



# Swiss Tooling for Screw Machines



**REGO-FIX®**

Swiss Precision Tools

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One of the main differences between REGO-FIX and our competitors is that we do more than just sell tools. We're innovative, dynamic, on the cutting edge of technology. Always looking for a new and better way to improve your process and to save you money. We'll leave it to other companies to just *sell* tools. We create, improve, and manufacture our own Swiss quality products to the high standards that are required in today's manufacturing processes.

Each REGO-FIX tool has a lot number that allows for product traceability. The benefit: you know exactly where your tool came from; Swiss made in Tenniken, Switzerland for over 50 years in the same area where the finest and most precise watches in the entire world are made. How many other companies that just *sell* tools can say that? For that matter, do you really know where some of the other companies get their tooling, and from how many different sources? With today's high-precision machines, where your tooling comes from does matter.



To get the tooling you need, there is only one place to go that has been around for over 50 years...REGO-FIX. And don't forget, we are the proud inventor of the ER collet and many other fine machine tool products. To find more information about our other products, contact us at 1-800-REGO-FIX or visit us online at [www.rego-fix.com/screwmachine](http://www.rego-fix.com/screwmachine).

\*Front photo courtesy of Tornos Technologies US Corporation

# ER 8 ER 8-UP ER 8-MB



- ER 8 (STANDARD)
- ER 8-UP (ULTRA-PRECISION)
- ER 8-MB (Microbore)

## Metric Collets

Clamping Capacity [mm]	Clamping Capacity [inch]	Ø [inch]	ER 8 Part No.	ER 8-UP Part No.
1.00 ... 0.70	0.0394 ... 0.0275	1/32"	1108.01000	1108.01001
1.50 ... 1.00	0.0591 ... 0.0394		1108.01500	1108.01501
2.00 ... 1.50	0.0787 ... 0.0591	1/16"	1108.02000	1108.02001
2.50 ... 2.00	0.0984 ... 0.0787	3/32"	1108.02500	1108.02501
3.00 ... 2.50	0.1181 ... 0.0984		1108.03000	1108.03001
3.50 ... 3.00	0.1378 ... 0.1181	1/8"	1108.03500	1108.03501
4.00 ... 3.50	0.1575 ... 0.1378	5/32"	1108.04000	1108.04001
4.50 ... 4.00	0.1772 ... 0.1575		1108.04500	1108.04501
5.00 ... 4.50	0.1969 ... 0.1772	3/16"	1108.05000	1108.05001


## Inch Collets

Ø [inch]	Clamping Capacity [inch]	Clamping Capacity [mm]	ER 8 Part No.	ER 8-UP Part No.
1/16"	0.0625 ... 0.0425	1.59 ... 1.09	1108.01592	1108.01593
1/8"	0.1250 ... 0.0850	3.18 ... 2.18	1108.03182	1108.03183
3/16"	0.1875 ... 0.1475	4.76 ... 3.76	1108.04762	1108.04763

## Inch Collet Sets

	Set ER 8 Part No.	Set ER 8-UP Part No.
True inch collet set (3 pc set includes collets listed above)	1108.00002	1108.00003

- METRIC COLLET SET
- ER 8 (STANDARD)
- ER 8-UP (ULTRA-PRECISION)

Clamping Capacity [mm]				Set ER 8 Part No.	Set ER 8-UP Part No.
1.0 ... 0.5	1.5 ... 1.0	2.0 ... 1.5	2.5 ... 2.0	1108.00000	1108.00001
3.0 ... 2.5	3.5 ... 3.0	4.0 ... 3.5	4.5 ... 4.0	 <p>Supplied with: 9 Collets 1 Wooden Tray</p>	
5.0 ... 4.5	-	-	-		
Wooden Tray ZWT/8					

## Note for microbore collets:

Special inch and metric diameters can be manufactured at an additional cost.

## Microbore Collets



Clamping Capacity [mm]	Clamping Capacity [inch]	ER 8-MB Part No.
0.2	0.0079	1308.00200
0.3	0.0118	1308.00300
0.4	0.0157	1308.00400
0.5	0.0197	1308.00500

Clamping Capacity [mm]	Clamping Capacity [inch]	ER 8-MB Part No.
0.6	0.0236	1308.00600
0.7	0.0276	1308.00700
0.8	0.0315	1308.00800
0.9	0.0354	1308.00900



# ER 11 ER 11-UP ER 11-MB

- ER 11 (STANDARD)
- ER 11-UP (ULTRA-PRECISION)
- ER 11-MB (Microbore)

## Metric Collets

Clamping Capacity		Ø [inch]	ER 11 Part No.	ER 11-UP Part No.
[mm]	[inch]			
1.00 ... 0.50	0.0394 ... 0.0197	1/32"	1111.01000	1111.01001
1.50 ... 1.00	0.0591 ... 0.0394		1111.01500	1111.01501
2.00 ... 1.50	0.0787 ... 0.0591	1/16"	1111.02000	1111.02001
2.50 ... 2.00	0.0984 ... 0.0787	3/32"	1111.02500	1111.02501
3.00 ... 2.50	0.1181 ... 0.0984		1111.03000	1111.03001
3.50 ... 3.00	0.1378 ... 0.1181	1/8"	1111.03500	1111.03501
4.00 ... 3.50	0.1575 ... 0.1378	5/32"	1111.04000	1111.04001
4.50 ... 4.00	0.1772 ... 0.1575		1111.04500	1111.04501
5.00 ... 4.50	0.1969 ... 0.1772	3/16"	1111.05000	1111.05001
5.50 ... 5.00	0.2165 ... 0.1969		1111.05500	1111.05501
6.00 ... 5.50	0.2362 ... 0.2165	7/32"	1111.06000	1111.06001
6.50 ... 6.00	0.2559 ... 0.2362	1/4"	1111.06500	1111.06501
7.00 ... 6.50	0.2756 ... 0.2559		1111.07000	1111.07001


## Inch Collets

Ø [inch]	Clamping Capacity		ER 11 Part No.	ER 11-UP Part No.
	[inch]	[mm]		
1/16"	0.0625 ... 0.0425	1.59 ... 1.09	1111.01592	
3/32"	0.9375 ... 0.7375	2.38 ... 1.88	1111.02382	
1/8"	0.1250 ... 0.0850	3.18 ... 2.18	1111.03182	1111.03183
5/32"	0.1563 ... 0.1163	3.97 ... 2.97	1111.03972	
3/16"	0.1875 ... 0.1475	4.76 ... 3.76	1111.04762	1111.04763
7/32"	0.2188 ... 0.1788	5.56 ... 4.56	1111.05562	
1/4"	0.2500 ... 0.2100	6.35 ... 5.35	1111.06352	1111.06353

## Inch Collet Sets

	Set ER 11 Part No	Set ER 11-UP Part No
True inch collet set (7 pc standard set includes collets listed above with wooden tray) 3 pc UP set	1111.00002	1111.00003

- METRIC COLLET SET
- ER 11 (STANDARD)
- ER 11-UP (ULTRA-PRECISION)

