

RedLine® Tools
PERFORMANCE MATTERS

Toolholder Selection Guide

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RedLine Toolholder Selection Guide

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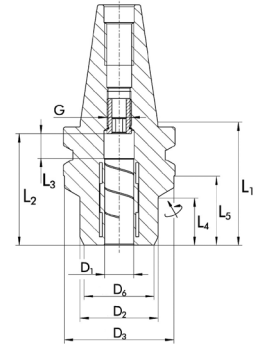
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BT30 Hydraulic Chuck

(Balanced to G2.5@25,000 RPM)

- Used for milling, drilling, reaming and boring
- Concentric to .00012"
- Wide range of coolant sealed or coolant flush reduction sleeves available.
- Safe operating temp should be between 68-122 degrees Fahrenheit
- **Hydraulic Chuck Sleeves can be found on pages 607.**



BT30 Hydraulic Chuck

Bore ø D1	Shank	D2	D3	D6	L1	L2	Min Clamp Depth - L3	L4	L5	G	Part #
1/2	BT30	1.26	N/A	1.13	2.00	1.81	1.42	.77	1.18	M10x1	RB3HC05000200

Successful Use and Care for RedLine Hydraulic Chucks

- RedLine hydraulic chucks can accept tools with a smooth cylindrical shank, weldon shank or a whistle notch without the use of reduction sleeves. Tools must have a H6 or better shank tolerance.
- To clamp a tool in the hydraulic chuck, turn the clamping screw with an allen key with 7-8.5 ft. lbs. torque completely to the limit stop. Never use a power screwdriver to turn the actuation screw!
- Testing of the clamping force should be done before the first use and after approximately 100 tool changes or every 3 months. A test shaft should be inserted at least to the minimum clamping depth into the toolholder. Tighten the clamping screw to a dead stop. If the test shaft can be easily removed from the toolholder manually and without any effort, the clamping force is not high enough. The hydraulic chuck shouldn't be used and sent in for repair.
- When using intermediate sleeves, they must be inserted completely into the hydraulic chuck, so the edge of the sleeve makes contact with the face of the hydraulic chuck. Failure to do this will result in poor run-out and lower grip force.
- *Tools with weldon shanks or whistle notches influence balance and will affect the max rpm the tools can run.
- If tools are not clamped to minimum clamping depth there is a risk of damaging the expansion sleeve and will result in a loss of accuracy.
- The vent screw of the hydraulic system is protected with a pin or resin. Don't remove it!
- The axial length stop is set with an allen key via the length adjustment screw. There is 10MM (.394") adjustment. Never actuate the length adjustment screw when tools are clamped. Axial adjustment screws maximum tightening torque is 2.2 ft. lbs.

Clamping / Unclamping

- The tool shank must be burr-free and free of dirt.
- Always insert the tool down to the minimum clamping depth into the toolholder.
- Do not combine several extensions. The clamp screw is not secured against dropping out!
- Hydraulic Chucks must not be clamped without a tool or workpiece.

Shanks to be used in hydraulic expansion toolholders

- Type A with straight cylindrical shaft. Cylindrical shaft acc. to DIN 6535 HA and form A according to DIN 6535 part 1
- Type AB with one weldon flat cylinder shank form B according to DIN 1835 part 1 and DIN 6535 HB
- Type B with two weldon flats cylinder shank B according to DIN 1835 part 1
- Type E with whistle notch flat cylinder shank E according to DIN 1835 part 1 and DIN 6535 HE

Care, Storage and Maintenance

- For optimum clamping force, the clamping bore and groove must be cleaned after every tool change with a solvent.
- Before storage, oil the entire surface of the hydraulic chuck and store in an unclamped position.
- Warranty is void if repairs are by anyone other than RedLine Tools.
- It may be necessary to adjust and lubricate the actuation screw, especially with a high number of clamping cycles, high operating temperatures or where abrasive dirt or swarf are present. For optimum lubrication of the actuation screw, we are recommending the use of copper paste MOLYKOTE CU 7439 (100 g tube, Id.-No. 9247204).
- Adjustment range of the length adjustment: .394"
- Operating temperature: 68-122°F
- Max. coolant pressure: 1160 P.S.I.

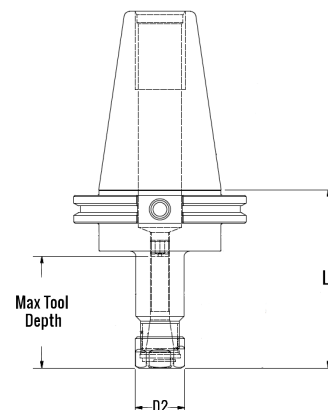
Collet Chucks - ER11

CAT40 & Straight Shank Collet Chucks - ER11

(Balanced to G2.5@25,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER11 Collets found on page 591.**



CAT40 ER11 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0078-.2755	CAT40	.75	2.50	2.25	22 ft lbs	RC4ER11250Z
.0078-.2755	CAT40	.75	4.00	2.25	22 ft lbs	RC4ER11400Z
.0078-.2755	CAT40	.75	6.00	2.25	22 ft lbs	RC4ER11600Z

Part numbers above include nosepiece

ER11 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.500	.62	6.65	12 ft lbs		RSSER110500665Z
.625	.62	6.65	12 ft lbs		RSSER110625665Z
.750	.62	6.65	12 ft lbs		RSSER110750665Z

ER11 Parts & Accessories

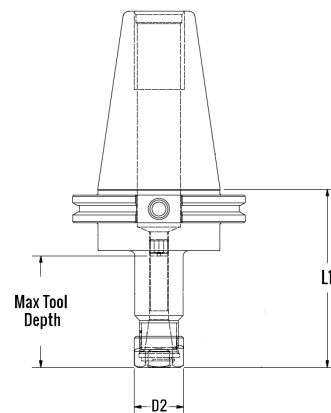
Description	Photo	Dimensions	Part #
ER11 Replacement Nosepiece			RER11HNZ
ER11 Open Hex Style Wrench 11/16"			RER11HWZ
ER11 Stop Screw			RBS0312LHZ
ER11 Slimline Nut			RER11SNZ
ER11 Slimline Wrench 9/16"			RER11SNWZ

CAT40 & Straight Shank Collet Chucks - ER16

(Balanced to G2.5@25,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER16 Collets found on pages 592 and 593.**



CAT40 ER16 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0200-.3930	CAT40	1.10	2.50	2.25	42 ft lbs	RC4ER16250Z
.0200-.3930	CAT40	1.10	3.00	2.50	42 ft lbs	RC4ER16300Z
.0200-.3930	CAT40	1.10	4.00	2.50	42 ft lbs	RC4ER16400Z
.0200-.3930	CAT40	1.10	5.00	2.50	42 ft lbs	RC4ER16500Z
.0200-.3930	CAT40	1.10	8.00	2.50	42 ft lbs	RC4ER16800Z

ER16 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.10	5.50	42 ft lbs		RSSER160750550Z
.750	1.10	7.50	42 ft lbs		RSSER160750750Z
.750	.86	7.10	20 ft lbs		RSSER160750710Z

ER16 Parts & Accessories

Description	Photo	Dimensions	Part #
ER16 Replacement Nosepiece			RER16HNZ
ER16 Open Hex Style Wrench 1"			RER16HWZ
ER16 Stop Screw			RBS0437LHZ
ER16 Slimline Nut			RER16SNZ
ER16 Slimline Wrench 7/8"			RER16SNWZ

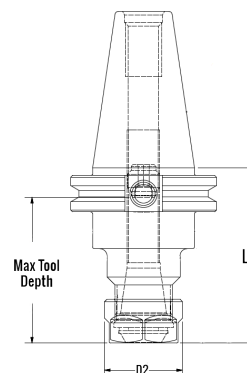
Collet Chucks - ER20

CAT40 & Straight Shank Collet Chucks - ER20

(Balanced to G2.5@25,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER20 Collets found on pages 594 and 595.**



CAT40 ER20 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.5110	CAT40	1.34	3.00	2.50	59 ft lbs	RC4ER20300Z
.0400-.5110	CAT40	1.34	4.00	3.50	59 ft lbs	RC4ER20400Z
.0400-.5110	CAT40	1.34	6.00	3.50	59 ft lbs	RC4ER20600Z
.0400-.5110	CAT40	1.34	8.00	3.50	59 ft lbs	RC4ER20800Z

ER20 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.34	7.20	59 ft lbs		RSSER200750720Z
1.000	1.10	7.20	22 ft lbs		RSSER201000720Z

ER20 Parts & Accessories

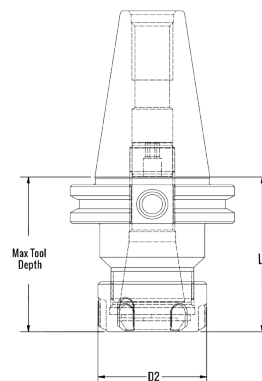
Description	Photo	Dimensions	Part #
ER20 Replacement Nosepiece			RER20HNZ
ER20 Open Hex Wrench 1-1/8"			RER20HWZ
ER20 Stop Screw			RBS0562LHZ
ER20 Slimline Nut			RER20SNZ
ER20 Slimline Wrench 1"			RER16HWZ

CAT40 & Straight Shank Collet Chucks - ER25

(Balanced to G2.5@25,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER25 Collets found on pages 596 and 597.**



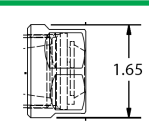
CAT40 ER25 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.6299	CAT40	1.65	2.50	2.50	77 ft lbs	RC4ER25250Z
.0400-.6299	CAT40	1.65	4.00	3.50	77 ft lbs	RC4ER25400Z
.0400-.6299	CAT40	1.65	6.00	3.50	77 ft lbs	RC4ER25600Z

ER25 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.65	5.31	77 ft lbs		RSSER250750531Z

ER25 Parts & Accessories

Description	Photo	Dimensions	Part #
ER25 Replacement Nosepiece			RER25NZ
ER25 Fixed Spanner Wrench			RER25SWZ
ER25 Stop Screw			RBS0687LHZ

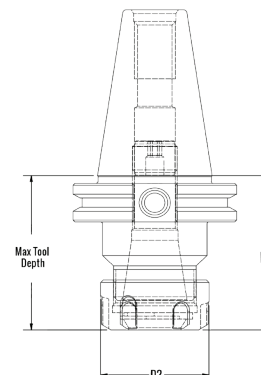
Collet Chucks - ER32



CAT40 & Straight Shank Collet Chucks - ER32

(Balanced to G2.5@25,000 RPM)

- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER32 Collets found on pages 598 and 599.**



CAT40 ER32 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.7870	CAT40	1.97	2.36	2.50	100 ft lbs	RC4ER32236Z
.0400-.7870	CAT40	1.97	3.00	3.00	100 ft lbs	RC4ER32300Z
.0400-.7870	CAT40	1.97	4.00	3.50	100 ft lbs	RC4ER32400Z
.0400-.7870	CAT40	1.97	6.00	3.50	100 ft lbs	RC4ER32600Z
.0400-.7870	CAT40	1.97	8.00	3.50	100 ft lbs	RC4ER32800Z

ER32 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
1.000	1.97	4.25	100 ft lbs		RSSER321000425Z
1.250	1.97	8.05	100 ft lbs		RSSER321250805Z

ER32 Parts & Accessories

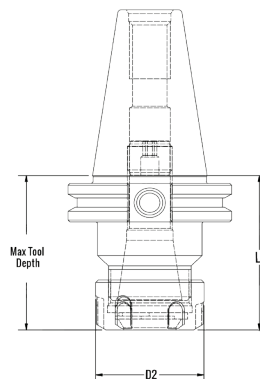
Description	Photo	Dimensions	Part #
ER32 Replacement Nosepiece			RER32NZ
ER32 Fixed Spanner Wrench			RER32SWZ
ER32 Stop Screw			RBS0812LHZ



CAT40 & Straight Shank Collet Chucks - ER40

(Balanced to G2.5@25,000 RPM)

- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER40 Collets found on pages 600-602.**



CAT40 ER40 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.1181-1.1875	CAT40	2.48	4.00	4.00	130 ft lbs	RC4ER40400Z
.1181-1.1875	CAT40	2.48	6.00	4.00	130 ft lbs	RC4ER40600Z

ER40 Straight Shank Collet Extension

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
1.250	2.48	4.85	130 ft lbs		RSSER401250485Z

ER40 Parts & Accessories

Description	Photo	Dimensions	Part #
ER40 Replacement Nosepiece			RER40NZ
ER40 Fixed Spanner Wrench			RER40SWZ
ER40 Stop Screw			RBS1250LHZ

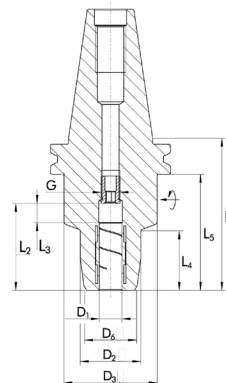
Hydraulic Chucks



CAT40 Hydraulic Chucks

(Balanced to G2.5@25,000 RPM)

- Used for milling, drilling, reaming and boring
- Concentric to .00012"
- Wide range of coolant sealed or coolant flush reduction sleeves available.
- Safe operating temp should be between 68-122 degrees Fahrenheit
- **Hydraulic Chuck Sleeves can be found on pages 607 and 608.**



CAT40 Hydraulic Chucks

Bore ø D1	Shank	D2	D3	D6	L1	L2	Min Clamp Depth - L3	L4	L5	G	Part #
1/2	CAT40	1.26	1.93	1.19	2.50	1.81	1.42	.97	1.75	M10x1	RC4HC05000250
1/2	CAT40	1.26	1.93	1.19	4.00	1.81	1.42	.97	3.25	M10x1	RC4HC05000400
3/4	CAT40	1.75	2.36	1.71	2.50	2.01	1.61	.91	1.75	M12x1	RC4HC07500250
3/4	CAT40	1.75	1.93	1.57	4.00	1.99	1.59	1.70	3.25	M12x1	RC4HC07500400

Successful Use and Care for RedLine Hydraulic Chucks

- RedLine hydraulic chucks can accept tools with a smooth cylindrical shank, weldon shank or a whistle notch without the use of reduction sleeves. Tools must have a H6 or better shank tolerance.
- To clamp a tool in the hydraulic chuck, turn the clamping screw with an allen key with 7-8.5 ft. lbs. torque completely to the limit stop. Never use a power screwdriver to turn the actuation screw!
- Testing of the clamping force should be done before the first use and after approximately 100 tool changes or every 3 months. A test shaft should be inserted at least to the minimum clamping depth into the toolholder. Tighten the clamping screw to a dead stop. If the test shaft can be easily removed from the toolholder manually and without any effort, the clamping force is not high enough. The hydraulic chuck shouldn't be used and sent in for repair.
- When using intermediate sleeves, they must be inserted completely into the hydraulic chuck, so the edge of the sleeve makes contact with the face of the hydraulic chuck. Failure to do this will result in poor run-out and lower grip force.
- *Tools with weldon shanks or whistle notches influence balance and will affect the max rpm the tools can run.
- If tools are not clamped to minimum clamping depth there is a risk of damaging the expansion sleeve and will result in a loss of accuracy.
- The vent screw of the hydraulic system is protected with a pin or resin. Don't remove it!
- The axial length stop is set with an allen key via the length adjustment screw. There is 10MM (.394") adjustment. Never actuate the length adjustment screw when tools are clamped. Axial adjustment screws maximum tightening torque is 2.2 ft. lbs.

Clamping / Unclamping

- The tool shank must be burr-free and free of dirt.
- Always insert the tool down to the minimum clamp depth into the toolholder.
- Do not combine several extensions. The clamping screw is not secured against dropping out!
- Hydraulic Chucks must not be clamped without a tool or workpiece.

Shanks To Be Used in Hydraulic Expansion Toolholders

- Type A with straight cylindrical shaft. Cylindrical shaft acc. to DIN 6535 HA and form A according to DIN 6535 part 1
- Type AB with one weldon flat cylinder shank form B according to DIN 1835 part 1 and DIN 6535 HB
- Type B with two weldon flats cylinder shank B according to DIN 1835 part 1
- Type E with whistle-notch flat cylinder shank E according to DIN 1835 part 1 and DIN 6535 HE

Care, Storage and Maintenance

- For optimum clamping force, the clamping bore and groove must be cleaned after every tool change with a solvent.
- Before storage, oil the entire surface of the hydraulic chuck and store in an unclamped position.
- Warranty is void if repairs are by anyone other than RedLine Tools.
- It may be necessary to adjust and lubricate the actuation screw, especially with a high number of clamping cycles, high operating temperatures or where abrasive dirt or swarf are present. For optimum lubrication of the actuation screw, we are recommending the use of copper paste MOLYKOTE CU 7439 (100 g tube, Id.-No. 9247204).
- Adjustment range of the length adjustment: .394"
- Operating temperature: 68-122°F
- Max. coolant pressure: 1160 P.S.I.



