		D	D1	L	L1
		Metric	Inch	Pipe		Comp.	Tens.				
CDSPL-12-MT2	MT2										0.708
CDSPL-12-MT3	MT3	M3-M12	#6 - 1/2	1/8	0.039	0.393	0.787	2.283	2.086	5.314	-
CDSPL-12-SS1	1"										0.787
CDSPL-20-MT3	MT3										0.905
CDSPL-20-MT4	MT4	M8-M20	1/4 - 3/4	1/8 - 1/4P	0.058	0.0393	0.787	3.267	2.992	6.732	-
CDSPL-20-SS1	1"										1.102
QCSPL-30-MT4*	MT4										
QCSPL-30-MT5*	MT5	M14-M30	13/16 - 1-3/8	3/4 - 1	0.078	0.393	1.181	4.173	2.835	10.080	

\*NOTE: Uses CWE3 Adapters. See page 81.

Keys	Part No.
CDSPL12	CDSPLK12
CDSPL20	CDSPLK20

# CENTAUR

## Precision VDI Tool Holders



2008

## Table of Contents

STANDARD RADIAL OVERHEAD TOOL HOLDERS	B1-B4 Page 91
LONG RADIAL OVERHEAD TOOL HOLDERS	B5-B8 Page 92
AXIAL TOOL HOLDERS	C1-C4 Page 93
BORING BAR HOLDERS, STEEL PLUGS & MORSE TAPER ADAPTERS	E2 Page 94
SPLIT BORING BAR HOLDERS	EE2 Page 95
SPECIAL COMPACT AXIAL TOOL HOLDERS	CC1 Page 95
TAPPING HOLDERS & TAP ADAPTERS	Page 96
COLLET CHUCKS RD/ER, RDO/ORTLIEB, RDG/TG	Page 97
NOTES	Page 98

**2008**

## Precision Engineered VDI Tool Holding Systems

Performance and value make VDI tooling from Centaur the right choice for CNC turn/mill centers.

Product Features:

- Case hardened and completely finish ground
- Blackened to retard oxidation
- Internal coolant supplies with adjustable ball-type nozzles
- Square tools can be preset with spring-loaded pressure plates

**NOTE:** Holders not listed are available upon request.

*Specifications subject to change without notice.*

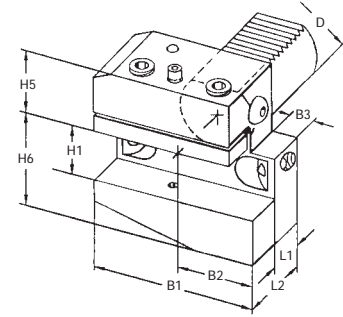
STANDARD RADIAL OVERHEAD TOOL HOLDERS

PER VDI 3425

DIN 69880

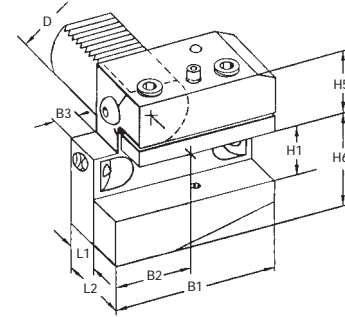
Form B1 RIGHT HAND SHORT

Part No.	D	B1	B2	B3	H1	H5	H6	L1	L2
433020	30	70	35	10	3/4"	28	38	22	40
434025	40	85	42.5	12.5	1"	32.5	48	22	44
435032	50	100	50	16	1-1/4"	35	60	30	55



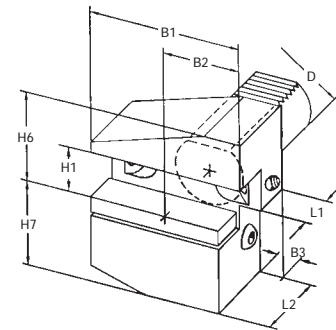
Form B2 LEFT HAND SHORT

Part No.	D	B1	B2	B3	H1	H5	H6	L1	L2
443020	30	70	35	10	3/4"	28	38	22	40
444025	40	85	42.5	12.5	1"	32.5	48	22	55
445032	50	100	50	16	1-1/4"	35	60	30	55