Clamping Capacity [mm]					Set ER 11 Part No.	Set ER 11-UP Part No.
1.0 ... 0.5	1.5 ... 1.0	2.0 ... 1.5	2.5 ... 2.0	3.0 ... 2.5	1111.00000	1111.00001
3.5 ... 3.0	4.0 ... 3.5	4.5 ... 4.0	5.0 ... 4.5	5.5 ... 5.0	 Supplied with: 13 Collets 1 Wooden Tray	
6.0 ... 5.5	6.5 ... 6.0	7.0 ... 6.5				

## Microbore Collets

Clamping Capacity [mm]	Clamping Capacity [inch]	ER 11-MB Part No.
0.2	0.0079	1311.00200
0.3	0.0118	1311.00300
0.4	0.0157	1311.00400
0.5	0.0197	1311.00500

Clamping Capacity [mm]	Clamping Capacity [inch]	ER 11-MB Part No.
0.6	0.0236	1311.00600
0.7	0.0276	1311.00700
0.8	0.0315	1311.00800
0.9	0.0354	1311.00900



# ER 16 ER 16-UP



■ **ER 16 (STANDARD)**  
**ER 16-UP (ULTRA-PRECISION)**

### Metric Collets

Clamping Capacity [mm]	Clamping Capacity [inch]	ø [inch]	ER 16 Part No.	ER 16-UP Part No.
1.00 ... 0.50	0.0394 ... 0.0197	1/32"	1116.01000	1116.01001
1.50 ... 1.00	0.0591 ... 0.0394		1116.01500	1116.01501
2.00 ... 1.00	0.0787 ... 0.0394	1/16"	1116.02000	1116.02001
2.50 ... 1.50	0.0984 ... 0.0591	3/32"	1116.02500	1116.02501
3.00 ... 2.00	0.1181 ... 0.0787		1116.03000	1116.03001
3.50 ... 2.50	0.1378 ... 0.0984	1/8"	1116.03500	1116.03501
4.00 ... 3.00	0.1575 ... 0.1181	5/32"	1116.04000	1116.04001
4.50 ... 3.50	0.1772 ... 0.1378		1116.04500	1116.04501
5.00 ... 4.00	0.1969 ... 0.1575	3/16"	1116.05000	1116.05001
5.50 ... 4.50	0.2165 ... 0.1772		1116.05500	1116.05501
6.00 ... 5.00	0.2362 ... 0.1969	7/32"	1116.06000	1116.06001
6.50 ... 5.50	0.2559 ... 0.2165	1/4"	1116.06500	1116.06501
7.00 ... 6.00	0.2756 ... 0.2362		1116.07000	1116.07001
7.50 ... 6.50	0.2953 ... 0.2559	9/32"	1116.07500	1116.07501
8.00 ... 7.00	0.3150 ... 0.2756	5/16"	1116.08000	1116.08001
8.50 ... 7.50	0.3347 ... 0.2953		1116.08500	1116.08501
9.00 ... 8.00	0.3543 ... 0.3150	11/32"	1116.09000	1116.09001
9.50 ... 8.50	0.3740 ... 0.3347		1116.09500	1116.09501
10.00 ... 9.00	0.3937 ... 0.3543	3/8"	1116.10000	1116.10001

### Inch Collets

ø [inch]	Clamping Capacity [inch]	Clamping Capacity [mm]	ER 16 Part No.	ER 16-UP Part No.
1/16"	0.0625 ... 0.0425	1.59 ... 1.09	1116.01592	1116.01593
3/32"	0.9375 ... 0.7375	2.38 ... 1.88	1116.02382	1116.02383
1/8"	0.1250 ... 0.0850	3.18 ... 2.18	1116.03182	1116.03183
5/32"	0.1563 ... 0.1163	3.97 ... 2.97	1116.03972	1116.03973
3/16"	0.1875 ... 0.1475	4.76 ... 3.76	1116.04762	1116.04763
7/32"	0.2188 ... 0.1788	5.56 ... 4.56	1116.05562	1116.05563
1/4"	0.2500 ... 0.2100	6.35 ... 5.35	1116.06352	1116.06353
9/32"	0.2813 ... 0.2413	7.14 ... 6.14	1116.07142	1116.07143
5/16"	0.3125 ... 0.2725	7.94 ... 6.94	1116.07942	1116.07943
11/32"	0.3438 ... 0.3038	8.73 ... 7.73	1116.08732	1116.08733
3/8"	0.3750 ... 0.3350	9.53 ... 8.53	1116.09532	1116.09533
13/32"	0.4063 ... 0.3663	10.32 ... 9.32	1116.10322	1116.10323

### Inch Collet Sets

	Set ER 16 Part No.	Set ER 16-UP Part No.
True inch collet set (12 pc set includes collets listed above) with wooden tray	1116.00002	1116.00003

■ **METRIC COLLET SET**  
**ER 16 (STANDARD)**  
**ER 16-UP (ULTRA-PRECISION)**

Clamping Capacity [mm]					Set ER 16 Part No.	Set ER 16-UP Part No.
1.0 ... 0.5	2.0 ... 1.0	3.0 ... 2.0	4.0 ... 3.0	5.0 ... 4.0	1116.00000	1116.00001
6.0 ... 5.0	7.0 ... 6.0	8.0 ... 7.0	9.0 ... 8.0	10.0 ... 9.0	<b>Supplied with:</b> <b>10 Collets</b> <b>1 Wooden Tray</b>	
Wooden Tray ZWT116						





■ **ER 20 (STANDARD)**  
**ER 20-UP (ULTRA-PRECISION)**

### Metric Collets

Clamping Capacity [mm]	Clamping Capacity [inch]	Ø [inch]	ER 20 Part No.	ER 20-UP Part No.
1.00 ... 0.50	0.0394 ... 0.0197	1/32"	1120.01000	1120.01001
1.50 ... 1.00	0.0591 ... 0.0394		1120.01500	1120.01501
2.00 ... 1.00	0.0787 ... 0.0394	1/16"	1120.02000	1120.02001
2.50 ... 1.50	0.0984 ... 0.0591	3/32"	1120.02500	1120.02501
3.00 ... 2.00	0.1181 ... 0.0787		1120.03000	1120.03001
3.50 ... 2.50	0.1378 ... 0.0984	1/8"	1120.03500	1120.03501
4.00 ... 3.00	0.1575 ... 0.1181	5/32"	1120.04000	1120.04001
4.50 ... 3.50	0.1772 ... 0.1378		1120.04500	1120.04501
5.00 ... 4.00	0.1969 ... 0.1575	3/16"	1120.05000	1120.05001
5.50 ... 4.50	0.2165 ... 0.1772		1120.05500	1120.05501
6.00 ... 5.00	0.2362 ... 0.1969	7/32"	1120.06000	1120.06001
6.50 ... 5.50	0.2559 ... 0.2165	1/4"	1120.06500	1120.06501
7.00 ... 6.00	0.2756 ... 0.2362		1120.07000	1120.07001
7.50 ... 6.50	0.2953 ... 0.2559	9/32"	1120.07500	1120.07501
8.00 ... 7.00	0.3150 ... 0.2756	5/16"	1120.08000	1120.08001
8.50 ... 7.50	0.3347 ... 0.2953		1120.08500	1120.08501
9.00 ... 8.00	0.3543 ... 0.3150	11/32"	1120.09000	1120.09001
9.50 ... 8.50	0.3740 ... 0.3347		1120.09500	1120.09501
10.00 ... 9.00	0.3937 ... 0.3543	3/8"	1120.10000	1120.10001
10.50 ... 9.50	0.4134 ... 0.3740	13/32"	1120.10500	1120.10501
11.00 ... 10.00	0.4330 ... 0.3937		1120.11000	1120.11001
11.50 ... 10.50	0.4528 ... 0.4134	7/16"	1120.11500	1120.11501
12.00 ... 11.00	0.4724 ... 0.4375	15/32"	1120.12000	1120.12001
12.50 ... 11.50	0.4921 ... 0.4528		1120.12500	1120.12501
13.00 ... 12.00	0.5118 ... 0.4724	1/2"	1120.13000	1120.13001