Style 2

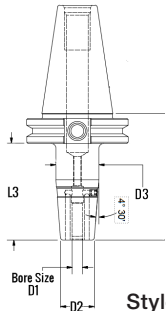


Style 3

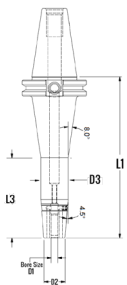
CAT40 Shrink Fit with Coolant Ports

(Balanced to G2.5 @ 25,000 RPM)

- Concentric to .0001" TIR for increased cutting tool life
- 2 Angled ports direct coolant to cutting area
- Gage lengths match international standards
- AT3 or better shank taper allows for accurate, rigid tool holder-spindle mount
- Made from H13 tool steel for superior rigidity and maximum grip for extended longevity
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance



Style 2



Style 3

CAT40 Shrink Fit Holders with Coolant Ports

Taper	Bore Size	Style	D2	D3	L1	L3	Part #
CAT40	1/4	2	.83	1.06	3.15	2.40	RC4SFCT20250315Z
CAT40	1/4	2	.83	1.06	5.12	4.37	RC4SFCT20250512Z
CAT40	1/4	3	.83	1.06	6.30	3.15	RC4SFCT30250630Z
CAT40	5/16	2	.83	1.06	3.15	2.40	RC4SFCT20312315Z
CAT40	5/16	2	.83	1.06	5.12	4.37	RC4SFCT20312512Z
CAT40	5/16	3	.83	1.06	6.30	3.15	RC4SFCT30312630Z
CAT40	3/8	2	.94	1.26	3.15	2.40	RC4SFCT20375315Z
CAT40	3/8	2	.94	1.26	5.12	4.37	RC4SFCT20375512Z
CAT40	3/8	3	.94	1.26	6.30	3.15	RC4SFCT30375630Z
CAT40	1/2	2	.94	1.26	3.15	2.40	RC4SFCT20500315Z
CAT40	1/2	2	.94	1.26	5.12	4.37	RC4SFCT20500512Z
CAT40	1/2	3	.94	1.26	6.30	3.15	RC4SFCT30500630Z
CAT40	5/8	2	1.06	1.34	3.15	2.40	RC4SFCT20625315Z
CAT40	5/8	2	1.06	1.34	5.12	4.37	RC4SFCT20625512Z
CAT40	5/8	3	1.06	1.34	6.30	3.15	RC4SFCT30625630Z
CAT40	3/4	2	1.30	1.65	3.15	2.40	RC4SFCT20750315Z
CAT40	3/4	2	1.30	1.65	5.12	4.37	RC4SFCT20750512Z
CAT40	3/4	2	1.30	1.65	6.30	3.15	RC4SFCT20750630Z
CAT40	1	2	1.73	2.09	3.94	2.92	RC4SFCT21000394Z
CAT40	1	2	1.73	2.09	5.12	4.37	RC4SFCT21000512Z
CAT40	1	2	1.73	2.09	6.30	3.15	RC4SFCT21000630Z
CAT40	1-1/4	2	1.73	2.09	3.94	2.92	RC4SFCT21250394Z
CAT40	1-1/4	2	1.73	2.09	5.12	4.37	RC4SFCT21250512Z
CAT40	1-1/4	2	1.73	2.09	6.30	3.15	RC4SFCT21250630Z



Shrink fit machines found on pages 611-612.

CAT40 Shrink Fit Stop Screws

Bore Size	Thread	Hex	Length	Photo	Part #
1/4	M5x.8	2.5 mm	.630		RSFSS250Z
5/16	M6X1	3 mm	.630		RSFSS312Z
3/8	M8x1	4 mm	.630		RSFSS375Z
1/2	M10X1	5 mm	.787		RSFSS500Z
9/16	M10X1	5 mm	.787		RSFSS500Z
5/8	M12X1	6 mm	.787		RSFSS625Z
3/4	M16X1	8 mm	.787		RSFSS750Z
1	M16X1	8 mm	.787		RSFSS750Z
1-1/4	M16X1	8 mm	.787		RSFSS750Z

Endmill Holders



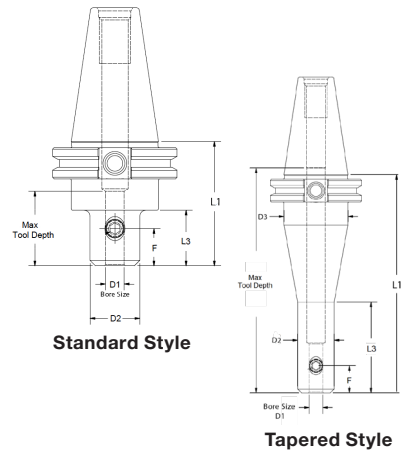
Standard Style

Tapered Style

CAT40 Endmill Holders

(Balanced to G6.3@15,000 RPM)

- Holders through 1.000" accept double end cutters saving on tool costs
- Fine thread screws match weldon flats - lock tight, stay tight
- H5 bore tolerance. H5 is an extremely accurate bore I.D. and provides improved T.I.R. to .0002" for extended cutting tool life.
- Taper ground to AT3 or better for accurate, rigid toolholder-to-spindle mount
- Less tool wear and replacement means less scrap
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance



CAT40 Endmill Holders - Fractional

Taper	Bore Size - D1	D2	L1	L3	Style	F	Set Screw Qty (Distance Apart)	Max Tool Depth	Part #
CAT40	1/8	.69	2.50	-	Std.	.38	1	3.80	RC4EM0125250Z
CAT40	1/8	1.00	3.00	-	Std.	.38	1	3.00	RC4EM0125300Z
CAT40	3/16	.69	2.50	-	Std.	.38	1	3.80	RC4EM0187250Z
CAT40	1/4	.88	1.75	-	Std.	.38	1	3.00	RC4EM0250175Z
CAT40	1/4	.88	2.50	-	Std.	.38	1	3.80	RC4EM0250250Z
CAT40	1/4	1.00	3.00	-	Std.	.38	1	3.00	RC4EM0250300Z
CAT40	1/4	1.00	6.00	2.50	Taper	.38	1	3.80	RC4EM0250600Z
CAT40	5/16	1.00	2.50	-	Std.	.44	1	3.80	RC4EM0312250Z
CAT40	3/8	1.00	1.75	-	Std.	.63	1	3.00	RC4EM0375175Z
CAT40	3/8	1.00	2.50	-	Std.	.75	1	3.80	RC4EM0375250Z
CAT40	3/8	1.00	4.50	1.00	Taper	.75	1	3.80	RC4EM0375450Z
CAT40	3/8	1.00	6.00	2.50	Taper	.75	1	3.80	RC4EM0375600Z
CAT40	7/16	1.25	2.62	-	Std.	.75	1	3.80	RC4EM0437262Z
CAT40	1/2	1.25	2.62	-	Std.	.88	1	3.80	RC4EM0500262Z
CAT40	1/2	1.75	1.75	-	Std.	.88	1	3.00	RC4EM0500175Z
CAT40	1/2	1.25	4.62	-	Std.	.88	1	3.80	RC4EM0500462Z
CAT40	1/2	1.25	6.00	3.00	Taper	.88	1	3.12	RC4EM0500600Z
CAT40	9/16	1.25	2.62	-	Std.	.88	1	2.05	RC4EM0562262Z
CAT40	5/8	1.75	1.75	-	Std.	.94	1	2.24	RC4EM0625175Z
CAT40	5/8	1.50	2.75	-	Std.	.94	1	3.62	RC4EM0625275Z
CAT40	5/8	1.50	6.00	-	Std.	.94	1	3.31	RC4EM0625600Z
CAT40	3/4	1.75	1.75	-	Std.	.94	1	2.37	RC4EM0750175Z
CAT40	3/4	1.75	3.50	-	Std.	1.00	1	3.94	RC4EM0750350Z
CAT40	3/4	1.75	6.00	-	Std.	.94	1	3.94	RC4EM0750600Z
CAT40	1	2.00	1.75	-	Std.	1.00	1	2.38	RC4EM1000175Z
CAT40	1	2.00	4.00	-	Std.	1.13	2 (1")	4.50	RC4EM1000400Z
CAT40	1	2.00	6.00	-	Std.	1.13	2 (1")	4.50	RC4EM1000600Z



Endmill Holder Replacement Lock Screws

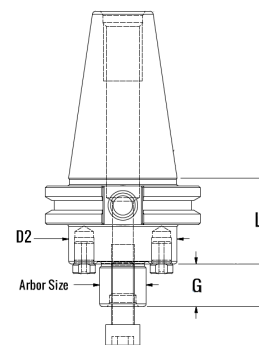
Holder Size	Screw Thread Size	Length	Max Torque	Photo	Part #
1/8	10-32	.25	3 ft lbs		REMLS0125Z
3/16	1/4-28	.25	7 ft lbs		REMLS0187Z
1/4	1/4-28	.25	7 ft lbs		REMLS0250Z
5/16	1/4-28	.25	7 ft lbs		REMLS0312Z
3/8	3/8-24	.31	13 ft lbs		REMLS0375Z
7/16	3/8-24	.31	13 ft lbs		REMLS0437Z
1/2	7/16-20	.38	19 ft lbs		REMLS0500Z
9/16	7/16-20	.38	19 ft lbs		REMLS0562Z
5/8	9/16-18	.43	31 ft lbs		REMLS0625Z
3/4	5/8-18	.50	45 ft lbs		REMLS0750Z
7/8	5/8-18	.50	48 ft lbs		REMLS0875Z
1	3/4-16	.50	69 ft lbs		REMLS1000Z
1-1/4	3/4-16	.62	69 ft lbs		REMLS1250Z
1-1/2	3/4-16	.62	69 ft lbs		REMLS1500Z
2	1-14	.88	80 ft lbs		REMLS2000Z
2-1/2	1-14	.88	80 ft lbs		REMLS2500Z

Facemill Holders



CAT40 Facemill Holders

- Arbor pilot TIR <.0002"
- Compatible with all facemills
- Constructed of alloy steel
- Hardened to 56-60 Rc for long service life



CAT40 Facemill Holders

Taper	Arbor Size	D2	L1	G	Part #
CAT40	3/4	1.75	1.38	.69	RC4SM0750138Z
CAT40	3/4	1.75	1.50	.69	RC4SM0750150Z
CAT40	3/4	1.75	2.00	.69	RC4SM0750200Z
CAT40	3/4	1.75	4.00	.69	RC4SM0750400Z
CAT40	1	2.25	1.00	.69	RC4SM1000100Z
CAT40	1	2.25	2.00	.69	RC4SM1000200Z
CAT40	1	2.25	4.00	.69	RC4SM1000400Z
CAT40	1-1/4	2.75	1.62	.69	RC4SM1250162Z
CAT40	1-1/4	2.75	2.25	.69	RC4SM1250225Z
CAT40	1-1/4	2.75	4.00	.69	RC4SM1250400Z
CAT40	1-1/2	3.75	2.40	.94	RC4SM1500240Z
CAT40	1-1/2	3.75	4.00	.94	RC4SM1500400Z

Facemill Holder Replacement Lock Screws

Arbor Size	A	B	C	Thread	Hex	Torque	Photo	Dimensions	Part #
3/4	.56	.38	1.37	3/8-24	5/16	45 ft lbs			RSMLS0750Z
1	1.19	.28	1.12	1/2-20	5/16	60 ft lbs			RSMLS1000Z
1-1/4	1.50	.50	1.44	5/8-18	5/16	70 ft lbs			RSMLS1250Z
1-1/2	1.88	.50	1.75	3/4-16	3/8	75 ft lbs			RSMLS1500Z
3/4	.88	.38	.97	3/8-24	1/4	45 ft lbs			RSMLSC0750Z
1	1.19	.28	1.20	1/2-20	5/16	60 ft lbs			RSMLSC1000Z
1-1/2	1.88	.50	1.75	3/4-16	3/8	75 ft lbs			RSMLSC1500Z

*Coolant Thru Option

Facemill Holder Replacement Socket Head Cap Screws

Arbor Size	A	B	C	Thread	Hex	Torque	Photo	Part #
3/4	.56	.37	1.37	3/8-24	5/16	45 ft lbs		RSMCS0750Z
1	.75	.50	1.75	1/2-20	3/8	60 ft lbs		RSMCS1000Z
1-1/4	.94	.62	1.87	5/8-18	1/2	70 ft lbs		RSMCS1250Z
3/4	.56	.37	1.37	1/2-20	5/16	45 ft lbs		RSMCSC0750Z
1	.75	.50	1.75	3/8-24	3/8	60 ft lbs		RSMCSC1000Z

*Coolant Thru Option

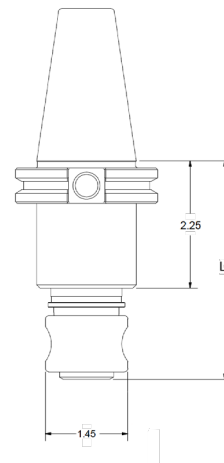
Facemill Holder Replacement Drive Keys

Arbor Size	A	B	C	Photo	Dimensions	Part #
3/4	.31	.52	.16			RSMKD0750Z
1	.38	.67	.19			RSMKD1000Z
1-1/4	.50	.86	.25			RSMKD1250Z
1-1/2	.62	1.04	.31			RSMKD1500Z



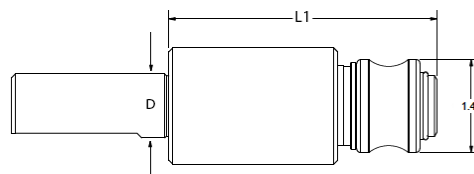
CAT40 & Straight Shank Bilz Style #1

- From 0-9/16" standard and 1/16"-1/8" NPT
- For use with popular Bilz style #1 adapters
- Rigid for use with synchronous tapping cycles
- Radial float improves thread quality and tap life
- Adjustable short compression stroke ensures accurate depth control
- Free-floating tension stroke ensures thread size and quality
- **Bilz Style #1 Collets can be found on page 609.**



CAT40 Bilz Style #1 Tap Holders

Taper	Collet Size	Compression	Tension	L1	Part #
CAT40	Bilz #1	0 - .250	.56	3.96	RC4THT01396Z
CAT40	Bilz #1	Rigid	Rigid	3.96	RC4THR01396Z



Straight Shank Bilz Style #1 Tap Holders

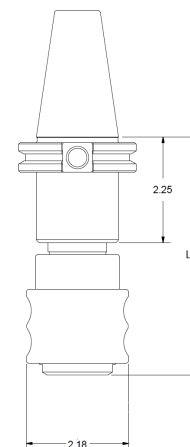
Diameter (D)	Collet Size	Compression	Tension	L1	Part #
1.00	Bilz #1	Rigid	Rigid	4.21	RTHSSR0110421Z
1.00	Bilz #1	0 - .250	.56	4.43	RTHSST0110443Z

Tap Holders - Bilz Style #2



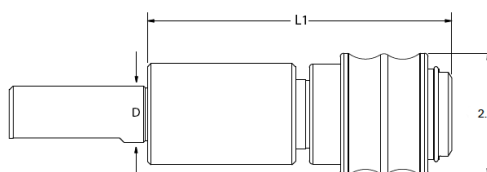
CAT40 & Straight Shank Bilz Style #2

- From 5/16"-7/8" standard and 1/4"-1/2" NPT
- For use with popular Bilz style #2 adapters
- Rigid for use with synchronous tapping cycles
- Radial float improves thread quality and tap life
- Adjustable short compression stroke ensures accurate depth control
- Free-floating tension stroke ensures thread size and quality
- **Bilz Style #2 Collets can be found on page 609.**



CAT40 Bilz Style #2 Tap Holders

Taper	Collet Size	Compression	Tension	L1	Part #
CAT40	Bilz #2	0 - .250	.56	5.06	RC4THT02425Z
CAT40	Bilz #2	Rigid	Rigid	3.86	RC4THR02386Z



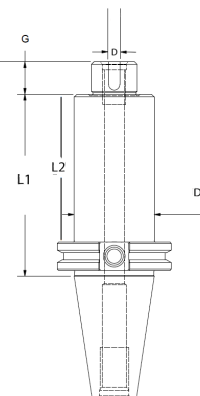
Straight Shank Bilz Style #2 Tap Holders

Diameter (D)	Collet Size	Compression	Tension	L1	Part #
1.00	Bilz #2	0 - .250	.56	5.46	RTHSST0210546Z
1.00	Bilz #2	Rigid	Rigid	5.46	RTHSSR0210546Z
1.25	Bilz #2	0 - .250	.56	5.46	RTHSST02125546Z



CAT40 Stub Arbor Holders - Lock Screw Style

- Face is perpendicular to center line within .0002"
- Pilot diameter is sized for precision fit with cutter and is keyed for positive drive
- Heavy duty lock screw and three arbor spacers are included - 1/4", 3/8", 3/4"



CAT40 Stub Arbor Holders - Lock Screw Style

Taper	Pilot Dia	D2	L1	L2	D	G	Part #
CAT40	1.00	1.75	4.00	3.25	.25	.72	RC4T2SAH1000400Z
CAT40	1.25	1.75	4.00	3.25	.31	.72	RC4T2SAH1250400Z
CAT40	1.50	2.12	4.00	3.25	.37	.98	RC4T2SAH1500400Z

Part numbers above include drive key and nut

CAT40 Stub Arbor Holder Components

Description	Part #
Drive key for 1" Diameter Pilot Stub Arbor Holder	RSAKT21000Z
Lock screw for 1" Diameter Pilot Stub Arbor Holder	RSMLS1000Z
Drive key for 1.25" Diameter Pilot Stub Arbor Holder	RSAKT21250Z
Lock screw for 1.25" Diameter Pilot Stub Arbor Holder	RSMLS1250Z
Drive key for 1.50" Diameter Pilot Stub Arbor Holder	RSAKT21500Z
Lock screw for 1.50" Diameter Pilot Stub Arbor Holder	RSMLS1500Z

CAT40 Stub Arbor Holder Spacers

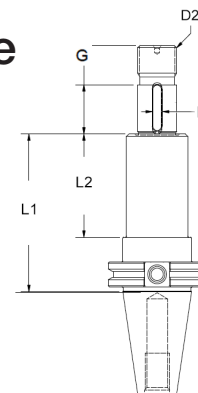
Pilot Diameter	Description	Part #
1" Pilot Diameter	1/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000125Z
	1/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000250Z
	3/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000375Z
	3/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000750Z
1.25" Pilot Diameter	1/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500125Z
	1/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500250Z
	3/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500375Z
	3/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500750Z
1.50" Pilot Diameter	1/8" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000125Z
	1/4" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000250Z
	3/8" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000375Z
	1/2" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000500Z
	3/4" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000750Z

Stub Arbor Holders



CAT40 Stub Arbor Holders - Lock Nut Style

- Pilot thread is ground concentric to the tapered shank
- Face is perpendicular to center line within .0002"
- Pilot diameter is sized for precision fit with cutter and is keyed for positive drive
- Heavy duty locking nut and three arbor spacers are included - 1/4", 3/8", 3/4"



CAT40 Stub Arbor Holders - Lock Nut Style

Taper	Pilot Dia	D2	L1	L2	D	G	Part #
CAT40	1.00	1.56	4.00	2.62	.25	1.25	RC4T1SAH1000400Z
CAT40	1.25	1.88	4.00	2.45	.31	1.25	RC4T1SAH1250400Z

Part numbers above include drive key and nut

CAT40 Stub Arbor Holder Components

Description	Part #
Drive key for 1.00" Diameter Pilot Stub Arbor Holder	RSAKT11000Z
Lock nut for 1.00" Diameter Pilot Stub Arbor Holder	RSAN1000Z
Drive key for 1.25" Diameter Pilot Stub Arbor Holder	RSAKT11250Z
Lock nut for 1.25" Diameter Pilot Stub Arbor Holder	RSAN1250Z

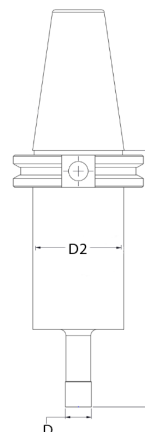
CAT40 Stub Arbor Holder Spacers

Pilot Diameter	Description	Part #
1" Pilot Diameter	1/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000125Z
	1/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000250Z
	3/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000375Z
	3/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000750Z
1.25" Pilot Diameter	1/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500125Z
	1/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500250Z
	3/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500375Z
	3/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500750Z