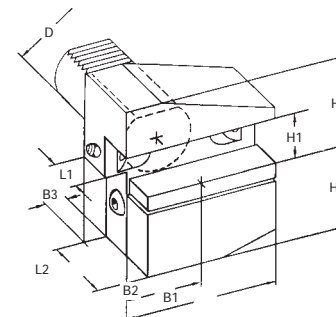
Form B3 RIGHT HAND SHORT REVERSE

Part No.	D	B1	B2	B3	H1	H6	H7	L1	L2
453020	30	70	35	10	3/4"	38	35	22	40
454025	40	85	42.5	12.5	1"	48	42.5	22	44
455032	50	100	50	16	1-1/4"	60	50	30	55



Form B4 LEFT HAND SHORT REVERSE

Part No.	D	B1	B2	B3	H1	H6	H7	L1	L2
463020	30	70	35	10	3/4"	38	35	42	40
464025	40	85	42.5	12.5	1"	48	42.5	22	44
465032	50	100	50	16	1-1/4"	60	50	30	55



## LONG RADIAL OVERHEAD TOOLHOLDERS

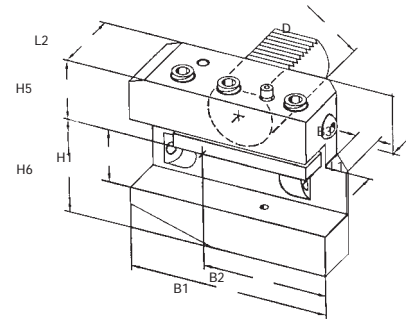
PER VDI 3425

DIN 69880

Form B5

RIGHT HAND LONG

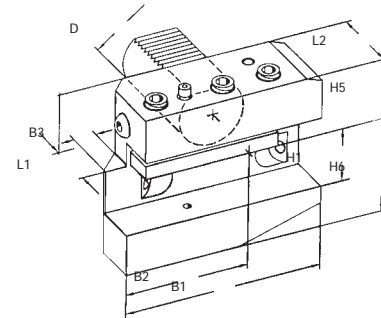
Part No.	D	B1	B2	B3	H1	H5	H6	L1	L2
473020	30	100	65	10	3/4"	28	38	22	40
474025	40	118	75.5	12.5	1"	32.5	48	22	44
475032	50	130	80	16	1-1/4"	35	60	30	55



Form B6

LEFT HAND LONG

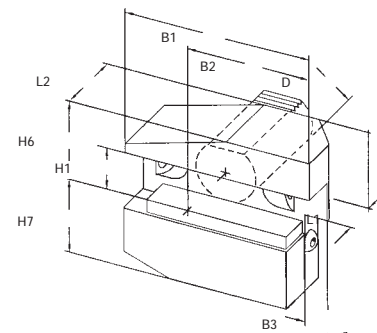
Part No.	D	B1	B2	B3	H1	H5	H6	L1	L2
483020	30	100	65	10	3/4"	28	38	22	40
484025	40	118	75.5	12.5	1"	32.5	48	22	44
485032	50	130	80	16	1-1/4"	35	60	30	55



Form B7

RIGHT HAND LONG REVERSE

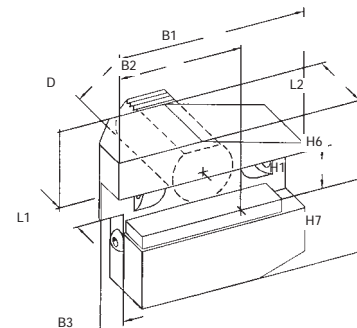
Part No.	D	B1	B2	B3	H1	H6	H7	L1	L2
493020	30	100	65	10	3/4"	38	35	22	40
494025	40	118	75.5	12.5	1"	48	42.5	22	44
495032	50	130	80	16	1-1/4"	60	50	30	55



Form B8

LEFT HAND LONG REVERSE

Part No.	D	B1	B2	B3	H1	H6	H7	L1	L2
503020	30	100	65	10	3/4"	38	35	22	40
504025	40	118	75.5	12.5	1"	48	42.5	22	44
505032	50	130	80	16	1-1/4"	60	50	30	55