### Inch Collets

Ø [inch]	Clamping Capacity [inch]	Clamping Capacity [mm]	ER 20 Part No.	ER 20-UP Part No.
1/8"	0.1250 ... 0.0850	3.18 ... 2.18	1120.03182	1120.03183
3/16"	0.1875 ... 0.1475	4.76 ... 3.76	1120.04762	1120.04763
1/4"	0.2500 ... 0.2100	6.35 ... 5.35	1120.06352	1120.06353
5/16"	0.3125 ... 0.2725	7.94 ... 6.94	1120.07942	1120.07943
3/8"	0.3750 ... 0.3350	9.53 ... 8.53	1120.09532	1120.09533
7/16"	0.4375 ... 0.3975	11.11 ... 10.11	1120.11112	1120.11113
1/2"	0.5000 ... 0.4600	12.70 ... 11.70	1120.12702	1120.12703

### Inch Collet Sets

	Set ER 20 Part No.	Set ER 20-UP Part No.
True inch collet set (7 pc set includes collets listed above) with wooden tray	1120.00002	1120.00003

■ **METRIC COLLET SET**  
**ER 20 (STANDARD)**  
**ER 20-UP (ULTRA-PRECISION)**

Clamping Capacity [mm]					Set ER 20 Part No.	Set ER 20-UP Part No.
2.0 ... 1.0	3.0 ... 2.0	4.0 ... 3.0	5.0 ... 4.0	 <b>Wooden Tray</b> <b>ZWT/20</b>	1120.00000	1120.00001
6.0 ... 5.0	7.0 ... 6.0	8.0 ... 7.0	9.0 ... 8.0			
10.0 ... 9.0	11.0 ... 10.0	12.0 ... 11.0	13.0 ... 12.0			

Supplied with:  
**12 Collets**  
**1 Wooden Tray**

# ER 25 ER 25-UP



■ **ER 25 (STANDARD)**  
**ER 25-UP (ULTRA-PRECISION)**

### Metric Collets

Clamping Capacity [mm]	Clamping Capacity [inch]	ø [inch]	ER 25 Part No.	ER 25-UP Part No.
1.00 ... 0.50	0.0394 ... 0.0197	1/32"	1125.01000	1125.01001
1.50 ... 1.00	0.0591 ... 0.0394		1125.01500	1125.01501
2.00 ... 1.00	0.0787 ... 0.0394	1/16"	1125.02000	1125.02001
2.50 ... 1.50	0.0984 ... 0.0591	3/32"	1125.02500	1125.02501
3.00 ... 2.00	0.1181 ... 0.0787		1125.03000	1125.03001
3.50 ... 2.50	0.1378 ... 0.0984	1/8"	1125.03500	1125.03501
4.00 ... 3.00	0.1575 ... 0.1181	5/32"	1125.04000	1125.04001
4.50 ... 3.50	0.1772 ... 0.1378		1125.04500	1125.04501
5.00 ... 4.00	0.1969 ... 0.1575	3/16"	1125.05000	1125.05001
5.50 ... 4.50	0.2165 ... 0.1772		1125.05500	1125.05501
6.00 ... 5.00	0.2362 ... 0.1969	7/32"	1125.06000	1125.06001
6.50 ... 5.50	0.2559 ... 0.2165	1/4"	1125.06500	1125.06501
7.00 ... 6.00	0.2756 ... 0.2362		1125.07000	1125.07001
7.50 ... 6.50	0.2953 ... 0.2559	9/32"	1125.07500	1125.07501
8.00 ... 7.00	0.3150 ... 0.2756	5/16"	1125.08000	1125.08001
8.50 ... 7.50	0.3347 ... 0.2953		1125.08500	1125.08501
9.00 ... 8.00	0.3543 ... 0.3150	11/32"	1125.09000	1125.09001
9.50 ... 8.50	0.3740 ... 0.3347		1125.09500	1125.09501
10.00 ... 9.00	0.3937 ... 0.3543	3/8"	1125.10000	1125.10001
10.50 ... 9.50	0.4134 ... 0.3740	13/32"	1125.10500	1125.10501
11.00 ... 10.00	0.4330 ... 0.3937		1125.11000	1125.11001
11.50 ... 10.50	0.4528 ... 0.4134	7/16"	1125.11500	1125.11501
12.00 ... 11.00	0.4724 ... 0.4375	15/32"	1125.12000	1125.12001

■ **METRIC COLLET SET**  
**ER 25 (STANDARD)**  
**ER 25-UP (ULTRA-PRECISION)**

Clamping Capacity [mm]					Set ER 25 Part No.	Set ER 25-UP Part No.
2.0 ... 1.0	3.0 ... 2.0	4.0 ... 3.0	5.0 ... 4.0	6.0 ... 5.0	1125.00000	1125.00001
7.0 ... 6.0	8.0 ... 7.0	9.0 ... 8.0	10.0 ... 9.0	11.0 ... 10.0	<b>Supplied with:</b> <b>15 Collets</b> <b>1 Wooden Tray</b>	
12.0 ... 11.0	13.0 ... 12.0	14.0 ... 13.0	15.0 ... 14.0	16.0 ... 15.0		
<i>Wooden Tray ZWT/25</i>						



### Metric Collets (Con't)

Clamping Capacity [mm]	Clamping Capacity [inch]	ø [inch]	ER 25 Part No.	ER 25-UP Part No.
12.50 ... 11.50	0.4921 ... 0.4528		1125.12500	1125.12501
13.00 ... 12.00	0.5118 ... 0.4724	1/2"	1125.13000	1125.13001
13.50 ... 12.50	0.5315 ... 0.4921	17/32"	1125.13500	1125.13501
14.00 ... 13.00	0.5512 ... 0.5118		1125.14000	1125.14001
14.50 ... 13.50	0.5709 ... 0.5315	9/16"	1125.14500	1125.14501
15.00 ... 14.00	0.5905 ... 0.5512		1125.15000	1125.15001
15.50 ... 14.50	0.6102 ... 0.5315	19/32"	1125.15500	1125.15501
16.00 ... 15.00	0.6300 ... 0.5905	5/8"	1125.16000	1125.16001