CAT40 Probe Calibration Gage

- Works on all CAT40 spindle machines
- This tool is to be used as a standard for gage length and diameter
- Can be used to calibrate your table tool probe
- Can be kept in tool changer for periodic probe calibration
- All critical tool holder surfaces precision ground
- Made from alloy steel hardened to 54-56rc
- Individual calibration certificate is included with each tool holder
- Concentricity of gage diameter is .0001" or less



CAT40 Probe Calibration Gage				
Taper	D	D2	L	Part #
CAT40	.500	1.63	5.00	RC4CA0500500Z

Calibration Certificate

PART NUMBER: RC4CA0500500
 PART NAME: CAT40 CALIBRATION PROBE
 SERIAL NUMBER: SN-7353



Diameter (D) Dimension: 0.5007"

Length (L) Dimension: 5.0030"

Calibrated by: John E. Capozzute
 Date: 1/9/2024

Temperature: 68°F (20°C)
 Humidity: 17.0 %

RedLine Tools
 PERFORMANCE MATTERS

RedLine Tools: 15150 25th Avenue North
 Plymouth (Mpls.), MN 55447 • (800) 791-7542
www.redlinetools.com • support@redlinetools.com

The adapter covered by this certification has been calibrated with equipment or compared with master reference standards traceable to the National Institute of Standards and Technology (NIST), Washington D.C.
 Outside diameter & gage line length measurements within +/- .00006"

Collet Chucks - ER16

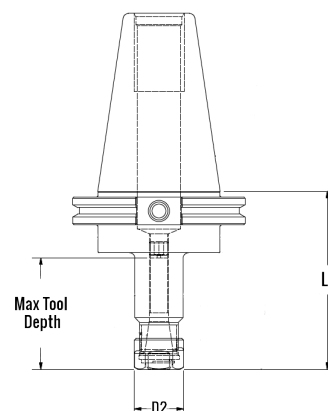
CAT50 & Straight Shank Collet Chucks - ER16

(Balanced to G2.5@20,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard

• **ER16 Collets found on pages 592 and 593.**



CAT50 ER16 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0200-.3930	CAT50	1.10	4.00	2.50	42 ft lbs	RC5ER16400Z
.0200-.3930	CAT50	1.10	6.00	2.50	42 ft lbs	RC5ER16600Z
.0200-.3930	CAT50	1.10	8.00	2.50	42 ft lbs	RC5ER16800Z
.0200-.3930	CAT50	1.10	10.00	2.50	42 ft lbs	RC5ER161000Z

ER16 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.10	5.50	42 ft lbs		RSSER160750550Z
.750	1.10	7.50	42 ft lbs		RSSER160750750Z
.750	.86	7.00	20 ft lbs		RSSER160750710Z

ER16 Parts & Accessories

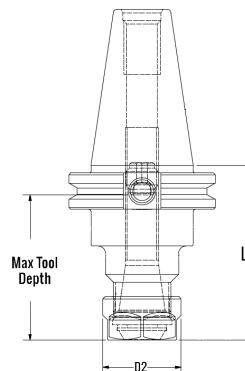
Description	Photo	Dimensions	Part #
ER16 Replacement Nosepiece			RER16HNZ
ER16 Open Hex Style Wrench 1"			RER16HWZ
ER16 Stop Screw			RBS0437LHZ
ER16 Slimline Nut			RER16SNZ
ER16 Slimline Wrench 7/8"			RER16SNWZ

CAT50 & Straight Shank Collet Chucks - ER20

(Balanced to G2.5@20,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER20 Collets found on pages 594 and 595.**



CAT50 ER20 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.5110	CAT50	1.34	4.00	2.50	59 ft lbs	RC5ER20400Z
.0400-.5110	CAT50	1.34	6.00	3.88	59 ft lbs	RC5ER20600Z
.0400-.5110	CAT50	1.34	8.00	3.88	59 ft lbs	RC5ER20800Z

ER20 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.34	7.20	59 ft lbs		RSSER200750720Z
1.000	1.10	7.20	22 ft lbs		RSSER201000720Z

ER20 Parts & Accessories

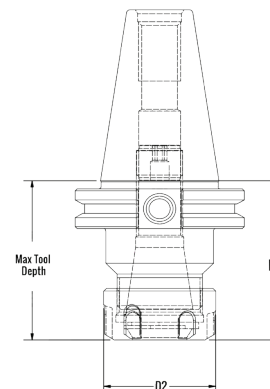
Description	Photo	Dimensions	Part #
ER20 Replacement Nosepiece			RER20HNZ
ER20 Open Hex Wrench 1-1/8"			RER20HWZ
ER20 Stop Screw			RBS0562LHZ
ER20 Slimline Nut			RER20SNZ
ER20 Slimline Wrench 1"			RER16HWZ



CAT50 & Straight Shank Collet Chucks - ER25

(Balanced to G2.5@20,000 RPM)

- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER25 Collets found on pages 596 and 597.**



CAT50 ER25 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.6299	CAT50	1.65	4.00	4.00	77 ft lbs	RC5ER25400Z
.0400-.6299	CAT50	1.65	6.00	4.00	77 ft lbs	RC5ER25600Z
.0400-.6299	CAT50	1.65	8.00	4.00	77 ft lbs	RC5ER25800Z
.0400-.6299	CAT50	1.65	10.00	4.00	77 ft lbs	RC5ER251000Z

ER25 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.65	5.81	77 ft lbs		RSSER250750581Z
1.000	1.65	5.31	77 ft lbs		RSSER251000531Z

ER25 Parts & Accessories

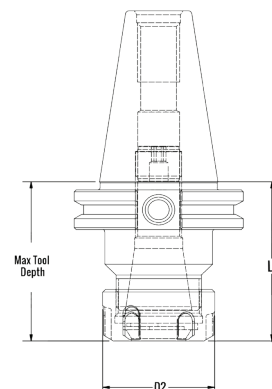
Description	Photo	Dimensions	Part #
ER25 Replacement Nosepiece			RER25NZ
ER25 Fixed Spanner Wrench			RER25SWZ
ER25 Stop Screw			RBS0687LHZ

CAT50 & Straight Shank Collet Chucks - ER32

(Balanced to G2.5@20,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER32 Collets found on pages 598-599.**



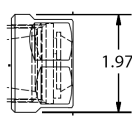
CAT50 ER32 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.7870	CAT50	1.97	4.00	3.88	100 ft lbs	RC5ER32400Z
.0400-.7870	CAT50	1.97	6.00	3.88	100 ft lbs	RC5ER32600Z
.0400-.7870	CAT50	1.97	8.00	3.88	100 ft lbs	RC5ER32800Z
.0400-.7870	CAT50	1.97	10.00	3.88	100 ft lbs	RC5ER321000Z

ER32 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
1.000	1.97	4.25	100 ft lbs		RSSER321000425Z
1.250	1.97	8.05	100 ft lbs		RSSER321250805Z

ER32 Parts & Accessories

Description	Photo	Dimensions	Part #
ER32 Replacement Nosepiece			RER32NZ
ER32 Fixed Spanner Wrench			RER32SWZ
ER32 Stop Screw			RBS0812LHZ

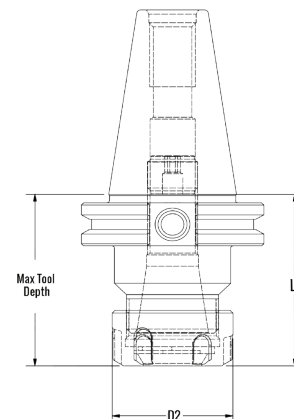
Collet Chucks - ER40

CAT50 & Straight Shank Collet Chucks - ER40

(Balanced to G2.5@20,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- AT3 or better shank taper allows for accurate, rigid toolholder-to-spindle mount
- Wide range collets reduce collet and toolholder inventories
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance
- Through spindle coolant standard
- **ER40 Collets found on pages 600-602.**



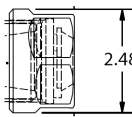
CAT50 ER40 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.1181-1.1875	CAT50	2.48	4.00	4.10	130 ft lbs	RC5ER40400Z
.1181-1.1875	CAT50	2.48	6.00	4.10	130 ft lbs	RC5ER40600Z
.1181-1.1875	CAT50	2.48	8.00	4.10	130 ft lbs	RC5ER40800Z
.1181-1.1875	CAT50	2.48	10.00	4.10	130 ft lbs	RC5ER401000Z

ER40 Straight Shank Collet Extension

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
1.250	2.48	4.85	130 ft lbs		RSSER401250485Z

ER40 Parts & Accessories

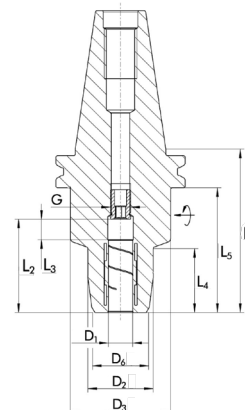
Description	Photo	Dimensions	Part #
ER40 Replacement Nosepiece			RER40NZ
ER40 Fixed Spanner Wrench			RER40SWZ
ER40 Stop Screw			RBS1250LHZ



CAT50 Hydraulic Chucks

(Balanced to G2.5@25,000 RPM)

- Used for milling, drilling, reaming and boring
- Concentric to .00012"
- Wide range of coolant sealed or coolant flush reduction sleeves available.
- Safe operating temp should be between 68-122 degrees Fahrenheit
- **Hydraulic Chuck Sleeves can be found on pages 607-608.**



CAT50 Hydraulic Chucks

Bore ø D1	Shank	D2	D3	D6	L1	L2	Min Clamp Depth - L3	L4	L5	G	Part #
3/4	CAT50	1.75	1.93	1.58	3.19	1.99	1.59	1.73	2.44	M12x1	RC5HC07500320
1-1/4	CAT50	2.44	3.15	2.18	3.19	2.38	1.99	1.50	2.44	M12x1	RC5HC12500320

Successful Use and Care for RedLine Hydraulic Chucks

- RedLine Hydraulic Chucks can accept tools with a smooth cylindrical shank, weldon shank or a whistle notch without the use of reduction sleeves. Tools must have a H6 or better shank tolerance.
- To clamp a tool in the hydraulic chuck, turn the clamping screw with an allen key with 7-8.5 ft. lbs. torque completely to the limit stop. Never use a power screwdriver to turn the actuation screw!
- Testing of the clamping force should be done before the first use and after approximately 100 tool changes or every 3 months. A test shaft should be inserted at least to the minimum shank depth into the toolholder. Tighten the clamping screw to a dead stop. If the test shaft can be easily removed from the toolholder manually and without any effort, the clamping force is not high enough. The hydraulic chuck shouldn't be used and sent in for repair.
- When using intermediate sleeves, they must be inserted completely into the hydraulic chuck, so the edge of the sleeve makes contact with the face of the hydraulic chuck. Failure to do this will result in poor run-out and lower grip force.
- *Tools with weldon shanks or whistle notches influence balance and will affect the max rpm the tools can run.
- If tools are not clamped to minimum clamping depth there is a risk of damaging the expansion sleeve and will result in a loss of accuracy.
- The vent screw of the hydraulic system is protected with a pin or resin. Don't remove it!
- The axial length stop is set with an allen key via the length adjustment screw. There is 10MM (.394") adjustment. Never actuate the length adjustment screw when tools are clamped. Axial adjustment screws maximum tightening torque is 2.2 ft. lbs.

Clamping / Unclamping

- The tool shank must be burr-free and free of dirt.
- Always insert the tool down to the minimum clamping depth into the toolholder.
- Do not combine several extensions. The clamping screw is not secured against dropping out!
- Hydraulic Chucks must not be clamped without a tool or workpiece.

Shanks to be used in hydraulic expansion toolholders

- Type A with straight cylindrical shaft. Cylindrical shaft acc. to DIN 6535 HA and form A according to DIN 6535 part 1
- Type AB with one weldon flat cylinder shank form B according to DIN 1835 part 1 and DIN 6535 HB
- Type B with two weldon flats cylinder shank B according to DIN 1835 part 1
- Type E with whistle-notch flat cylinder shank E according to DIN 1835 part 1 and DIN 6535 HE

Care, Storage and Maintenance

- For optimum clamping force, the clamping bore and groove must be cleaned after every tool change with a solvent.
- Before storage, oil the entire surface of the hydraulic chuck and store in an unclamped position.
- Warranty is void if repairs are by anyone other than RedLine Tools.
- It may be necessary to adjust and lubricate the actuation screw, especially with a high number of clamping cycles, high operating temperatures or where abrasive dirt or swarf are present. For optimum lubrication of the actuation screw, we are recommending the use of copper paste MOLYKOTE CU 7439 (100 g tube, Id.-No. 9247204).
- Adjustment range of the length adjustment: .394"
- Operating temperature: 68-122°F
- Max. coolant pressure: 1160 P.S.I.



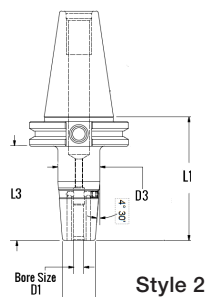
Style 2

Style 3

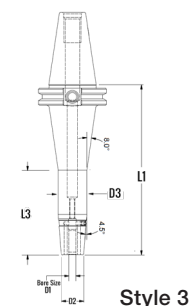
CAT50 Shrink Fit with Coolant Ports

(Balanced to G2.5@25,000 RPM)

- Concentric to .0001" TIR for increased cutting tool life
- 2 Angled ports direct coolant to cutting area
- Gage lengths match international standards
- AT3 or better shank taper allows for accurate, rigid toolholder-spindle mount
- Made from H13 tool steel for superior rigidity and maximum grip for extended longevity
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance



Style 2



Style 3



Shrink fit machines found on pages 611-612.

CAT50 Shrink Fit Holders with Coolant Ports

Taper	Bore Size - D1	Style	D2	D3	L1	L3	Part #
CAT50	1/4	2	.83	1.06	3.15	2.40	RC5SFCT20250315Z
CAT50	1/4	2	.83	1.06	5.12	4.37	RC5SFCT20250512Z
CAT50	1/4	3	.83	1.06	6.30	3.15	RC5SFCT30250630Z
CAT50	5/16	2	.83	1.06	3.15	2.40	RC5SFCT20312315Z
CAT50	5/16	2	.83	1.06	5.12	4.37	RC5SFCT20312512Z
CAT50	5/16	3	.83	1.06	6.30	3.15	RC5SFCT30312630Z
CAT50	3/8	2	.94	1.26	3.15	2.40	RC5SFCT20375315Z
CAT50	3/8	2	.94	1.26	5.12	4.37	RC5SFCT20375512Z
CAT50	3/8	3	.94	1.26	6.30	3.15	RC5SFCT30375630Z
CAT50	1/2	2	.94	1.26	3.15	2.40	RC5SFCT20500315Z
CAT50	1/2	2	.94	1.26	5.12	4.37	RC5SFCT20500512Z
CAT50	1/2	3	.94	1.26	6.30	3.15	RC5SFCT30500630Z
CAT50	5/8	2	1.06	1.34	3.15	2.40	RC5SFCT20625315Z
CAT50	5/8	2	1.06	1.34	5.12	4.37	RC5SFCT20625512Z
CAT50	5/8	3	1.06	1.34	6.30	3.15	RC5SFCT30625630Z
CAT50	3/4	2	1.30	1.65	3.15	2.40	RC5SFCT20750315Z
CAT50	3/4	2	1.30	1.65	5.12	4.37	RC5SFCT20750512Z
CAT50	3/4	3	1.30	1.65	6.30	3.15	RC5SFCT30750630Z
CAT50	1	2	1.73	2.09	3.94	3.19	RC5SFCT21000394Z
CAT50	1	2	1.73	2.09	5.12	4.37	RC5SFCT21000512Z
CAT50	1	2	1.73	2.09	6.30	3.15	RC5SFCT21000630Z
CAT50	1-1/4	2	1.73	2.09	3.94	3.19	RC5SFCT21250394Z
CAT50	1-1/4	2	1.73	2.09	5.12	4.37	RC5SFCT21250512Z
CAT50	1-1/4	2	1.73	2.09	6.30	3.15	RC5SFCT21250630Z

CAT50 Shrink Fit Stop Screws

Bore Size	Thread	Hex	Length	Photo	Part #
1/4	M5x.8	2.5 mm	.630		RSFSS250Z
5/16	M6X1	3 mm	.630		RSFSS312Z
3/8	M8x1	4 mm	.630		RSFSS375Z
1/2	M10X1	5 mm	.787		RSFSS500Z
9/16	M10X1	5 mm	.787		RSFSS500Z
5/8	M12X1	6 mm	.787		RSFSS625Z
3/4	M16X1	8 mm	.787		RSFSS750Z
1	M16X1	8 mm	.787		RSFSS750Z
1-1/4	M16X1	8 mm	.787		RSFSS750Z

CAT50 Endmill Holders

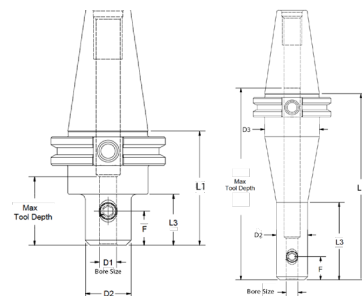
(Balanced to G6.3@15,000 RPM)

- Holders through 1.000" accept double end cutters saving on tool costs
- Fine thread screws match weldon flats - lock tight, stay tight
- H5 bore tolerance. H5 is an extremely accurate bore I.D. and provides improved T.I.R. to .0002" for extended cutting tool life.
- Taper ground to AT3 or better for accurate, rigid toolholder-to-spindle mount
- Less tool wear and replacement means less scrap
- Fully ground flange and V-groove is easy on tool changers for less spindle and changer maintenance



