GenSwiss®

Advancing Small Parts Manufacturing

Signature Series
Tool Holding Solutions

Rigid & Accurate ID Tool Holding

- Swiss Precision Collet Sleeves
- Double Ended Collet Sleeves
- Coolant-Through Collet Sleeves
- Quick Change Holding Solutions
- Standard & Coolant-Thru ER Collets

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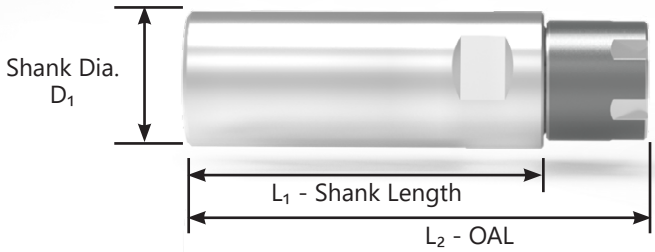
SIGNATURE SERIES
COLLET SLEEVES

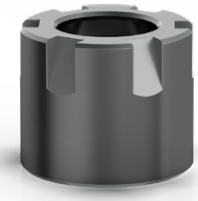
ER Style Collets are the tool holding system of choice for use in CNC machine applications. Swiss Precision collet sleeves provide rigid & accurate holding of ID tooling. These collet sleeves feature ground shanks and tapers. Mini nuts are used to reduce interference and to make setup and tool changing easier than collet sleeves with hexagonal clamping nuts.

Our Single Ended Swiss Precision Sleeves Feature:

- **Locking Flats To Prevent Damage To Sleeve Shank & Provides Orientation For Use With Boring Bars**
- **Precision Ground & Hardened For Accuracy & Precision**
- **Internal Stop Screw Prevents Tool Pushback**

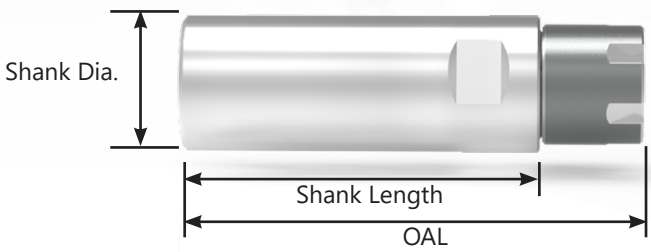


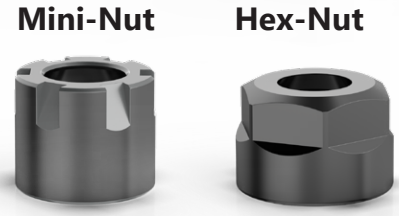
Mini-Nut



Precision ER Collet Sleeves - Inch Shanks

Part No.	Collet	Shank Dia. (D_1)	Shank Length (L_1)	OAL (L_2)	With Locking Flat	Stop Screw	Nut Type
CS-08-095-070	ER08	0.375in	70mm	93mm	No	No	Mini-Nut
CS-11-127-023	ER11	0.5in	23mm	30mm	Yes	No	No Mini-Nut
CS-11-158-022		0.625in	22mm	30mm	Yes	No	No Mini-Nut
CS-11-158-050		0.625in	50mm	62mm	Yes	Yes	Mini-Nut
CS-11-158-100		0.625in	100mm	112mm	Yes	Yes	Mini-Nut
CS-11-190-070		0.75in	70mm	82mm	Yes	Yes	Mini-Nut
CS-11-190-115		0.75in	115mm	135mm	Yes	Yes	Mini-Nut
CS-16-158-075	ER16	0.625in	75mm	90mm	Yes	Yes	Mini-Nut
CS-16-190-035		0.75in	35mm	50mm	Yes	Yes	Mini-Nut
CS-16-190-050		0.75in	50mm	65mm	Yes	Yes	Mini-Nut
CS-16-190-070		0.75in	70mm	85mm	Yes	Yes	Mini-Nut
CS-16-190-100		0.75in	100mm	115mm	Yes	Yes	Mini-Nut
CS-16-190-120		0.75in	120mm	148mm	Yes	Yes	Mini-Nut
CS-16-254-022		1in	22mm	37mm	Yes	Yes	Mini-Nut
CS-16-254-033		1in	33mm	49mm	Yes	Yes	Mini-Nut
CS-16-254-038		1in	38mm	53mm	Yes	Yes	Mini-Nut
CS-16-254-065		1in	65mm	80mm	Yes	No	Mini-Nut
CS-16-254-075		1in	75mm	90mm	Yes	No	Mini-Nut
CS-16-254-080		1in	80mm	95mm	Yes	Yes	Mini-Nut
CS-16-254-100		1in	100mm	115mm	Yes	Yes	Mini-Nut
CS-16-254-130		1in	130mm	145mm	Yes	Yes	Mini-Nut
CS-20-254-100	ER20	1in	100mm	117mm	Yes	No	Mini-Nut
CS-20-254-140		1in	140mm	157mm	Yes	No	Mini-Nut





