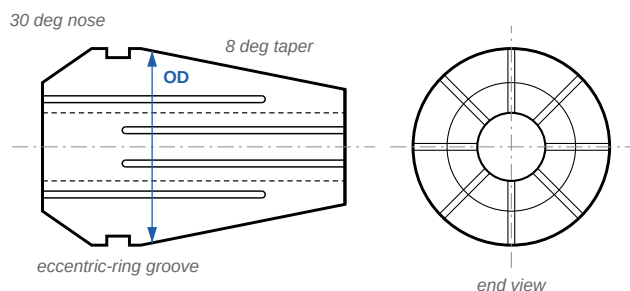
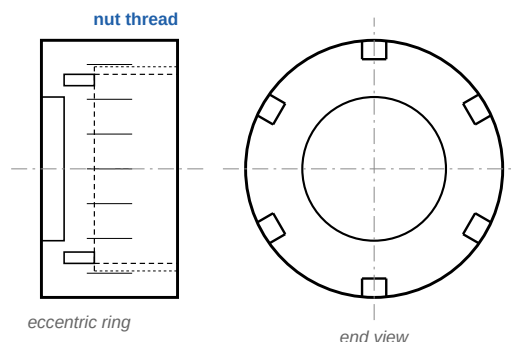


ER collet (DIN 6499 / ISO 15488)



ER clamping nut



ER collet sizes

Collet	Clamping range mm	Collet OD mm	Length mm	Nut thread	Set steps mm
ER8	0.5 - 5	8.5	13.5	M12 x 0.75	0.5
ER11	0.5 - 7	11.5	18	M14 x 0.75	0.5
ER16	0.5 - 10	17	27.5	M22 x 1.5	0.5 / 1
ER20	1 - 13	21	31.5	M25 x 1.5	1
ER25	1 - 16	26	34	M32 x 1.5	1
ER32	2 - 20	33	40	M40 x 1.5	1
ER40	3 - 26	41	46	M50 x 1.5	1
ER50	6 - 34	52	60	M64 x 2	2

The number is the collet OD in mm, roughly: ER32 is about 33 mm across the body.

Each collet grips from its marked size down by its collapse range - about 0.5 mm on ER8 / ER11 and 1 mm on ER20 to ER40 -

so a set in 1 mm steps covers every size in between. Tapping collets with a square drive are also made for ER16 to ER40.

Always fit the collet into the nut (it clicks into the eccentric ring) before screwing the nut onto the holder.

The nut thread identifies the holder: e.g. an ER32 holder has an M40 x 1.5 thread.

Collet Chart

Mining and Industrial Suppliers (Pvt) Ltd

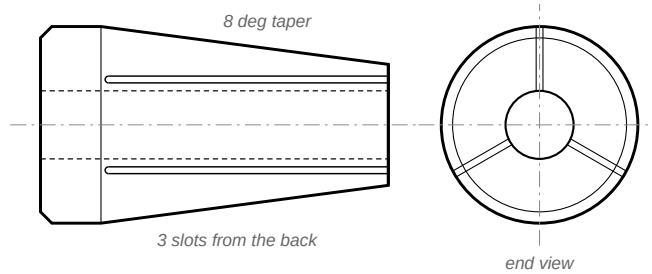
No 2 Hood Road, Southerton, Harare

OZ collets (DIN 6388) - also sold as HK or EOC collets - for milling chucks and older collet chucks.

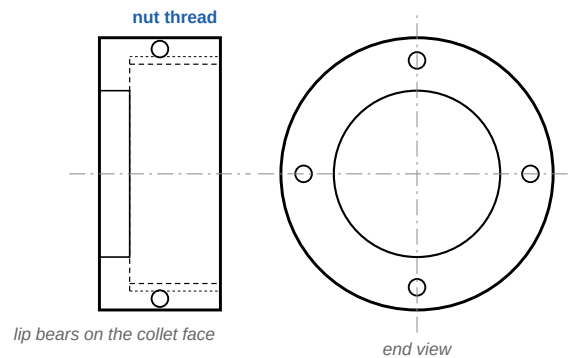
+263 867 7007412 | sales@mis.co.zw

© Mining and Industrial Suppliers (Pvt) Ltd. Trade names and trademarks belong to their respective owners.

OZ collet (DIN 6388) - also sold as HK / EOC



OZ chuck nut



OZ collet sizes

Series	Holds up to mm	Collet D mm	Length mm	Nut thread	Nut OD mm	Form A	Form B
OZ8 (EOC8)	8	14.4	26	M20 x 1.5	26	401E	-
OZ16 (EOC16)	16	24	43	M33 x 1.5	43	410E	yes
OZ20 (EOC20)	20	29.8	45	M42 x 2	50	-	4541E
OZ25 (EOC25)	25	35	52	M48 x 2	60	444E	462E
OZ32 (EOC32)	32	43.7	60	M60 x 2.5	72	450E	467E

OZ collets have a single 8 deg taper and are pushed into the chuck by a nut bearing on the front face - there is no drawbar.