### Inch Collets

ø [inch]	Clamping Capacity [inch]	Clamping Capacity [mm]	ER 25 Part No.	ER 25-UP Part No.
1/8"	0.1250 ... 0.0850	3.18 ... 2.18	1125.03182	1125.03183
3/16"	0.1875 ... 0.1475	4.76 ... 3.76	1125.04762	1125.04763
1/4"	0.2500 ... 0.2100	6.35 ... 5.35	1125.06352	1125.06353
5/16"	0.3125 ... 0.2725	7.94 ... 6.94	1125.07942	1125.07943
3/8"	0.3750 ... 0.3350	9.53 ... 8.53	1125.09532	1125.09533
7/16"	0.4375 ... 0.3975	11.11 ... 10.11	1125.11112	1125.11113
1/2"	0.5000 ... 0.4600	12.70 ... 11.70	1125.12702	1125.12703
9/16"	0.5625 ... 0.5225	14.29 ... 13.29	1125.14292	1125.14293
5/8"	0.6250 ... 0.5820	15.88 ... 14.88	1125.15882	1125.15883

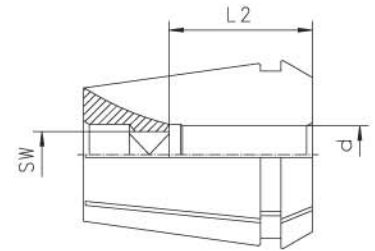
### Inch Collet Sets

	Set ER 25 Part No.	Set ER 25-UP Part No.
True inch collet set (9 pc set includes collets listed above) with wooden tray	1125.00002	1125.00003



■ **ER-GB RIGID TAPPING COLLETS WITH SQUARE DRIVE – METRIC SIZES**

d [mm]	SW [mm]	L2 [mm]	STD	ER 16-GB Part No.	ER 20-GB Part No.	ER 25-GB Part No.
4.0	3.15/3.2	18	ISO, JIS	1416.04002	1420.04002	1425.04002
4.5	3.4	18	DIN	1416.04500	1420.04500	1425.04500
5.0	4.0	18	ISO, JIS	1416.05002	1420.05002	1425.05002
5.5	4.3	18	DIN	1416.05500	1420.05500	1425.05500
5.5	4.5	18	JIS	1416.05501	1420.05501	1425.05501
6.0	4.5	18	JIS	1416.06001	1420.06001	1425.06001
6.0	4.9	18	DIN	1416.06000	1420.06000	1425.06000
6.2	5.0	18	JIS	1416.06201	1420.06201	1425.06201
6.3	5.0	18	ISO	1416.06302	1420.06302	1425.06302
7.0	5.5	18	DIN, JIS	1416.07000	1420.07000	1425.07000
7.1	5.6	18	ISO	1416.07102	1420.07102	1425.07102
8.0	6.2/6.3	22	DIN, ISO	1416.08000	1420.08000	1425.08000
8.5	6.5	22	JIS	1416.08501	1420.08501	1425.08501
9.0	7.0/7.1	22	DIN, ISO	1416.09000	1420.09000	1425.09000
10.0	8.0	25	DIN, ISO		1420.10000	1425.10000
10.5	8.0	25	JIS		1420.10501	1425.10501
11.0	9.0	25	DIN		1420.11000	1425.11000
11.2	9.0	25	ISO		1420.11202	1425.11202
12.0	9.0	25	DIN			1425.12000
12.5	10.0	25	ISO, JIS			1425.12502
14.0	11.0/11.2	25	DIN, ISO, JIS			1425.14000
15.0	12.0	25	JIS			1425.15001
16.0	12.0	25	DIN			1425.16000
17.0	13.0	25	JIS			
18.0	14.0/14.5	25	DIN, ISO			
20.0	16.0	28	DIN, ISO			
22.0	18.0	28	DIN			



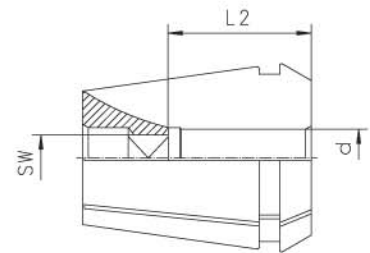


# ER-GB



■ **ER-GB RIGID TAPPING COLLETS WITH SQUARE DRIVE**  
– INCH SIZES

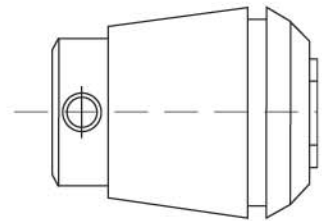
d [inch]	SW [inch]	L2 [mm]	Pipe Tap	ER 16-GB Part No.	ER 20-GB Part No.	ER 25-GB Part No.
0.168	0.131	18	–	1416.04275	1420.04275	1425.04275
0.194	0.152	18	–	1416.04935	1420.04935	1425.04935
0.220	0.165	18	–	1416.05595	1420.05595	1425.05595
0.255	0.191	18	–	1416.06485	1420.06485	1425.06485
0.318	0.238	22	–		1420.08085	1425.08085
0.323	0.242	22	–		1420.08215	1425.08215
0.367	0.275	22	–		1420.09325	1425.09325
0.381	0.286	22	–		1420.09685	1425.09685
0.429	0.322	25	–			1425.10905
0.437	0.328	25	–			1425.11104
0.480	0.360	25	–			1425.12195



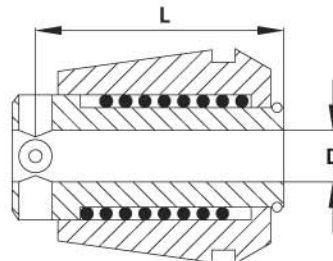


■ **PCM ET1 TAPPING COLLETS WITH AXIAL COMPENSATION – INCH SIZES**

Shank Dia. [inch] D	Shank Dia. [mm] D	ET1-12 Part No.	ET1-16 Part No.	ET1-20 Part No.	ET1-25 Part No.
0.141	3.580	1512.03581	1516.03581	1520.03581	1525.03581
0.168	4.270		1516.04271	1520.04271	1525.04271
0.194	4.930		1516.04931	1520.04931	1525.04931
0.220	5.590		1516.05591	1520.05591	1525.05591
0.255	6.480			1520.06481	1525.06481
0.318	8.080				1525.08081
0.323	8.205				1525.08211
0.367	9.320				1525.09321
0.381	9.680				1525.09681



Collet	L [mm]	L [inch]
ET1-12	20	0.78
ET1-16	24	0.94
ET1-20	26.5	1.04
ET1-25	29	1.14



The following tapping process is recommended for tapping collets PCM ET1:

Fast approach, then feed the tap with approximately 95% of the pitch value, which uses 20 - 30% of the compensation stroke when the spindle rotation and the feed movement are simultaneously reversed.

Return feed must be made with 100% of the pitch, which maintains the sleeve of the tapping collet in the compensation stroke up to the tap disengagement; quick return can then be programmed with usual stroke security. The relatively long axial compensation assists easy programming.

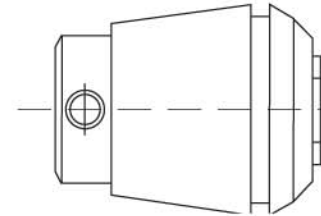
When tapping with very high speed, an appropriate programming compensation may be necessary to balance the differences of inertia between the spindle and the feed movement on reverse. Do not disturb the axial compensation – use external coolant supply only!