Precision ER Collet Sleeves - Metric Shanks

Part No.	Collet	Shank Dia. (D_1)	Shank Length (L_1)	OAL (L_2)	With Locking Flat	Stop Screw	Nut Type
CS-08-080-080	ER08	8mm	80mm	106mm	No	No	Mini-Nut
CS-11-080-056	ER11	8mm	56mm	78mm	No	Yes	Mini-Nut
CS-11-160-038		16mm	38mm	51mm	Yes	Yes	Mini-Nut
CS-11-200-070		20mm	70mm	82mm	Yes	Yes	Mini-Nut
CS-16-200-035	ER16	20mm	35mm	50mm	Yes	Yes	Mini-Nut
CS-16-200-070		20mm	70mm	85mm	Yes	Yes	Mini-Nut
CS-16-200-100		20mm	100mm	115mm	Yes	Yes	Mini-Nut
CS-16-200-140		20mm	140mm	168mm	Yes	Yes	Mini-Nut
CS-16-220-070		22mm	70mm	86mm	Yes	Yes	Mini-Nut
CS-16-220-100		22mm	100mm	116mm	Yes	Yes	Mini-Nut
CS-16-250-065		25mm	65mm	81mm	Yes	Yes	Mini-Nut
CS-16-250-100		25mm	100mm	115mm	Yes	No	Hex-Nut
CS-16-250-160		25mm	160mm	175mm	Yes	No	Hex-Nut
CS-20-220-080	ER20	22mm	80mm	97mm	Yes	No	Mini-Nut
CS-20-250-154		25mm	154mm	170mm	Yes	Yes	Mini-Nut
CS-25-220-070	ER25	22mm	70mm	117mm	Yes	Yes	Mini-Nut
CS-25-250-145		25mm	145mm	181mm	Yes	Yes	Mini-Nut

REGO-FIX®

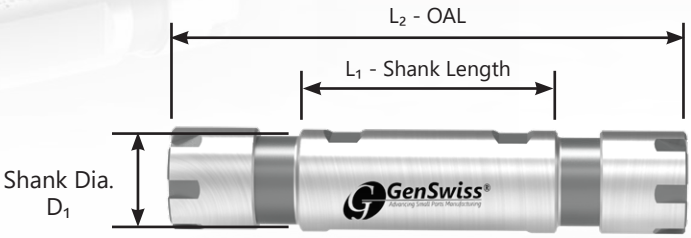
Standard, Ultra-Precision, & Coolant-Thru ER Collets Available

- T.I.R < .0004" Standard
- T.I.R < .0002" Ultra-Precision
- ER8, ER11, ER16, ER20 Sizes
- Inch Diameters ($.^{0625}$-$.^{5}$in) & Metric Diameters (1-13mm)
- Coolant-Thru Rated To 2000PSI