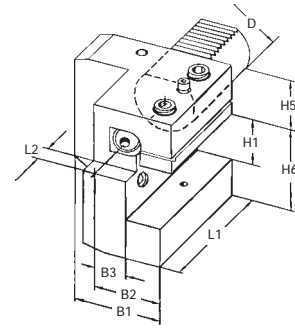
AXIAL TOOLHOLDERS

PER VDI 3425

DIN 69880

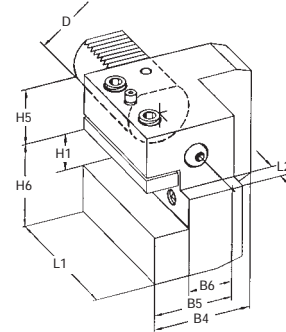
Form C1 RIGHT HAND

Part No.	D	B1	B2	B3	H1	H5	H6	L1	L2
513020	30	70	35	17	3/4"	28	38	70	10
514025	40	85	42.5	20.5	1"	32.5	48	85	12.5
515032	50	100	50	25.5	1-1/4"	35	60	100	16



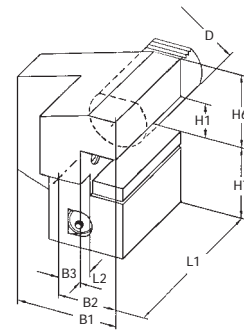
Form C2 LEFT HAND

Part No.	D	B4	B5	B6	H1	H5	H6	L1	L2
523020	30	76	41	23	3/4"	28	38	70	10
524025	40	90	47.5	25.5	1"	32.5	48	85	12.5
525032	50	105	55	30.5	1-1/4"	35	60	100	16



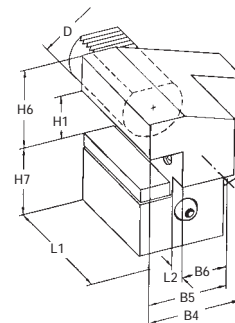
Form C3 RIGHT HAND REVERSE

Part No.	D	B1	B2	B3	H1	H6	H7	L1	L2
533020	30	70	35	17	3/4"	38	35	70	10
534025	40	85	42.5	20.5	1"	48	42.5	85	12.5
535032	50	100	50	25.5	1-1/4"	60	50	100	16



Form C4 LEFT HAND REVERSE

Part No.	D	B4	B5	B6	H1	H6	H7	L1	L2
543020	30	76	41	23	3/4"	38	35	70	10
544025	40	90	47.5	25.5	1"	48	42.5	85	12.5
545032	50	105	55	30.5	1-1/4"	60	50	100	16



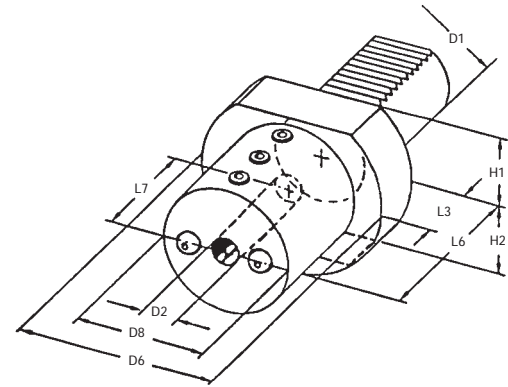
**BORING BAR HOLDERS**

PER VDI 3425

DIN 69880

Form E2

Part No.	D1	D2	D6	D8	H1	H2	L3	L6	L7
553012	30	1/2"	68	55	28	30	22	60	51
553016	30	5/8"	68	55	28	30	22	60	51
553020	30	3/4"	68	55	28	30	22	60	51
553025	30	1"	68	55	28	30	22	60	51
553032	30	1-1/4"	68	55	28	30	22	75	61
554012	40	1/2"	83	55	32.5	—	22	75	61
554016	40	5/8"	83	55	32.5	—	22	75	61
554020	40	3/4"	83	55	32.5	—	22	75	61
554025	40	1"	83	55	32.5	—	22	75	61
554032	40	1-1/4"	83	83	32.5	—	22	75	61
555012	50	1/2"	98	68	35	—	30	90	76
555016	50	5/8"	98	68	35	—	30	90	76
555020	50	3/4"	98	68	35	—	30	90	76
555025	50	1"	98	68	35	—	30	90	76
555032	50	1-1/4"	98	68	35	—	30	90	76



NOTE: Flat on lower side of 30mm shank tools.