Form A collets are slotted from one end and grip only close to their marked size (about 0.5 mm collapse).

Form B collets are slotted from both ends for a little more grip range. Both forms fit the same chuck.

Nut threads are set by the chuck standard (DIN 6391): e.g. an OZ25 chuck takes an M48 x 2 nut, OZ32 an M60 x 2.5.

Series names vary: OZ25 is also sold as EOC25 or SYOZ25 (types 444E / 462E); OZ32 as EOC32 (450E / 467E).

Collet Chart

Mining and Industrial Suppliers (Pvt) Ltd

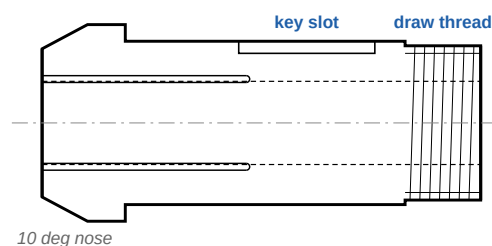
No 2 Hood Road, Southerton, Harare

Draw-in and threaded collets - 5C, R8, Morse taper and Clarkson / Autolock screwed-shank.

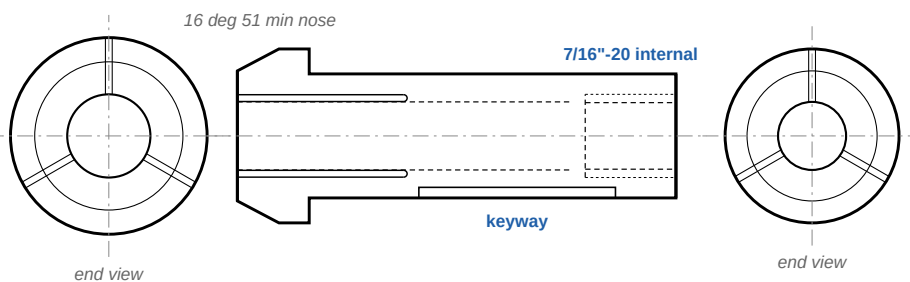
+263 867 7007412 | sales@mis.co.zw

© Mining and Industrial Suppliers (Pvt) Ltd. Trade names and trademarks belong to their respective owners.

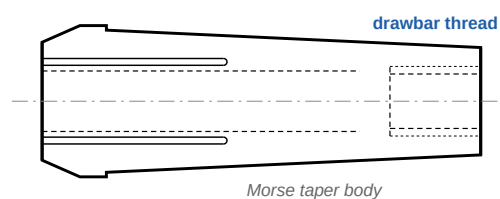
5C collet



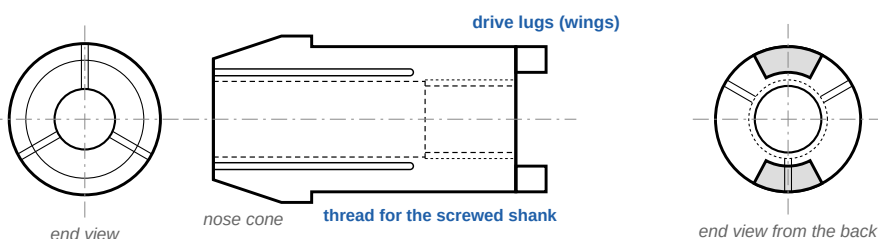
R8 collet



Morse taper draw-in collet (MT2 / MT3)



Clarkson / Autolock collet



Draw-in and threaded collets

Type	Capacity	Body	Thread / fixing	Used on
5C	Round to 1.1/16" (27 mm); also hex and square	1.250" body, 10 deg half-angle	1.238"-20 external, pulled by a draw tube	Lathe spindles, collet blocks, indexers
R8	Round to 3/4" (20 mm)	0.9495" body, 16 deg 51 min included	7/16"-20 UNF drawbar, keyway in body	Bridgeport-type milling machines
MT2 draw-in	Round to 1/2" (12 mm)	Morse taper 2 body	Internal drawbar thread - 3/8"-16 UNC or M10 (by machine)	Small lathes and mills
MT3 draw-in	Round to 5/8" (16 mm)	Morse taper 3 body	Internal drawbar thread - 1/2"-12 BSW, 1/2"-13 UNC or M12 (by machine)	Lathes, mills
Clarkson / Autolock	6, 8, 10, 12, 16, 20, 25 mm; 1/4" - 1"	Nose cone closed by the chuck cap; two drive lugs (wings) at the back	Holds screwed-shank cutters: 20 TPI Whitworth-form thread (BS 122 / DIN 1835 Form D)	Older mills - end mills with threaded shanks

Draw-in collets are pulled into the spindle taper by a drawbar or draw tube - the thread must match the machine.

Morse taper collets were made with several drawbar threads (metric, UNC and Whitworth): check the old drawbar before ordering.

Clarkson / Autolock chucks hold end mills with screwed shanks; the thread on the cutter stops it pulling out under load.

Plain parallel-shank cutters need a plain (ER or side-lock) holder instead.