





# ER Collets PG Collets Hydraulic Sleeves

# 2

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## Features | Benefits

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### Swiss Quality

Made in Switzerland to ISO 9001/ISO 14001.

1

### Marking

Type and size (reduces collet selection errors).

2

### Traceability

Lot number is marked on all products for traceability throughout the entire manufacturing process.

3

### Original REGO-FIX®

REGO-FIX® is the inventor of the worldwide standardized ER collet system. Our extensive experience results in a well-engineered system. When buying ER collets, please note the REGO-FIX® quality symbol  $\triangle$  on the front of the collet.

### Wide Clamping Range

The 16-slot design allows a wide clamping range while maintaining best T.I.R.

### Broad Range of Products

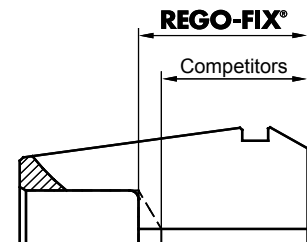
Sizes from ER 8 up to ER 50 for diameters from 0.0079" (0.2 mm) up to 1.334" (34 mm).

### Worldwide Availability

With the global REGO-FIX® distribution network.

### Up to 20% more Clamping Length

For small diameters, up to 20% more clamping length than the competition, which results in better run-out.



### Matched Tooling System

All REGO-FIX® components such as collets, toolholders, clamping nuts and spanners are all manufactured by REGO-FIX®. The compatibility of the whole system results in maximum precision, balance and tool life.

### ER Standard Collets

REGO-FIX® collets made to DIN 6499 are used for drilling, milling, reaming, tapping and grinding.

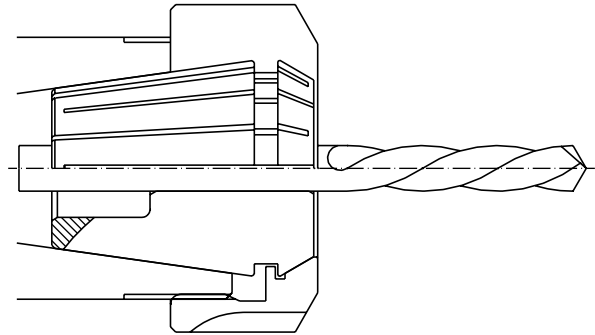
#### Special Advantages

T.I.R.  $\leq 0.0004"$  (10  $\mu\text{m}$ ) over the entire clamping range

Clamping range from diameter 0.0079" (0.2 mm)  
up to 1.334" (34 mm)

Vibration dampening

Combining the smallest design (ER 8) with the highest precision (ER-UP)



2

### ER-UP High Precision Collets

#### Special Advantages

T.I.R.  $\leq 0.0002"$  (5  $\mu\text{m}$ ) over the entire clamping range

Clamping range equal to the standard collets

Provides the lowest T.I.R. equal to or better than nominal diameter (on size) collets

ER collets are primarily used for high-speed cutting applications, where the lowest T.I.R. (Total Indicated Runout) is required. Low T.I.R. improves tool life, part finish and reduces spindle wear.

For the influence of T.I.R. on tool life see graph on page 2.03



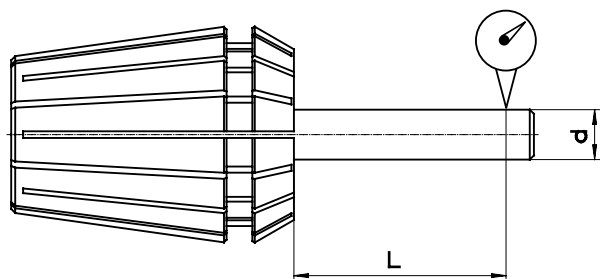
When buying ER collets, please note the REGO-FIX® quality symbol  $\triangle$  on the front of the collet!

## Concentricity T.I.R.

DIN 6499/ISO 15488

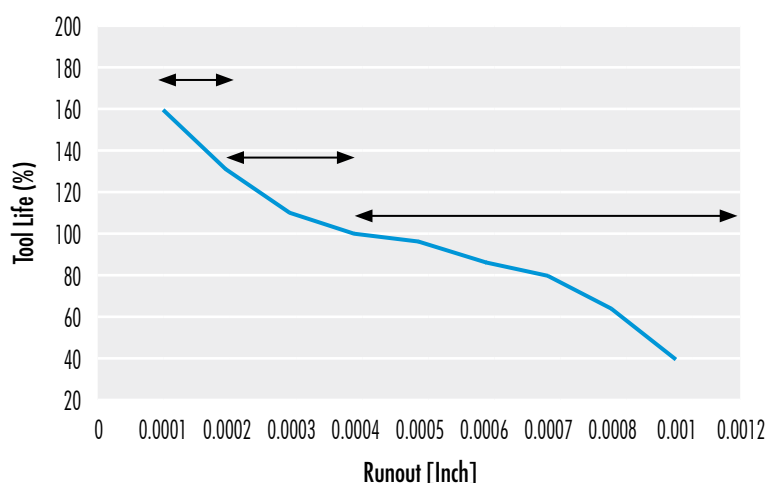
### ER (Standard) and ER-UP (Ultra-Precision)

2



Clamping Range [mm]			T.I.R. max.		
From d	To d	L	DIN 6499/ ISO 15488 Form B	△ ER	△ ER-UP
1.0	1.6	6.0			
1.6	3.0	10.0	0.0006" (0.015mm)	0.0004" (0.010mm)	0.0002" (0.005mm)
3.0	6.0	16.0			
6.0	10.0	25.0			
10.0	18.0	40.0	0.0008" (0.020mm)	0.0004" (0.010mm)	0.0002" (0.005mm)
18.0	26.0	50.0			
26.0	34.0	60.0	0.001" (0.025mm)	0.0006" (0.015mm)	0.0004" (0.010mm)

### Influence of Tool Run-out (T.I.R.) on Tool Life



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

### Collets ER and ER-UP

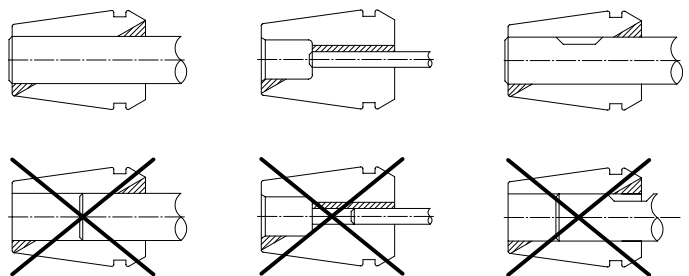
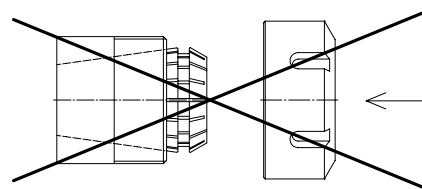
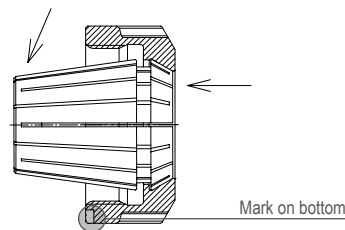
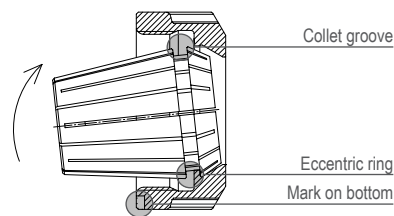
#### Assembling Instructions

Insert groove of collet into eccentric ring of the clamping nut at the mark on the bottom of the nut. Push collet in the direction of the arrow until it clicks in place. Screw nut with collet onto toolholder. We recommend tightening the nut with a torque wrench.

For recommended tightening torque please refer to list on page 14.03

#### Disassembly Instructions

After the nut is unscrewed from the toolholder, press on the face of the collet while simultaneously pushing sideways on the back of the collet opposite the mark until it disengages from the clamping nut.

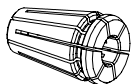


Improper assembly can permanently damage the concentricity of the collet and may result in damage to the clamping nut.

Only assemble the clamping nuts with correctly assembled collets!

Never clamp oversized tool shanks!  
E.G. never use a Ø 12–11 mm collet to clamp a Ø 12.2 mm shank. Rather, use the next bigger collet (Ø 12.5–11.5 mm or 13–12 mm collet).

Insert tool to the full length of the collet for best results if possible. However, never insert the tool less than  $\frac{2}{3}$  of the collet bore length. Improper tool insertion can permanently deform the collet and will result in poor run-out.