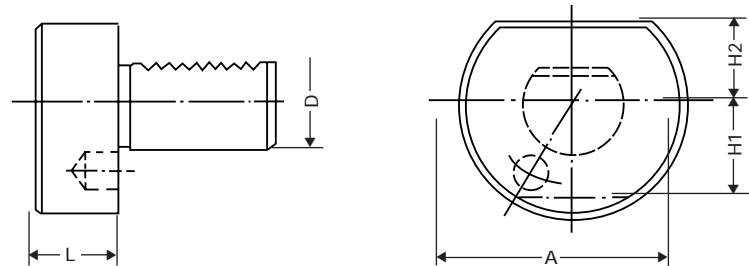
**STEEL PLUGS**

PER VDI 3425

DIN 69880

Form Z2

Part No.	D	L	A	H1	H2
611640*	16	13	40	23	18
612050*	20	16	50	23	23
612558*	25	16	58	25	25
613068	30	16	68	30	28
614083	40	20	83	—	32.5
615098	50	20	98	—	35
616023*	60	20	123	—	42.5



NOTE: Stock items available upon special request.

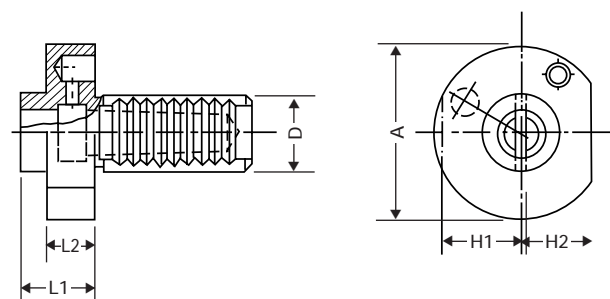
**MORSE TAPER ADAPTERS**

PER VDI 3425

DIN 69880

Form F For Shanks With Tang

Part No.	D	Tool Shank	L1	L2	A	H1	H2
623001	30	1	27	—	68	30	28
623002	30	2	27	—	68	30	28
623003	30	3	45	—	68	30	28
624001	40	1	36	22	83	32.5	—
624002	40	2	36	22	83	32.5	—
624003	40	3	36	22	83	32.5	—
624004	40	4	80	22	83	32.5	—
625002	50	2	36	30	98	35	—
625003	50	3	36	30	98	35	—
625004	50	4	50	30	98	35	—





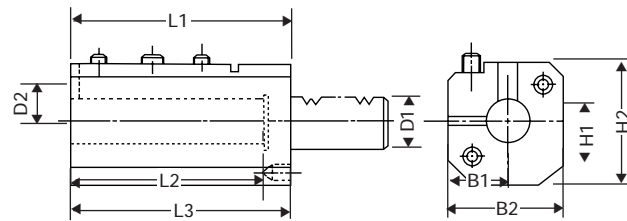
SPLIT CLAMPING BORING BAR HOLDER FOR REDUCED VIBRATION

PER VDI 3425

DIN 69880

Form EE2

Part No.	D1	D2	L1	L2	L3	H1	H2	B1	B2
563025	30	1"	60	70	80	30	58	35	65
563032	30	1-1/4"	60	70	80	30	58	35	65
564025	40	1"	60	70	80	40	72.5	42	79
564032	40	1-1/4"	60	70	80	40	72.5	42	79
564037	40	1-1/2"	60	70	80	40	72.5	42	79
565025	50	1"	65	75	90	48	83	50	95
565032	50	1-1/4"	65	75	90	48	83	50	95
565073	50	1-1/2"	65	75	90	48	83	50	95