**Note:** *These collets are not suitable for coolant through applications!*

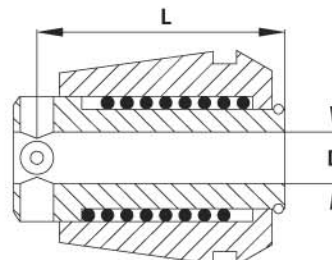


■ **PCM ET1 TAPPING COLLETS WITH AXIAL COMPENSATION - METRIC SIZES**

Shank Dia. [mm] D	STD	ET1-12 Part No.	ET1-16 Part No.	ET1-20 Part No.	ET1-25 Part No.
1.40	DIN	1512.01400	1516.01400		
1.60	DIN	1512.01600	1516.01600		
1.80	DIN	1512.01800	1516.01800		
2.00	ISO	1512.02000	1516.02000		
2.20	DIN	1512.02200	1516.02200	1520.02200	
2.24	ISO	1512.02240	1516.02240	1520.02240	
2.50	DIN, ISO	1512.02500	1516.02500	1520.02500	1525.02500
2.80	DIN, ISO	1512.02800	1516.02800	1520.02800	1525.02800
3.00	JIS	1512.03000	1516.03000	1520.03000	1525.30000
3.15	ISO	1512.03150	1516.03150	1520.03150	1525.03150
3.50	DIN	1512.03500	1516.03500	1520.03500	1525.03500
3.55	ISO	1512.03550	1516.03550	1520.03550	1525.03550
4.00	DIN, ISO, JIS		1516.04000	1520.04000	1525.04000
4.50	DIN, ISO		1516.04500	1520.04500	1525.04500
5.00	ISO, JIS		1516.05000	1520.05000	1525.05000
5.50	DIN, ISO		1516.05500	1520.05500	1525.05500
5.60	ISO		1516.05600	1520.05600	1525.05600
6.00	DIN, JIS		1516.06000	1520.06000	1525.06000
6.20	JIS		1516.06200	1520.06200	1525.06200
6.30	ISO		1516.06300	1520.06300	1525.06300
7.00	DIN, JIS			1520.07000	1525.07000
7.10	ISO				1525.07100
8.00	DIN, ISO, JIS				1525.08000
8.50	JIS				1525.08500
9.00	DIN, ISO				1525.09000
10.00	DIN, ISO				1525.10000

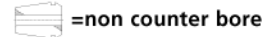
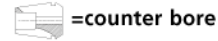


Collet	L [mm]	L [inch]
ET1-12	20	0.78
ET1-16	24	0.94
ET1-20	26.5	1.04
ET1-25	29	1.14

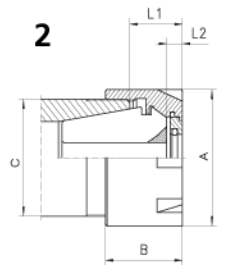
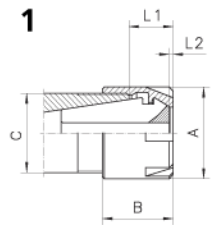


## CLAMPING NUTS

Type	Part No.	Standard	With Friction Bearing	Balanced	For Coolant Through Tools	Collet Locking System	Mini-nut	Nut with External Thread	A [mm]	B [mm]	C	L1 [mm]	L2 [mm]	Max Torque*		Dwg.
														[ft-lbs]	[ft-lbs]	
Hi-Q/ERM 8	3508.00000		▲						12	10.8	M 10 x 0.75	4.3 ... 6.1	1.5	4	4	1
Hi-Q/ERM 11	3511.00000		▲**						16	12.0	M 13 x 0.75	5.7 ... 7.5	0.9	10	15	1
Hi-Q/ERM 16	3516.00000		▲						22	18.4	M 19 x 1.00	8.0 ... 11.5	0.9	20	20	1
Hi-Q/ERM 20	3520.00000		▲						28	19.0	M 24 x 1.00	8.0 ... 11.5	-	25	25	1
Hi-Q/ERM 25	3525.00000		▲						35	20.0	M 30 x 1.00	8.5 ... 12.0	-	30	30	1
Hi-Q/ERMC 16	3516.20000		▲	●					22	22.0	M 19 x 1.00	11.5 ... 15.0	4.5	20	20	2
Hi-Q/ERMC 20	3520.20000		▲	●					28	24.0	M 24 x 1.00	13.0 ... 16.5	5.0	25	25	2
Hi-Q/ERMC 25	3525.20000		▲	●					35	25.0	M 30 x 1.00	13.5 ... 17.0	5.0	30	30	2



Max Torque\*



Max Torque\* = Maximum tightening torque [ft-lbs]. Recommended torque = 80% of Ma max.  
Conversion from ft-lbs to Nm = ft-lbs/0.738.

\*\*ER11 Coolant nuts available late Spring 2002

## ASSEMBLY INSTRUCTIONS FOR SEALING DISKS DS/ER

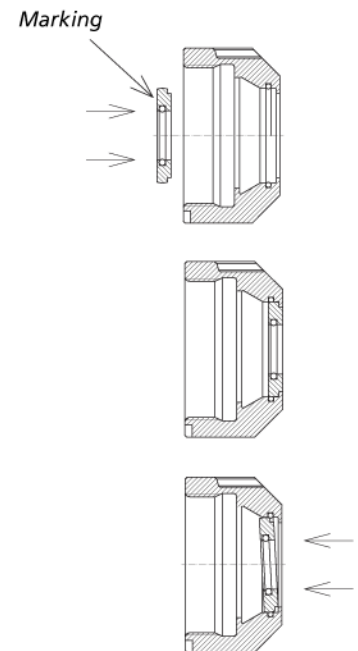
### Assembling Sealing Disk:

Insert the small diameter of the disk into the center of the coolant nut and apply even pressure until the disk is properly seated into the nut.

The disk must be flush with the outside of the nut and the marking on the disk must be seen inside the nut.

### Removing Sealing Disk:

To remove the disk, simply press evenly on the outside of the disk until it snaps out.

