
E93-68
13.

Tapping Collets 3

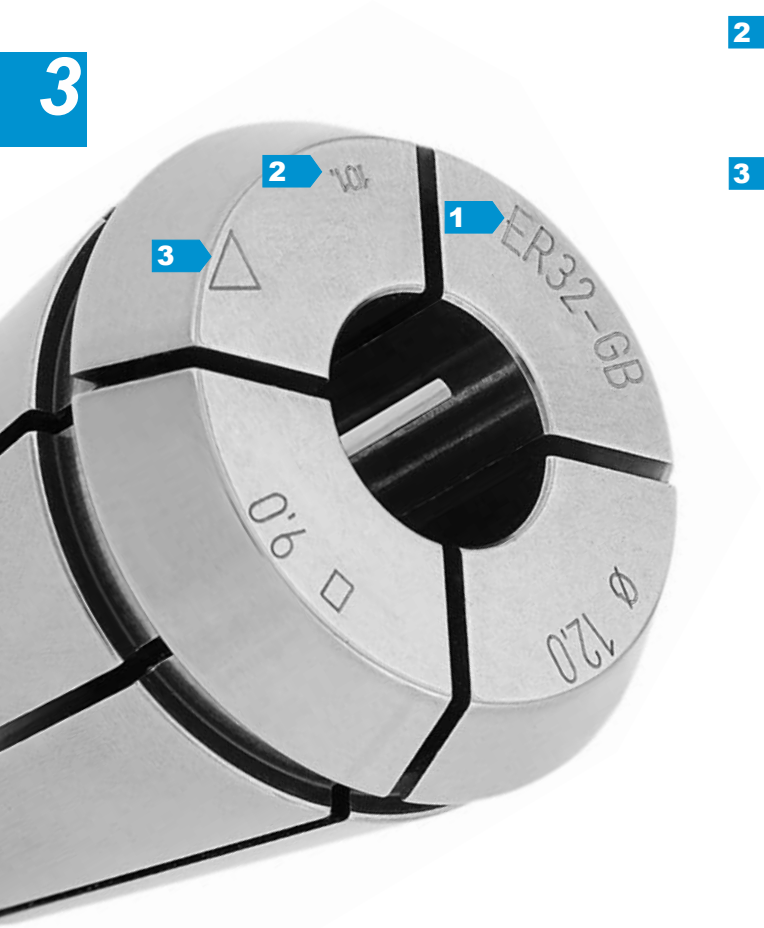
ER *SYSTEM*

powRgrip *SYSTEM*

Swiss Precision Tools

ER
Tapping Collets

3



Features | Benefits

Swiss Quality
Made in Switzerland to ISO 9001/ISO 14001.

1 ### Marking
Type and size (reduced collet selection errors).

2 ### Traceability
Lot number marking on all products for traceability through 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 seal △ on the front of the collet.

Interchangeable
With standard ER collet DIN 6499/ISO 15488.
No additional toolholders and clamping nuts necessary.

Wide Product Range
Sizes: ER-GB 11 to 50
Standards: DIN, ISO, JIS, (ANSI on request)

Strength: Square for tight grip of tap
Eliminates tap slippage in collets.

Matched Tooling System
All REGO-FIX® components such as tapping collets, toolholders, clamping nuts and spanners are from one source. The compatibility of the whole system results in the maximum precision, balance and tool life.

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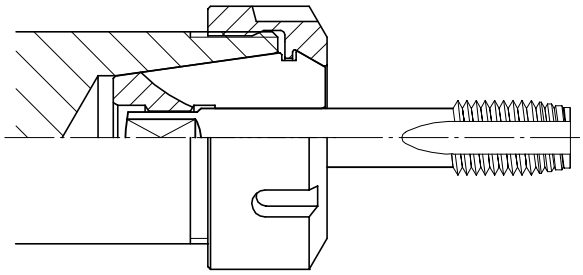
Information

ER-GB Tapping Collets
without Axial Compensation



These rigid tapping collets are compatible with taps per DIN, ISO, JIS and ANSI standards.

The REGO-FIX® ER-GB tapping collets are manufactured with an internal square. They are intended for use on CNC machines that have synchronized machine spindle speed and feed rate. Machines that have such «rigid» tapping capabilities require only minimal compensation.