SPECIAL COMPACT AXIAL TOOLHOLDER

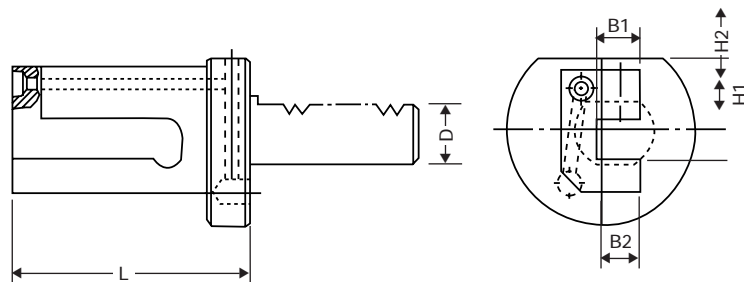
PER VDI 3425

DIN 69880

Form CC1

RIGHT HAND

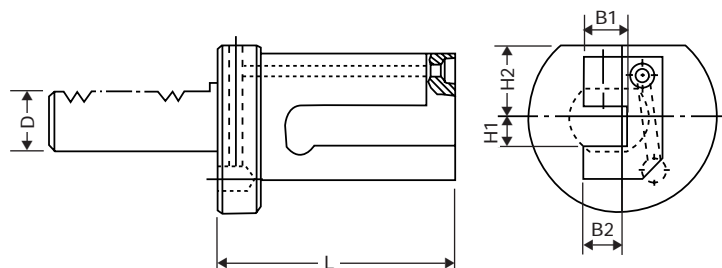
Part No.	D	L	H1	H2	B1	B2
583032	30	85	16	28	16	16
584040	40	110	20	32.5	20	20
585050	50	120	25	35	25	25



Form CC2

LEFT HAND

Part No.	D	L	H1	H2	B1	B2
593032	30	85	16	28	16	16
594040	40	110	20	32.5	20	20
595050	50	120	25	35	25	25

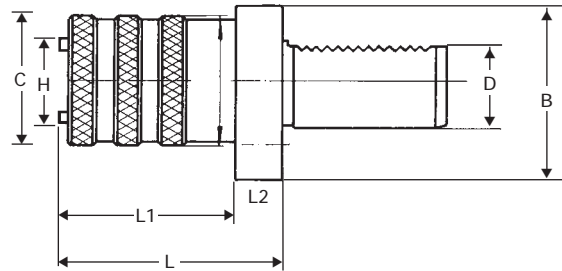


TENSION-COMPRESSION TAP HOLDERS

PER VDI 3425

DIN 69880

Part No.	D	Series	L	L1	L2	B	H	C	Tension	Compression
573014	30	CWE 1	70	40	30	68	28	36	7.62	7.62
574014	40	CWE 1	70	40	30	83	32.5	36	7.62	7.62
574022	40	CWE 2	93	63	30	83	32.5	55.5	12.45	12.45
575014	50	CWE 1	70	40	30	98	35	36	7.62	7.62
575022	50	CWE 2	93	63	30	98	35	55.5	12.45	12.45

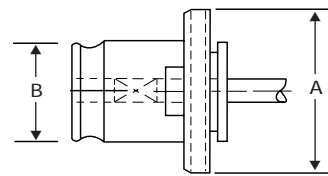


QUICK-CHANGE POSITIVE DRIVE TAP ADAPTERS

Hand Tap Size	Tap Shank Dia.	Part No. CWE 1	Depth Tap Enters	Part No. CWE 2	Depth Tap Enters
0-6	0.141	100006	0.85	200006	0.85
0-8	0.168	100008	0.92	200008	0.92
0-10	0.194	100010	0.92	200010	0.92
0-12	0.220	100012	0.95	200012	0.95
1/4	0.255	100125	0.95	200125	0.95
5/16	0.318	100312	0.98	200312	1.49
3/8	0.381	100375	1.05	200375	1.56
7/16	0.323	100437	1.08	200437	1.59
1/2	0.367	100500	1.11	200500	1.62
9/16	0.429	100562	1.17	200562	1.68
5/8	0.480			200625	1.74
11/16	0.542			200687	1.81
3/4	0.590			200750	1.87
13/16	0.652			200812	1.87
7/8	0.697			200875	1.93

TAP ADAPTER DIMENSIONS

	A	B
CWE 1	1.18	0.75
CWE 2	1.89	1.22

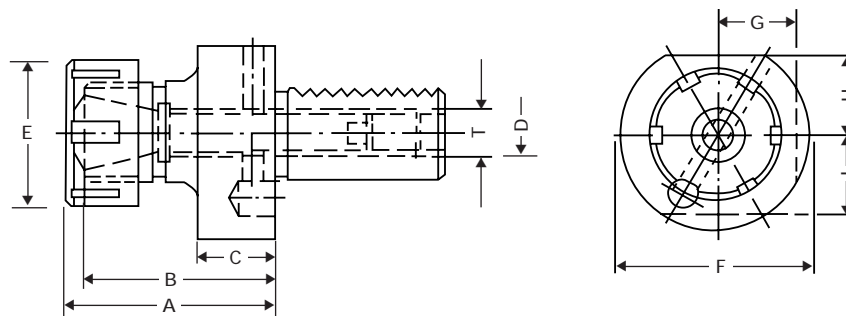


Pipe Tap Size	Tap Shank Dia.	Part No. CWE 1	Depth Tap Enters	Part No. CWE 2	Depth Tap Enters
1/8 - SS	0.313	105062	1.05	205062	1.49
1/8 - LS	0.437	105063	1.05	205063	1.05
1/4	0.562			205125	1.18
3/8	0.700			205375	1.24
1/2	0.687			205500	1.37

NOTE: Metric and Japanese standard sizes upon special request.