Standard Style

Tapered Style



Standard Style

Tapered Style

CAT50 Endmill Holders - Fractional

Taper	Bore Size - D1	D2	L1	L3	Style	F	Set Screw Qty (Distance Apart)	Max Tool Depth	Part #
CAT50	1/4	.88	2.50	-	Std.	.38	1	3.00	RC5EM0250250Z
CAT50	1/4	.88	4.50	-	Std.	.38	1	3.00	RC5EM0250450Z
CAT50	3/8	1.00	2.50	-	Std.	.75	1	3.00	RC5EM0375250Z
CAT50	3/8	1.00	4.50	-	Std.	.75	1	3.00	RC5EM0375450Z
CAT50	3/8	1.00	6.50	-	Std.	.75	1	3.00	RC5EM0375650Z
CAT50	1/2	1.25	2.62	-	Std.	.88	1	3.00	RC5EM0500262Z
CAT50	1/2	1.25	4.62	-	Std.	.88	1	5.00	RC5EM0500462Z
CAT50	1/2	1.25	6.62	-	Std.	.88	1	5.00	RC5EM0500662Z
CAT50	5/8	1.50	3.75	-	Std.	.94	1	3.50	RC5EM0625375Z
CAT50	5/8	1.50	5.75	-	Std.	.94	1	3.50	RC5EM0625575Z
CAT50	3/4	1.75	3.75	-	Std.	1.00	1	4.00	RC5EM0750375Z
CAT50	3/4	1.75	5.75	-	Std.	1.00	1	4.00	RC5EM0750575Z
CAT50	3/4	1.75	7.75	4.25	Taper	1.00	1	4.00	RC5EM0750775Z
CAT50	1	2.75	1.63	-	Std.	1.13	1	2.50	RC5EM1000163Z
CAT50	1	2.00	4.00	-	Std.	1.12	2 (1")	4.44	RC5EM1000400Z
CAT50	1	2.00	6.00	-	Std.	1.13	2 (1")	4.44	RC5EM1000600Z
CAT50	1-1/4	2.75	2.63	-	Std.	1.12	2 (1")	3.50	RC5EM1250263Z
CAT50	1-1/4	2.50	4.00	-	Std.	1.13	2 (1")	3.35	RC5EM1250400Z
CAT50	1-1/4	2.50	6.00	-	Std.	1.13	2 (1")	3.35	RC5EM1250600Z
CAT50	1-1/2	2.75	2.63	-	Std.	1.50	2 (1")	2.25	RC5EM1500263Z
CAT50	1-1/2	2.75	4.00	-	Std.	1.13	2 (1")	4.50	RC5EM1500400Z
CAT50	1-1/2	2.75	6.00	-	Std.	1.13	2 (1")	4.50	RC5EM1500600Z

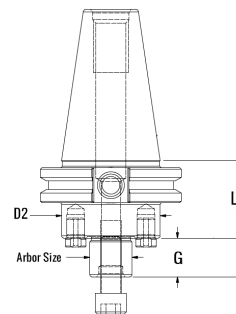
Endmill Holder Replacement Lock Screws

Holder Size	Screw Thread Size	Length	Max Torque	Photo	Part #
1/8	10-32	.25	3 ft lbs		REMLS0125Z
3/16	1/4-28	.25	7 ft lbs		REMLS0187Z
1/4	1/4-28	.25	7 ft lbs		REMLS0250Z
5/16	1/4-28	.25	7 ft lbs		REMLS0312Z
3/8	3/8-24	.31	13 ft lbs		REMLS0375Z
7/16	3/8-24	.31	13 ft lbs		REMLS0437Z
1/2	7/16-20	.38	19 ft lbs		REMLS0500Z
9/16	7/16-20	.38	19 ft lbs		REMLS0562Z
5/8	9/16-18	.43	31 ft lbs		REMLS0625Z
3/4	5/8-18	.50	45 ft lbs		REMLS0750Z
7/8	5/8-18	.50	48 ft lbs		REMLS0875Z
1	3/4-16	.50	69 ft lbs		REMLS1000Z
1-1/4	3/4-16	.62	69 ft lbs		REMLS1250Z
1-1/2	3/4-16	.62	69 ft lbs		REMLS1500Z
2	1-14	.88	80 ft lbs		REMLS2000Z
2-1/2	1-14	.88	80 ft lbs		REMLS2500Z



CAT50 Facemill Holders

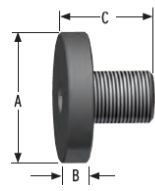
- Arbor pilot TIR <0.002"
- Compatible with all facemills
- Constructed of alloy steel
- Hardened to 56-60 Rc for long service life



CAT50 Facemill Holders

Taper	Arbor Size	D2	L1	G	Part #
CAT50	3/4	1.75	1.50	.68	RC5SM0750150Z
CAT50	3/4	1.75	3.50	.68	RC5SM0750350Z
CAT50	3/4	1.75	5.50	.68	RC5SM0750550Z
CAT50	1	2.25	2.00	.68	RC5SM1000200Z
CAT50	1	2.25	4.00	.68	RC5SM1000400Z
CAT50	1	2.25	6.00	.68	RC5SM1000600Z
CAT50	1	2.25	8.00	.68	RC5SM1000800Z
CAT50	1-1/4	2.75	1.50	.68	RC5SM1250150Z
CAT50	1-1/4	2.75	3.50	.68	RC5SM1250350Z
CAT50	1-1/4	2.75	5.50	.68	RC5SM1250550Z
CAT50	1-1/2	3.75	2.40	.94	RC5SM1500240Z
CAT50	1-1/2	3.75	4.00	.94	RC5SM1500400Z
CAT50	1-1/2	3.75	6.00	.94	RC5SM1500600Z
CAT50	2	4.88	2.40	.94	RC5SM2000240Z
CAT50	2	4.88	4.00	.94	RC5SM2000400Z
CAT50	2	4.88	6.00	.94	RC5SM2000600Z
CAT50	2-1/2	4.88	2.40	1.12	RC5SM2500240Z
CAT50	2-1/2	4.88	4.00	1.12	RC5SM2500400Z
CAT50	2-1/2	4.88	6.00	1.12	RC5SM2500600Z

Facemill Holder Replacement Lock Screws

Arbor Size	A	B	C	Thread	Hex	Torque	Photo	Dimensions	Part #
3/4	.88	.38	1.06	3/8-24	1/4	45 ft lbs			RSMLS0750Z
1	1.19	.28	1.12	1/2-20	5/16	60 ft lbs			RSMLS1000Z
1-1/4	1.50	.50	1.44	5/8-18	5/16	70 ft lbs			RSMLS1250Z
1-1/2	1.88	.50	1.75	3/4-16	3/8	75 ft lbs			RSMLS1500Z
2	2.50	.50	1.75	1-14	1/2	100 ft lbs			RSMLS2000Z
2-1/2	3.12	.50	1.75	1-14	1/2	100 ft lbs			RSMLS2500Z
3/4	.88	.38	.97	3/8-24	1/4	45 ft lbs			RSMLSC0750Z *
1	1.19	.28	1.20	1/2-20	5/16	60 ft lbs			RSMLSC1000Z *
1-1/2	1.88	.50	1.75	3/4-16	3/8	75 ft lbs			RSMLSC1500Z *

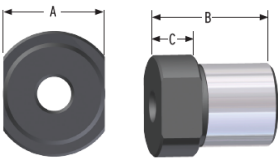
*Coolant Thru Option

Facemill Holder Replacement Socket Head Cap Screws

Arbor Size	A	B	C	Thread	Hex	Torque	Photo	Part #
3/4	.56	.37	1.37	3/8-24	5/16	45 ft lbs		RSMCS0750Z
1	.75	.50	1.75	1/2-20	3/8	60 ft lbs		RSMCS1000Z
1-1/4	.94	.62	1.87	5/8-18	1/2	70 ft lbs		RSMCS1250Z
3/4	.56	.37	1.37	1/2-20	5/16	45 ft lbs		RSMCSC0750Z *
1	.75	.50	1.75	3/8-24	3/8	60 ft lbs		RSMCSC1000Z *

*Coolant Thru Option

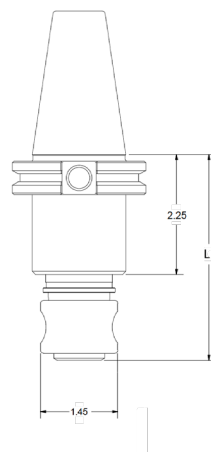
Facemill Holder Replacement Drive Keys

Arbor Size	A	B	C	Photo	Dimensions	Part #
3/4	.31	.52	.16			RSMDK0750Z
1	.38	.67	.19			RSMDK1000Z
1-1/4	.50	.86	.25			RSMDK1250Z
1-1/2	.62	1.04	.31			RSMDK1500Z
2	.75	1.10	.38			RSMDK2000Z
2-1/2	1.00	1.23	.50			RSMDK2500Z



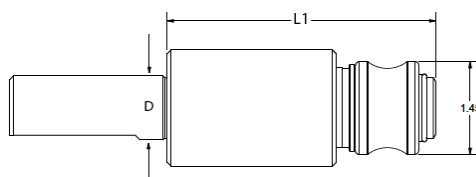
CAT50 & Straight Shank Bilz Style #1

- From 0-9/16" standard and 1/16"-1/8" NPT
- For use with popular Bilz style #1 adapters
- Rigid for use with synchronous tapping cycles
- Radial float improves thread quality and tap life
- Adjustable short compression stroke ensures accurate depth control
- Free-floating tension stroke ensures thread size and quality
- **Bilz style #1 collets can be found on page 609.**



CAT50 Bilz Style #1 Tap Holders

Taper	Collet Size	Compression	Tension	L1	Part #
CAT50	Bilz #1	0 - .250	.56	3.15	RC5THT01315Z
CAT50	Bilz #1	Rigid	Rigid	3.15	RC5THR01315Z



Straight Shank Bilz Style #1 Tap Holders

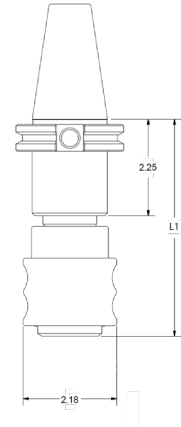
Diameter (D)	Collet Size	Compression	Tension	L1	Part #
1.00	Bilz #1	Rigid	Rigid	4.21	RTHSSR0110421Z
1.00	Bilz #1	0 - .250	.56	4.43	RTHSST0110443Z

Tap Holders - Bilz Style #2 and #3



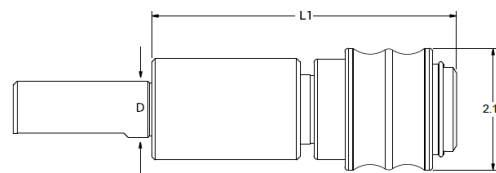
CAT50 & Straight Shank Bilz Style #2

- From 5/16"-7/8" standard and 1/4"-1/2" NPT
- For use with popular Bilz style #2 adapters
- Rigid for use with synchronous tapping cycles
- Radial float improves thread quality and tap life
- Adjustable short compression stroke ensures accurate depth control
- Free-floating tension stroke ensures thread size and quality
- **Bilz style #2 collets can be found on page 609.**



CAT50 Bilz Style #2 Tap Holders

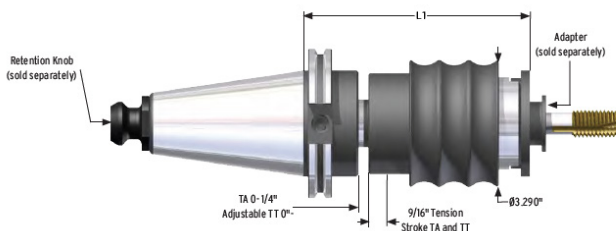
Taper	Collet Size	Compression	Tension	L1	Part #
CAT50	Bilz #2	0 - .250	.56	4.25	RC5THT02425Z
CAT50	Bilz #2	Rigid	Rigid	4.25	RC5THR02425Z



Straight Shank Bilz Style #2 Tap Holders

Diameter (D)	Collet Size	Compression	Tension	L1	Part #
1.00	Bilz #2	0 - .250	.56	5.46	RTHSST0210546Z
1.00	Bilz #2	Rigid	Rigid	5.46	RTHSSR0210546Z
1.25	Bilz #2	0 - .250	.56	5.46	RTHSST02125546Z

CAT50 Bilz Style #3



- From 3/16"-1-3/8" standard and 3/4"-1" NPT
- For use with popular Bilz style #3 adapters
- Radial float improves thread quality and tap life
- Adjustable short compression stroke ensures accurate depth control
- Free-floating tension stroke ensures thread size and quality
- **Bilz style #3 collets can be found on page 609.**

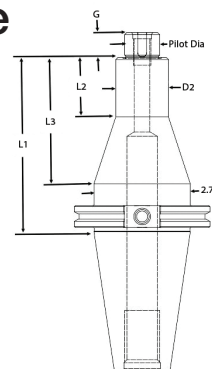
CAT50 Bilz Style #3 Tap Holder

Taper	Collet Size	Compression	Tension	L1	Part #
CAT50	Bilz #3	0 - .250	.56	5.65	RC5THT03565Z



CAT50 Stub Arbor Holders - Lock Screw Style

- Face is perpendicular to center line within .0002"
- Pilot diameter is sized for precision fit with cutter and is keyed for positive drive
- Heavy duty lock screw and three arbor spacers are included - 1/4", 3/8", 3/4"



CAT50 Stub Arbor Holders - Lock Screw Style

Taper	Pilot Dia	D2	L1	L2	L3	D	G	Part #
CAT50	1.00	1.50	5.00	1.70	3.62	.25	.720	RC5T2SAH1000500Z
CAT50	1.25	1.75	6.00	1.50	4.62	.31	.720	RC5T2SAH1250600Z
CAT50	1.50	2.12	6.00	1.62	4.62	.37	.980	RC5T2SAH1500600Z

* Part numbers above include Drive Key and Nut

CAT50 Stub Arbor Holder Components

Description	Part #
Drive key for 1" Diameter Pilot Stub Arbor Holder	RSAKT21000Z
Lock screw for 1" Diameter Pilot Stub Arbor Holder	RSMLS1000Z
Drive key for 1.25" Diameter Pilot Stub Arbor Holder	RSAKT21250Z
Lock screw for 1.25" Diameter Pilot Stub Arbor Holder	RSMLS1250Z
Drive key for 1.50" Diameter Pilot Stub Arbor Holder	RSAKT21500Z
Lock screw for 1.50" Diameter Pilot Stub Arbor Holder	RSMLS1500Z

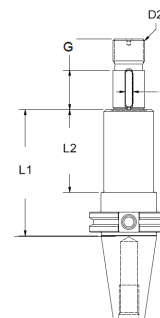
CAT50 Stub Arbor Holder Spacers

Pilot Diameter	Description	Part #
1" Pilot Diameter	1/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000125Z
	1/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000250Z
	3/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000375Z
	3/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000750Z
1.25" Pilot Diameter	1/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500125Z
	1/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500250Z
	3/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500375Z
	3/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500750Z
1.50" Pilot Diameter	1/8" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000125Z
	1/4" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000250Z
	3/8" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000375Z
	1/2" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000500Z
	3/4" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000750Z



CAT50 Stub Arbor Holders - Lock Nut Style

- Pilot thread is ground concentric to the tapered shank
- Face is perpendicular to center line within .0002"
- Pilot diameter is sized for precision fit with cutter and is keyed for positive drive
- Heavy duty locking nut and three arbor spacers are included - 1/4", 3/8", 3/4"



CAT50 Stub Arbor Holders - Lock Nut Style

Taper	Pilot Dia	D2	L1	L2	D	G	Part #
CAT50	1.00	1.56	4.00	2.62	.25	1.25	RC5T1SAH1000400Z
CAT50	1.00	1.56	6.00	4.62	.25	1.25	RC5T1SAH1000600Z
CAT50	1.25	1.88	4.00	2.62	.31	1.25	RC5T1SAH1250400Z
CAT50	1.25	1.88	6.00	4.62	.31	1.25	RC5T1SAH1250600Z
CAT50	1.50	2.00	4.00	2.62	.37	1.25	RC5T1SAH1500400Z
CAT50	1.50	2.00	6.00	2.62	.37	1.25	RC5T1SAH1500600Z
CAT50	2.00	2.75	6.00	5.25	.50	1.25	RC5T1SAH2000600Z

Part numbers above include drive key and nut

CAT50 Stub Arbor Components

Description	Part #
Drive key for 1" Diameter Pilot Stub Arbor Holder	RSAKT11000Z
Lock nut for 1" Stub Arbor Holder	RSAN1000Z
Drive key for 1.25" Diameter Pilot Stub Arbor Holder	RSAKT11250Z
Lock nut for 1.25" Stub Arbor Holder	RSAN1250Z
Drive key for 1.50" Diameter Pilot Stub Arbor Holder	RSAKT11500Z
Lock nut for 1.50" Stub Arbor Holder	RSAN1500Z
Drive key for 2" Diameter Pilot Stub Arbor Holder	RSAKT12000Z
Lock nut for 2" Stub Arbor Holder	RSAN2000Z

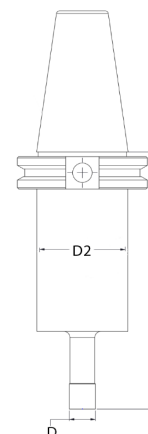
CAT50 Stub Arbor Holder Spacers

Pilot Diameter	Description	Part #
1" Pilot Diameter	1/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000125Z
	1/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000250Z
	3/8" Thick Spacer for 1" Stub Arbor Holder	RSAS10000375Z
	3/4" Thick Spacer for 1" Stub Arbor Holder	RSAS10000750Z
1.25" Pilot Diameter	1/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500125Z
	1/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500250Z
	3/8" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500375Z
	3/4" Thick Spacer for 1.25" Stub Arbor Holder	RSAS12500750Z
1.50" Pilot Diameter	1/8" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000125Z
	1/4" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000250Z
	3/8" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000375Z
	1/2" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000500Z
	3/4" Thick Spacer for 1.50" Stub Arbor Holder	RSAS15000750Z
2" Pilot Diameter	1/4" Thick Spacer for 2" Stub Arbor Holder	RSAS20000125Z
	3/8" Thick Spacer for 2" Stub Arbor Holder	RSAS20000375Z
	3/4" Thick Spacer for 2" Stub Arbor Holder	RSAS20000750Z



CAT50 Probe Calibration Gage

- Works on all CAT50 spindle machines
- This tool is to be used as a standard for gage length and diameter
- Can be used to calibrate your table tool probe
- Can be kept in tool changer for periodic probe calibration
- All critical tool holder surfaces precision ground
- Made from alloy steel hardened to 54-56rc
- Individual calibration certificate is included with each tool holder
- Concentricity of gage diameter is .0001" or less



CAT50 Probe Calibration Gage				
Taper	D	D2	L	Part #
CAT50	.500	1.63	5.000	RC5CA0500500Z