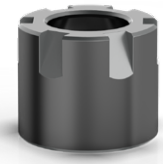
SIGNATURE SERIES
DOUBLE ENDED COLLET SLEEVES

Double Ended Swiss Precision Sleeves Features:

- **Adds Additional ID Tool Positions**
- **Enables Simultaneous Main & Subspindle Operations**
- **Precision Ground & Hardened To Ensure High Accuracy**



Mini-Nut



Double Ended Precision ER Collet Sleeves - Inch Shanks

Part No.	Collet	Shank Dia. (D_1)	Shank Length (L_1)	OAL (L_2)	With Locking Flat	Stop Screw	Nut Type
CS-08-158-015D	8	0.625in	15mm	45mm	Yes	No	Mini-Nut
CS-11-190-035D	11	0.75in	35mm	51mm	Yes	No	Mini-Nut
CS-11-190-057D		0.75in	57mm	73mm	Yes	No	Mini-Nut
CS-11-190-069D		0.75in	69mm	85mm	Yes	No	Mini-Nut
CS-11-190-096D		0.75in	96mm	112mm	Yes	No	Mini-Nut
CS-16-190-056D	16	0.75in	56mm	87mm	Yes	No	Mini-Nut
CS-16-254-045D		1.0in	45mm	75mm	Yes	No	Mini-Nut
CS-16-254-075D		1.0in	75mm	105mm	Yes	No	Mini-Nut

Double Ended Precision ER Collet Sleeves - Metric Shanks

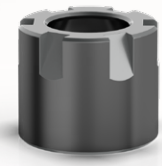
Part No.	Collet	Shank Dia. (D_1)	Shank Length (L_1)	OAL (L_2)	With Locking Flat	Stop Screw	Nut Type
CS-11-160-050D	ER11	16mm	50mm	77mm	Yes	No	Mini-Nut
CS-11-200-030D		20mm	30mm	57mm	Yes	No	Mini-Nut
CS-11-200-050D		20mm	50mm	90mm	Yes	No	Mini-Nut
CS-16-200-055D	ER16	20mm	55mm	107mm	Yes	No	Mini-Nut
CS-16-220-055D		22mm	55mm	91mm	Yes	No	Mini-Nut
CS-16-220-075D		22mm	75mm	111mm	Yes	No	Mini-Nut
CS-16-250-062D		25mm	62mm	118mm	Yes	No	Mini-Nut
CS-20-320-075D	ER20	32mm	75mm	107mm	Yes	No	Mini-Nut
CS-20-320-110D		32mm	110mm	142mm	Yes	No	Mini-Nut

SIGNATURE SERIES
COOLANT-FED COLLET SLEEVES

Coolant-Fed Collet Sleeves Features:

- **Designed For High-Pressure Coolant Delivery Systems**
- **Single & Duel Coolant Port Versions Available**
- **Use With Sealed Coolant-Style ER Collets Or Standard Collets**

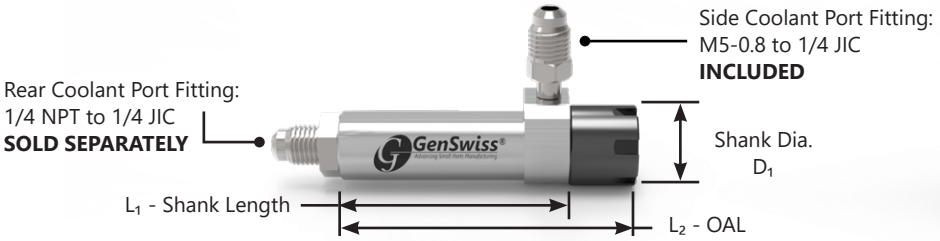
Mini-Nut



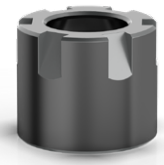
Coolant-Fed ER Collet Sleeves - Inch Shanks — Single Coolant Port