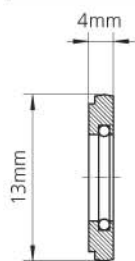


# DS/ER 16, 20 AND 25

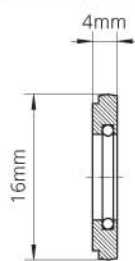


## SEALING DISKS DS/ER 16 AND DS/ER 20

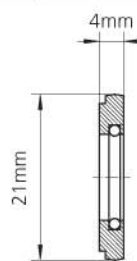
Sealing Capacity [mm]	Sealing Capacity [inch]	ø [inch]	DS/ER 16 Part No.	DS/ER 20 Part No.	DS/ER 25 Part No.
3.00 ... 2.50	0.1181 ... 0.0984	3/32"	3916.00300	3920.00300	3925.00300
3.50 ... 3.00	0.1378 ... 0.1181	1/8"	3916.00350	3920.00350	3925.00350
4.00 ... 3.50	0.1575 ... 0.1378	5/32"	3916.00400	3920.00400	3925.00400
4.50 ... 4.00	0.1772 ... 0.1575		3916.00450	3920.00450	3925.00450
5.00 ... 4.50	0.1969 ... 0.1772	3/16"	3916.00500	3920.00500	3925.00500
5.50 ... 5.00	0.2165 ... 0.1969	7/32"	3916.00550	3920.00550	3925.00550
6.00 ... 5.50	0.2362 ... 0.2165		3916.00600	3920.00600	3925.00600
6.50 ... 6.00	0.2559 ... 0.2362	1/4"	3916.00650	3920.00650	3925.00650
7.00 ... 6.50	0.2756 ... 0.2559		3916.00700	3920.00700	3925.00700
7.50 ... 7.00	0.2953 ... 0.2756	9/32"	3916.00750	3920.00750	3925.00750
8.00 ... 7.50	0.3150 ... 0.2953	5/16"	3916.00800	3920.00800	3925.00800
8.50 ... 8.00	0.3347 ... 0.3150		3916.00850	3920.00850	3925.00850
9.00 ... 8.50	0.3543 ... 0.3347	11/32"	3916.00900	3920.00900	3925.00900
9.50 ... 9.00	0.3740 ... 0.3543	3/8"	3916.00950	3920.00950	3925.00950
10.00 ... 9.50	0.3937 ... 0.3740		3916.01000	3920.01000	3925.01000
10.50 ... 10.00	0.4134 ... 0.3937	13/32"	-	3920.01050	3925.01050
11.00 ... 10.50	0.4330 ... 0.4134		-	3920.01100	3925.01100
11.50 ... 11.00	0.4528 ... 0.4330	7/16"	-	3920.01150	3925.01150
12.00 ... 11.50	0.4724 ... 0.4528	15/32"	-	3920.01200	3925.01200
12.50 ... 12.00	0.4921 ... 0.4724		-	3920.01250	3925.01250
13.00 ... 12.50	0.5118 ... 0.4921	1/2"	-	3920.01300	3925.01300
13.50 ... 13.00	0.5315 ... 0.5118	17/32"			3925.01350
14.00 ... 13.50	0.5512 ... 0.5315				3925.01400
14.50 ... 14.00	0.5709 ... 0.5512	9/16"			3925.01450
15.00 ... 14.50	0.5905 ... 0.5709				3925.01500
15.50 ... 15.00	0.6102 ... 0.5905	19/32"			3925.01550
16.00 ... 15.50	0.6300 ... 0.6102	5/8"			3925.01600



DS/ER 16



DS/ER 20



DS/ER 25

## SEALING DISK SETS DS/ER 16, 20 AND 25

Sealing Capacity [mm]	Set DS/ER 16 Part No.
	3916.00000
3.5 ... 10.0	Supplied with: 14 Sealing Disks 1 Wooden Tray
Wooden Tray DSR/16	

Sealing Capacity [mm]	Set DS/ER 20 Part No.
	3920.00000
3.5 ... 13.0	Supplied with: 20 Sealing Disks 1 Wooden Tray
Wooden Tray DSR/20	

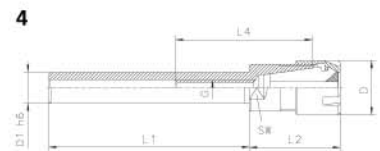
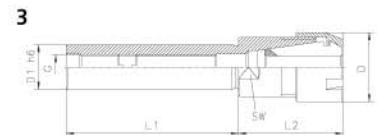
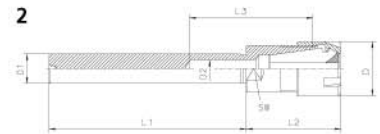
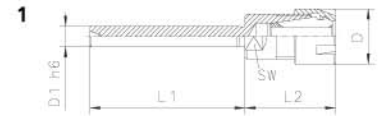
Sealing Capacity [mm]	Set DS/ER 25 Part No.
	3925.00000
3.5 ... 16.0	Supplied with: 26 Sealing Disks 1 Wooden Tray
Wooden Tray DSR/25	



# CYL/ER M ERM/ERM

## COLLET HOLDERS - CYLINDRICAL SHANKS IN METRIC AND INCH SIZES

Type	Part No.	D [mm]	D1 h6 [mm]	D2 [mm]	G	SW [mm]	L1 [mm]	L2 [mm]	L3 [mm]	L4 [mm]	For Citizen For Manurhin For Tornos	Drawing
CYL 06 x 45/ER 11 M	2606.21120	16	6	-	-	11	45	26.5	-	-		1
CYL 07 x 45/ER 11 M	2607.21120	16	7	-	-	11	45	26.5	-	-		1
CYL 08 x 80/ER 8 M	2608.20850	12	8	3	-	8	80	26	30	-		2
CYL 08 x 56/ER 11 M	2608.21130	16	8	4	-	11	56	26.5	46	-		2
CYL 3/8" x 70/ER 8 M	2609.20841	12	9.52	-	M5	8	70	23	-	-		3
CYL 10 x 60/ER 16 M	2610.21630	22	10	5.2	-	17	60	38.5	50	-		2
CYL 12 x 80/ER 8 M	2612.20850	12	12	5.2	-	10	80	17	30	-		2
CYL 12 x 80/ER 16 M	2612.21650	22	12	7	-	17	80	38.5	50	-		2
CYL 1/2" x 140/ER 11 M	2613.21191	16	12.7	-	M6	11	140	29.5	-	52		4
CYL 1/2" x 140/ER 16 M	2613.21691	22	12.7	-	M6	17	140	33.5	-	50		4
CYL 15 x 100/ER 20 M	2615.22060	28	15	8.5	-	22	100	42.5	60	-		2
CYL 16 x 150/ER 11 M	2616.21190	16	16	-	M8x1	14	150	21	-	-		2
CYL 16 x 100/ER 20 M	2616.22060	28	16	8.5	-	22	100	42.5	60	-		2
CYL 5/8" x 150/ER 11 M	2616.21191	16	15.87	-	M8x1	14	150	22.5	-	-		3
CYL 3/4" x 155/ER 16 M	2619.21691	22	19.05	-	M12x1	17	155	26.5	-	-		3
CYL 3/4" x 100/ER 25 M	2619.22561	35	19.05	-	M12x1	27	100	47	-	-		3
CYL 20 x 155/ER 16 M	2620.21690	22	20	-	M12x1	17	155	26	-	-	✓	3
CYL 25 x 155/ER 20 M	2625.22090	28	25	-	M14x1	22	155	26.5	-	-	✓	3
CYL 1" x 155/ER 20 M	2625.22091	28	25.5	-	M14x1	22	140	26.5	-	-	✓	3

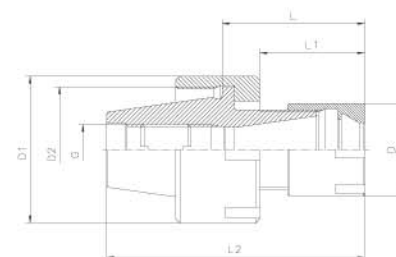


Supplied with: Collet holder, clamping nut and back-up screw  
(Back-up screw only with type according to drawing No. 3)

Other straight shank holders and clamping nut options available.  
Please call for details.