ER 8

ER 8-UP

(Ultra Precision)

DIN 6499/ISO 15488

## Metric

## Inch

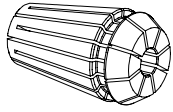
2

Clamping Capacity		ER 8	ER 8-UP
[mm]	[Inch]	Part No.	Part No.
1.00 – 0.70*	0.0394 – 0.0276	1108.01000	1108.01001
1.50 – 1.00*	0.0591 – 0.0394	1108.01500	1108.01501
2.00 – 1.50*	0.0787 – 0.0591	1108.02000	1108.02001
2.50 – 2.00*	0.0984 – 0.0787	1108.02500	1108.02501
3.00 – 2.50*	0.1181 – 0.0984	1108.03000	1108.03001
3.50 – 3.00*	0.1378 – 0.1181	1108.03500	1108.03501
4.00 – 3.50*	0.1575 – 0.1378	1108.04000	1108.04001
4.50 – 4.00*	0.1772 – 0.1575	1108.04500	1108.04501
5.00 – 4.50*	0.1969 – 0.1772	1108.05000	1108.05001
Collet Sets come in Standard and UP		1108.00000	1108.00001
*Sizes are included in Sets		9 Collets and 1 Tray	

Ø [inch]	Clamping Capacity		ER 8	ER 8-UP
	[inch]	[mm]	Part No.	Part No.
1/16*	0.0625 – 0.0425	1.59 – 1.09	1108.01592	1108.01593
1/8*	0.1250 – 0.1055	3.18 – 2.68	1108.03182	1108.03183
3/16*	0.1875 – 0.1675	4.76 – 4.26	1108.04762	1108.04763
Collet Sets come in Standard and UP			1108.00002	1108.00003
All Sizes listed above are included in Sets			3 Collets and 1 Tray	

Additional technical information on page 14.02

Related Items	
Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 11 | ER 11-UP<sub>(Ultra Precision)</sub>

DIN 6499/ISO 15488

### Metric

Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 11 Part No.	ER 11-UP Part No.
1.00 – 0.50*	0.0394 – 0.0197	1111.01000	1111.01001
1.50 – 1.00*	0.0591 – 0.0394	1111.01500	1111.01501
2.00 – 1.50*	0.0787 – 0.0591	1111.02000	1111.02001
2.50 – 2.00*	0.0984 – 0.0787	1111.02500	1111.02501
3.00 – 2.50*	0.1181 – 0.0984	1111.03000	1111.03001
3.50 – 3.00*	0.1378 – 0.1181	1111.03500	1111.03501
4.00 – 3.50*	0.1575 – 0.1378	1111.04000	1111.04001
4.50 – 4.00*	0.1772 – 0.1575	1111.04500	1111.04501
5.00 – 4.50*	0.1969 – 0.1772	1111.05000	1111.05001
5.50 – 5.00*	0.2165 – 0.1969	1111.05500	1111.05501
6.00 – 5.50*	0.2362 – 0.2165	1111.06000	1111.06001
6.50 – 6.00*	0.2559 – 0.2362	1111.06500	1111.06501
7.00 – 6.50*	0.2756 – 0.2559	1111.07000	1111.07001
Collet Sets come in Standard and UP *Sizes are included in Sets		1111.00000	1111.00001
		13 Collets and 1 Tray	

Additional technical information on page 14.02

### Inch

Ø [Inch]	Clamping Capacity [inch]	Clamping Capacity [mm]	ER 11 Part No.	ER 11-UP Part No.
1/16*	0.0625 – 0.0425	1.59 – 1.09	1111.01592	1111.01593
3/32*	0.0938 – 0.0738	2.38 – 1.88	1111.02382	1111.02383
1/8*	0.1250 – 0.1050	3.18 – 2.68	1111.03182	1111.03183
5/32*	0.1563 – 0.1363	3.97 – 3.47	1111.03972	1111.03973
3/16*	0.1875 – 0.1675	4.76 – 4.26	1111.04762	1111.04763
7/32*	0.2188 – 0.1988	5.56 – 5.06	1111.05562	1111.05563
1/4*	0.2500 – 0.2300	6.35 – 5.85	1111.06352	1111.06353
Collet Sets come in Standard and UP *Sizes are included in Sets			1111.00002	1111.00003
			7 Collets and 1 Tray	

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## ER 11-ND<sub>(Nominal Diameter)</sub>

DIN 6499/ISO 15488

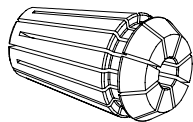
Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 11ND Part No.
3.00	0.1181	1111.03005
4.00	0.1575	1111.04005
6.00	0.2362	1111.06005

Additional technical information on page 14.02

For use with the HSK -F Micro Milling holders to achieve the best TIR for high speed machining. See page 8.07 for matching holders.

Related Items	
Wrenches	See page 13.01
Nuts	See Section 4.00





## ER 16 | ER 16-UP<sup>(Ultra Precision)</sup>

DIN 6499/ISO 15488

### Metric

### Inch

2

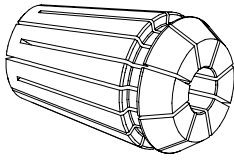
Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 16 Part No.	ER 16-UP Part No.
1.00 – 0.50*	0.0394 – 0.0197	1116.01000	1116.01001
1.50 – 1.00	0.0591 – 0.0394	1116.01500	1116.01501
2.00 – 1.00*	0.0787 – 0.0394	1116.02000	1116.02001
2.50 – 1.50	0.0984 – 0.0591	1116.02500	1116.02501
3.00 – 2.00*	0.1181 – 0.0787	1116.03000	1116.03001
3.50 – 2.50	0.1378 – 0.0984	1116.03500	1116.03501
4.00 – 3.00*	0.1575 – 0.1181	1116.04000	1116.04001
4.50 – 3.50	0.1772 – 0.1378	1116.04500	1116.04501
5.00 – 4.00*	0.1969 – 0.1575	1116.05000	1116.05001
5.50 – 4.50	0.2165 – 0.1772	1116.05500	1116.05501
6.00 – 5.00*	0.2362 – 0.1969	1116.06000	1116.06001
6.50 – 5.50	0.2559 – 0.2165	1116.06500	1116.06501
7.00 – 6.00*	0.2756 – 0.2362	1116.07000	1116.07001
7.50 – 6.50	0.2953 – 0.2559	1116.07500	1116.07501
8.00 – 7.00*	0.3150 – 0.2756	1116.08000	1116.08001
8.50 – 7.50	0.3347 – 0.2953	1116.08500	1116.08501
9.00 – 8.00*	0.3543 – 0.3150	1116.09000	1116.09001
9.50 – 8.50	0.3740 – 0.3347	1116.09500	1116.09501
10.00 – 9.00*	0.3937 – 0.3543	1116.10000	1116.10001
Collet Sets come in Standard and UP		1116.00000	1116.00001
*Sizes are included in Sets		10 Collets and 1 Tray	

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*	0.0938 – 0.0738	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
Collet Sets come in Standard and UP			1116.00002	1116.00003
*Sizes are included in Sets			12 Collets and Tray	

Additional technical information on page 14.02

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 20 | ER 20-UP<sup>(Ultra Precision)</sup>

DIN 6499/ISO 15488

### Metric

Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 20 Part No.	ER 20-UP Part No.
1.00 – 0.50	0.0394 – 0.0197	1120.01000	1120.01001
1.50 – 1.00	0.0591 – 0.0394	1120.01500	1120.01501
2.00 – 1.00*	0.0787 – 0.0394	1120.02000	1120.02001
2.50 – 1.50	0.0984 – 0.0591	1120.02500	1120.02501
3.00 – 2.00*	0.1181 – 0.0787	1120.03000	1120.03001
3.50 – 2.50	0.1378 – 0.0984	1120.03500	1120.03501
4.00 – 3.00*	0.1575 – 0.1181	1120.04000	1120.04001
4.50 – 3.50	0.1772 – 0.1378	1120.04500	1120.04501
5.00 – 4.00*	0.1969 – 0.1575	1120.05000	1120.05001
5.50 – 4.50	0.2165 – 0.1772	1120.05500	1120.05501
6.00 – 5.00*	0.2362 – 0.1969	1120.06000	1120.06001
6.50 – 5.50	0.2559 – 0.2165	1120.06500	1120.06501
7.00 – 6.00*	0.2756 – 0.2362	1120.07000	1120.07001
7.50 – 6.50	0.2953 – 0.2559	1120.07500	1120.07501
8.00 – 7.00*	0.3150 – 0.2756	1120.08000	1120.08001
8.50 – 7.50	0.3347 – 0.2953	1120.08500	1120.08501
9.00 – 8.00*	0.3543 – 0.3150	1120.09000	1120.09001
9.50 – 8.50	0.3740 – 0.3347	1120.09500	1120.09501
10.00 – 9.00*	0.3937 – 0.3543	1120.10000	1120.10001
10.50 – 9.50	0.4134 – 0.3740	1120.10500	1120.10501
11.00 – 10.00*	0.4330 – 0.3937	1120.11000	1120.11001
11.50 – 10.50	0.4528 – 0.4134	1120.11500	1120.11501
12.00 – 11.00*	0.4724 – 0.4375	1120.12000	1120.12001
12.50 – 11.50	0.4921 – 0.4528	1120.12500	1120.12501
13.00 – 12.00*	0.5118 – 0.4724	1120.13000	1120.13001
Collet Sets come in Standard and UP		1120.00000	1120.00001
*Sizes are included in Sets		12 Collets and 1 Tray	