Part No.	Collet	Shank Dia. (D_1)	Shank Length (L_1)	OAL (L_2)	With Locking Flat	Stop Screw	Nut Type	Rear Coolant Port
CS-11-190-035C	ER11	0.75in	35mm	44.5mm	Yes	Yes	Mini-Nut	1/8 NPT
CS-11-190-062C		0.75in	62mm	71.5mm	Yes	Yes	Mini-Nut	1/8 NPT
CS-16-190-042C	ER16	0.75in	42mm	55mm	Yes	Yes	Mini-Nut	1/4 NPT
CS-16-190-062C		0.75in	62mm	75mm	Yes	Yes	Mini-Nut	1/4 NPT
CS-16-190-086C		0.75in	86mm	100mm	Yes	Yes	Mini-Nut	1/4 NPT
CS-16-254-049C		1in	49mm	65mm	Yes	Yes	Mini-Nut	3/8 NPT
CS-20-254-050C	ER20	1in	50mm	67mm	Yes	Yes	Mini-Nut	3/8 NPT
CS-20-254-085C		1in	83mm	100mm	Yes	Yes	Mini-Nut	3/8 NPT

NOTE: A fitting is included with each collet sleeve
NOTE: All shanks include stop screws



Mini-Nut



Coolant-Fed ER Collet Sleeves - Inch Shanks — Double Coolant Ports

Part No.	Collet	Shank Dia. (inch)	Shank Length (inch)	OAL (inch)	With Locking Flat	Nut Type	Side Coolant Port	Rear Coolant Port
CS-16-190-050GC	16	0.75in	50mm	77mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-190-060GC		0.75in	60mm	87mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-190-070GC		0.75in	70mm	97mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-254-050GC		1.0in	50mm	77mm	Yes	Mini-Nut	M5	1/4 NPT

NOTE: A 1/4 NPT plug for the rear coolant port is included

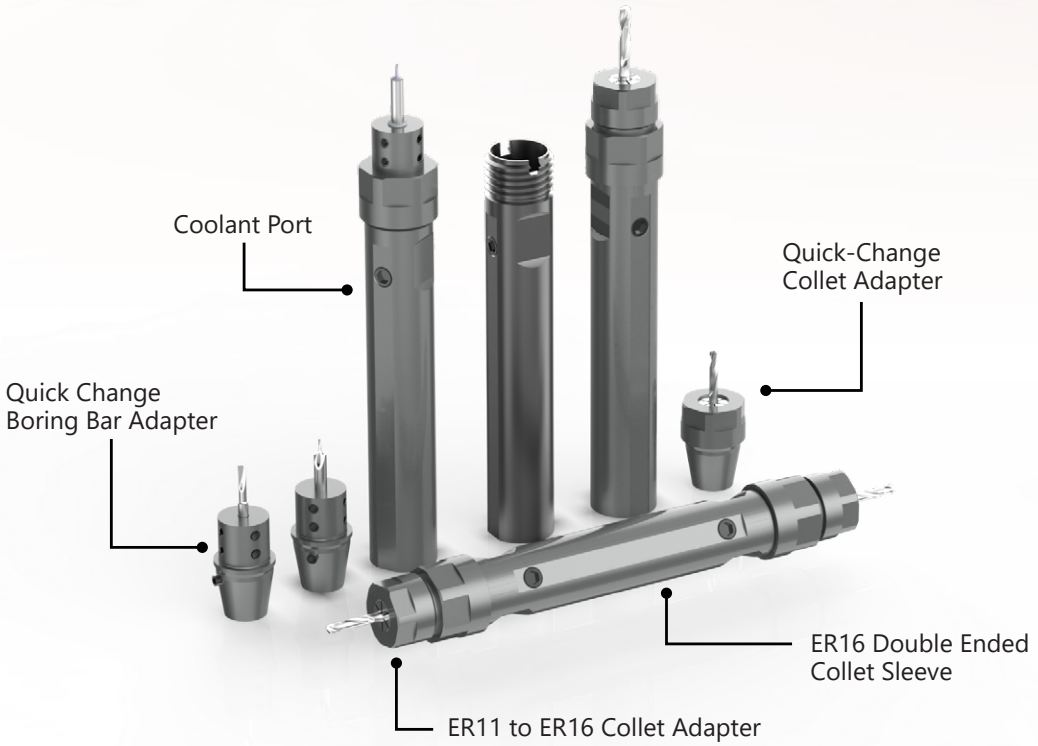
Coolant-Fed ER Collet Sleeves - Metric Shanks — Double Coolant Ports