## ERM/ERM COLLET REDUCTION

Type	Part No.	D [mm]	D1 [mm]	D2 [mm]	G [mm]	L [mm]	L1 [mm]	L2 [mm]	Tornos
ER 20 M/ER 16 M	7161.20160	22	28	M24x1	M10x1	30	23	52.5	✓
ER 25 M/ER 16 M	7161.25160	22	35	M30x1	M12x1	34	25	61.5	✓



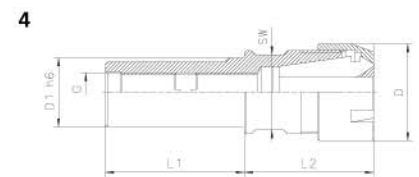
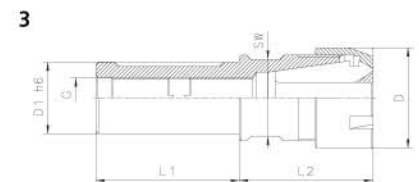
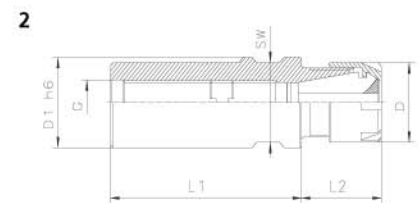
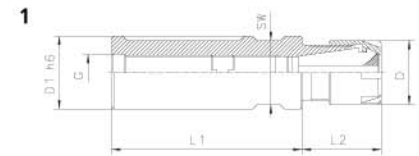
Supplied with: Collet reduction and two clamping nuts

# CYL/ER MF



■ COLLET HOLDERS - CYLINDRICAL HOLDERS WITH GROUND FLAT IN BOTH METRIC AND INCH SIZES

Type	Part No.	D [mm]	D1 h6 [mm]	G [mm]	L1 [mm]	L2 [mm]	SW [mm]	For Citizen	For Manurhin	For Schütte	For Star	For Tornos-
CYL 5/8" x 150/ER 11MF	2616.21193	16	16	M8x1	150	20	14					1
CYL 16 x 038/ER 11 MF	2616.21112	16	16	M8x1	38	20	14				✓	1
CYL 16 x 140/ER 11 MF	2616.21192	16	16	M8x1	140	20	14					1
CYL 16 x 035/ER 16 MF	2616.21612	22	16	M8x1	35	36	17				✓	3
CYL 3/4"x 038/ER 16 MF	2619.21613	22	19.05	M12x1	38	26	17	✓				1
CYL 3/4"x 050/ER 16 MF	2619.21623	22	19.05	M12x1	50	26	17	✓				1
CYL 3/4"x 070/ER 16 MF	2619.21643	22	19.05	M12x1	70	26	17	✓				1
CYL 3/4"x 120/ER 16 MF	2619.21683	22	19.05	M12x1	120	26	17	✓				1
CYL 3/4"x 140/ER 16 MF	2619.21693	22	19.05	M12x1	140	26	17	✓				1
CYL 20 x 050/ER 16 MF	2620.21622	22	20	M12x1	50	26	17	✓				1
CYL 20 x 070/ER 16 MF	2620.21642	22	20	M12x1	70	26	17	✓				1
CYL 20 x 120/ER 16 MF	2620.21682	22	20	M12x1	120	26	17	✓				1
CYL 20 x 140/ER 16 MF	2620.21692	22	20	M12x1	140	26	17	✓				1
CYL 22 x 038/ER 16 MF	2622.21612	22	22	M12x1	38	26	19				✓	1
CYL 22 x 070/ER 16 MF	2622.21642	22	22	M12x1	70	26	19				✓	1
CYL 22 x 100/ER 16 MF	2622.21662	22	22	M12x1	100	28	19				✓	1
CYL 22 x 080/ER 20 MF	2622.22052	28	22	M12x1	80	39	21				✓	3
CYL 22 x 070/ER 25 MF	2622.22542	35	22	M12x1	70	47	27				✓	3
CYL 25 x 065/ER 16 MF	2625.21642	22	25	M12x1	65	28	22					2
CYL 25 x 100/ER 20 MF	2625.22062	28	25	M14x1	100	28	22					2
CYL 25 x 140/ER 20 MF	2625.22092	28	25	M14x1	140	28	22					2
CYL 25 x 154/ER 20 MF	2625.22002	28	25	M14x1	154	28	22					2
CYL 25 x 075/ER 25 MF	2625.22552	35	25	M14x1	75	47.5	27		✓			4
CYL 25 x 145/ER 25 MF	2625.22592	35	25	M14x1	145	36	27					4
CYL 1"x 065/ER 16 MF	2625.21643	22	25.4	M12x1	65	28	22		✓			1
CYL 1"x 075/ER 16 MF	2625.21653	22	25.4	M12x1	75	28	22	✓				1
CYL 1"x 100/ER 16 MF	2625.21663	22	25.4	M12x1	100	28	22	✓				1
CYL 1"x 100/ER 20 MF	2625.22063	28	25.4	M14x1	100	28	22	✓				1
CYL 1"x 140/ER 20 MF	2625.22093	28	25.4	M14x1	140	28	22	✓				1
CYL 32 x 070/ER 25 MF	2632.22542	35	32	M18x1	70	30	27			✓		1

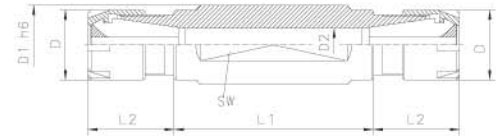


Supplied with: Collet holder and clamping nut  
Other straight shank holders and clamping nut options available.  
Please call for details.



■ COLLET HOLDERS - CYLINDRICAL DOUBLE-SIDED  
HOLDERS IN BOTH METRIC AND INCH SIZES

Type	Part No.	D [mm]	D1 h6 [mm]	D2 [mm]	L1 [mm]	L2 [mm]	SW [mm]	For Citizen	For Manurhin	For Star
CYD 16 x 50/ER 11 MF	2616.21124	16	16	7.5	50	20	14			
CYD 3/4" x 70/ER 11 MF	2619.21145	16	19.05	7.5	70	20	17	✓		
CYD 3/4" x 55/ER 16 MF	2619.21635	22	19.05	10.5	55	26	17	✓		
CYD 20 x 30/ER 11 MF	2620.21114	16	20	7.5	30	20	17	✓		
CYD 20 x 50/ER 11 MF	2620.21124	16	20	7.5	50	20	17	✓		
CYD 20 x 55/ER 16 MF	2620.21634	22	20	10.5	55	26	17	✓		
CYD 22 x 55/ER 16 MF	2622.21634	22	22	10.5	55	28	19		✓	
CYD 22 x 75/ER 16 MF	2622.21654	22	22	10.5	75	28	19		✓	
CYD 25 x 62/ER 16 MF	2625.21634	22	25	10.5	62	28	22			
CYD 1" x 62/ER 16 MF	2625.21635	22	25.4	10.5	62	28	22		✓	
CYD 32 x 55/ER 20 MF	2632.22034	28	32	13.5	55	28	27			✓
CYD 32 x 75/ER 20 MF	2632.22054	28	32	13.5	75	28	27			✓

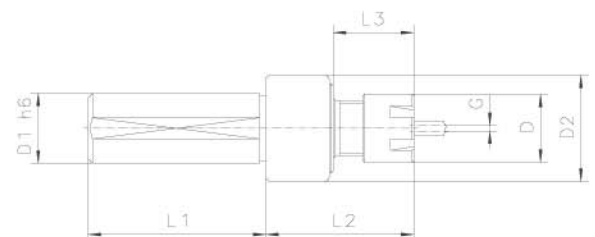


Supplied with: Collet holder and two clamping nuts

■ MINI-FLOATING CHUCKS



Type	Part No.	D [mm]	D1 h6 [mm]	D2 [mm]	G float	L1 [mm]	L2 [mm]	L3 [mm]
MPH 8/ER 11 M	2608.91107	16	8	25	0.5	42	35	19
MPH 10/ER 11 M	2610.91107	16	10	25	0.5	42	35	19
MPH 3/4"/ER 11 M	2619.91108	16	19.05	25	0.5	70	35	19
MPH 20/ER 11 M	2620.91107	16	20	25	0.5	42	35	19
MPH 22/ER 11 M	2622.91107	16	22	25	0.5	42	35	19
MPH 1"/ER 11 M	2625.91108	16	25.40	25	0.5	42	35	19