Calibration Certificate

PART NUMBER: RC5CA0500500
 PART NAME: CAT50 CALIBRATION PROBE
 SERIAL NUMBER: SN-7353



Diameter (D) Dimension: 0.5007"

Length (L) Dimension: 5.0030"

Calibrated by: John E. Capezzute
 Date: 1/9/2024

Temperature: 68°F (20°C)
 Humidity: 17.0 %

RedLine Tools
 PERFORMANCE MATTERS

RedLine Tools: 15150 25th Avenue North
 Plymouth (Mpls.), MN 55447 • (800) 791-7542
www.redlinetools.com • support@redlinetools.com

The adapter covered by this certification has been calibrated with equipment or compared with master reference standards traceable to the National Institute of Standards and Technology (NIST), Washington D.C. Outside diameter & gage line length measurements within +/- .00006"

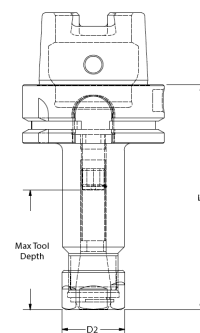
Collet Chucks - ER16



HSK63A & Straight Shank Collet Chucks - ER16

(Balanced to G2.5@25,000 RPM)

- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- Wide range collets reduce collet and toolholder inventories
- Through spindle coolant standard
- **ER16 Collets found on pages 592 and 593.**



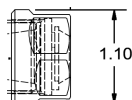
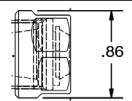
HSK63A ER16 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0200-.3930	HSK63A	1.10	3.94	2.10	42 ft lbs	RHSK63AER16394Z
.0200-.3930	HSK63A	1.10	6.30	3.00	42 ft lbs	RHSK63AER16630Z

ER16 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.10	5.50	42 ft lbs		RSSER160750550Z
.750	1.10	7.50	42 ft lbs		RSSER160750750Z
.750	.86	7.00	20 ft lbs		RSSER160750710Z

ER16 Parts & Accessories

Description	Photo	Dimensions	Part #
ER16 Replacement Nosepiece			RER16HNZ
ER16 Open Hex Style Wrench 1"			RER16HWZ
ER16 Stop Screw			RBS0437LHZ
ER16 Slimline Nut			RER16SNZ
ER16 Slimline Wrench 7/8"			RER16SNWZ

HSK63A Coolant Accessories

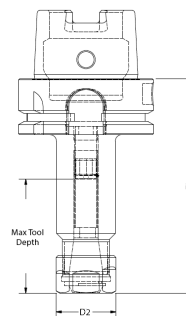
HSK63A Coolant Tube	HSK63A Coolant Tube Wrench
	
RHSK63ACTZ	RHSK63ATWZ



HSK63A & Straight Shank Collet Chucks - ER20

(Balanced to G2.5@25,000 RPM)

- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- Wide range collets reduce collet and toolholder inventories
- Through spindle coolant standard
- **ER20 Collets found on page 595.**



HSK63A ER20 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.5110	HSK63A	1.34	3.94	1.88	59 ft lbs	RHSK63AER20394Z
.0400-.5110	HSK63A	1.34	6.30	1.88	59 ft lbs	RHSK63AER20630Z

ER20 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.34	7.20	59 ft lbs		RSSER200750720Z
1.000	1.10	7.20	22 ft lbs		RSSER201000720Z

ER20 Parts & Accessories

Description	Photo	Dimensions	Part #
ER20 Replacement Nosepiece		1.34	RER20HNZ
ER20 Open Hex Wrench 1-1/8"			RER20HWZ
ER20 Stop Screw Coolant Thru			RBS0562LHZ
ER20 Slimline Nut		1.10	RER20SNZ
ER20 Slimline Wrench 1"			RER16HWZ

HSK63A Coolant Accessories

HSK63A Coolant Tube	HSK63A Coolant Tube Wrench
RHSK63ACTZ	RHSK63ATWZ

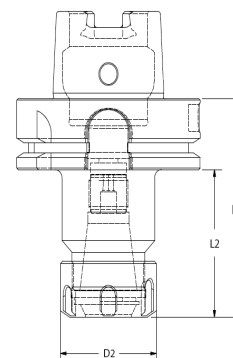
Collet Chucks - ER25



HSK63A & Straight Shank Collet Chucks - ER25

(Balanced to G2.5@25,000 RPM)

- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- Wide range collets reduce collet and toolholder inventories
- Through spindle coolant standard
- **ER25 Collets found on page 596-597.**



HSK63A ER25 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.6299	HSK63A	1.65	3.15	1.50	77 ft lbs	RHSK63AER25315Z
.0400-.6299	HSK63A	1.65	6.30	2.30	77 ft lbs	RHSK63AER25630Z

ER25 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
.750	1.65	5.81	77 ft lbs		RSSER250750581Z
1.000	1.65	5.31	77 ft lbs		RSSER251000531Z

ER25 Parts & Accessories

Description	Photo	Dimensions	Part #
ER25 Replacement Nosepiece			RER25NZ
ER25 Fixed Spanner Wrench			RER25SWZ
ER25 Stop Screw			RBS0687LHZ

HSK63A Coolant Accessories

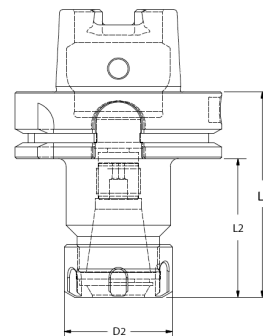
HSK63A Coolant Tube	HSK63A Coolant Tube Wrench
RHSK63ACTZ	RHSK63ATWZ

HSK63A & Straight Shank Collet Chucks - ER32

(Balanced to G2.5@25,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- Wide range collets reduce collet and toolholder inventories
- Through spindle coolant standard
- **ER32 Collets found on pages 598-599.**



HSK63A ER32 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.0400-.7870	HSK63A	1.97	3.15	2.00	100 ft lbs	RHSK63AER32315Z
.0400-.7870	HSK63A	1.97	4.72	2.50	100 ft lbs	RHSK63AER32472Z

ER32 Straight Shank Collet Extensions

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
1.000	1.97	4.25	100 ft lbs		RSSER321000425Z
1.250	1.97	8.05	100 ft lbs		RSSER321250805Z

ER32 Parts & Accessories

Description	Photo	Dimensions	Part #
ER32 Replacement Nosepiece			RER32NZ
ER32 Fixed Spanner Wrench			RER32SWZ
ER32 Stop Screw			RBS0812LHZ

HSK63A Coolant Accessories

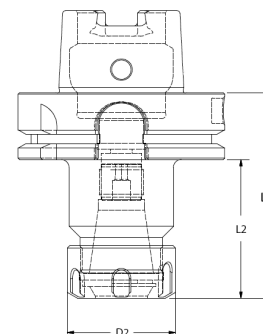
HSK63A Coolant Tube	HSK63A Coolant Tube Wrench
RHSK63ACTZ	RHSK63ATWZ

HSK63A & Straight Shank Collet Chucks - ER40

(Balanced to G2.5@25,000 RPM)



- Small diameter nose well-suited for working in close quarters
- Increased flexibility for milling, drilling, and reaming
- Flush precision collet nut, grips tool close to cutting edge for accuracy and rigidity
- Concentric to .0001" TIR puts tool precisely on spindle center line
- Wide range collets reduce collet and toolholder inventories
- Through spindle coolant standard
- **ER40 Collets found on pages 600-602.**



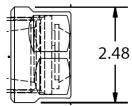
HSK63A ER40 Collet Chucks

Capacity	Taper	D2	L1	Max Tool Depth	Max Nosepiece Torque	Part #
.1181-1.1875	HSK63A	2.48	3.94	2.50	130 ft lbs	RHSK63AER40394Z

ER40 Straight Shank Collet Extension

A (Dia)	D2 (Dia)	OAL	Max Nosepiece Torque	Photo	Part #
1.250	2.48	4.85	130 ft lbs		RSSER401250485Z

ER40 Parts & Accessories

Description	Photo	Dimensions	Part #
ER40 Replacement Nosepiece			RER40NZ
ER40 Fixed Spanner Wrench			RER40SWZ
ER40 Stop Screw			RBS1250LHZ

HSK63A Coolant Accessories

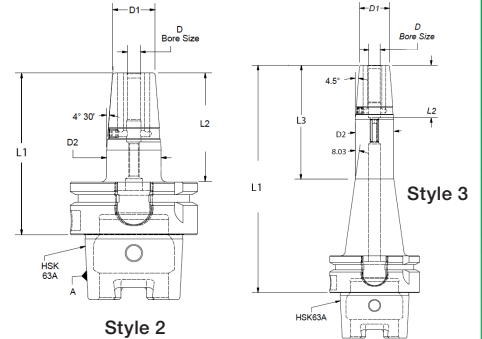
HSK63A Coolant Tube	HSK63A Coolant Tube Wrench
	
RHSK63ACTZ	RHSK63ATWZ

HSK63A Shrink Fit with Coolant Ports

(Balanced to G2.5@25,000 RPM)



- Concentric to .0001" TIR for increased cutting tool life
- 2 Angled ports direct coolant to cutting area
- Gage lengths match international standards
- AT3 or better shank taper allows for accurate, rigid tool holder-spindle mount
- Made from H13 tool steel for superior rigidity and maximum grip for extended longevity



Shrink fit machines found on pages 611-612.

HSK63A Shrink Fit Holders with Coolant Ports

Taper	Bore Size	Style	D2	D3	L1	L3	Part #
HSK63A	1/4	2	.83	1.06	3.15	2.40	RHSK63ASFCT20250315Z
HSK63A	1/4	2	.83	1.06	5.12	4.37	RHSK63ASFCT20250512Z
HSK63A	1/4	3	.83	1.06	6.30	3.15	RHSK63ASFCT30250630Z
HSK63A	5/16	2	.83	1.06	3.15	2.40	RHSK63ASFCT20312315Z
HSK63A	5/16	2	.83	1.06	5.12	4.37	RHSK63ASFCT20312512Z
HSK63A	5/16	3	.83	1.06	6.30	3.15	RHSK63ASFCT30312630Z
HSK63A	3/8	2	.94	1.26	3.35	2.32	RHSK63ASFCT20375335Z
HSK63A	3/8	2	.94	1.26	5.12	4.37	RHSK63ASFCT20375512Z
HSK63A	3/8	3	.94	1.26	6.30	3.15	RHSK63ASFCT30375630Z
HSK63A	1/2	2	.94	1.26	3.54	2.52	RHSK63ASFCT20500354Z
HSK63A	1/2	2	.94	1.26	5.12	4.37	RHSK63ASFCT20500512Z
HSK63A	1/2	3	.94	1.26	6.30	3.15	RHSK63ASFCT30500630Z
HSK63A	5/8	2	1.06	1.34	3.75	2.72	RHSK63ASFCT20625375Z
HSK63A	5/8	2	1.06	1.34	5.12	4.37	RHSK63ASFCT20625512Z
HSK63A	5/8	3	1.06	1.34	6.30	3.15	RHSK63ASFCT30625630Z
HSK63A	3/4	2	1.30	1.65	3.94	3.19	RHSK63ASFCT20750394Z
HSK63A	3/4	2	1.30	1.65	5.12	4.37	RHSK63ASFCT20750512Z
HSK63A	3/4	2	1.30	1.65	6.30	3.15	RHSK63ASFCT20750630Z
HSK63A	1	2	1.73	2.09	4.53	3.50	RHSK63ASFCT21000453Z
HSK63A	1	2	1.73	2.09	6.30	3.15	RHSK63ASFCT21000630Z
HSK63A	1-1/4	2	1.73	2.09	4.72	3.70	RHSK63ASFCT21250472Z
HSK63A	1-1/4	2	1.73	2.09	6.30	3.15	RHSK63ASFCT21250630Z

HSK63A Shrink Fit Stop Screws

Bore Size	Thread	Hex	Length	Photo	Part #
1/4	M5x.8	2.5 mm	.630		RSFSS250Z
5/16	M6X1	3 mm	.630		RSFSS312Z
3/8	M8x1	4 mm	.630		RSFSS375Z
1/2	M10X1	5 mm	.787		RSFSS500Z
9/16	M10X1	5 mm	.787		RSFSS500Z
5/8	M12X1	6 mm	.787		RSFSS625Z
3/4	M16X1	8 mm	.787		RSFSS750Z
1	M16X1	8 mm	.787		RSFSS750Z
1-1/4	M16X1	8 mm	.787		RSFSS750Z

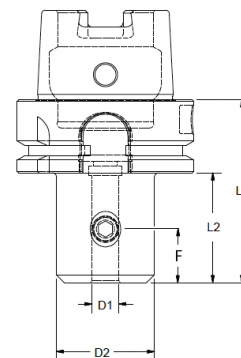
Endmill Holders



HSK63A Endmill Holders

(Balanced to G6.3@15,000 RPM)

- Holders through 1.000" accept double end cutters saving on tool costs
- Fine thread screws match weldon flats - lock tight, stay tight
- H5 bore tolerance. H5 is an extremely accurate bore I.D. and provides improved T.I.R. to .0002" for extended cutting tool life.
- Taper ground to AT3 or better for accurate, rigid toolholder-to-spindle mount
- Less tool wear and replacement means less scrap



HSK63A Endmill Holders - Fractional

Taper	Bore Size D1	D2	L1	L2	F	Set Screw Qty (Distance Apart)	Max Tool Depth	Part #
HSK63A	1/8	1.00	2.56	1.54	.38	1	1.40	RHSK63AEM0125256Z
HSK63A	1/8	1.00	4.00	2.98	.38	1	2.00	RHSK63AEM0125400Z
HSK63A	3/16	1.00	4.00	2.98	.38	1	2.50	RHSK63AEM0188400Z
HSK63A	1/4	1.10	2.56	1.54	.38	1	1.53	RHSK63AEM0250256Z
HSK63A	1/4	1.10	4.00	2.98	.38	1	3.00	RHSK63AEM0250400Z
HSK63A	5/16	1.00	4.00	2.98	.44	1	3.00	RHSK63AEM0313400Z
HSK63A	3/8	1.38	2.56	1.54	.75	1	1.54	RHSK63AEM0375256Z
HSK63A	3/8	1.00	4.00	2.98	.75	1	2.00	RHSK63AEM0375400Z
HSK63A	1/2	1.25	4.00	2.98	.88	1	2.20	RHSK63AEM0500400Z
HSK63A	5/8	1.75	4.00	2.98	.94	1	2.90	RHSK63AEM0625400Z
HSK63A	3/4	1.94	3.13	2.11	1.00	1	2.12	RHSK63AEM0750313Z
HSK63A	3/4	1.94	4.00	2.98	1.00	1	2.75	RHSK63AEM0750400Z
HSK63A	1	2.56	4.25	3.23	1.13	2 (1")	3.00	RHSK63AEM1000425Z

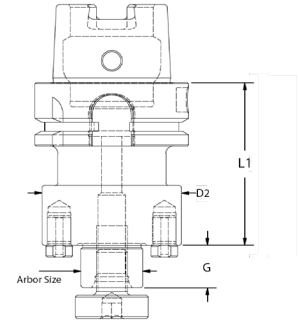
Endmill Holder Replacement Lock Screws

Holder Size	Screw Thread Size	Length	Max Torque	Photo	Part #
1/8	10-32	.25	3 ft lbs		REMLS0125Z
3/16	1/4-28	.25	7 ft lbs		REMLS0187Z
1/4	1/4-28	.25	7 ft lbs		REMLS0250Z
5/16	1/4-28	.25	7 ft lbs		REMLS0312Z
3/8	3/8-24	.31	13 ft lbs		REMLS0375Z
7/16	3/8-24	.31	13 ft lbs		REMLS0437Z
1/2	7/16-20	.38	19 ft lbs		REMLS0500Z
9/16	7/16-20	.38	19 ft lbs		REMLS0562Z
5/8	9/16-18	.43	31 ft lbs		REMLS0625Z
3/4	5/8-18	.50	45 ft lbs		REMLS0750Z
7/8	5/8-18	.50	48 ft lbs		REMLS0875Z
1	3/4-16	.50	69 ft lbs		REMLS1000Z
1-1/4	3/4-16	.62	69 ft lbs		REMLS1250Z



HSK63A Facemill Holders

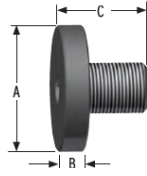
- Arbor pilot TIR <.0002"
- Compatible with all facemills
- Constructed of alloy steel
- Hardened to 56-60 Rc for long service life



HSK63A Facemill Holders

Taper	Arbor Size	D2	L1	G	Part #
HSK63A	3/4	1.75	2.38	.69	RHSK63ASM0750238Z
HSK63A	1	2.25	2.63	.69	RHSK63ASM1000263Z
HSK63A	1-1/4	2.75	2.63	.69	RHSK63ASM1250263Z
HSK63A	1-1/2	3.75	2.63	.94	RHSK63ASM1500263Z

Facemill Holder Replacement Lock Screws

Arbor Size	A	B	C	Thread	Hex	Torque	Photo	Dimensions	Part #
3/4	.88	.38	1.06	3/8-24	1/4	45 ft lbs			RSMLS0750Z
1	1.19	.28	1.12	1/2-20	5/16	60 ft lbs			RSMLS1000Z
1-1/4	1.50	.50	1.44	5/8-18	5/16	70 ft lbs			RSMLS1250Z
1-1/2	1.88	.50	1.75	3/4-16	3/8	75 ft lbs			RSMLS1500Z
3/4	.88	.38	.97	3/8-24	1/4	45 ft lbs			RSMSC0750Z *
1	1.19	.28	1.20	1/2-20	5/16	60 ft lbs			RSMSC1000Z *
1-1/2	1.88	.50	1.75	3/4-16	3/8	75 ft lbs			RSMSC1500Z *

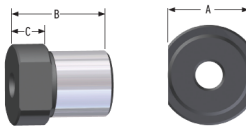
*Coolant Thru Option

Facemill Holder Replacement Socket Head Cap Screws

Arbor Size	A	B	C	Thread	Hex	Torque	Photo	Part #
3/4	.56	.37	1.37	3/8-24	5/16	45 ft lbs		RSMCS0750Z
1	.75	.50	1.75	1/2-20	3/8	60 ft lbs		RSMCS1000Z
1-1/4	.94	.62	1.87	5/8-18	1/2	70 ft lbs		RSMCS1250Z
3/4	.56	.37	1.37	1/2-20	5/16	45 ft lbs		RSMCSC0750Z *
1	.75	.50	1.75	3/8-24	3/8	60 ft lbs		RSMCSC1000Z *