We recommend the use of our SSY Softsynchro® tapping holders. They compensate minimal synchronizing differences of CNC machines.
See chapter 7 (HSK Softsynchro® tapping toolholders), page 7.16 and chapter 9 (cylindrical Softsynchro® tapping toolholders), page 9.14.

For machines without tapping option we recommend the use of our axial compensating GSF tapping holders.
See chapter 9 (cylindrical tapping toolholders), page 9.16.

For additional technical information and dimensions of taps on ER-GB see page 13.5 and 13.13.

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Matching Products

Clamping Nuts | Spanner

3

Clamping Nut and Spanner	ER 11	ER 16	ER 20	ER 25	ER 32	ER 40	ER 50	Page	Standard	With Friction Bearing	Balanced	For Coolant Through Tools	Collet Locking System*	Mini-Nut	Nut with External Thread	Spanner
Hi-Q/ER	3411.00000	3416.00000	3420.00000	3425.00000	3432.00000	3440.00000	3450.00000	4.4	■		■		■			
Hi-Q/ERC	3411.20300 - 3411.20700	3416.20000	3420.20000	3425.20000	3432.20000	3440.20000	-	4.6 4.8			■	■	■			
Hi-Q/ERB	-	3416.30000	3420.30000	3425.30000	3432.30000	3440.30000	3450.30000	4.10		■	■		■			
Hi-Q/ERBC	-	3416.40000	3420.40000	3425.40000	3432.40000	3440.40000	-	4.10		■	■	■	■			
EP	7112.11010	7112.16010	7112.20010	-	-	-	-	12.1								■
E	-	-	-	7111.25000	7111.32000	7111.40000	7111.50000	12.1								■
Hi-Q/ERM	3511.00000	3516.00000	3520.00000	3525.00000	-	-	-	4.12 4.14			■		■	■		
Hi-Q/ERMC	3511.20300 - 3511.20700	3516.20000	3520.20000	3525.20000	-	-	-	4.12 4.14			■	■	■	■		
EM	7113.11000	7113.16000	7113.20000	7113.25000	-	-	-	12.1								■
Hi-Q/ERAX	3311.60000	3316.60000	3320.60000	3325.60000	3332.60000	3340.60000	-	4.18			■		■		■	
EAX	7117.11000	7117.16000	7117.20000	7117.25000	7117.32000	7117.40000	-	12.2								■
Hi-Q/ERAXC	-	3316.70000	3320.70000	3325.70000	3332.70000	3340.70000	-	4.18			■	■	■		■	
EAX	7117.11000	7117.16000	7117.20000	7117.25000	7117.32000	7117.40000	-	12.2								■

*Does not apply with use of ER11-GB collets.

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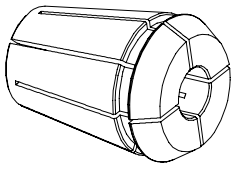
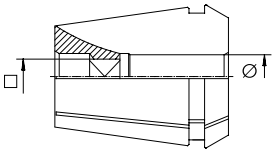