Additional technical information on page 14.02

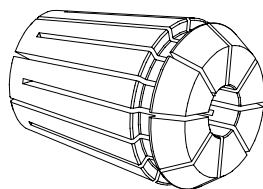
### Inch

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
Collet Sets come in Standard and UP			1120.00002	1120.00003
*Sizes are included in Sets			7 Collets and 1 Tray	

2

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 25 | ER 25-UP<sup>(Ultra Precision)</sup>

DIN 6499/ISO 15488

### Metric

2

Clamping Capacity		ER 25	ER 25-UP
[mm]	[Inch]	Part No.	Part No.
1.00 – 0.50	0.0394 – 0.0197	1125.01000	1125.01001
1.50 – 1.00	0.0591 – 0.0394	1125.01500	1125.01501
2.00 – 1.00*	0.0787 – 0.0394	1125.02000	1125.02001
2.50 – 1.50	0.0984 – 0.0591	1125.02500	1125.02501
3.00 – 2.00*	0.1181 – 0.0787	1125.03000	1125.03001
3.50 – 2.50	0.1378 – 0.0984	1125.03500	1125.03501
4.00 – 3.00*	0.1575 – 0.1181	1125.04000	1125.04001
4.50 – 3.50	0.1772 – 0.1378	1125.04500	1125.04501
5.00 – 4.00*	0.1969 – 0.1575	1125.05000	1125.05001
5.50 – 4.50	0.2165 – 0.1772	1125.05500	1125.05501
6.00 – 5.00*	0.2362 – 0.1969	1125.06000	1125.06001
6.50 – 5.50	0.2559 – 0.2165	1125.06500	1125.06501
7.00 – 6.00*	0.2756 – 0.2362	1125.07000	1125.07001
7.50 – 6.50	0.2953 – 0.2559	1125.07500	1125.07501
8.00 – 7.00*	0.3150 – 0.2756	1125.08000	1125.08001
8.50 – 7.50	0.3347 – 0.2953	1125.08500	1125.08501
9.00 – 8.00*	0.3543 – 0.3150	1125.09000	1125.09001
9.50 – 8.50	0.3740 – 0.3347	1125.09500	1125.09501
10.00 – 9.00*	0.3937 – 0.3543	1125.10000	1125.10001
10.50 – 9.50	0.4134 – 0.3740	1125.10500	1125.10501
11.00 – 10.00*	0.4330 – 0.3937	1125.11000	1125.11001
11.50 – 10.50	0.4528 – 0.4134	1125.11500	1125.11501
12.00 – 11.00*	0.4724 – 0.4375	1125.12000	1125.12001
12.50 – 11.50	0.4921 – 0.4528	1125.12500	1125.12501
13.00 – 12.00*	0.5118 – 0.4724	1125.13000	1125.13001
13.50 – 12.50	0.5315 – 0.4921	1125.13500	1125.13501

### Metric (cont.)

Clamping Capacity		ER 25	ER 25-UP
[mm]	[Inch]	Part No.	Part No.
14.00 – 13.00*	0.5512 – 0.5118	1125.14000	1125.14001
14.50 – 13.50	0.5709 – 0.5315	1125.14500	1125.14501
15.00 – 14.00*	0.5905 – 0.5512	1125.15000	1125.15001
15.50 – 14.50	0.6102 – 0.5315	1125.15500	1125.15501
16.00 – 15.00*	0.6300 – 0.5905	1125.16000	1125.16001
Collet Sets come in Standard and UP		1125.00000	1125.00001
*Sizes are included in Sets		15 Collets and 1 Tray	

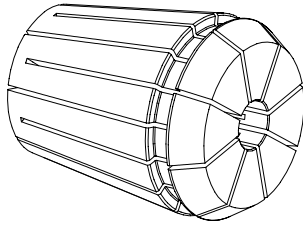
Additional technical information on page 14.02

### Inch

Ø [Inch]	Clamping Capacity		ER 25	ER 25-UP
	[inch]	[mm]	Part No.	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
Collet Sets come in Standard and UP			1125.00002	1125.00003
*Sizes are included in Sets			9 Collets and 1 Tray	

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 32 | ER 32-UP<sup>(Ultra Precision)</sup>

DIN 6499/ISO 15488

### Metric

Clamping Capacity		ER 32	ER 32-UP
[mm]	[Inch]	Part No.	Part No.
2.00 – 1.00	0.0787 – 0.0394	1132.02000	1132.02001
2.50 – 1.50	0.0984 – 0.0591	1132.02500	1132.02501
3.00 – 2.00*	0.1181 – 0.0787	1132.03000	1132.03001
3.50 – 2.50	0.1378 – 0.0984	1132.03500	1132.03501
4.00 – 3.00*	0.1575 – 0.1181	1132.04000	1132.04001
4.50 – 3.50	0.1772 – 0.1378	1132.04500	1132.04501
5.00 – 4.00*	0.1969 – 0.1575	1132.05000	1132.05001
5.50 – 4.50	0.2165 – 0.1772	1132.05500	1132.05501
6.00 – 5.00*	0.2362 – 0.1969	1132.06000	1132.06001
6.50 – 5.50	0.2559 – 0.2165	1132.06500	1132.06501
7.00 – 6.00*	0.2756 – 0.2362	1132.07000	1132.07001
7.50 – 6.50	0.2953 – 0.2559	1132.07500	1132.07501
8.00 – 7.00*	0.3150 – 0.2756	1132.08000	1132.08001
8.50 – 7.50	0.3347 – 0.2953	1132.08500	1132.08501
9.00 – 8.00*	0.3543 – 0.3150	1132.09000	1132.09001
9.50 – 8.50	0.3740 – 0.3347	1132.09500	1132.09501
10.00 – 9.00*	0.3937 – 0.3543	1132.10000	1132.10001
10.50 – 9.50	0.4134 – 0.3740	1132.10500	1132.10501
11.00 – 10.00*	0.4330 – 0.3937	1132.11000	1132.11001
11.50 – 10.50	0.4528 – 0.4134	1132.11500	1132.11501
12.00 – 11.00*	0.4724 – 0.4375	1132.12000	1132.12001
12.50 – 11.50	0.4921 – 0.4528	1132.12500	1132.12501
13.00 – 12.00*	0.5118 – 0.4724	1132.13000	1132.13001
13.50 – 12.50	0.5315 – 0.4921	1132.13500	1132.13501
14.00 – 13.00*	0.5512 – 0.5118	1132.14000	1132.14001
14.50 – 13.50	0.5709 – 0.5315	1132.14500	1132.14501
15.00 – 14.00*	0.5905 – 0.5512	1132.15000	1132.15001
15.50 – 14.50	0.6102 – 0.5315	1132.15500	1132.15501
16.00 – 15.00*	0.6300 – 0.5905	1132.16000	1132.16001
16.50 – 15.50	0.6496 – 0.6102	1132.16500	1132.16501
17.00 – 16.00*	0.6693 – 0.6300	1132.17000	1132.17001

### Metric (cont.)

Clamping Capacity		ER 32	ER 32-UP
[mm]	[Inch]	Part No.	Part No.
17.50 – 16.50	0.6890 – 0.6496	1132.17500	1132.17501
18.00 – 17.00*	0.7087 – 0.6693	1132.18000	1132.18001
18.50 – 17.50	0.7284 – 0.6890	1132.18500	1132.18501
19.00 – 18.00*	0.7480 – 0.7078	1132.19000	1132.19001
19.50 – 18.50	0.7677 – 0.7284	1132.19500	1132.19501
20.00 – 19.00*	0.7874 – 0.7480	1132.20000	1132.20001
Collet Sets come in Standard and UP		1132.00000	1132.00001
*Sizes are included in Sets		18 Collets and 1 Tray	

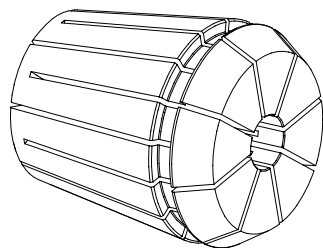
Additional technical information on page 14.02

### Inch

Ø [inch]	Clamping Capacity		ER 32	ER 32-UP
	[inch]	[mm]	Part No.	Part No.
1/8*	0.1250 – 0.0850	3.18 – 2.18	1132.03182	1132.03183
3/16*	0.1875 – 0.1475	4.76 – 3.76	1132.04762	1132.04763
1/4*	0.2500 – 0.2100	6.35 – 5.35	1132.06352	1132.06353
5/16*	0.3125 – 0.2725	7.94 – 6.94	1132.07942	1132.07943
3/8*	0.3750 – 0.3350	9.53 – 8.53	1132.09532	1132.09533
7/16*	0.4375 – 0.3975	11.11 – 10.11	1132.11112	1132.11113
1/2*	0.5000 – 0.4600	12.70 – 11.70	1132.12702	1132.12703
9/16*	0.5625 – 0.5225	14.29 – 13.29	1132.14292	1132.14293
5/8*	0.6250 – 0.5850	15.88 – 14.88	1132.15882	1132.15883
11/16*	0.6875 – 0.6475	17.46 – 16.46	1132.17462	1132.17463
3/4*	0.7500 – 0.7100	19.05 – 18.05	1132.19052	1132.19053
13/16*	0.8125 – 0.7725	20.64 – 19.64	1132.20642	1132.20643
Collet Sets come in Standard and UP			1132.00002	1132.00003
*Sizes are included in Set			12 Collets and 1 Tray	