*Coolant Thru Option

Facemill Holder Replacement Drive Keys

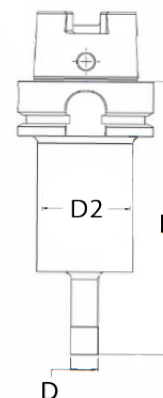
Arbor Size	A	B	C	Photo	Dimensions	Part #
3/4	.31	.52	.16			RSMDB0750Z
1	.38	.67	.19			RSMDB1000Z
1-1/4	.50	.86	.25			RSMDB1250Z
1-1/2	.62	1.04	.31			RSMDB1500Z

Probe Calibration Gage



HSK63A Probe Calibration Gage

- Works on all HSK63A spindle machines
- This tool is to be used as a standard for gage length and diameter
- Can be used to calibrate your table tool probe
- Can be kept in tool changer for periodic probe calibration
- All critical tool holder surfaces precision ground
- Made from alloy steel hardened to 54-56rc
- Individual calibration certificate is included with each tool holder
- Concentricity of gage diameter is .0001" or less

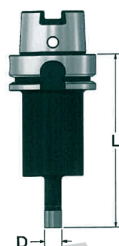


HSK63A Probe Calibration Gage

Taper	D	D2	L	Part #
HSK63A	.500	1.630	5.000	RHSK63ACA0500500Z

Calibration Certificate

PART NUMBER: RHSK63ACA0500500
 PART NAME: HSK63A CALIBRATION PROBE
 SERIAL NUMBER: SN-7364



Diameter (D) Dimension: 0.5004"

Length (L) Dimension: 5.0025"

Calibrated by: John E. Capozzuto
 Date: 1/23/2024

Temperature: 68.00 °F
 Humidity: 45.00 %

SAMPLE

RedLine Tools
 PERFORMANCE MATTERS

RedLine Tools: 15150 25th Avenue North
 Plymouth (Mpls.), MN 55447 • (800) 791-7542
www.redlinetools.com • support@redlinetools.com

The adapter covered by this certification has been calibrated with equipment or compared with master reference standards traceable to the National Institute of Standards and Technology (NIST), Washington D.C. Outside diameter & gage line length measurements within +/- .00006"

REGO-FIX® ER11 Collet Sets

Description	Part #	Photo
Fractional 7 pc Collet Set with tray; includes all sizes except 1/32"	1111.00002	
Metric 13 pc Collet Set with tray	1111.00000	

REGO-FIX® ER11 Fractional Collets

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/32	.0394-.0197	1.00-0.50	1111.01000	
1/16	.0625-.0425	1.59-1.09	1111.01592	
3/32	.0938-.0738	2.38-1.88	1111.02382	
1/8	.1250-.1050	3.18-2.68	1111.03182	
5/32	.1563-.1363	3.97-3.47	1111.03972	
3/16	.1875-.1675	4.76-4.26	1111.04762	
7/32	.2188-.1988	5.56-5.06	1111.05562	
1/4	.2500-.2300	6.35-5.85	1111.06352	

REGO-FIX® ER11 Metric Collets

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
1.00-0.50	.0394-.0197	1/32	1111.01000	
1.50-1.00	.0591-.0394	—	1111.01500	
2.00-1.50	.0787-.0591	1/16	1111.02000	
2.50-2.00	.0984-.0787	3/32	1111.02500	
3.00-2.50	.1181-.0984	—	1111.03000	
3.50-3.00	.1378-.1181	1/8	1111.03500	
4.00-3.50	.1575-.1378	5/32	1111.04000	
4.50-4.00	.1772-.1575	—	1111.04500	
5.00-4.50	.1969-.1772	3/16	1111.05000	
5.50-5.00	.2165-.1969	—	1111.05500	
6.00-5.50	.2362-.2165	7/32	1111.06000	
6.50-6.00	.2559-.2362	1/4	1111.06500	
7.00-6.50	.2756-.2559	—	1111.07000	



ER16 Collets

REGO-FIX® ER16 Collet Sets

Description	Part #	Photo
Fractional 12 pc Collet Set with tray; includes all sizes except 1/32"	1116.00002	
Fractional Metallic Sealed 5 pc Collet Set with tray; includes all sizes except 1/32"	1216.00002	
Metric 10 pc Collet Set with tray *Sizes that are included in sets- See page 593	1116.00000	
Metric Metallic Sealed 8 pc Collet Set with tray *See page 593	1216.00000	

REGO-FIX® ER16 Fractional Collets

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/32	.0394-.0197	1.00-0.50	1116.01000	
1/16	.0625-.0425	1.59-1.09	1116.01592	
3/32	.0938-.0738	2.38-1.88	1116.02382	
1/8	.1250-.0850	3.18-2.18	1116.03182	
5/32	.1563-.1163	3.97-2.97	1116.03972	
3/16	.1875-.1475	4.76-3.76	1116.04762	
7/32	.2188-.1788	5.56-4.56	1116.05562	
1/4	.2500-.2100	6.35-5.35	1116.06352	
9/32	.2813-.2413	7.14-6.14	1116.07142	
5/16	.3125-.2725	7.94-6.94	1116.07942	
11/32	.3438-.3038	8.73-7.73	1116.08732	
3/8	.3750-.3350	9.53-8.53	1116.09532	
13/32	.4063-.3663	10.32-9.32	1116.10322	

REGO-FIX® ER16 Fractional Metallic Sealed Collets (Good to 2000 psi)

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/8	.1250	3.18	1216.03182	
3/16	.1875	4.76	1216.04762	
1/4	.2500-.2303	6.35-5.85	1216.06352	
5/16	.3125-.2929	7.94-7.44	1216.07942	
3/8	.3750-.3556	9.53-9.03	1216.09532	



REGO-FIX® ER16 Metric Collets

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
1.00-0.50*	.0394-.0197	1/32	1116.01000	
1.50-1.00	.0591-.0394	—	1116.01500	
2.00-1.00*	.0787-.0394	1/16	1116.02000	
2.50-1.50	.0984-.0591	—	1116.02500	
3.00-2.00*	.1181-.0787	3/32	1116.03000	
3.50-2.50	.1378-.0984	—	1116.03500	
4.00-3.00*	.1575-.1181	1/8	1116.04000	
4.50-3.50	.1772-.1378	5/32	1116.04500	
5.00-4.00*	.1969-.1575	3/16	1116.05000	
5.50-4.50	.2165-.1772	—	1116.05500	
6.00-5.00*	.2362-.1969	7/32	1116.06000	
6.50-5.50	.2559-.2165	—	1116.06500	
7.00-6.00*	.2756-.2362	1/4	1116.07000	
7.50-6.50	.2953-.2559	—	1116.07500	
8.00-7.00*	.3150-.2756	9/32	1116.08000	
8.50-7.50	.3347-.2953	5/16	1116.08500	
9.00-8.00*	.3543-.3150	11/32	1116.09000	
9.50-8.50	.3740-.3347	—	1116.09500	
10.00-9.00*	.3937-.3543	3/8	1116.10000	

REGO-FIX® ER16 Metric Metallic Sealed Collets
(Good to 2000 psi)

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
3.00	.1181	—	1216.03000	
4.00	.1575	—	1216.04000	
5.00-4.50	.1969-.1772	3/16	1216.05000	
6.00-5.50	.2362-.2165	7/32	1216.06000	
7.00-6.50	.2756-.2559	—	1216.07000	
8.00-7.50	.3150-.2953	5/16	1216.08000	
9.00-8.50	.3543-.3347	11/32	1216.09000	
10.00-9.50	.3937-.3740	3/8	1216.10000	

* Represents items included in the Collet Set on page 592.



ER20 Collets

REGO-FIX® ER20 Collet Sets

Description	Part #	Photo
Fractional 7 pc Collet Set with tray; includes all sizes	1120.00002	
Fractional Metallic Sealed 7 pc Collet Set with tray; includes all sizes	1220.00002	
Metric 12 pc Collet Set with tray *Sizes that are included in sets - see page 595	1120.00000	
Metric Metallic Sealed 11 pc Collet Set with tray *Sizes that are included in sets - see page 595	1220.00000	

REGO-FIX® ER20 Fractional Collets

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/8	.1250-.0850	3.18-2.18	1120.03182	
3/16	.1875-.1475	4.76-3.76	1120.04762	
1/4	.2500-.2100	6.35-5.35	1120.06352	
5/16	.3125-.2725	7.94-6.94	1120.07942	
3/8	.3750-.3350	9.53-8.53	1120.09532	
7/16	.4375-.3975	11.11-10.11	1120.11112	
1/2	.5000-.4600	12.70-11.70	1120.12702	

REGO-FIX® ER20 Fractional Metallic Sealed Collets (Good to 2000 psi)

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/8	.1250	3.18	1220.03182	
3/16	.1875	4.76	1220.04762	
1/4	.2500	6.35	1220.06352	
5/16	.3125-.2929	7.94-7.44	1220.07942	
3/8	.3750-.3556	9.53-9.03	1220.09532	
7/16	.4375-.4177	11.11-10.61	1220.11112	
1/2	.5000-.4803	12.70-12.20	1220.12702	



REGO-FIX® ER20 Metric Collets

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
1.00-0.50	.0394-.0197	1/32	1120.01000	
1.50-1.00	.0591-.0394	—	1120.01500	
2.00-1.00*	.0787-.0394	1/16	1120.02000	
2.50-1.50	.0984-.0591	—	1120.02500	
3.00-2.00*	.1181-.0787	3/32	1120.03000	
3.50-2.50	.1378-.0984	—	1120.03500	
4.00-3.00*	.1575-.1181	1/8	1120.04000	
4.50-3.50	.1772-.1378	5/32	1120.04500	
5.00-4.00*	.1969-.1575	3/16	1120.05000	
5.50-4.50	.2165-.1772	—	1120.05500	
6.00-5.00*	.2362-.1969	7/32	1120.06000	
6.50-5.50	.2559-.2165	—	1120.06500	
7.00-6.00*	.2756-.2362	1/4	1120.07000	
7.50-6.50	.2953-.2559	9/32	1120.07500	
8.00-7.00*	.3150-.2756	5/16	1120.08000	
8.50-7.50	.3347-.2953	—	1120.08500	
9.00-8.00*	.3543-.3150	11/32	1120.09000	
9.50-8.50	.3740-.3347	—	1120.09500	
10.00-9.00*	.3937-.3543	3/8	1120.10000	
10.50-9.50	.4134-.3740	13/32	1120.10500	
11.00-10.00*	.4330-.3937	—	1120.11000	
11.50-10.50	.4528-.4134	7/16	1120.11500	
12.00-11.00*	.4724-.4330	15/32	1120.12000	
12.50-11.50	.4921-.4528	—	1120.12500	
13.00-12.00*	.5118-.4724	1/2	1120.13000	

REGO-FIX® ER20 Metric Metallic Sealed Collets

(Good to 2000 psi)

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
3.00	.1181	—	1220.03000	
4.00	.1575	—	1220.04000	
5.00	.1969	—	1220.05000	
6.00	.2362	—	1220.06000	
7.00-6.50	.2756-.2559	—	1220.07000	
8.00-7.50	.3150-.2653	9/32 & 5/16	1220.08000	
9.00-8.50	.3543-.3347	11/32	1220.09000	
10.00-9.50	.3937-.3740	3/8	1220.10000	
11.00-10.50	.4330-.4134	—	1220.11000	
12.00-11.50	.4724-.4528	15/32	1220.12000	
13.00-12.50	.5118-.4921	1/2	1220.13000	

* Represents items included in the Collet Set on page 594.



ER25 Collets

REGO-FIX® ER25 Collet Sets

Description	Part #	Photo
Fractional 9 pc Collet Set with tray; includes all sizes	1125.00002	
Fractional Metallic Sealed 7 pc Collet Set with tray; includes all sizes	1225.00002	
Metric 15 pc Collet Set with tray *Sizes that are included in sets - see page 597	1125.00000	
Metric Metallic Sealed 6 pc Collet Set with tray *Sizes that are included in sets - see page 597	1225.00000	

REGO-FIX® ER25 Fractional Collets

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/8	.1250-.0850	3.18-2.18	1125.03182	
3/16	.1875-.1475	4.76-3.76	1125.04762	
1/4	.2500-.2100	6.35-5.35	1125.06352	
5/16	.3125-.2725	7.94-6.94	1125.07942	
3/8	.3750-.3350	9.53-8.53	1125.09532	
7/16	.4375-.3975	11.11-10.11	1125.11112	
1/2	.5000-.4600	12.70-11.70	1125.12702	
9/16	.5625-.5225	14.29-13.29	1125.14292	
5/8	.6250-.5820	15.88-14.88	1125.15882	

REGO-FIX® ER25 Fractional Metallic Sealed Collets (Good to 2000 psi)

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/4	.2500	6.35	1225.06352	
5/16	.3125-.2929	7.94-7.44	1225.07942	
3/8	.3750-.3556	9.53-9.03	1225.09532	
7/16	.4375-.4177	11.11-10.61	1225.11112	
1/2	.5000-.4803	12.70-12.20	1225.12702	
9/16	.5625-.5425	14.29-13.79	1225.14292	
5/8	.6250-.6055	15.88-15.38	1225.15882	



REGO-FIX® ER25 Metric Collets

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
1.00-0.50	.0394-.0197	1/32	1125.01000	
1.50-1.00	.0591-.0394	—	1125.01500	
2.00-1.00*	.0787-.0394	1/16	1125.02000	
2.50-1.50	.0984-.0591	3/32	1125.02500	
3.00-2.00*	.1181-.0787	—	1125.03000	
3.50-2.50	.1378-.0984	1/8	1125.03500	
4.00-3.00*	.1575-.1181	5/32	1125.04000	
4.50-3.50	.1772-.1378	—	1125.04500	
5.00-4.00*	.1969-.1575	3/16	1125.05000	
5.50-4.50	.2165-.1772	—	1125.05500	
6.00-5.00*	.2362-.1969	7/32	1125.06000	
6.50-5.50	.2559-.2165	—	1125.06500	
7.00-6.00*	.2756-.2362	1/4	1125.07000	
7.50-6.50	.2953-.2559	9/32	1125.07500	
8.00-7.00*	.3150-.2756	5/16	1125.08000	
8.50-7.50	.3347-.2953	—	1125.08500	
9.00-8.00*	.3543-.3150	11/32	1125.09000	
9.50-8.50	.3740-.3347	—	1125.09500	
10.00-9.00*	.3937-.3543	3/8	1125.10000	
10.50-9.50	.4134-.3740	13/32	1125.10500	
11.00-10.00*	.4330-.3937	—	1125.11000	
11.50-10.50	.4528-.4134	7/16	1125.11500	
12.00-11.00*	.4724-.4330	15/32	1125.12000	
12.50-11.50	.4921-.4528	—	1125.12500	
13.00-12.00*	.5118-.4724	1/2	1125.13000	
13.50-12.50	.5315-.4921	—	1125.13500	
14.00-13.00*	.5512-.5118	17/32	1125.14000	
14.50-13.50	.5709-.5315	—	1125.14500	
15.00-14.00*	.5905-.5512	9/16	1125.15000	
15.50-14.50	.6102-.5709	19/32	1125.15500	
16.00-15.00*	.6300-.5905	5/8	1125.16000	

REGO-FIX® ER25 Metric Metallic Sealed Collets

(Good to 2000 psi)

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
6.00	.2362	—	1225.06000	
8.00-7.50	.3150-.2953	5/16	1225.08000	
10.00-9.50	.3937-.3740	3/8	1225.10000	
12.00-11.50	.4724-.4528	15/32	1225.12000	
14.00-13.50	.5512-.5315	—	1225.14000	
16.00-15.50	.6300-.6102	5/8	1225.16000	



* Represents items included in the Collet Set on page 596.

ER32 Collets

REGO-FIX® ER32 Collet Sets

Description	Part #	Photo
Fractional 12 pc Collet Set with tray; includes all sizes	1132.00002	
Fractional Metallic Sealed 9 pc Collet Set with tray; includes all sizes	1232.00002	
Metric 18 pc Collet Set with tray *Sizes that are included in sets - see page 599.	1132.00000	
Metric Metallic Sealed 8 pc Collet Set with tray - see page 599.	1232.00000	

REGO-FIX® ER32 Fractional Collets

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/8	.1250-.0850	3.18-2.18	1132.03182	
3/16	.1875-.1475	4.76-3.76	1132.04762	
1/4	.2500-.2100	6.35-5.35	1132.06352	
5/16	.3125-.2725	7.94-6.94	1132.07942	
3/8	.3750-.3350	9.53-8.53	1132.09532	
7/16	.4375-.3975	11.11-10.11	1132.11112	
1/2	.5000-.4600	12.70-11.70	1132.12702	
9/16	.5625-.5225	14.29-13.29	1132.14292	
5/8	.6250-.5820	15.88-14.88	1132.15882	
11/16	.6875-.6475	17.46-16.46	1132.17462	
3/4	.7500-.7100	19.05-18.05	1132.19052	
13/16	.8125-.7725	20.64-19.64	1132.20642	

REGO-FIX® ER32 Fractional Metallic Sealed Collets (Good to 2000 psi)

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/4	.2500	6.35	1232.06352	
5/16	.3125-.2929	7.94-7.44	1232.07942	
3/8	.3750-.3556	9.53-9.03	1232.09532	
7/16	.4375-.4177	11.11-10.61	1232.11112	
1/2	.5000-.4803	12.70-12.20	1232.12702	
9/16	.5625-.5425	14.29-13.79	1232.14292	
5/8	.6250-.6055	15.88-15.38	1232.15882	
11/16	.6875-.6677	17.46-16.96	1232.17462	
3/4	.7500-.7303	19.05-18.55	1232.19052	



REGO-FIX® ER32 Metric Collets

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
2.00-1.00	.0787-.0394	1/16	1132.02000	
2.50-1.50	.0984-.0591	—	1132.02500	
3.00-2.00*	.1181-.0787	3/32	1132.03000	
3.50-2.50	.1378-.0984	—	1132.03500	
4.00-3.00*	.1575-.1181	1/8	1132.04000	
4.50-3.50	.1772-.1378	5/32	1132.04500	
5.00-4.00*	.1969-.1575	3/16	1132.05000	
5.50-4.50	.2165-.1772	—	1132.05500	
6.00-5.00*	.2362-.1969	7/32	1132.06000	
6.50-5.50	.2559-.2165	—	1132.06500	
7.00-6.00*	.2756-.2362	1/4	1132.07000	
7.50-6.50	.2953-.2559	9/32	1132.07500	
8.00-7.00*	.3150-.2756	5/16	1132.08000	
8.50-7.50	.3347-.2953	—	1132.08500	
9.00-8.00*	.3543-.3150	11/32	1132.09000	
9.50-8.50	.3740-.3347	—	1132.09500	
10.00-9.00*	.3937-.3543	3/8	1132.10000	
10.50-9.50	.4134-.3740	13/32	1132.10500	
11.00-10.00*	.4330-.3937	—	1132.11000	
11.50-10.50	.4528-.4134	—	1132.11500	
12.00-11.00*	.4724-.4330	7/16	1132.12000	
12.50-11.50	.4921-.4528	15/32	1132.12500	
13.00-12.00*	.5118-.4724	1/2	1132.13000	
13.50-12.50	.5315-.4921	17/32	1132.13500	
14.00-13.00*	.5512-.5118	—	1132.14000	
14.50-13.50	.5709-.5315	—	1132.14500	
15.00-14.00*	.5905-.5512	9/16	1132.15000	
15.50-14.50	.6102-.5709	19/32	1132.15500	
16.00-15.00*	.6300-.5905	5/8	1132.16000	
16.50-15.50	.6496-.6102	—	1132.16500	
17.00-16.00*	.6693-.6300	21/32	1132.17000	
17.50-16.50	.6890-.6496	—	1132.17500	
18.00-17.00*	.7087-.6693	11/16	1132.18000	
18.50-17.50	.7284-.6890	23/32	1132.18500	
19.00-18.00*	.7480-.7087	—	1132.19000	
19.50-18.50	.7677-.7284	—	1132.19500	
20.00-19.00*	.7874-.7480	3/4 & 25/32	1132.20000	

REGO-FIX® ER32 Metric Metallic Sealed Collets (Good to 2000 psi)

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
6.00	.2362	—	1232.06000	
8.00-7.50	.3150-.2953	5/16	1232.08000	
10.00-9.50	.3937-.3740	3/8	1232.10000	
12.00-11.50	.4724-.4528	15/32	1232.12000	
14.00-13.50	.5512-.5315	—	1232.14000	
16.00-15.50	.6300-.6102	5/8	1232.16000	
18.00-17.50	.7087-.6890	11/16	1232.18000	
20.00-19.50	.7874-.7677	25/32	1232.20000	

* Represents items included in the Collet Set on page 598.