ER-GB



Tapping Collets without Axial Compensation

Ø [mm]	□ [mm]	Standard	ER 11-GB Part No.	ER 16-GB Part No.	ER 20-GB Part No.	ER 25-GB Part No.	ER 32-GB Part No.	ER 40-GB Part No.	ER 50-GB Part No.
2.5	2.1/2.0	DIN/ISO	1411.02500	–	–	–	–	–	–
2.8	2.1	DIN	1411.02800	–	–	–	–	–	–
3.5	2.7	DIN	1411.03500	–	–	–	–	–	–
4.0	3.0	DIN	1411.04000	–	–	–	–	–	–
4.0	3.15/3.2	ISO, JIS	1411.04002	1416.04002	1420.04002	1425.04002	1432.04002	–	–
4.5	3.4	DIN	1411.04500	1416.04500	1420.04500	1425.04500	1432.04500	–	–
5.0	4.0	ISO, JIS	1411.05002	1416.05002	1420.05002	1425.05002	1432.05002	–	–
5.5	4.3	DIN	–	1416.05500	1420.05500	1425.05500	1432.05500	–	–
5.5	4.5	JIS	–	1416.05501	1420.05501	1425.05501	1432.05501	–	–
6.0	4.5	JIS	–	1416.06001	1420.06001	1425.06001	1432.06001	1440.06001	–
6.0	4.9	DIN	1411.06000	1416.06000	1420.06000	1425.06000	1432.06000	1440.06000	–
6.2	5.0	JIS	–	1416.06201	1420.06201	1425.06201	1432.06201	1440.06201	–
6.3	5.0	ISO	–	1416.06302	1420.06302	1425.06302	1432.06302	1440.06302	–
7.0	5.5	DIN, JIS	–	1416.07000	1420.07000	1425.07000	1432.07000	1440.07000	–
7.1	5.6	ISO	–	1416.07102	1420.07102	1425.07102	1432.07102	1440.07102	–
8.0	6.2/6.3	DIN, ISO	–	1416.08000	1420.08000	1425.08000	1432.08000	1440.08000	–
8.5	6.5	JIS	–	1416.08501	1420.08501	1425.08501	1432.08501	1440.08501	–
9.0	7.0/7.1	DIN, ISO	–	1416.09000	1420.09000	1425.09000	1432.09000	1440.09000	–
10.0	8.0	DIN, ISO	–	–	1420.10000	1425.10000	1432.10000	1440.10000	–
10.5	8.0	JIS	–	–	1420.10501	1425.10501	1432.10501	1440.10501	–
11.0	9.0	DIN	–	–	1420.11000	1425.11000	1432.11000	1440.11000	–
11.2	9.0	ISO	–	–	1420.11202	1425.11202	1432.11202	1440.11202	–
12.0	9.0	DIN	–	–	1420.12000	1425.12000	1432.12000	1440.12000	–
12.5	10.0	ISO, JIS	–	–	–	1425.12502	1432.12502	1440.12502	–
14.0	11.0/11.2	DIN, ISO, JIS	–	–	–	1425.14000	1432.14000	1440.14000	–
15.0	12.0	JIS	–	–	–	1425.15001	1432.15001	1440.15001	–
16.0	12.0/12.5	DIN, ISO	–	–	–	1425.16000	1432.16000	1440.16000	–
17.0	13.0	JIS	–	–	–	–	1432.17001	1440.17001	–
18.0	14.0/14.5	DIN, ISO	–	–	–	–	1432.18000	1440.18000	–
20.0	16.0	DIN, ISO	–	–	–	–	1432.20000	1440.20000	–
22.0	18.0	DIN	–	–	–	–	–	1440.22000	1450.22000
25.0	20.0	DIN	–	–	–	–	–	–	1450.25000
28.0	22.0	DIN	–	–	–	–	–	–	1450.28000
32.0	24.0	DIN	–	–	–	–	–	–	1450.32000

Additional technical information on page 13.5.
See page 7.16 for HSK Softsynchro® tapping toolholders and pages 9.14/9.16 for cylindrical Softsynchro® tapping toolholders.

Swiss Precision Tools

ET1

Tapping Collets

3

Features | Benefits

Swiss Quality
Made in Switzerland to ISO 9001/ISO 14001.

Interchangeable
With REGO-FIX® standard ER collet DIN 6499/ISO 15488.

Compatible
ET1-12 is compatible with ER11 colletholders.

Cost Saving
No expensive tapping tools necessary.

Spring Tension
Adapted to tap size.

Compact
Very robust design with smallest space requirement.

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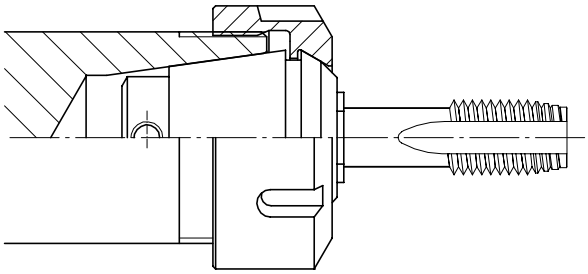
Information



ET1 Tapping Collets
with Axial Compensation

PCM ET1 tapping collets with axial compensation offer a smart and cost-effective tool holding option for machines which need axial compensation for tapping.

