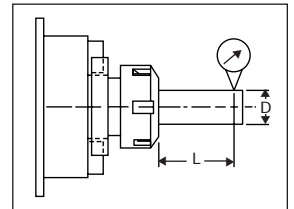


## RD/ER COLLET SYSTEM FEATURES

- *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		

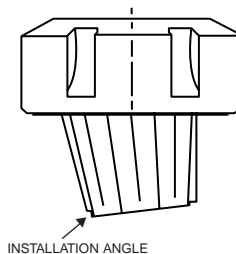


## METHOD OF INSERTION &amp; RELEASE FOR RD/ER COLLETS

## 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.

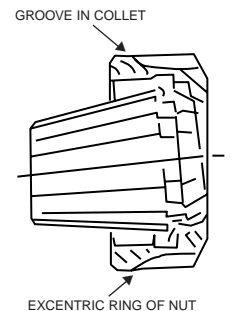
**IMPORTANT:** Never screw nut onto collet unless collet is properly seated in nut.



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 Collet is automatically withdrawn from chuck by eccentric ring of nut when unscrewed.



EXCENTRIC RING OF NUT