ER40 Collets

REGO-FIX® ER40 Collet Sets

Description	Part #	Photo
Fractional 14 pc Collet Set with tray; includes all sizes	1140.00002	
Fractional Metallic Sealed 10 pc Collet Set with tray; includes all sizes	1240.00002	
Metric 23 pc Collet Set with tray *Sizes that are included in sets - see page 601	1140.00000	
Metric Metallic Sealed 12 pc Collet Set with tray; includes all sizes - see page 602	1240.00000	

REGO-FIX® ER40 Fractional Collets

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
1/8	.1250-.0850	3.18-2.18	1140.03182	
3/16	.1875-.1475	4.76-3.76	1140.04762	
1/4	.2500-.2100	6.35-5.35	1140.06352	
5/16	.3125-.2725	7.94-6.94	1140.07942	
3/8	.3750-.3350	9.53-8.53	1140.09532	
7/16	.4375-.3975	11.11-10.11	1140.11112	
1/2	.5000-.4600	12.70-11.70	1140.12702	
9/16	.5625-.5225	14.29-13.29	1140.14292	
5/8	.6250-.5850	15.88-14.88	1140.15882	
11/16	.6875-.6475	17.46-16.46	1140.17462	
3/4	.7500-.7100	19.05-18.05	1140.19052	
13/16	.8125-.7725	20.64-19.64	1140.20642	
7/8	.8750-.8350	22.23-21.23	1140.22232	
1	1.000-.9600	25.40-24.40	1140.25402	

REGO-FIX® ER40 Fractional Metallic Sealed Collets (Good to 2000 psi)

ø (Inch)	Range (Inch)	Range (mm)	Part #	Photo
3/8	.3750-.3556	9.53-9.03	1240.09532	
7/16	.4375-.4177	11.11-10.61	1240.11112	
1/2	.5000-.4803	12.70-12.20	1240.12702	
9/16	.5625-.5425	14.29-13.79	1240.14292	
5/8	.6250-.6055	15.88-15.38	1240.15882	
11/16	.6875-.6677	17.46-16.96	1240.17462	
3/4	.7500-.7303	19.05-18.55	1240.19052	
13/16	.8125-.7929	20.64-20.14	1240.20642	
7/8	.8750-.8555	22.23-21.73	1240.22232	
1	1.0000-.9803	25.40-24.90	1240.25402	



REGO-FIX® ER40 Metric Collets

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
3.00-2.00	.1181-.0787	3/32	1140.03000	
3.50-2.50	.1378-.0984	—	1140.03500	
4.00-3.00*	.1575-.1181	1/8	1140.04000	
4.50-3.50	.1772-.1378	5/32	1140.04500	
5.00-4.00*	.1969-.1575	3/16	1140.05000	
5.50-4.50	.2165-.1772	—	1140.05500	
6.00-5.00*	.2362-.1969	7/32	1140.06000	
6.50-5.50	.2559-.2165	—	1140.06500	
7.00-6.00*	.2756-.2362	1/4	1140.07000	
7.50-6.50	.2953-.2559	9/32	1140.07500	
8.00-7.00*	.3150-.2756	5/16	1140.08000	
8.50-7.50	.3347-.2953	—	1140.08500	
9.00-8.00*	.3543-.3150	11/32	1140.09000	
9.50-8.50	.3740-.3347	—	1140.09500	
10.00-9.00*	.3937-.3543	3/8	1140.10000	
10.50-9.50	.4134-.3740	13/32	1140.10500	
11.00-10.00*	.4330-.3937	—	1140.11000	
11.50-10.50	.4528-.4134	—	1140.11500	
12.00-11.00*	.4724-.4330	7/16	1140.12000	
12.50-11.50	.4921-.4528	15/32	1140.12500	
13.00-12.00*	.5118-.4724	1/2	1140.13000	
13.50-12.50	.5315-.4921	17/32	1140.13500	
14.00-13.00*	.5512-.5118	—	1140.14000	
14.50-13.50	.5709-.5315	—	1140.14500	
15.00-14.00*	.5905-.5512	9/16	1140.15000	
15.50-14.50	.6102-.5709	19/32	1140.15500	
16.00-15.00*	.6300-.5905	5/8	1140.16000	
16.50-15.50	.6496-.6102	—	1140.16500	
17.00-16.00*	.6693-.6300	21/32	1140.17000	
17.50-16.50	.6890-.6496	—	1140.17500	
18.00-17.00*	.7087-.6693	11/16	1140.18000	
18.50-17.50	.7284-.6890	23/32	1140.18500	
19.00-18.00*	.7480-.7087	—	1140.19000	
19.50-18.50	.7677-.7284	—	1140.19500	
20.00-19.00*	.7874-.7480	3/4 & 25/32	1140.20000	
20.50-19.50	.8071-.7677	—	1140.20500	
21.00-20.00*	.8268-.7874	13/16	1140.21000	
21.50-20.50	.8465-.8071	27/32	1140.21500	
22.00-21.00*	.8661-.8268	—	1140.22000	
22.50-21.50	.8858-.8465	7/8	1140.22500	
23.00-22.00*	.9055-.8661	—	1140.23000	
23.50-22.50	.9252-.8858	29/32	1140.23500	
24.00-23.00*	.9449-.9055	15/16	1140.24000	
24.50-23.50	.9646-.9252	—	1140.24500	
25.00-24.00*	.9843-.9449	31/32	1140.25000	
25.50-24.50	1.0039-.9646	1	1140.25500	
26.00-25.00*	1.0236-.9843	—	1140.26000	
27.00-26.00	1.0630-1.0236	1-1/16	1140.27000	
28.00-27.00	1.1024-1.0630	1-3/32	1140.28000	
29.00-28.00	1.1417-1.1024	1-1/8	1140.29000	
30.00-29.00	1.1811-1.1417	1-5/32	1140.30000	

* Represents items included in the Collet Set on page 600.



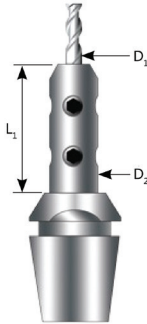
ER40 Collets

REGO-FIX[®] ER40 Metric Metallic Sealed Collets

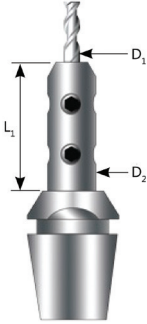
(Good to 2000 psi)

Range (mm)	Range (Inch)	ø (Inch)	Part #	Photo
6.00	.2362	—	1240.06000	
8.00	.3150	—	1240.08000	
10.00-9.50	.3937-.3740	3/8	1240.10000	
12.00-11.50	.4724-.4528	15/32	1240.12000	
14.00-13.50	.5512-.5315	—	1240.14000	
16.00-15.50	.6300-.6102	5/8	1240.16000	
18.00-17.50	.7087-.6890	—	1240.18000	
20.00-19.50	.7874-.7677	25/32	1240.20000	
22.00-21.50	.8661-.8465	—	1240.22000	
24.00-23.50	.9449-.9252	15/16	1240.24000	
25.00-24.50	.9843-.9646	31/32	1240.25000	
26.00-25.50	1.0236-1.0039	—	1240.26000	

ER11 Small Tool Adapter for Milling & Boring

Bore Ø D1	Neck Ext. Ø D2	Ext. Length L1	Taper	Part #	Photo	Dimensions
.1181 (3mm)	.315 (8mm)	.394 (10mm)	ER11	RA1000		
.1181 (3mm)	.315 (8mm)	.590 (15mm)	ER11	RA1001		
.1181 (3mm)	.315 (8mm)	.787 (20mm)	ER11	RA1002		
.1250 (1/8)	.315 (8mm)	.394 (10mm)	ER11	RA1006		
.1250 (1/8)	.315 (8mm)	.590 (15mm)	ER11	RA1007		
.1250 (1/8)	.315 (8mm)	.787 (20mm)	ER11	RA1008		
.1574 (4mm)	.315 (8mm)	.787 (20mm)	ER11	RA1010		

ER16 Small Tool Adapter for Milling & Boring

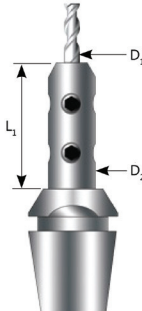
Bore Ø D1	Neck Ext. Ø D2	Ext. Length L1	Taper	Part #	Photo	Dimensions
.1181 (3mm)	.374 (9.5mm)	.630 (16mm)	ER16	RA1014		
.1181 (3mm)	.374 (9.5mm)	.984 (25mm)	ER16	RA1015		
.1250 (1/8)	.374 (9.5mm)	.630 (16mm)	ER16	RA1018		
.1250 (1/8)	.374 (9.5mm)	.984 (25mm)	ER16	RA1019		
.1574 (4mm)	.374 (9.5mm)	.630 (16mm)	ER16	RA1022		
.1574 (4mm)	.374 (9.5mm)	.984 (25mm)	ER16	RA1023		
.1875 (3/16)	.374 (9.5mm)	.630 (16mm)	ER16	RA1026		
.1875 (3/16)	.374 (9.5mm)	.984 (25mm)	ER16	RA1027		
.1969 (5mm)	.374 (9.5mm)	.630 (16mm)	ER16	RA1032		
.1969 (5mm)	.374 (9.5mm)	.984 (25mm)	ER16	RA1033		

Replacement Hardware for Small Tool Milling and Boring Adapters

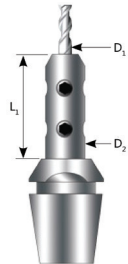
Type	Description	Part #
M3 X .5 X 3	Socket Head Set Screws Stainless	RA1050
M6 X 1.0 X 5	Socket Head Stop Screw	RA1051
M8 X 1.25 X 8	Socket Head Stop Screw	RA1054

Small Tool Adapters

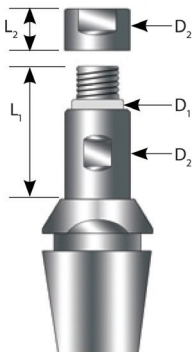
ER20 Small Tool Adapter for Milling & Boring

Bore Ø D1	Neck Ext. Ø D2	Ext. Length L1	Taper	Part #	Photo	Dimensions
.1181 (3mm)	.374 (9.5MM)	.984 (25mm)	ER20	RA1040		
.1250 (1/8)	.374 (9.5MM)	.630 (16mm)	ER20	RA1041		
.1250 (1/8)	.374 (9.5MM)	.984 (25mm)	ER20	RA1042		
.1575 (4mm)	.374 (9.5MM)	.630 (16mm)	ER20	RA1043		
.1575 (4mm)	.374 (9.5MM)	.984 (25mm)	ER20	RA1044		
.1875 (3/16)	.449 (11.4)	.551 (14mm)	ER20	RA1055		
.1875 (3/16)	.449 (11.4)	.630 (16mm)	ER20	RA1056		
.1875 (3/16)	.449 (11.4)	.984 (25mm)	ER20	RA1057		
.1969 (5mm)	.449 (11.4)	.551 (14mm)	ER20	RA1058		
.1969 (5mm)	.449 (11.4)	.984 (25mm)	ER20	RA1059		
.2362 (6mm)	.492 (12.5)	.551 (14mm)	ER20	RA1060		
.2362 (6mm)	.492 (12.5)	.984 (25mm)	ER20	RA1061		
.2500 (1/4)	.492 (12.5)	.551 (14mm)	ER20	RA1062		
.2500 (1/4)	.492 (12.5)	.984 (25mm)	ER20	RA1063		

ER25 Small Tool Adapter for Milling & Boring

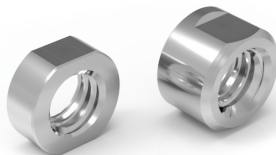
Bore Ø D1	Neck Ext. Ø D2	Ext. Length L1	Taper	Part #	Photo	Dimensions
.1181 (3mm)	.394 (10mm)	.984 (25mm)	ER25	RA1070		
.1250 (1/8)	.394 (10mm)	.984 (25mm)	ER25	RA1071		
.1575 (4mm)	.394 (10mm)	.984 (25mm)	ER25	RA1072		
.1875 (3/16)	.492 (12.5)	.984 (25mm)	ER25	RA1073		
.1969 (5mm)	.492 (12.5)	.984 (25mm)	ER25	RA1074		
.2362 (6mm)	.492 (12.5)	.984 (25mm)	ER25	RA1075		
.2756 (7mm)	.630 (16mm)	.984 (25mm)	ER25	RA1076		
.3125 (5/16)	.630 (16mm)	.984 (25mm)	ER25	RA1077		
.3150 (8mm)	.630 (16mm)	.984 (25mm)	ER25	RA1078		

ER16 Small Tool Adapter for Sawing

Pilot Dia D1	Nut Dia D2	Ext. Length L1	Nut Length L2	Thread	Taper	Part #	Photo	Dimensions
.1181 (3mm)	.252 (6.4mm)	.984 (25mm)	.354 (9mm)	M3X.5	ER16	RA2000	 	
.1181 (3mm)	.252 (6.4mm)	1.260 (32mm)	.354 (9mm)	M3X.5	ER16	RA2001		
.1250 (1/8)	.252 (6.4mm)	.984 (25mm)	.354 (9mm)	M3X.5	ER16	RA2004		
.1250 (1/8)	.252 (6.4mm)	1.260 (32mm)	.354 (9mm)	M3X.5	ER16	RA2005		
.1875 (3/16)	.374 (9.5mm)	.984 (25mm)	.354 (9mm)	10-32	ER16	RA2008		
.1875 (3/16)	.374 (9.5mm)	1.260 (32mm)	.354 (9mm)	10-32	ER16	RA2009		
.1969 (5mm)	.374 (9.5mm)	.984 (25mm)	.354 (9mm)	M5X.8	ER16	RA2012		
.1969 (5mm)	.374 (9.5mm)	1.260 (32mm)	.354 (9mm)	M5X.8	ER16	RA2013		
.2362 (6mm)	.374 (9.5mm)	.984 (25mm)	.354 (9mm)	M6X1	ER16	RA2016		
.2362 (6mm)	.374 (9.5mm)	1.260 (32mm)	.354 (9mm)	M6X1	ER16	RA2017		
.2500 (1/4)	.374 (9.5mm)	.984 (25mm)	.354 (9mm)	1/4-32	ER16	RA2020		
.2500 (1/4)	.374 (9.5mm)	1.260 (32mm)	.354 (9mm)	1/4-32	ER16	RA2021		
.3125 (5/16)	.394 (10mm)	.984 (25mm)	.354 (9mm)	5/16-32	ER16	RA2024		
.3125 (5/16)	.394 (10mm)	1.260 (32mm)	.354 (9mm)	5/16-32	ER16	RA2025		
.3150 (8mm)	.394 (10mm)	.984 (25mm)	.354 (9mm)	5/16-32	ER16	RA2028		
.3150 (8mm)	.394 (10mm)	1.260 (32mm)	.354 (9mm)	5/16-32	ER16	RA2029		

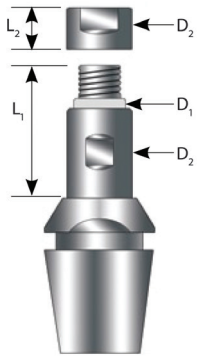
Note: Recommended MAX. SAW THICKNESS: ~2mm / .080"

Small Tool Saw Adapter Spare Arbor Nuts

Description	Nut Diameter	Nut Thickness	Type	Part #	Dimensions
M3X.5 Arbor Jam Nut	.240 (6.0mm)	.118 (2.9mm)	1	RA2040	 Type 1 Type 2
M3X.5 Arbor Nut	.252 (6.4mm)	.354 (9mm)	2	RA2050	
10-32 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2041	
10-32 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2051	
M5X.8 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2042	
M5X.8 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2052	
M6X1 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2043	
M6X1 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2053	
1/4-32 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2044	
1/4-32 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2054	
5/16-32 Arbor Jam Nut	.384 (9.7mm)	.118 (2.9mm)	1	RA5045	
5/16-32 Arbor Nut	.394 (10mm)	.354 (9mm)	2	RA2055	