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 40 | ER 40-UP<sub>(Ultra Precision)</sub>

DIN 6499/ISO 15488

### Metric

Clamping Capacity		ER 40	ER 40-UP
[mm]	[Inch]	Part No.	Part No.
3.00 – 2.00	0.1181 – 0.0787	1140.03000	1140.03001
3.50 – 2.50	0.1378 – 0.0984	1140.03500	1140.03501
4.00 – 3.00*	0.1575 – 0.1181	1140.04000	1140.04001
4.50 – 3.50	0.1772 – 0.1378	1140.04500	1140.04501
5.00 – 4.00*	0.1969 – 0.1575	1140.05000	1140.05001
5.50 – 4.50	0.2165 – 0.1772	1140.05500	1140.05501
6.00 – 5.00*	0.2362 – 0.1969	1140.06000	1140.06001
6.50 – 5.50	0.2559 – 0.2165	1140.06500	1140.06501
7.00 – 6.00*	0.2756 – 0.2362	1140.07000	1140.07001
7.50 – 6.50	0.2953 – 0.2559	1140.07500	1140.07501
8.00 – 7.00*	0.3150 – 0.2756	1140.08000	1140.08001
8.50 – 7.50	0.3347 – 0.2953	1140.08500	1140.08501
9.00 – 8.00*	0.3543 – 0.3150	1140.09000	1140.09001
9.50 – 8.50	0.3740 – 0.3347	1140.09500	1140.09501
10.00 – 9.00*	0.3937 – 0.3543	1140.10000	1140.10001
10.50 – 9.50	0.4134 – 0.3740	1140.10500	1140.10501
11.00 – 10.00*	0.4330 – 0.3937	1140.11000	1140.11001
11.50 – 10.50	0.4528 – 0.4134	1140.11500	1140.11501
12.00 – 11.00*	0.4724 – 0.4330	1140.12000	1140.12001
12.50 – 11.50	0.4921 – 0.4528	1140.12500	1140.12501
13.00 – 12.00*	0.5118 – 0.4724	1140.13000	1140.13001
13.50 – 12.50	0.5315 – 0.4921	1140.13500	1140.13501
14.00 – 13.00*	0.5512 – 0.5118	1140.14000	1140.14001
14.50 – 13.50	0.5709 – 0.5315	1140.14500	1140.14501
15.00 – 14.00*	0.5905 – 0.5512	1140.15000	1140.15001
15.50 – 14.50	0.6102 – 0.5315	1140.15500	1140.15501
16.00 – 15.00*	0.6300 – 0.5905	1140.16000	1140.16001
16.50 – 15.50	0.6496 – 0.6102	1140.16500	1140.16501

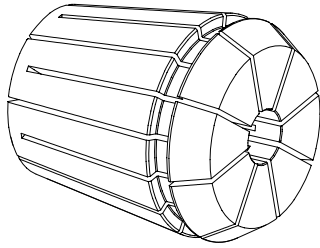
### Metric (cont.)

Clamping Capacity		ER 40	ER 40-UP
[mm]	[Inch]	Part No.	Part No.
17.00 – 16.00*	0.6693 – 0.6300	1140.17000	1140.17001
17.50 – 16.50	0.6890 – 0.6496	1140.17500	1140.17501
18.00 – 17.00*	0.7087 – 0.6693	1140.18000	1140.18001
18.50 – 17.50	0.7284 – 0.6890	1140.18500	1140.18501
19.00 – 18.00*	0.7480 – 0.7078	1140.19000	1140.19001
19.50 – 18.50	0.7677 – 0.7284	1140.19500	1140.19501
20.00 – 19.00*	0.7874 – 0.7480	1140.20000	1140.20001
20.50 – 19.50	0.8071 – 0.7677	1140.20500	1140.20501
21.00 – 20.00*	0.8268 – 0.7874	1140.21000	1140.21001
21.50 – 20.50	0.8465 – 0.8071	1140.21500	1140.21501
22.00 – 21.00*	0.8661 – 0.8268	1140.22000	1140.22001
22.50 – 21.50	0.8858 – 0.8465	1140.22500	1140.22501
23.00 – 22.00*	0.9055 – 0.8661	1140.23000	1140.23001
23.50 – 22.50	0.9252 – 0.8858	1140.23500	1140.23501
24.00 – 23.00*	0.9449 – 0.9055	1140.24000	1140.24001
24.50 – 23.50	0.9646 – 0.9252	1140.24500	1140.24501
25.00 – 24.00*	0.9843 – 0.9449	1140.25000	1140.25001
25.50 – 24.50	1.0039 – 0.9646	1140.25500	1140.25501
26.00 – 25.00*	1.0236 – 0.9843	1140.26000	1140.26001
27.00 – 26.00	1.0630 – 1.0236	1140.27000	1140.27001
28.00 – 27.00	1.1024 – 1.0630	1140.28000	1140.28001
29.00 – 28.00	1.1417 – 1.1024	1140.29000	1140.29001
30.00 – 29.00	1.1811 – 1.1417	1140.30000	1140.30001
Collet Sets come in Standard and UP		1140.00000	1140.00001
*Sizes are included in Set		23 Collets and 1 Tray	

Additional technical information on page 14.02

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



# ER 40 | ER 40-UP<sub>(Ultra Precision)</sub>

DIN 6499/ISO 15488

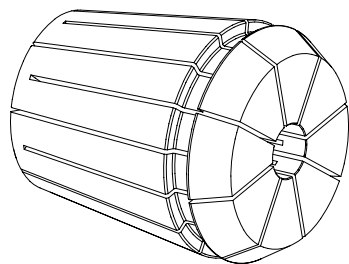
## Inch

2

Ø [Inch]	Clamping Capacity		ER 40 Part No.	ER 40-UP Part No.
[Inch]	[inch]	[mm]		
1/8*	0.1250 – 0.0850	3.18 – 2.18	1140.03182	1140.03183
3/16*	0.1875 – 0.1475	4.76 – 3.76	1140.04762	1140.04763
1/4*	0.2500 – 0.2100	6.35 – 5.35	1140.06352	1140.06353
5/16*	0.3125 – 0.2725	7.94 – 6.94	1140.07942	1140.07943
3/8*	0.3750 – 0.3350	9.53 – 8.53	1140.09532	1140.09533
7/16*	0.4375 – 0.3975	11.11 – 10.11	1140.11112	1140.11113
1/2*	0.5000 – 0.4600	12.70 – 11.70	1140.12702	1140.12703
9/16*	0.5625 – 0.5225	14.29 – 13.29	1140.14292	1140.14293
5/8*	0.6250 – 0.5850	15.88 – 14.88	1140.15882	1140.15883
11/16*	0.6875 – 0.6475	17.46 – 16.46	1140.17462	1140.17463
3/4*	0.7500 – 0.7100	19.05 – 18.05	1140.19052	1140.19053
13/16*	0.8125 – 0.7725	20.64 – 19.64	1140.20642	1140.20643
7/8*	0.8750 – 0.8350	22.23 – 21.23	1140.22232	1140.22233
1*	1.0000 – 0.9600	25.40 – 24.40	1140.25402	1140.25403
Collet Sets come in Standard and UP			1140.00002	1140.00003
*Sizes are included in Set			14 Collets and 1 Tray	

### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 50 | ER 50-UP<sub>(Ultra Precision)</sub>

DIN 6499/ISO 15488

### Metric

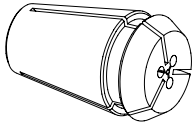
2

Clamping Capacity [mm]	Clamping Capacity [Inch]	Ø [Inch]	ER 50 Part No.	ER 50-UP Part No.
6.00 – 4.00	0.2362 – 0.1575	3/16"	1150.06000	1150.06001
8.00 – 6.00	0.3150 – 0.2362	1/4"	1150.08000	1150.08001
10.00 – 8.00	0.3937 – 0.3150	3/8"	1150.10000	1150.10001
12.00 – 10.00*	0.4724 – 0.3937	7/16"	1150.12000	1150.12001
14.00 – 12.00*	0.5512 – 0.4724	1/2"	1150.14000	1150.14001
16.00 – 14.00*	0.6300 – 0.5512	5/8"	1150.16000	1150.16001
18.00 – 16.00*	0.7087 – 0.6300	11/16"	1150.18000	1150.18001
20.00 – 18.00*	0.7874 – 0.7087	3/4"	1150.20000	1150.20001
22.00 – 20.00*	0.8661 – 0.7874	13/16"	1150.22000	1150.22001
24.00 – 22.00*	0.9449 – 0.8661	7/8"	1150.24000	1150.24001
25.00 – 23.00	0.9843 – 0.9055	31/32"	1150.25000	1150.25001
26.00 – 24.00*	1.0236 – 0.9449	1"	1150.26000	1150.26001
28.00 – 26.00*	1.1024 – 1.0236	1-1/16"	1150.28000	1150.28001
30.00 – 28.00*	1.1811 – 1.1024	1-1/8"	1150.30000	1150.30001
32.00 – 30.00*	1.2598 – 1.1811	1-1/4"	1150.32000	1150.32001
34.00 – 32.00*	1.3386 – 1.2598	1-5/16"	1150.34000	1150.34001
Collet Sets come in Standard and UP			1150.00000	1150.00001
*Sizes are included in Set			12 Collets and 1 Tray	