Part No.	Collet	Shank Dia. (mm)	Shank Length (mm)	OAL (mm)	With Locking Flat	Nut Type	Side Coolant Port	Rear Coolant Port
CS-16-200-050GC	16	20mm	50mm	77mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-200-070GC		20mm	70mm	97mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-220-050GC		22mm	50mm	77mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-220-070GC		22mm	70mm	97mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-250-050GC		25mm	50mm	77mm	Yes	Mini-Nut	M5	1/4 NPT
CS-16-250-070GC		25mm	70mm	97mm	Yes	Mini-Nut	M5	1/4 NPT

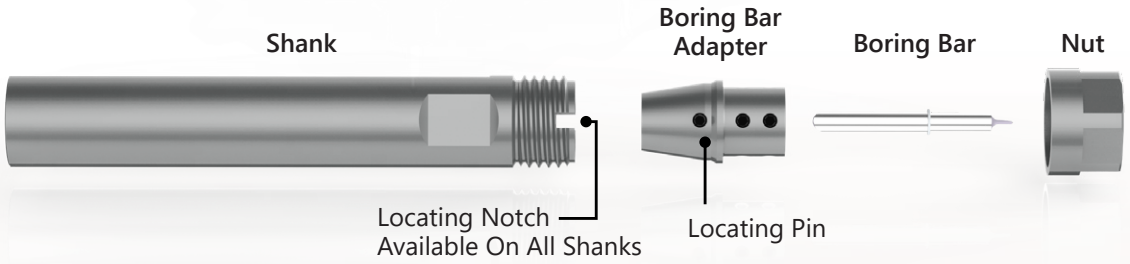
NOTE: A 1/4 NPT plug for the rear coolant port is included

QUICK CHANGE TOOL HOLDING SOLUTIONS

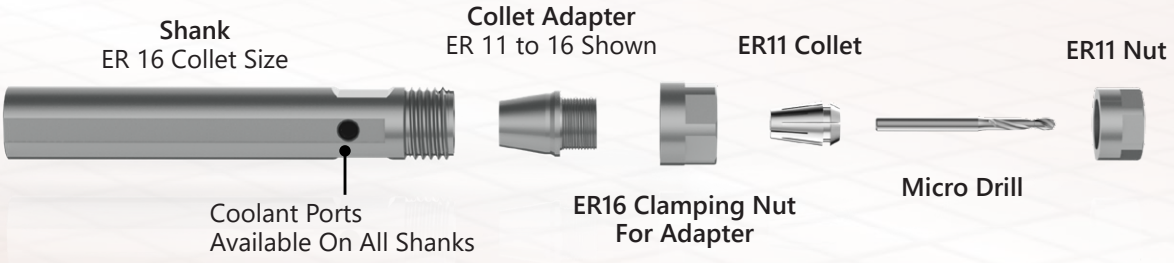
These collet sleeves are cost effective solutions to tool holding and are available in a variety of both Inch and Metric sized shank diameters. Also featuring a solid shank for rigidity and a side coolant port for connection to a high-pressure coolant delivery system. Every unit has a notched collet taper for easy tool orientation when combined with Quick-Change boring bar adapters.