Directions for Use

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

Fast approach, then tapping feed 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. In order to not disturb the axial compensation, use external coolant supply only!

Table with current dimensions of taps on page 13.13.
Additional technical information on page 13.6.

! Not for coolant through tools and not for applications with sealing disks.

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Matching Products

Clamping Nuts | Spanner

Clamping Nut and Spanner	ET1-12	ET1-16	ET1-20	ET1-25	ET1-32	ET1-40	Page	Standard	With Friction Bearing	Balanced	For Coolant Through Tools	Collet Locking System*	Mini-Nut	Nut with External Thread	Spanner
Hi-Q/ER	3411.00000	3416.00000	3420.00000	3425.00000	3432.00000	3440.00000	4.4	■		■		■			
Hi-Q/ERB	-	3416.30000	3420.30000	3425.30000	3432.30000	3440.30000	4.10		■	■		■			
EP	7112.11010	7112.16010	7112.20010	-	-	-	12.1								■
E	-	-	-	7111.25000	7111.32000	7111.40000	12.1								■
Hi-Q/ERM	3511.00000	3516.00000	3520.00000	3525.00000	-	-	4.12			■		■	■		
EM	7113.11000	7113.16000	7113.20000	7113.25000	-	-	12.1								■
Hi-Q/ERAX	3311.60000	3316.60000	3320.60000	3325.60000	3332.60000	3340.60000	4.18			■		■		■	
EAX	7117.11000	7117.16000	7117.20000	7117.25000	7117.32000	7117.40000	12.2								■

*Does not apply with use of ET1 collets.

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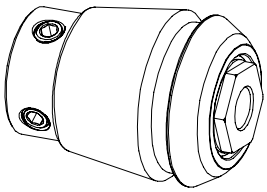

PCM Tapping Collets with Axial Compensation

Shank Ø [mm]	Standard	ET1-12 Part No.	ET1-16 Part No.	ET1-20 Part No.	ET1-25 Part No.	ET1-32 Part No.	ET1-40 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	1525.03000	-	-
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	1532.04500	-
5.00	ISO, JIS	-	1516.05000	1520.05000	1525.05000	1532.05000	-
5.50	DIN, ISO	-	1516.05500	1520.05500	1525.05500	1532.05500	-
5.60	ISO	-	1516.05600	1520.05600	1525.05600	1532.05600	-
6.00	DIN, JIS	-	1516.06000	1520.06000	1525.06000	1532.06000	1540.06000
6.20	JIS	-	1516.06200	1520.06200	1525.06200	1532.06200	1540.06200
6.30	ISO	-	1516.06300	1520.06300	1525.06300	1532.06300	1540.06300
7.00	DIN, JIS	-	-	1520.07000	1525.07000	1532.07000	1540.07000
7.10	ISO	-	-	-	1525.07100	1532.07100	1540.07100
8.00	DIN, ISO, JIS	-	-	-	1525.08000	1532.08000	1540.08000
8.50	JIS	-	-	-	1525.08500	1532.08500	1540.08500
9.00	DIN, ISO	-	-	-	1525.09000	1532.09000	1540.09000
10.00	DIN, ISO	-	-	-	1525.10000	1532.10000	1540.10000
10.50	JIS	-	-	-	-	1532.10500	1540.10500
11.00	DIN	-	-	-	-	1532.11000	1540.11000
11.20	ISO	-	-	-	-	1532.11200	1540.11200
12.00	DIN	-	-	-	-	1532.12000	1540.12000
12.50	ISO, JIS	-	-	-	-	1532.12500	1540.12500
14.00	JIS	-	-	-	-	-	1540.14000
15.00	JIS	-	-	-	-	-	1540.15000
16.00	DIN, ISO	-	-	-	-	-	1540.16000
17.00	JIS	-	-	-	-	-	1540.17000

Additional technical information on page 13.6.
See page 7.16 for HSK Softsynchro® tapping toolholders and pages 9.14/9.16 for cylindrical Softsynchro® tapping toolholders.