Additional technical information on page 14.02

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 8 – ER 16 Microbore

DIN 6499/ISO15488

### ER 8 Microbore

Clamping Diameter h7		ER 8-MB Part No.
[mm]	[Inch]	
0.2	0.0079	1308.00200
0.3	0.0118	1308.00300
0.4	0.0157	1308.00400
0.5	0.0197	1308.00500
0.6	0.0236	1308.00600
0.7	0.0276	1308.00700
0.8	0.0315	1308.00800
0.9	0.0354	1308.00900
Additional technical information on page 14.06		

### ER 11 Microbore

Clamping Diameter h7		ER 11-MB Part No.
[mm]	[Inch]	
0.2	0.0079	1311.00200
0.3	0.0118	1311.00300
0.4	0.0157	1311.00400
0.5	0.0197	1311.00500
0.6	0.0236	1311.00600
0.7	0.0276	1311.00700
0.8	0.0315	1311.00800
0.9	0.0354	1311.00900
Additional technical information on page 14.06		

2

### ER 16 Microbore

Clamping Diameter h7		ER 16-MB Part No.
[mm]	[Inch]	
0.2	0.0079	1316.00200
0.3	0.0118	1316.00300
0.4	0.0157	1316.00400
0.5	0.0197	1316.00500
0.6	0.0236	1316.00600
0.7	0.0276	1316.00700
0.8	0.0315	1316.00800
0.9	0.0354	1316.00900
Additional technical information on page 14.06		

Microbore Collets have a run-out of 0.0002" (6µm). They have been developed by REGO-FIX® especially for small tool shank diameters.

Special diameters in inch and metric sizes can be quoted upon request

Related Items	
Wrenches	See page 13.01
Nuts	See Section 4.00



### ER DM | Metallic Sealed

For Coolant Through Tooling

Designed and patented by REGO-FIX®, our metallic sealed collets will seal the tool to the collet and the collet to the toolholder.

#### Universal Fit

Will work with any standard or friction bearing nut, no need to purchase any special coolant nuts or disks for coolant sealing.

#### Swiss Quality

- 1 Made in Switzerland to ISO 9001/ISO 14001.

#### Marking

- 2 Type and size (reduces collet selection errors).

#### Traceability

- 3 Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

#### High Pressure

For applications up to 2000psi (150 bar).

#### Original REGO-FIX®

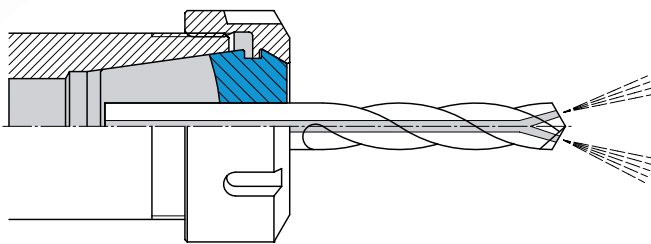
REGO-FIX® is the inventor of the worldwide standardized ER collet system. Our extensive experience results in a well-engineered system. When buying ER collets, please note the REGO-FIX® quality symbol  $\triangle$  on the front of the collet.

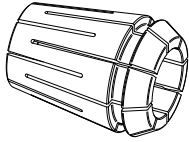
#### Worldwide Availability

With the global REGO-FIX® distribution network.

#### Matched Tooling System

All REGO-FIX® components such as collets, toolholders, clamping nuts and spanners are all manufactured by REGO-FIX®. The compatibility of the whole system results in maximum precision, balance and tool life.





## ER 16 DM | Metallic Sealed

For Coolant Through Tooling

### Metric

Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 16 DM Part No.
3.00	0.1181	1216.03000
4.00	0.1575	1216.04000
5.00 – 4.50	0.1969 – 0.1772	1216.05000
6.00 – 5.50	0.2362 – 0.2165	1216.06000
7.00 – 6.50	0.2756 – 0.2559	1216.07000
8.00 – 7.50	0.3150 – 0.2953	1216.08000
9.00 – 8.50	0.3543 – 0.3347	1216.09000
10.00 – 9.50	0.3937 – 0.3740	1216.10000
ER 16 Metric Metallic Sealed Collet Set		1216.00000

### Inch

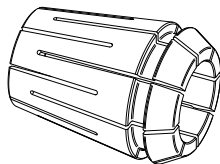
Ø [Inch]	Clamping Capacity [Inch]	Clamping Capacity [mm]	ER 16 DM Part No.
1/8	0.1250	3.18	1216.03182
3/16	0.1875	4.76	1216.04762
1/4	0.2500 – 0.2303	6.35 – 5.85	1216.06352
5/16	0.3125 – 0.2929	7.94 – 7.44	1216.07942
3/8	0.3750 – 0.3556	9.53 – 9.03	1216.09532
ER 16 Inch Metallic Sealed Collet Set			1216.00002

2

Sizes listed with no clamping range are produced to maintain the lowest T.I.R. possible. Larger diameter collets have a 0.020" (0.5 mm) range.

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



ER 20 DM

Metallic Sealed

For Coolant Through Tooling

## Metric

## Inch

2

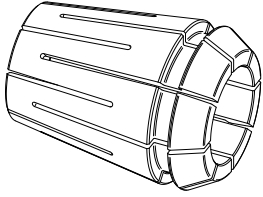
Clamping Capacity		ER 20 DM Part No.
[mm]	[Inch]	
3.00	0.1181	1220.03000
4.00	0.1575	1220.04000
5.00	0.1969	1220.05000
6.00	0.2362	1220.06000
7.00 – 6.50	0.2756 – 0.2559	1220.07000
8.00 – 7.50	0.3150 – 0.2953	1220.08000
9.00 – 8.50	0.3543 – 0.3347	1220.09000
10.00 – 9.50	0.3937 – 0.3740	1220.10000
11.00 – 10.50	0.4330 – 0.4134	1220.11000
12.00 – 11.50	0.4724 – 0.4528	1220.12000
13.00 – 12.50	0.5118 – 0.4921	1220.13000
ER 20 Metric Metallic Sealed Collet Set		1220.00000

Ø [Inch]	Clamping Capacity		ER 20 DM Part No.
	[Inch]	[mm]	
1/8	0.1250	3.18	1220.03182
3/16	0.1875	4.76	1220.04762
1/4	0.2500	6.35	1220.06352
5/16	0.3125 – 0.2929	7.94 – 7.44	1220.07942
3/8	0.3750 – 0.3556	9.53 – 9.03	1220.09532
7/16	0.4375 – 0.4177	11.11 – 10.61	1220.11112
1/2	0.5000 – 0.4803	12.70 – 12.20	1220.12702
ER 20 Inch Metallic Sealed Collet Set			1220.00002

Sizes listed with no clamping range are produced to maintain the lowest T.I.R. possible. Larger diameter collets have a 0.020" (0.5 mm) range.

## Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 25 DM | Metallic Sealed

For Coolant Through Tooling

### Metric

Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 25 DM Part No.
6.00	0.2362	1225.06000
8.00 – 7.50	0.3150 – 0.2953	1225.08000
10.00 – 9.50	0.3937 – 0.3740	1225.10000
12.00 – 11.50	0.4724 – 0.4528	1225.12000
14.00 – 13.50	0.5512 – 0.5315	1225.14000
16.00 – 15.50	0.6300 – 0.6102	1225.16000
ER 25 Metric Metallic Sealed Collet Set		1225.00000

### Inch

Ø [Inch]	Clamping Capacity [Inch]	Clamping Capacity [mm]	ER 25 DM Part No.
1/4	0.2500	6.35	1225.06352
5/16	0.3125 – 0.2929	7.94 – 7.44	1225.07942
3/8	0.3750 – 0.3556	9.53 – 9.03	1225.09532
7/16	0.4375 – 0.4177	11.11 – 10.61	1225.11112
1/2	0.5000 – 0.4803	12.70 – 12.20	1225.12702
9/16	0.5625 – 0.5425	14.29 – 13.79	1225.14292
5/8	0.6250 – 0.6055	15.88 – 15.38	1225.15882
ER 25 Inch Metallic Sealed Collet Set			1225.00002

2

Sizes listed with no clamping range are produced to maintain the lowest T.I.R. possible. Larger diameter collets have a 0.020" (0.5 mm) range.

