

# ER Single Angle Collet Systems



## Drilling – Milling – Tapping

CV Shank

- ER-style collets (DIN 6499) offer flexibility in drilling, milling, and tapping operations, with or without coolant.

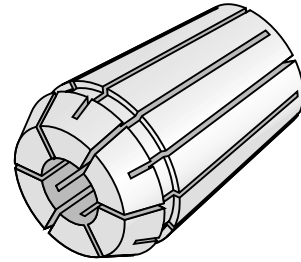
BT Shank

- Various types of collets and locknuts are available.

- Maximum collapse is .040 (1,0 mm).

- Bonded collets are available upon request.

DV Shank



HSK Shank

Straight Shank

Collets/Sleeves

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## ER-Style Collet Identification System

### System Size

11  
16  
20  
25  
32  
40

### Special Features

C = coolant style - bonded  
TC = solid tapping (square for drive)  
TCT = solid tapping with tension only

### Unit Size

M= metric  
" = (left blank) collet number built in inch units.

**40**

**ER**

**C**

**160**

**M**

### Collet Style

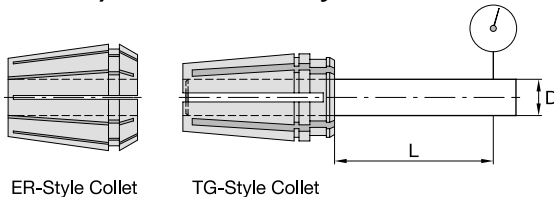
ER - DIN 6499  
single angle

### Collet Bore Size

**metric** 010 = 1mm  
(xx.x) 160 = 16mm  
245 = 24,5mm

**inch** 0125 = 1/8"  
(x.xxx) 0500 = 1/2"  
1000 = 1"

## TG- and ER-Style (DIN 6499) Collet Accuracy

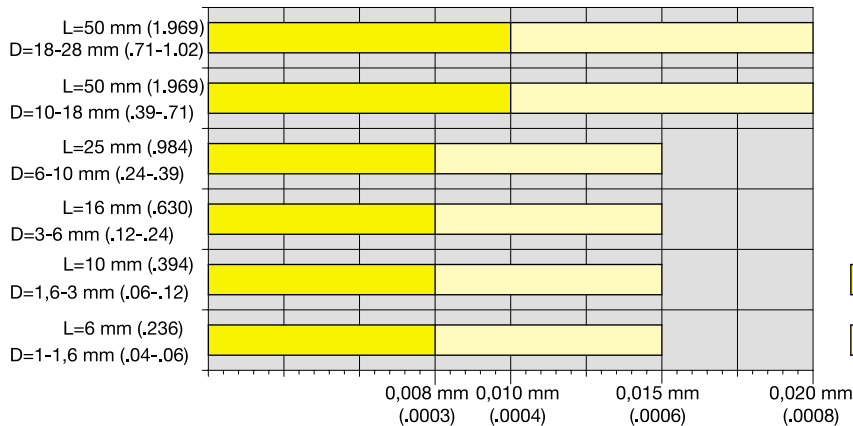


ER-Style Collet

TG-Style Collet

### IMPORTANT:

Inserting the cutting tool less than 2/3rd the gripping length into the collet can damage the collet permanently. Full length of the gripping bore needs to be maintained to achieve maximum accuracy and safety. Collet accuracies are based on size-for-size conditions. Using the collapsible range can influence the accuracy and gripping powers. Never try to stretch the collets by clamping oversize cutting tools.



### Runout

TGHP (precision) = DIN 6499 Class I

TG (standard) = ER - DIN 6499 Class II

Maximum Runout Error

# Collets and Sleeves



## Single Angle (ER) Collets (DIN 6499)



### ER — Single Angle

- Provides good grip and accuracy for all drilling applications.
- Wide clamping range.
- Available in both inch and metric bores.
- .040 (1,0 mm) range of collapse.
- Manufactured to DIN 6499.
- Accuracy to DIN 6499 Class II.



### ERC — Single Angle Coolant Style (available upon request)

- Rubber-filled slots seal collet for coolant-fed tool applications.
- Suitable for coolant pressure up to 70 bar (1000 psi).
- Fits all standard ER-style collet chucks.
- .005 (0,13 mm) range of collapse.



### ERTC — Single Angle Tap Collet

- Designed to grip taps on shank and square to eliminate slippage.
- Fits all standard ER-style collet chucks.
- .005 (0,13 mm) range of collapse.
- Manufactured to DIN 6499.



### ERTCT — Single Angle Tap Collet with Axial Compensation

- Designed to grip taps on shank and square to eliminate slippage.
- Tension only, cost effective solution for machines that require axial compensation for tapping.
- Fits all standard ER-style collet chucks.

CV Shank

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