Supplied with: Floating chuck, clamping nut and clamping wrench

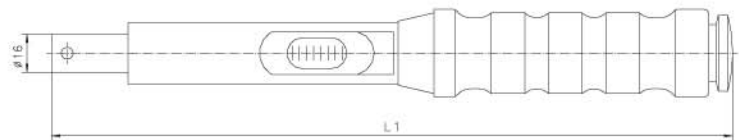


# TORQUE WRENCHES AND WRENCH HEADS

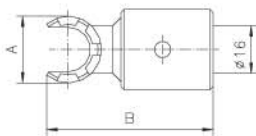


## ■ TORQUE WRENCHES

Type	Part No.	Range		L1 [mm]
		[Nm]	[ft-lbs]	
Micro	7150.05050	5 ... 50	3.7 ... 37	335
Small	8020.08060	8 ... 60	5.9 ... 44	300

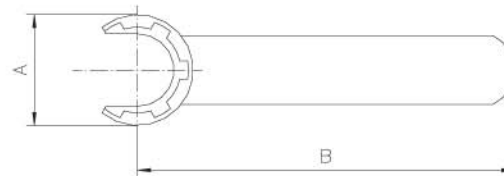


## ■ WRENCH HEADS FOR TORQUE WRENCHES



Type	Part No.	Size	A	B
			[mm]	[mm]
A-E 8 M	7153.08000	ER 8	12.4	53
A-E 11 M	7153.11000	ER 11	16.8	54
A-E 16 M	7153.16000	ER 16	22.5	56
A-E 20 M	7153.20000	ER 20	29.0	58
A-E 25 M	7153.25000	ER 25	36.0	70

## ■ STANDARD WRENCHES

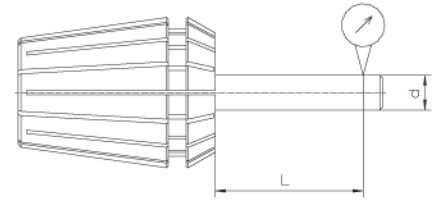


Type	Part No.	Size	A	B
			[mm]	[mm]
E 8 M	7113.08000	ER 8	12.4	70
E 11 M	7113.11000	ER 11	16.8	90
E 16 M	7113.16000	ER 16	22.5	110
E 20 M	7113.20000	ER 20	29.0	120
E 25 M	7113.25000	ER 25	36.0	130

# CONCENTRICITY

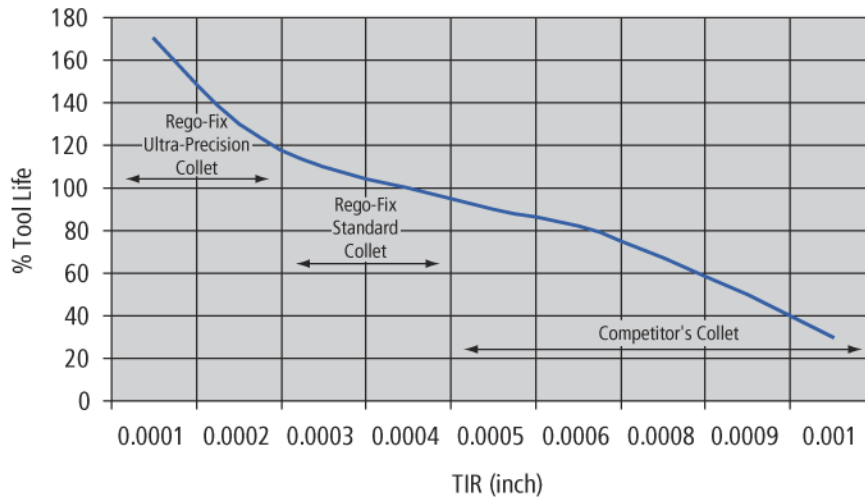
■ **CONCENTRICITY (T.I.R.) OF COLLETS (DIN 6499 FORM B), TYPE ER (STANDARD) AND ER-UP (ULTRA-PRECISION)**

Clamping Range [mm]			Concentricity [mm]*		
from d	to d	L	DIN	ER (standard)	ER-UP (Ultra-Precision)
1.0	1.6	6.0			
1.6	3.0	10.0	0.015 (0.0006")	0.010 (0.0004")	0.005 (0.0002")
3.0	6.0	16.0			
6.0	10.0	25.0			
10.0	18.0	40.0	0.020 (0.0008")	0.010 (0.0004")	0.005 (0.0002")
18.0	26.0	50.0			
26.0	34.0	60.0	0.025 (0.001")	0.015 (0.0006")	0.010 (0.0004")



\*Concentricity is guaranteed over the FULL clamping range.

■ **INFLUENCE OF TOOL RUN-OUT (T.I.R.) ON TOOL LIFE**



**Precision is a function of the whole system of toolholder, collet and nut. For best results, we recommend that you use REGO-FIX toolholders, collets and nuts.**

# Why use REGO-FIX Tooling?

## *Swiss Precision--Lowest T.I.R in the Industry*

- Higher precision means longer tool-life, less downtime, longer machine life
- Higher quality parts produced from your machining processes
- Cost savings from extended tool-life and quicker machining time

## *Product Traceability*

- Consistent quality control and accountability

## *Originators of the "ER" Collet system (DIN 6499)*

- Proven success
- Worldwide acceptance

## *Extensive Product Offering*

- Largest selection of straight shank cylindrical holders in the industry
- Widest selection of ER collets and toolholding components in the world

## *Delivery*

- High levels of stock to ensure immediate availability
- 98% of all orders shipped the same day

## *Service and Technical Support*

- Knowledgeable technical support to answer questions
- Coast to coast representation through distributor and rep network
- Willingness to identify problems at the machine and provide cost saving solutions
- Customer satisfaction and service is our mission

## *System versatility*

- Broad range of collets covers a wide range of tool sizes and machining operations
- All collets, toolholders, clamping nuts and disks totally interchangeable
- REGO-FIX user-friendly system represents the highest level of accuracy and precision



## Use REGO-FIX holders, collets and nuts



for maximum system precision!

# Other High Quality Products from **REGO-FIX**



- Full range of ER collets
- Tapping collets w/square drive
- Tapping collets w/axial compensation
- Steep taper and HSK toolholders
- Largest selection of cylindrical holders
- Drill chucks
- End mill and shell mill holders



- Clamping nuts
- Hydraulic reduction sleeves
- Balanceable toolholders
- Sealing disk system
- Coolant through floating chucks
- Spindle speeders and angle heads
- Balancing machines



 **REGO-FIX<sup>®</sup>**  
Swiss Precision Tools

1-800-REGO-FIX  
[www.rego-fix.com/screwmachine](http://www.rego-fix.com/screwmachine)