#### Related Items

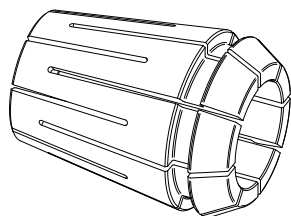
Wrenches	See page 13.01
Nuts	See Section 4.00



Swiss  
Precision  
Tools

# ER

## Metallic Sealed Collets



## ER 32 DM | Metallic Sealed

For Coolant Through Tooling

### Metric

### Inch

2

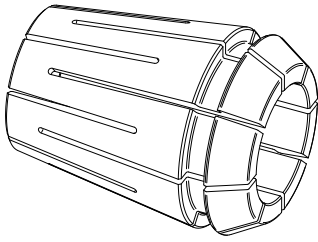
Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 32 DM Part No.
6.00	0.2362	1232.06000
8.00 – 7.50	0.3150 – 0.2953	1232.08000
10.00 – 9.50	0.3937 – 0.3740	1232.10000
12.00 – 11.50	0.4724 – 0.4528	1232.12000
14.00 – 13.50	0.5512 – 0.5315	1232.14000
16.00 – 15.50	0.6300 – 0.6102	1232.16000
18.00 – 17.50	0.7087 – 0.6890	1232.18000
20.00 – 19.50	0.7874 – 0.7677	1232.20000
ER 32 Metric Metallic Sealed Collet Set		1232.00000

Ø [Inch]	Clamping Capacity [Inch]	Clamping Capacity [mm]	ER 32 DM Part No.
1/4	0.2500	6.35	1232.06352
5/16	0.3125 – 0.2929	7.94 – 7.44	1232.07942
3/8	0.3750 – 0.3556	9.53 – 9.03	1232.09532
7/16	0.4375 – 0.4177	11.11 – 10.61	1232.11112
1/2	0.5000 – 0.4803	12.70 – 12.20	1232.12702
9/16	0.5625 – 0.5425	14.29 – 13.79	1232.14292
5/8	0.6250 – 0.6055	15.88 – 15.38	1232.15882
11/16	0.6875 – 0.6677	17.46 – 16.96	1232.17462
3/4	0.7500 – 0.7303	19.05 – 18.55	1232.19052
ER 32 Inch Metallic Sealed Collet Set			1232.00002

Sizes listed with no clamping range are produced to maintain the lowest T.I.R. possible. Larger diameter collets have a 0.020" (0.5 mm) range.

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



## ER 40 DM | Metallic Sealed

For Coolant Through Tooling

### Metric

Clamping Capacity [mm]	Clamping Capacity [Inch]	ER 40 DM Part No.
6.00	0.2362	1240.06000
8.00	0.3150	1240.08000
10.00 – 9.50	0.3937 – 0.3740	1240.10000
12.00 – 11.50	0.4724 – 0.4528	1240.12000
14.00 – 13.50	0.5512 – 0.5315	1240.14000
16.00 – 15.50	0.6300 – 0.6102	1240.16000
18.00 – 17.50	0.7087 – 0.6890	1240.18000
20.00 – 19.50	0.7874 – 0.7677	1240.20000
22.00 – 21.50	0.8661 – 0.8465	1240.22000
24.00 – 23.50	0.9449 – 0.9252	1240.24000
25.00 – 24.50	0.9843 – 0.9646	1240.25000
26.00 – 25.50	1.0236 – 1.0039	1240.26000
ER 40 Metric Metallic Sealed Collet Set		1240.00000

Select availability, please call for stock status

### Inch

Ø [Inch]	Clamping Capacity [Inch]	Clamping Capacity [mm]	ER 40 DM Part No.
3/8	0.3750 – 0.3556	9.53 – 9.03	1240.09532
7/16	0.4375 – 0.4177	11.11 – 10.61	1240.11112
1/2	0.5000 – 0.4803	12.70 – 12.20	1240.12702
9/16	0.5625 – 0.5425	14.29 – 13.79	1240.14292
5/8	0.6250 – 0.6055	15.88 – 15.38	1240.15882
11/16	0.6875 – 0.6677	17.46 – 16.96	1240.17462
3/4	0.7500 – 0.7303	19.05 – 18.55	1240.19052
13/16	0.8125 – 0.7929	20.64 – 20.14	1240.20642
7/8	0.8750 – 0.8555	22.23 – 21.73	1240.22232
1	1.0000 – 0.9803	25.40 – 24.90	1240.25402
ER 40 Inch Metallic Sealed Collet Set			1240.00002

2

Sizes listed with no clamping range are produced to maintain the lowest T.I.R. possible. Larger diameter collets have a 0.020" (0.5 mm) range.

#### Related Items

Wrenches	See page 13.01
Nuts	See Section 4.00



Swiss  
Precision  
Tools

# PG

## Collets

## Features | Benefits

2



### Swiss Quality

Made in Switzerland to ISO9001/ISO14001.

1

### Marking

With type and size (reduces collet selection error).

2

### Product Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

### Original REGO-FIX®

When buying PG collets, please note the REGO-FIX® quality symbol  $\triangle$  on the front of the collet.

### Precision

Highest run-out accuracy 0.0001" (<3  $\mu$ m).

### Accurate Length Adjustment <0.0004" (10 $\mu$ m)

With integrated adjustment screw.

### Clamping of all h6 Tool Shanks

Cylindrical, WELDON and Whistle-Notch. (WELDON and Whistle-Notch shank tools will lessen clamping force.)

### Clamping of all Shank Materials

Solid carbide and HSS tool shanks.

### Clamping Diameters

0.0079"– 1.0" (0.2 to 25.4 mm)

### Fast

Clamping in less than 10 seconds.

### High Vibration Dampening

High vibration dampening due to the interrupted surfaces between the toolholder to collet and the collet to tool shank.

### Highest Transferable Torque

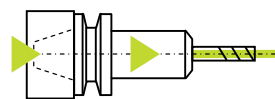
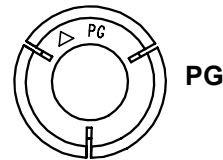
The powRgrip® system yields the highest transferable torque of all comparable systems.

**5** Year  
WARRANTY  
20,000  
CYCLES

### PG Standard Collets

Modern machining techniques like High Speed Cutting (HSC) and High Performance Cutting (HPC) require better toolholding systems. The powRgrip® system offers a unique combination of the best run-out, high clamping force and optimal vibration dampening. This system meets all requirements for the most efficient manufacturing process.

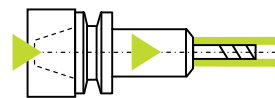
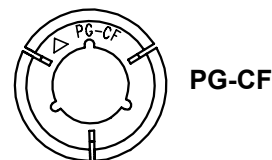
The REGO-FIX® powRgrip® system clamps cutting tools safely and with high precision. The tool and collet are pressed into the toolholder with forces as high as 9 tons by the powRgrip® hydraulic press. For unclamping the compression cycle is simply reversed.



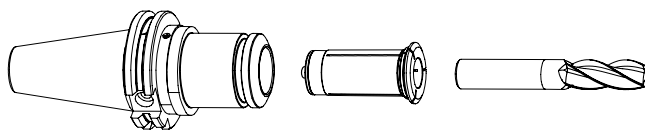
Metallically sealed for coolant through tools

### PG-CF Coolant Flush Collets

Coolant flush collets direct coolant along the shank when working with tools without internal cooling channels.



With coolant channels for peripheral cooling



powRgrip® toolholder  
different types available

exchangeable  
powRgrip® collet

h6 cutting tool



Clamp h6-tolerance tool shanks only!

Never clamp collet without tool.

Collet will be damaged!

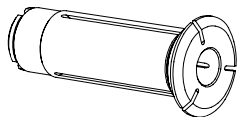
MQL (Minimum Quantity Lubrication)  
compatible collets upon request.

Always use proper tool insertion depth of  
the cutting tool into the collet.

**Please note:** PG-CF collets will have a decreased clamping force versus standard collets due to the reduced surface area contacting the tool shank.