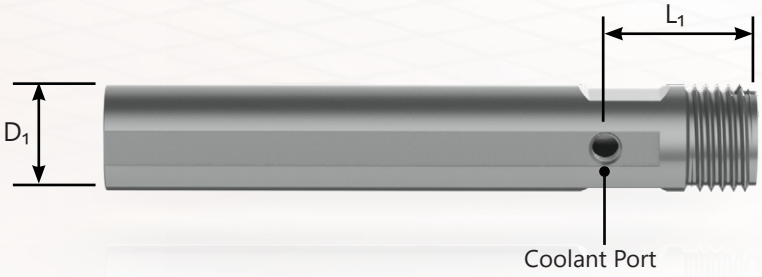
Single Ended Shank Used With The Quick Change Boring Bar Adapter

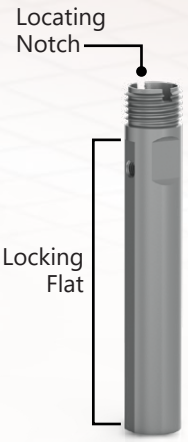


Single Ended Shank Used With The Quick Change Collet Adapter



SINGLE ENDED SHANKS





Shank Only - Inch

Part No.	Collet	D_1	L_1	OAL
CQS-SS-160500	ER16	.500in	1.1in	4.5in
CQS-SS-160625	ER16	.625in	1.1in	4.5in
CQS-SS-160750	ER16	.750in	1.1in	4.5in
CQS-SS-161000	ER16	1.00in	1.1in	4.5in
CQS-SS-200750	ER20	.750in	1.2in	4.5in
CQS-SS-201000	ER20	1.00in	1.2in	4.5in
CQS-SS-201250	ER20	1.25in	1.2in	4.5in

Shank w/ Nut - Inch

Part No. W/ Nut
CQS-S16-0500-CSE
CQS-S16-0625-CSE
CQS-S16-0750-CSE
CQS-S16-1000-CSE
CQS-S20-0750-CSE
CQS-S20-1000-CSE
CQS-S20-1250-CSE

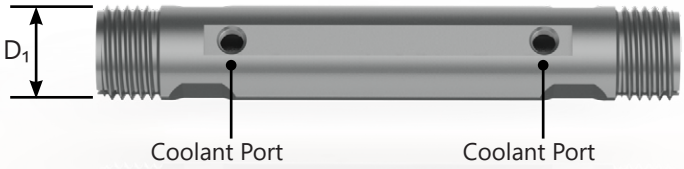
Shank Only - Metric

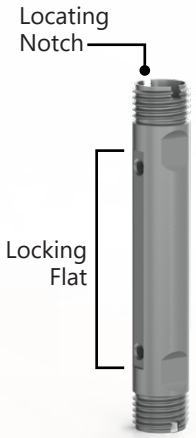
Part No.	Collet	D_1	L_1	OAL
CQS-SS-160787	ER16	20mm	28mm	114mm
CQS-SS-160866	ER16	22mm	28mm	118mm
CQS-SS-160984	ER16	25mm	28mm	95mm
CQS-SS-200866	ER20	22mm	30mm	114mm
CQS-SS-201260	ER20	32mm	30mm	118mm

Shank w/ Nut - Metric

Part No. W/ Nut
CQS-S16-0787-CSE
CQS-S16-0866-CSE
CQS-S16-0984-CSE
CQS-S20-0866-CSE
CQS-S20-1260-CSE

DOUBLE ENDED SHANKS





Inch

Part No.	Collet	D_1	OAL
CQS-S16-0750-CDE	ER16	.750in	4.5in
CQS-S16-1000-CDE	ER16	1.00in	4.5in
CQS-S20-1000-CDE	ER20	1.00in	4.5in