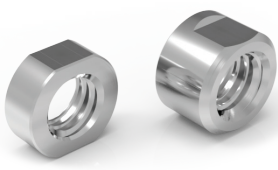
Saw Adapters

ER20 Small Tool Adapter for Sawing

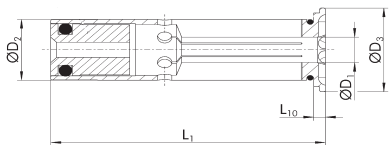
Pilot Dia D1	Nut Dia D2	Ext. Length L1	Nut Length L2	Thread	Taper	Part #	Photo	Dimensions
.118 (3.00mm)	.250 (6.35mm)	.709 (18mm)	.250 (6.35mm)	M3x.5	ER20	RA2070		
.118 (3.00mm)	.250 (6.35mm)	1.180 (30mm)	.250 (6.35mm)	M3x.5	ER20	RA2071		
.125 (3.18mm)	.250 (6.35mm)	.709 (18mm)	.250 (6.35mm)	M3x.5	ER20	RA2072		
.125 (3.18mm)	.250 (6.35mm)	1.180 (30mm)	.250 (6.35mm)	M3x.5	ER20	RA2073		
.187 (4.76mm)	.375 (9.53mm)	.709 (18mm)	.250 (6.35mm)	3/16-32	ER20	RA2074		
.187 (4.76mm)	.375 (9.53mm)	1.180 (30mm)	.250 (6.35mm)	3/16-32	ER20	RA2075		
.197 (5.00mm)	.375 (9.53mm)	.709 (18mm)	.250 (6.35mm)	3/16-32	ER20	RA2076		
.197 (5.00mm)	.375 (9.53mm)	1.180 (30mm)	.250 (6.35mm)	3/16-32	ER20	RA2077		
.236 (6.00mm)	.375 (9.53mm)	.709 (18mm)	.250 (6.35mm)	M6x1	ER20	RA2078		
.236 (6.00mm)	.375 (9.53mm)	1.180 (30mm)	.250 (6.35mm)	M6x1	ER20	RA2079		
.250 (6.35mm)	.375 (9.53mm)	.709 (18mm)	.250 (6.35mm)	1/4-32	ER20	RA2080		
.250 (6.35mm)	.375 (9.53mm)	1.180 (30mm)	.250 (6.35mm)	1/4-32	ER20	RA2081		
.312 (7.94mm)	.375 (9.50mm)	.709 (18mm)	.250 (6.35mm)	5/16-32	ER20	RA2082		
.312 (7.94mm)	.375 (9.53mm)	1.180 (30mm)	.250 (6.35mm)	5/16-32	ER20	RA2083		
.315 (8.00mm)	.394 (10.00mm)	.709 (18mm)	.250 (6.35mm)	5/16-32	ER20	RA2084		
.315 (8.00mm)	.394 (10.00mm)	1.180 (30mm)	.250 (6.35mm)	5/16-32	ER20	RA2085		
.375 (9.52mm)	.492 (12.00mm)	.709 (18mm)	.276 (7.00mm)	3/8-32	ER20	RA2086		
.375 (9.52mm)	.492 (12.00mm)	1.180 (30mm)	.276 (7.00mm)	3/8-32	ER20	RA2087		
.394 (10.00mm)	.492 (12.00mm)	.709 (18mm)	.276 (7.00mm)	3/8-32	ER20	RA2088		
.394 (10.00mm)	.492 (12.00mm)	1.180 (30mm)	.276 (7.00mm)	3/8-32	ER20	RA2089		

Note: Recommended MAX. SAW THICKNESS: ~2mm / .080"

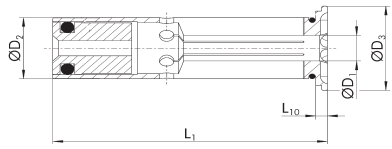
Small Tool Saw Adapter Spare Arbor Nuts

Description	Nut Diameter	Nut Thickness	Type	Part #	Dimensions
M3X.5 Arbor Jam Nut	.240 (6.0mm)	.118 (2.9mm)	1	RA2040	
M3X.5 Arbor Nut	.252 (6.4mm)	.354 (9mm)	2	RA2050	
10-32 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2041	
10-32 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2051	
M5X.8 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2042	
M5X.8 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2052	
M6X1 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2043	
M6X1 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2053	
1/4-32 Arbor Jam Nut	.365 (9.2mm)	.118 (2.9mm)	1	RA2044	
1/4-32 Arbor Nut	.374 (9.5mm)	.354 (9mm)	2	RA2054	
5/16-32 Arbor Jam Nut	.384 (9.7mm)	.118 (2.9mm)	1	RA5045	
5/16-32 Arbor Nut	.394 (10mm)	.354 (9mm)	2	RA2055	

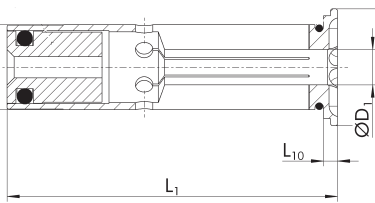
SCHUNK 1/2" Hydraulic Chuck Sleeves Coolant Sealed & Coolant Flush Metric

Bore Ø Metric D1	D2	D3	L1	L10	Coolant Sealed Part #	Coolant Flush Part #	Photo	Dimensions
3mm (.1181)	1/2	16.5	45	2	0224381	—		
4mm (.1575)	1/2	16.5	45	2	0224382	—		
5mm (.1969)	1/2	16.5	45	2	0224383	0217383		
6mm (.2362)	1/2	16.5	45	2	0224384	0217384		
8mm (.3150)	1/2	16.5	45	2	0224385	—		

SCHUNK 1/2" Hydraulic Chuck Sleeves Coolant Sealed & Coolant Flush Fractional

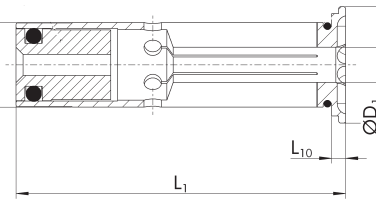
Bore Ø Inch D1	D2	D3	L1	L10	Coolant Sealed Part #	Coolant Flush Part #	Photo	Dimensions
1/8	1/2	16.5	45	2	0224376	0217376		
3/16	1/2	16.5	45	2	0224377	0217377		
1/4	1/2	16.5	45	2	0224378	0217378		
5/16	1/2	16.5	45	2	0224379	0217379		
3/8	1/2	16.5	45	2	0224380	0217380		

SCHUNK 3/4" Hydraulic Chuck Sleeves Coolant Sealed & Coolant Flush Fractional

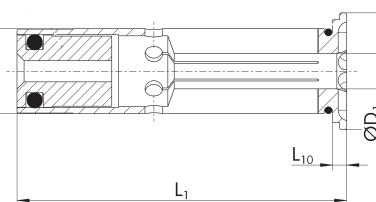
Bore Ø Inch D1	D2	D3	L1	L10	Coolant Sealed Part #	Coolant Flush Part #	Photo	Dimensions
1/8	3/4	24.0	50.5	2.0	0224386	0217960		
3/16	3/4	24.0	50.5	2.0	0224387	0217961		
1/4	3/4	24.0	50.5	2.0	0224388	0217962		
5/16	3/4	24.0	50.5	2.0	0224389	0217963		
3/8	3/4	24.0	50.5	2.0	0224390	0217964		
7/16	3/4	24.0	50.5	2.0	0224391	0217965		
1/2	3/4	24.0	50.5	2.0	0224392	0217966		
9/16	3/4	24.0	50.5	2.0	0224393	0217967		
5/8	3/4	24.0	50.5	2.0	0224394	0217968		

Hydraulic Chuck Sleeves

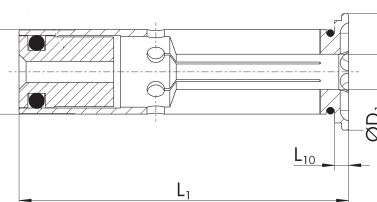
SCHUNK 3/4" Hydraulic Chuck Sleeves Coolant Sealed & Coolant Flush Metric

Bore Ø Metric D1	D2	D3	L1	L10	Coolant Sealed Part #	Coolant Flush Part #	Photo	Dimensions
3mm (.1181)	3/4	24.0	50.5	2.0	0224395	0217969		
4mm (.1575)	3/4	24.0	50.5	2.0	0224396	0217970		
5mm (.1969)	3/4	24.0	50.5	2.0	0224397	0217971		
6mm (.2362)	3/4	24.0	50.5	2.0	0224398	0217972		
8mm (.3150)	3/4	24.0	50.5	2.0	0224399	0217973		
10mm (.3937)	3/4	24.0	50.5	2.0	0224400	0217974		
12mm (.4724)	3/4	24.0	50.5	2.0	0224401	0217975		
14mm (.5512)	3/4	24.0	50.5	2.0	0224402	0217976		

SCHUNK 1-1/4" Hydraulic Chuck Sleeves Coolant Sealed & Coolant Flush Fractional

Bore Ø Inch D1	D2	D3	L1	L10	Coolant Sealed Part #	Coolant Flush Part #	Photo	Dimensions
1/4	1-1/4	35.5	60.5	3.0	0224404	0217980		
5/16	1-1/4	35.5	60.5	3.0	0224405	0217981		
3/8	1-1/4	35.5	60.5	3.0	0224406	0217982		
7/16	1-1/4	35.5	60.5	3.0	0224407	—		
1/2	1-1/4	35.5	60.5	3.0	0224408	0217984		
9/16	1-1/4	35.5	60.5	3.0	0224409	0217985		
5/8	1-1/4	35.5	60.5	3.0	0224410	0217986		
11/16	1-1/4	35.5	60.5	3.0	0224411	0217987		
3/4	1-1/4	35.5	60.5	3.0	0224412	0217988		
13/16	1-1/4	35.5	60.5	3.0	0224413	—		
7/8	1-1/4	35.5	60.5	3.0	0224414	0217990		
15/16	1-1/4	35.5	60.5	3.0	0224415	—		
1	1-1/4	35.5	60.5	3.0	0224416	0217992		

SCHUNK 1-1/4" Hydraulic Chuck Sleeves Coolant Sealed & Coolant Flush Metric

Bore Ø Metric D1	D2	D3	L1	L10	Coolant Sealed Part #	Coolant Flush Part #	Photo	Dimensions
8mm (.3150)	1-1/4	35.5	60.5	3.0	0224421	—		
10mm (.3937)	1-1/4	35.5	60.5	3.0	0224422	—		
12mm (.4724)	1-1/4	35.5	60.5	3.0	0224423	—		
14mm (.5512)	1-1/4	35.5	60.5	3.0	0224424	—		
16mm (.6299)	1-1/4	35.5	60.5	3.0	0224425	—		
18mm (.7087)	1-1/4	35.5	60.5	3.0	0224426	—		
20mm (.7874)	1-1/4	35.5	60.5	3.0	0224427	0218010		
25mm (.9843)	1-1/4	35.5	60.5	3.0	0224428	0218011		

BILZ #1 Tap Collets

Tap Size	Shank ø	Square	Part #	Photo
#0-6	.141	.110	21-100-019	
#8	.168	.131	21-100-027	
#10	.194	.152	21-100-038	
#12	.220	.165	21-100-046	
1/4 (M6)	.255	.191	21-100-063	
5/16 (M8)	.318	.238	21-100-089	
3/8 (M10)	.381	.286	21-100-112	
7/16	.323	.242	21-100-091	
1/2 (M12)	.367	.275	21-100-105	
9/16	.429	.322	21-100-119	
1/16 Pipe	.313	.234	21-100-081	
1/8 Pipe*	.437	.328	21-100-124	
Set includes one of each of the above EXCEPT 1/8 pipe.			21-100-SET	

* Large Shank

BILZ #2 Tap Collets

Tap Size	Shank ø	Square	Part #	Photo
1/4 (M6)	.255	.191	22-100-010	
5/16 (M8)	.318	.238	22-100-022	
3/8 (M10)	.381	.286	22-100-040	
7/16	.323	.242	22-100-023	
1/2 (M12)	.367	.275	22-100-033	
9/16	.429	.322	22-100-043	
5/8	.480	.360	22-100-058	
11/16	.542	.406	22-100-067	
3/4	.590	.442	22-100-147	
13/16	.652	.489	22-100-089	
7/8	.697	.523	22-100-093	
1/8 Pipe	.437	.328	22-102-016	
1/4 Pipe	.562	.421	22-102-002	
3/8 Pipe	.700	.531	22-102-005	
1/2 Pipe*	.687	.515	22-102-004	
Set includes one of each of the above EXCEPT 11/16, 13/16 and 7/8.			22-100-SET	

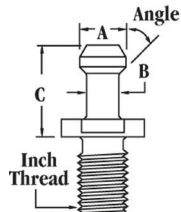
* Large Shank

BILZ #3 Tap Collets

Tap Size	Shank ø	Square	Part #	Photo
3/4	.590	.442	23-100-013	
13/16 (M20)	.652	.489	23-100-018	
7/8 (M22)	.697	.523	23-100-021	
15/16 (M24)	.760	.570	23-100-028	
1 (M25)	.800	.600	23-100-031	
1-1/8	.896	.672	23-100-038	
1-1/4	1.021	.766	23-100-045	
1-3/8	1.108	.831	23-100-053	
3/8 Pipe	.700	.531	23-102-035	
1/2 Pipe	.688	.515	23-102-049	
3/4 Pipe	.906	.679	23-102-004	
1 Pipe	1.125	.843	23-102-007	
Set includes one of each of the above.			23-100-SET	

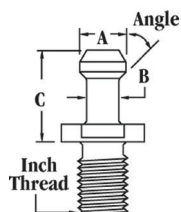
CAT40 Standard Retention Knobs

All retention knobs are compatible with all Haas CAT40 spindles. Retention knobs are also compatible with other manufacturers - please check your machine specifications to see if they are compatible with your equipment.

Machine Type	A	B	C	Angle	Thread Size	Hole ø	Torque Ft/lbs	Part #	Photo	Dimensions
Haas	.590	.390	1.270	45	5/8-11	—	50	RC4HRKZ		
Haas	.590	.390	1.270	45	5/8-11	.190	50	RC4HRKCZ		

CAT50 Standard Retention Knobs

All retention knobs are compatible with all Haas CAT50 spindles. Retention knobs are also compatible with other manufacturers - please check your machine specifications to see if they are compatible with your equipment.

Machine Type	A	B	C	Angle	Thread Size	Hole ø	Torque Ft/lbs	Part #	Photo	Dimensions
Haas	.910	.670	1.780	45	1-8	—	75	RC5HRKZ		
Haas	.910	.670	1.780	45	1-8	.310	75	RC5HRKCZ		

Swivel Tightening Fixtures

Swivels to vertical and horizontal orientation. Mounts directly to workbench. Compatible with BT30, CAT40, BT40, CAT50, BT50, HSK63A AND HSK100A.

Taper Size	Photo	Part #
BT30		RSTF30Z
CAT40, BT40		RSTF40Z
CAT50, BT50		RSTF50Z
HSK63A		RSTFHSK63AZ
HSK100A		RSTFHSK100AZ



PRODUCT FEATURES

- Connect to power and air and change tools in 5 minutes or less.
- Includes all 4 induction rings listed below.
- Includes toolholder adapter discs for **40 Taper, PSC6 and HSK63**
- CAT50 AND HSK100 are built into the machine. No adapter required.
- The **OPTIONAL Toolholder Adapter Disk Pack** includes toolholder adapter discs for the following spindle adaptations - BT30, 40 Taper, HSK 40/50/63 and PSC4/PSC5/PSC6 (Not Sold Individually)
- Tools with up to 11" Gage Lengths can be accommodated.
- Easy to use touch screen adjustments for temp and time settings.
- Cooling Cycle uses 90 PSI shop air to cool the holder for safe handling.

MACHINE SPECIFICATIONS

Tool Diameter	Power	L x D x H	Ship Wt	Part #
1/8"-1-1/4"	208-240VAC, single phase, 30A, NEMA L6-30P	16" x 16" x 22"	70 lbs	RSFM10
1/8"-1-1/4"	208-240VAC, 3 phase, 30A, NEMA L15-30P	16" x 16" x 22"	70 lbs	RSFM20

Accessories	Item #
Thermal Insulated Glove	RTIG01
Induction Ring (3MM-5MM)	RIR0305
Induction Ring (6MM-12MM)	RIR0612
Induction Ring (14MM-20MM)	RIR1420
Induction Ring (25MM-32MM)	RIR2532
Toolholder Adapter Disk Pack (Includes all adapters below)	RTHADPK10/20
Toolholder Adapter - BT30	Not Sold Individually
Toolholder Adapter - 40 Taper	Not Sold Individually
Toolholder Adapter - HSK40 & PSC4	Not Sold Individually
Toolholder Adapter - HSK50 & PSC5	Not Sold Individually
Toolholder Adapter - PSC6	Not Sold Individually
Toolholder Adapter - HSK63	Not Sold Individually



Induction Ring



Toolholder Adapter
Disc Pack

RSFM30



PRODUCT FEATURES

- Connect to Power and air and change tools in 2 minutes or less.
- The **RSFM30 Shrink Fit Machine** comes with all 4 induction rings listed below.
- Includes toolholder adapter discs for **BT30, 40 Taper, HSK40/50/63 and PSC4/PSC5/PSC6**
- **CAT50 AND HSK100 are built into the machine. No adapter required.**
- Tools with **Up to 24" Gage Lengths** can be accommodated with the **RSFM30**.
- Easy to use touch screen adjustments for temp and time settings.
- Cooling Cycle uses 90 PSI shop air to cool the holder for safe handling. The use of an in-line filter is required.

MACHINE SPECIFICATIONS

Tool Diameter	Power	L x D x H	Ship Wt	Part #
1/8"-1-1/4"	480VAC, 3 phase, 30A NEMA L16-30P	20" x 20" x 37"	84 lbs	RSFM30

Included Accessories

Accessory	Item #
Thermal Insulated Glove	RTIG01
Induction Ring (3MM-5MM)	RIR0305
Induction Ring (6MM-12MM)	RIR0612
Induction Ring (14MM-20MM)	RIR1420
Induction Ring (25MM-32MM)	RIR2532
Toolholder Adapter Disk Pack (Includes all adapters below)	RTHADPK30
Toolholder Adapter - BT30	Not Sold Individually
Toolholder Adapter - 40 Taper	Not Sold Individually
Toolholder Adapter - HSK40 & PSC4	Not Sold Individually
Toolholder Adapter - HSK50 & PSC5	Not Sold Individually
Toolholder Adapter - PSC6	Not Sold Individually
Toolholder Adapter - HSK63	Not Sold Individually



Induction Ring



Toolholder Adapter Disc Pack

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