For min/max clamping dimensions please see table on page 14.07



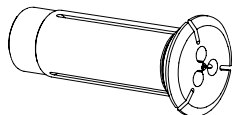


## PG 10 Standard PG 10-CF Coolant Flush

### Metric

Ø [mm]	Ø [Inch]	PG 10 Part No.	PG 10-CF Part No.
2.000	0.0787	1710.02000	–
2.500	0.0984	1710.02500	–
3.000	0.1181	1710.03000	1710.03002
4.000	0.1575	1710.04000	1710.04002
5.000	0.1969	1710.05000	1710.05002
6.000	0.2362	1710.06000	1710.06002

Additional technical information on page 14.07



## PG 10-MB Microbore (pat. pend.)

Ø [mm]	Ø [Inch]	Ø [Inch]	PG 10-MB Part No.
0.200	0.0079		1710.00209
0.300	0.0118		1710.00309
0.400	0.0157		1710.00409
0.500	0.0197		1710.00509
0.600	0.0236		1710.00609
0.700	0.0276		1710.00709
0.800	0.0315		1710.00809
0.900	0.0354		1710.00909
1.000	0.0394		1710.01009
1.500	0.0591		1710.01509
1.5875	0.0625	1/16"	1710.01589

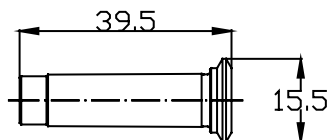
Additional technical information on page 14.07

## PG 10 | PG 10-CF | PG 10-MB

### Inch

Ø [Inch]	Ø [Inch]	Ø [mm]	PG 10 Part No.	PG 10-CF Part No.
1/8	0.1250	3.175	1710.03181	1710.03183
3/16	0.1875	4.763	1710.04761	1710.04763
1/4	0.2500	6.350	1710.06351	1710.06353

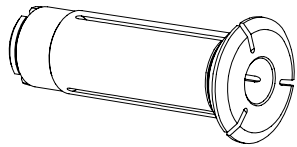
Additional technical information on page 14.07



PG collets do not have a clamping range.  
Nominal diameter only.



For special diameters please contact  
REGO-FIX® Customer Service.



## PG 15 | PG 15-CF

### PG 15 Standard PG 15-CF Coolant Flush

#### Metric

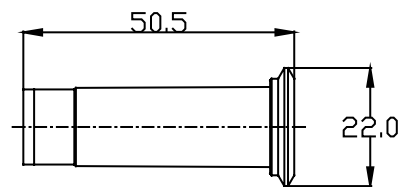
Ø [mm]	Ø [Inch]	PG 15 Part No.	PG 15-CF Part No.
3.000	0.1181	1715.03000	1715.03002
4.000	0.1575	1715.04000	1715.04002
5.000	0.1969	1715.05000	1715.05002
6.000	0.2362	1715.06000	1715.06002
7.000	0.2756	1715.07000	1715.07002
8.000	0.3150	1715.08000	1715.08002
9.000	0.3543	1715.09000	1715.09002
10.000	0.3937	1715.10000	1715.10002

Additional technical information on page 14.07

#### Inch

Ø [Inch]	Ø [Inch]	Ø [mm]	PG 15 Part No.	PG 15-CF Part No.
1/8	0.1250	3.175	1715.03181	1715.03183
3/16	0.1875	4.763	1715.04761	1715.04763
1/4	0.2500	6.350	1715.06351	1715.06353
5/16	0.3125	7.938	1715.07941	1715.07943
3/8	0.3750	9.525	1715.09521	1715.09523

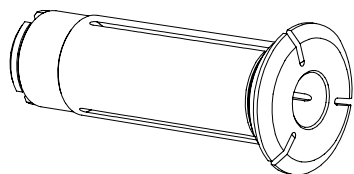
Additional technical information on page 14.07



PG collets do not have a clamping range.  
Nominal diameter only.



For special diameters please contact  
REGO-FIX® Customer Service.



## PG 25 | PG 25-CF

### PG 25 Standard PG 25-CF Coolant Flush

2

#### Metric

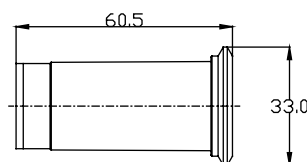
Ø [mm]	Ø [Inch]	PG 25 Part No.	PG 25-CF Part No.
3.000	0.1181	1725.03000	1725.03002
4.000	0.1575	1725.04000	1725.04002
5.000	0.1969	1725.05000	1725.05002
6.000	0.2362	1725.06000	1725.06002
7.000	0.2756	1725.07000	1725.07002
8.000	0.3150	1725.08000	1725.08002
9.000	0.3543	1725.09000	1725.09002
10.000	0.3937	1725.10000	1725.10002
11.000	0.4331	1725.11000	1725.11002
12.000	0.4724	1725.12000	1725.12002
14.000	0.5512	1725.14000	1725.14002
16.000	0.6300	1725.16000	1725.16002
18.000	0.7087	1725.18000	1725.18002
20.000	0.7874	1725.20000	1725.20002

Additional technical information on page 14.07

#### Inch

Ø [Inch]	Ø [Inch]	Ø [mm]	PG 25 Part No.	PG 25-CF Part No.
1/8	0.1250	3.175	1725.03181	1725.03183
3/16	0.1875	4.763	1725.04761	1725.04763
1/4	0.2500	6.350	1725.06351	1725.06353
5/16	0.3125	7.938	1725.07941	1725.07943
3/8	0.3750	9.525	1725.09521	1725.09523
7/16	0.4375	11.113	1725.11111	1725.11113
1/2	0.5000	12.700	1725.12701	1725.12703
9/16	0.5625	14.288	1725.14291	1725.14293
5/8	0.6250	15.875	1725.15881	1725.15883
3/4	0.7500	19.050	1725.19051	1725.19053

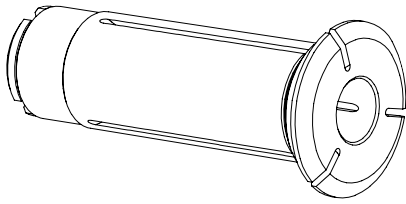
Additional technical information on page 14.07



PG collets do not have a clamping range.  
Nominal diameter only.



For special diameters please contact  
REGO-FIX® Customer Service.



## PG 32 | PG 32-CF

### PG 32 Standard PG 32-CF Coolant Flush

#### Metric

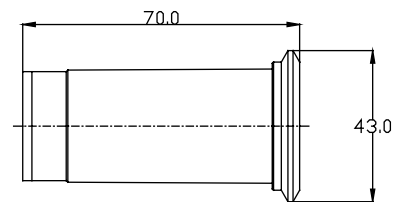
Ø [mm]	Ø [Inch]	PG 32 Part No.	PG 32-CF Part No.
6.000	0.2362	1732.06000	1732.06002
7.000	0.2756	1732.07000	1732.07002
8.000	0.3150	1732.08000	1732.08002
9.000	0.3543	1732.09000	1732.09002
10.000	0.3937	1732.10000	1732.10002
11.000	0.4331	1732.11000	1732.11002
12.000	0.4724	1732.12000	1732.12002
14.000	0.5512	1732.14000	1732.14002
16.000	0.6300	1732.16000	1732.16002
18.000	0.7087	1732.18000	1732.18002
20.000	0.7874	1732.20000	1732.20002
22.000	0.8661	1732.22000	1732.22002
25.000	0.9843	1732.25000	1732.25002

Additional technical information on page 14.07

#### Inch

Ø [Inch]	Ø [Inch]	Ø [mm]	PG 32 Part No.	PG 32-CF Part No.
1/4	0.2500	6.350	1732.06351	1732.06353
5/16	0.3125	7.938	1732.07941	1732.07943
3/8	0.3750	9.525	1732.09521	1732.09523
7/16	0.4375	11.113	1732.11111	1732.11113
1/2	0.5000	12.700	1732.12701	1732.12703
9/16	0.5625	14.288	1732.14291	1732.14293
5/8	0.6250	15.875	1732.15881	1732.15883
3/4	0.7500	19.050	1732.19051	1732.19053
7/8	0.8750	22.225	1732.22231	1732.22233
1	1.0000	25.400	1732.25401	1732.25403

Additional technical information on page 14.07



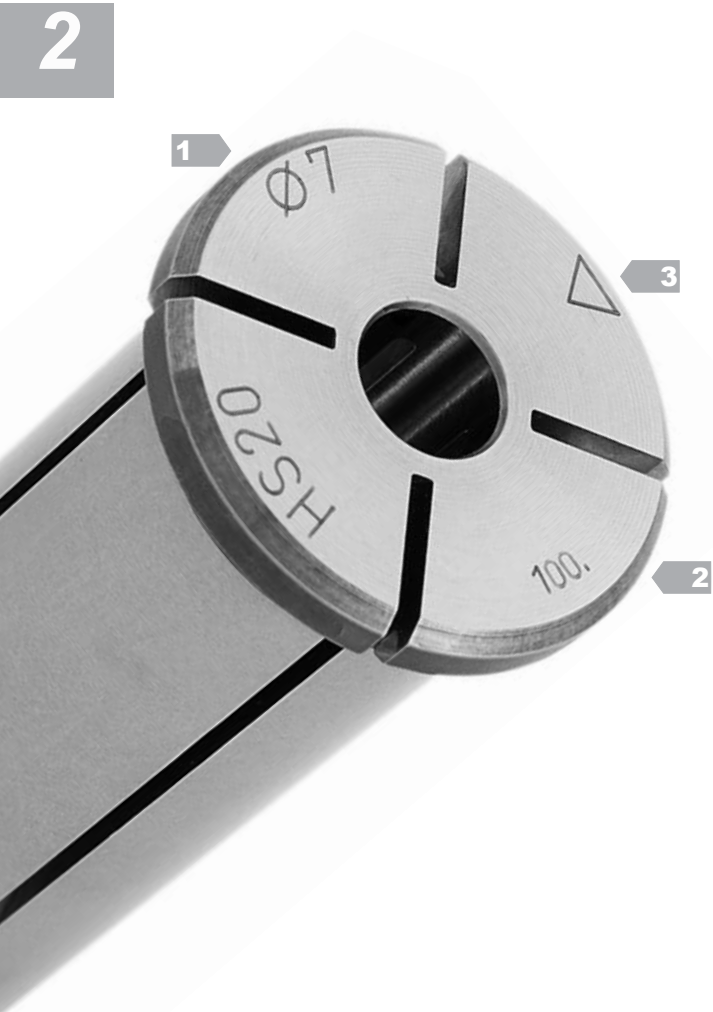
PG collets do not have a clamping range.  
Nominal diameter only.