COLLET CHUCKS

See Collet Section pages for RD/ER, RD/Ortlieb, RDG/TG and RDG collet availability.



PER VDI 3425      DIN 69880

RD/ER STYLE

Part No.	Description	D	A	B	C	E	F	G	H	I	T	Collet	Range	Wrench
411616*	16x40 RD 16	16	40	30	13	28	40	—	18	18	M 8x1	RD 16	0.5-10	GS 25
411620*	16x45 RD 16	16	45	33	13	34	40	—	18	18	M 8x1	RD 16	0.5-10	GS 25
412016*	20x40 RD 16	20	40	30	18	28	50	—	23	23	M 10x1	RD 16	0.5-10	GS 25
412025	20x50 RD 25	20	50	38	18	42	50	—	23	23	M 10x1	RD 25	1-16	E 25
412032	20x60 RD 32	20	60	48	18	50	50	—	23	23	M 10x1	RD 32	2-20	E 32
412040	20x66 RD 40	20	66	52	22	63	50	—	23	23	M 10x1	RD 40	3-26	E 40
412525*	25x50 RD 25	25	50	38	18	42	58	—	25	25	M 14x1.5	RD 25	1-16	E 25
412532*	30x60 RD 32	25	60	48	18	50	58	—	25	25	M 14x1.5	RD 32	2-20	E 32
413025	30x75 RD 25	30	75	63	22	50	68	30	28	30	M 18x1.5	RD 25	1-16	E 25
413032	30x75 RD 32	30	75	63	22	50	68	30	28	30	M 18x1.5	RD 32	2-20	E 32
413040	30x75 RD 40	30	75	61	22	63	68	30	28	30	M 18x1.5	RD 40	3-26	E 40
414025	40x75 RD 25	40	75	63	22	42	83	—	32.5		M 22x1.5	RD 25	1-16	E 25
414032	40x75 RD 32	40	75	63	22	50	83	—	32.5		M 22x1.5	RD 32	2-20	E 32
414040	40x75 RD 40	40	75	61	22	63	83	—	32.5		M 22x1.5	RD 40	3-26	E 40
415040*	50x75 RD 40	50	75	61	30	63	98	—	35		M 28x1.5	RD 40	3-26	E 40
416040*	60x75 RD 40	60	75	61	30	63	123	—	42.5		M 42x1.5	RD 40	3-26	E 40