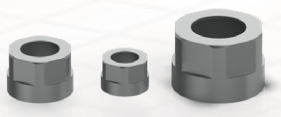
Metric

Part No.	Collet	D_1	OAL
CQS-S16-0866-CDE	ER16	22mm	114mm
CQS-S16-0984-CDE	ER16	25mm	95mm
CQS-S20-1260-CDE	ER20	32mm	118mm

NOTE: Each double ended shank is sold with two nuts

SPARE ER COLLET NUTS

Part No.	ER Size	Nut Thread
CQS-NT160001	ER16	M19 x 1.0
CQS-NT200001	ER20	M24 x 1.0
CQS-NT250001	ER25	M32 x 1.5



QUICK CHANGE COLLET ADAPTERS

Quick Change collet adapters make it easier to control quality in your shop. These adapters make it simple to have preset tooling available, eliminating the need to touch off the tool after a routine change. This also enables less experienced machine operators to be more productive.

- Simplifies Setup
- Decreases Downtime

Assembly With Collet

Part No.	Adapter	Collet	Middle Nut Thread
CQS-AS11-0801-xxx	ER11 to ER8	ER8	M13 x .75
CQS-AS11-0802-xxx	ER11 to ER8	ER8	M14 x .75
CQS-AS16-1101-xxx	ER16 to ER11	ER11	M19 x 1
CQS-AS16-1102-xxx	ER16 to ER11	ER11	M22 x 1.5
CQS-AS20-1601-xxx	ER20 to ER16	ER16	M24 x 1
CQS-AS20-1601-xxx	ER20 to ER16	ER16	M25 x 1.5

Assembly Only

Part No.	Adapter	Collet	Middle Nut Thread
CQS-AS11-0803	ER11 to ER8	ER8	M13 x .75
CQS-AS11-0804	ER11 to ER8	ER8	M14 x .75
CQS-AS16-1103	ER16 to ER11	ER11	M19 x 1
CQS-AS16-1104	ER16 to ER11	ER11	M22 x 1.5
CQS-AS20-1603	ER20 to ER16	ER16	M24 x 1
CQS-AS20-1604	ER20 to ER16	ER16	M25 x 1.5

*replace xxx with desired collet size in nominal inch or millimeter sizes

QUICK CHANGE BORING ADAPTERS

Quick Change Boring adaptors make it fast and simple to locate center position for boring bars when combined with notched ER holders. A simple locating pin rests within the notched holder ensuring accurate centering. These solid bushings utilize the ER collet system to securely hold a boring bar in a rigid fashion. Axial length can be easily set using any form of presetting device.

- *Easily Locates Boring Bar Axial & Radial Position*

ER16 (Inch)

Part No.	ER Size	Bore	Nut Thread
CQS-SH16-12501	ER16	.125in	M19 x 1
CQS-SH16-18701		.1875in	M19 x 1
CQS-SH16-25001		.250in	M19 x 1
CQS-SH16-31201		.3125in	M19 x 1
CQS-SH16-37501		.375in	M19 x 1

ER20 (Inch)

Part No.	ER Size	Bore	Nut Thread
CQS-SH20-12501	ER20	.125in	M24 x 1
CQS-SH20-187501		.1875in	M24 x 1
CQS-SH20-25001		.250in	M24 x 1
CQS-SH20-312501		.3125in	M24 x 1
CQS-SH20-37501		.375in	M24 x 1

ER16 (Metric)

Part No.	ER Size	Bore	Nut Thread
CQS-SH16-15701	ER16	4mm	M19 x 1
CQS-SH16-19701		5mm	M19 x 1
CQS-SH16-23601		6mm	M19 x 1
CQS-SH16-31501		8mm	M19 x 1

ER20 (Metric)

Part No.	ER Size	Bore	Nut Thread
CQS-SH16-19701	ER20	5mm	M24 x 1
CQS-SH16-23601		6mm	M24 x 1
CQS-SH16-31501		8mm	M24 x 1

Additional Size Options Available, please call.