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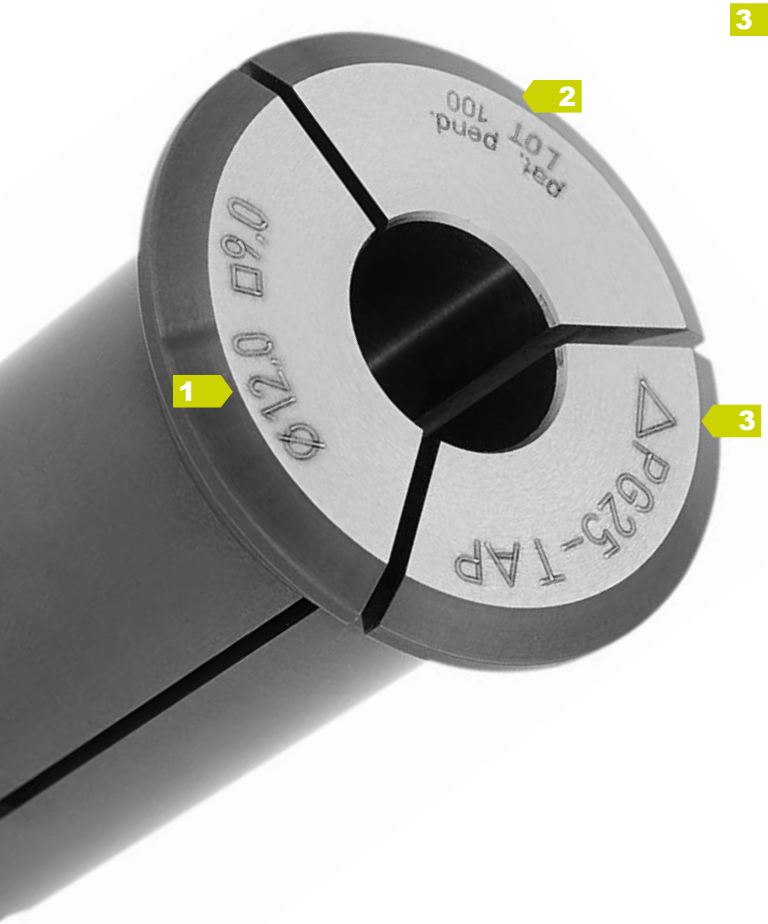
Swiss Precision Tools

PG

powRgrip® Tapping Collets

3

Features | Benefits



Swiss Quality
Made in Switzerland to ISO9001/ISO14001.

1 ### Marking
With type and size (reduced collet selection error).

2 ### Product Traceability
Lot number marked on collets, therefore traceable through entire manufacturing process.

3 ### Original REGO-FIX®
When buying PG collets please note the REGO-FIX® quality seal △ on the front of the collet.

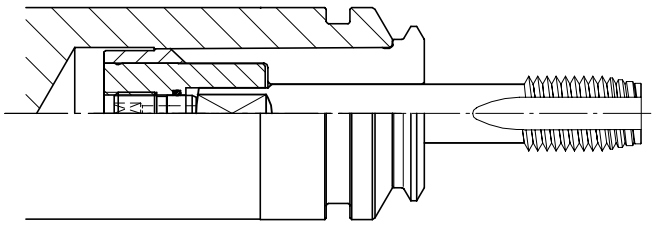
Coolant Through Tools
Metallic-sealed for coolant through tools.

Internal Square for Tap Shanks and Length Adjustment
Internal square for tight grip, integrated length adjustment screw, accepts h9 tool shanks.

Edition 11/2011

Informationen

PG-TAP Tapping Collets
without Axial Compensation



The PG-TAP tapping collets are compatible with DIN standard taps.

The REGO-FIX® powRgrip® tapping collets are manufactured with an internal square. They are intended for use on CNC machines that have synchronized machine spindle speed and feed rate. Machines that have such «rigid» tapping capabilities require only minimal compensation.

We recommend the use of our SSY Softsynchro® tapping holders. They compensate minimal synchronizing differences of CNC machines.
See chapter 7 (HSK Softsynchro® tapping toolholders), page 7.24 and chapter 9 (cylindrical Softsynchro® tapping toolholders), page 9.22.

For machines without tapping option we recommend the use of our axial compensating GSF tapping holders.
See chapter 9 (cylindrical tapping toolholders), page 9.24.

! Clamp h9-tolerance tool shanks only!