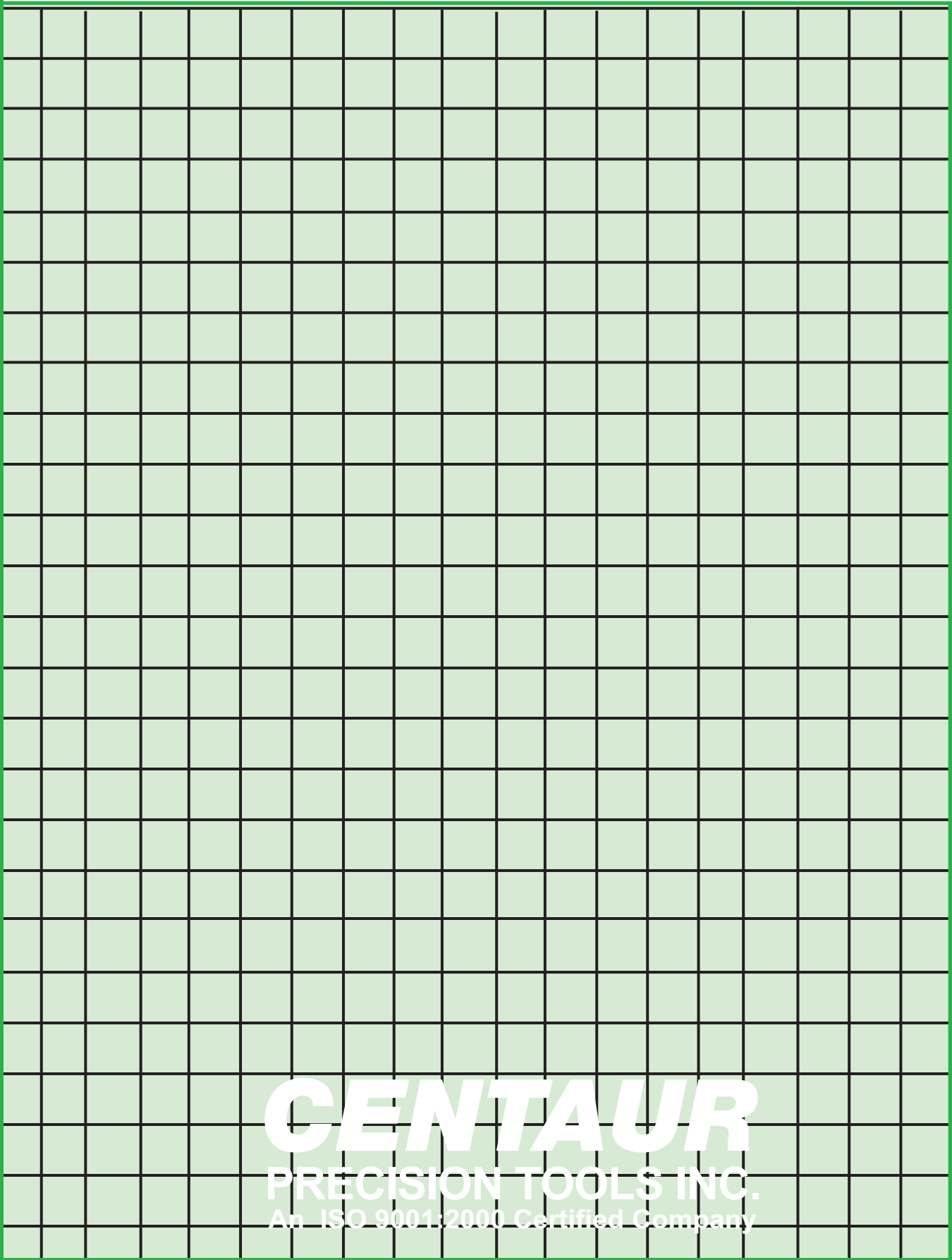
RD/ORTLIEB STYLE

Part No.	Description	D	A	B	C	E	F	G	H	I	T	Collet	Range	Wrench
422025*	20x57 RDO 25	20	57	43	18	43	50	—	23	23	M 10x1	RDO 25	1.5-16	HSO 25
422525*	20x62 RDO 25	25	62	48	18	43	58	—	25	25	M 14x1.5	RDO 25	1.5-16	HSO 25
423025	30x57 RDO 25	30	57	43	22	43	68	30	28	30	M 18x1.5	RDO 25	1.5-16	HSO 25
423035	30x75 RDO 35	30	75	59	22	60	68	30	28	30	M 18x1.5	RDO 35	1.5-25	HSO 35
424025*	40x57 RDO 25	40	57	43	22	43	83	—	32.5		M 22x1.5	RDO 25	1.5-16	HSO 25
424035	40x75 RDO 35	40	75	59	22	60	83	—	32.5		M 22x1.5	RDO 35	1.5-25	HSO 35
424044	40x90 RDO 44	40	90	73	22	72	83	—	32.5		M 22x1.5	RDO 44	3.5-32	HSO 44
425035*	50x75 RDO 35	50	75	59	30	60	98	—	35		M 28x1.5	RDO 35	1.5-25	HSO 35
425044	50x90 RDO 44	50	90	73	30	72	98	—	35		M 28x1.5	RDO 44	3.5-32	HSO 44
426044*	60x90 RDO 44	60	90	73	30	72	123	—	42.5		M 42x1.5	RDO 44	3.5-32	HSO 44

RDG/TG STYLE

Part No.	Description	D	A	C	E	F	H	T	Range	Wrench
4040100	40x108 RDG 100	40	108	22	62	83	32.5	M 22x1.5	3/32-1	E 40

\* Non-stock items available upon special request.



**CENTAUR**  
PRECISION TOOLS INC.  
An ISO 9001:2000 Certified Company