For special diameters please contact  
REGO-FIX® Customer Service.

## Features | Benefits

2



1

### Swiss Quality

Made in Switzerland to ISO9001/ISO14001.

### Marking

With type and size (reduces collet selection error).

2

### Product Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

### Original REGO-FIX®

When buying PG collets, please note the REGO-FIX® quality symbol  $\triangle$  on the front of the collet.

### Precision

Highest run-out accuracy 0.0001" ( $<3\mu\text{m}$ ).

### Increased Clamping Force

Using REGO-FIX® reduction sleeves.

See graph on page 2.29

### Flexibility

Clamping of different tool shank diameters in hydro-chucks. 4 standard sizes: 12, 20, 25, and 32 mm

### Coolant Through Tools

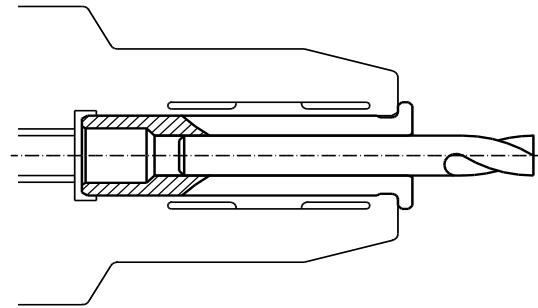
Metal-to-metal seal for cutting tools with internal coolant channels.

### Reduction Sleeves for Hydro-Chucks

REGO-FIX® reduction sleeves are designed to fit hydraulic toolholders of different manufacturers. They are specially suited for high precision clamping of cylindrical tool shanks.

For concentricity (T.I.R.) of REGO-FIX® high precision reduction sleeves, see graph on next page.

The special design of REGO-FIX® reduction sleeves allows the use of coolant through cutting tools. This self sealing system works with most common hydraulic toolholders.



2



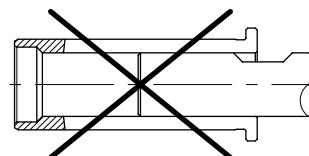
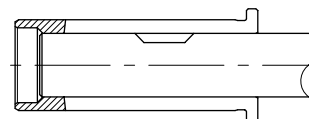
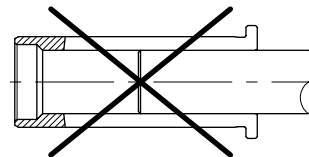
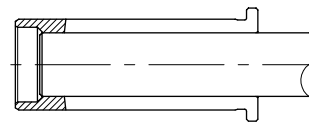
Improper assembly will damage the concentricity of the reduction sleeve.



Insert tools the full length of the reduction sleeve.

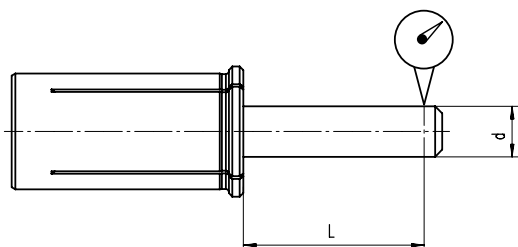
Only clamp h6 tool shanks.

Do not clamp reduction sleeve without a tool.



## Concentricity T.I.R.

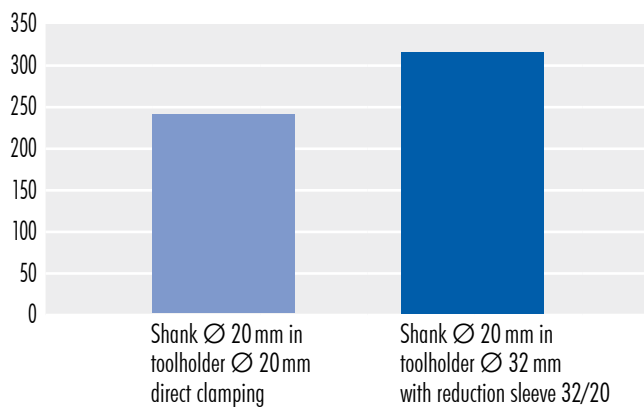
2



### Concentricity (T.I.R.) of HS Type Reduction Sleeves

Clamping Diameter			T.I.R. max.
Above d [mm]	Up to d [mm]	L [mm]	
3.0	6.0	16.0	0.0001" (0.003 mm)
6.0	10.0	25.0	0.0001" (0.003 mm)
10.0	18.0	40.0	0.0001" (0.003 mm)
18.0	26.0	50.0	0.0001" (0.003 mm)

### Comparison of Transferable Torque at Ø 20 mm

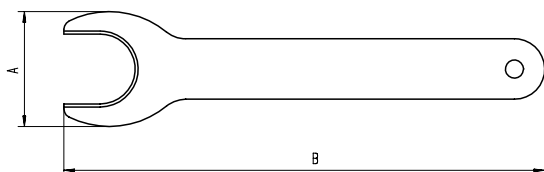


When using reduction sleeves the transferable torque is increased.

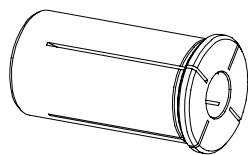
## Matching Products

### Extractor

The extractor helps to remove the reduction sleeve from the hydro-chuck.



Extractor	Part No.	For Sizes	A [mm]	B [mm]
EHS 12	7321.12000	HS 12	24.6	100
EHS 20	7321.20000	HS 20	38.0	160
EHS 25	7321.25000	HS 25	51.0	180
EHS 32	7321.32000	HS 32	63.0	200



HS 12 | 20 | 25 | 32

### Reduction Sleeves

#### Metric

Ø Bore [mm]	HS 12 (12mm O.D.) Part No.	HS 20 (20mm O.D.) Part No.	HS 25 (25mm O.D.) Part No.	HS 32 (32mm O.D.) Part No.
3.000	1912.03000	1920.03000	1925.03000	—
4.000	1912.04000	1920.04000	1925.04000	—
5.000	1912.05000	1920.05000	1925.05000	1932.05000
6.000	1912.06000	1920.06000	1925.06000	1932.06000
7.000	1912.07000	1920.07000	1925.07000	1932.07000
8.000	1912.08000	1920.08000	1925.08000	1932.08000
9.000	1912.09000	1920.09000	1925.09000	1932.09000
10.000	1912.10000	1920.10000	1925.10000	1932.10000
11.000	—	1920.11000	—	1932.11000
12.000	—	1920.12000	1925.12000	1932.12000
13.000	—	1920.13000	—	1932.13000
14.000	—	1920.14000	1925.14000	1932.14000
15.000	—	1920.15000	—	1932.15000
16.000	—	1920.16000	1925.16000	1932.16000
17.000	—	—	—	1932.17000
18.000	—	1920.18000	1925.18000	1932.18000
19.000	—	—	—	1932.19000
20.000	—	—	1925.20000	1932.20000
22.000	—	—	—	1932.22000
25.000	—	—	—	1932.25000

#### Inch

Ø Bore [Inch]	HS 12 (12mm O.D.) Part No.	HS 20 (20mm O.D.) Part No.	HS 25 (25mm O.D.) Part No.	HS 32 (32mm O.D.) Part No.
1/8"	1912.03181	1920.03181	1925.03181	—
3/16"	1912.04761	1920.04761	1925.04761	1932.04761
1/4"	1912.06351	1920.06351	1925.06351	1932.06351
5/16"	1912.07941	1920.07941	1925.07941	1932.07941
3/8"	1912.09521	1920.09521	1925.09521	1932.09521
7/16"	—	1920.11111	1925.11111	1932.11111
1/2"	—	1920.12701	1925.12701	1932.12701
9/16"	—	1920.14291	1925.14291	1932.14291
5/8"	—	1920.15881	1925.15881	1932.15881
11/16"	—	—	1925.17461	1932.17461
3/4"	—	—	1925.19051	1932.19051
13/16"	—	—	1925.20631	1932.20631
7/8"	—	—	—	1932.22221
15/16"	—	—	—	1932.23811
1"	—	—	—	1932.25401

Additional technical information on page  
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