Never clamp tapping collet without tool. Collet will be damaged!

When buying PG tapping collets please note the REGO-FIX® quality seal △ on the front of the tapping collet.

Presetting Range of PG-TAP Collets on page 13.8.
Table with current dimensions of taps on page 13.13.

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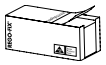
Matching Products

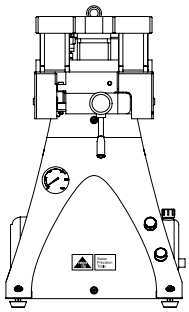
Accessories

Type	Description	Part No.	Page
VEW 15	Presetting tool for PG 15 toolholder	7619.15000	12.7
VEW 25	Presetting tool for PG 25 toolholder	7619.25000	12.7
TKCP 15	Taper cleaner for PG 15 toolholders	7657.15000	12.7
TKCP 25	Taper cleaner for PG 25 toolholders	7657.25000	12.7
CPS 15	Cleaning paper set for TKCP 15 / pack contains 250 sheets	7658.15000	12.7
CPS 25	Cleaning paper set for TKCP 25 / pack contains 250 sheets	7658.25000	12.7



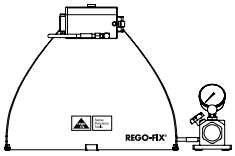
PGU 9000 Automatic Clamping Unit

Type	Description	Part No.	Page
PGU 9000 E	powRgrip® Automatic clamping unit 230 V	7610.90000	12.8
PGU 9000 A	powRgrip® Automatic clamping unit 110 V	7610.90100	12.8
PGU 9000 J	powRgrip® Automatic clamping unit 100 V	7610.90200	12.8
APG 915	PG 15 Clamping insert for PGU 9000, taper cleaner included	7611.15900	12.8
APG 925	PG 25 Clamping insert for PGU 9000, taper cleaner included	7611.25900	12.8



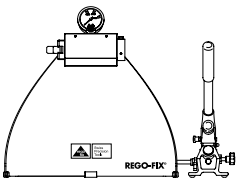
PGC Manual Clamping Unit PGC 1500

Type	Description	Part No.	Page
PGC 1500	Manual clamping unit PG 15, taper cleaner included	7621.15000	12.8
PGS 1	powRgrip® Compact stand no. 1	7625.00100	12.8
PGP 300 M	powRgrip® Hand pump, 300 bar	7629.00300	12.8



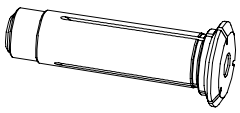
Set PGC 2510 Compact - Manual Clamping Unit

Type	Description	Part No.	Page
Set PGC 2510	powRgrip® Compact – manual clamping unit Supplied with: clamping unit, hand pump and stand.	7621.25109	12.8
APC 15	PG 15 Inserts for PGC 2510 for clamping unit	7622.15000	12.8
APC 25	PG 25 Inserts for PGC 2510 for clamping unit	7622.25000	12.8



Edition 11/2011

PG 15-TAP | PG 25-TAP



PG 15-TAP Tapping Collets

Ø [mm]	□ [mm]	Standard DIN	PG 15-TAP Part No.
3.500	2.700	371/376	1715.03505
4.500	3.400	371/376	1715.04505
6.000	4.900	371/376	1715.06005
7.000	5.500	371/376	1715.07005
8.000	6.200	371/376	1715.08005
9.000	7.000	371/376	1715.09005
10.000	8.000	371	1715.10005

PG 25-TAP Tapping Collets

Ø [mm]	□ [mm]	Standard DIN	PG 25-TAP Part No.
6.000	4.900	371/376	1725.06005
8.000	6.200	371/376	1725.08005
9.000	7.000	371/376	1725.09005
10.000	8.000	371	1725.10005
11.000	9.000	371/376	1725.11005
12.000	9.000	371/376	1725.12005
14.000	11.000	371/376	1725.14005
16.000	12.000	371/376	1725.16005

See on page 7.24 for HSK Softsynchro® tapping toolholders and on pages 9.22/9.24 for cylindrical Softsynchro® tapping toolholders.

See page 9.24 for cylindrical tapping toolholders with length compensation.

Edition 11/2011