





Cylindrical Shank Toolholders

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ER_{SYSTEM}

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Tapping Holders with Length Compensation



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Features | Benefits

Swiss Quality

Made in Switzerland to ISO 9001/ISO 14001.

1 Marking

Type and part number.

2 Traceability

Lot number marking on all products for traceability through the entire manufacturing process.

3 Original REGO-FIX®

Our extensive experience results in a well-engineered system. Original only with the REGO-FIX® quality seal \triangle . Guarantee for best quality.

Sizes

ER 8 – ER 40

Types

With flat or double ended collets.

T.I.R. <3 μm

Inner diameter to outer diameter.

Surface Finish max. Ra 0.25

Higher clamping force and higher transferable torque.

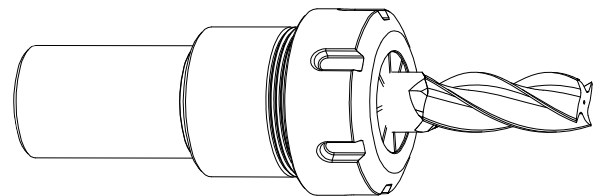


Information

CYL/ER Toolholders

Applications

Cylindrical REGO-FIX® collets are designed for automatic turning machines and can be utilized as extensions. They are available in different types.



CYL/ER

The short versions are particularly used on turret lathes where a short overhang is often required.

Detailed information see page 9.4.

CYL/ER M

This type is suited for Swiss screw machines, machining centers and conventional machines. The shank diameter is in accordance with type F collets but is adjustable in length.

With the CYL/ER M different length cutting tools can be adjusted to the same length. These toolholders accept collets of ER, ER-UP, ER-GB and ET1 type.

Detailed information see page 9.6.

CYL/ER MF

The program of cylindrical collets with clamping flat is particularly designed for CNC-machines such as Citizen, Manurhin, Star and Tornos, etc.

Detailed information see page 9.8.

CYL/ER MF

The program of double collets with clamping flat has been designed for CNC-machines such as Citizen, Manurhin, Star and Tornos and offers the possibility to hold two cutting tools on the same collet.

Detailed information see page 9.10.

CYL/ER NC

These collets are particularly suitable on CNC-turning machines, but can be used on conventional turning machines as well.

Detailed information see page 9.12.

CYL SSY/ERC

Softsynchro® tapping holders are designed to compensate pitch differences between synchronous spindles and tapping tools.

Detailed information see page 9.14.

CYL GSF/ERC

Tapping holders with length compensation in compression and tension directions are used on machines without synchronization of spindle feed and the pitch of the thread.

Detailed information see page 9.16.



We recommend tightening the clamping nuts with a torque wrench. The maximum torque shall not be more than 25% above the recommended tightening torque.

Recommended tightening torque see page 13.3/13.4.



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Matching Products

Clamping Nuts | Collets | Spanners

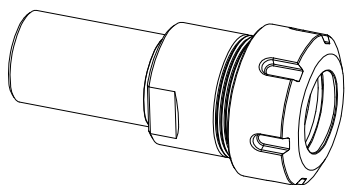
Clamping Nut and Spanner	ER 11	ER 16	ER 20	ER 25	ER 32	ER 40	Page	Standard	With Friction Bearing	Balanced	For Coolant Through Tools	Collet Locking System	Mini-Nut	Nut with External Thread	Spanner
Hi-Q/ER	3411.00000	3416.00000	3420.00000	3425.00000	3432.00000	3440.00000	3450.00000	4.4	■		■		■		
Hi-Q/ERC	3411.20300 - 3411.20700	3416.20000	3420.20000	3425.20000	3432.20000	3440.20000	-	4.6 4.8			■	■	■		
Hi-Q/ERB	-	3416.30000	3420.30000	3425.30000	3432.30000	3440.30000	3450.30000	4.10		■	■		■		
Hi-Q/ERBC	-	3416.40000	3420.40000	3425.40000	3432.40000	3440.40000	-	4.10		■	■	■	■		
EP	7112.11010	7112.16010	7112.20010	-	-	-	-	12.1							■
E	-	-	-	7111.25000	7111.32000	7111.40000	7111.50000	12.1							■

Recommended tightening torque on page 13.3/13.4.

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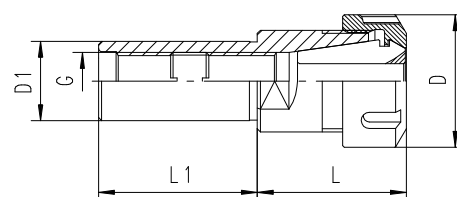
Collet	ER 11/ET1-12		ER 16/ET1-16		ER 20/ET1-20		ER 25/ET1-25		ER 32/ET1-32		ER 40/ET1-40	
	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page
ER	0.5 – 7.0	2.8	0.5 – 10.0	2.10	0.5 – 13.0	2.12	0.5 – 16.0	2.14	1.0 – 20.0	2.16	2.0 – 30.0	2.18
ER-UP	0.5 – 7.0	2.8	0.5 – 10.0	2.10	0.5 – 13.0	2.12	0.5 – 16.0	2.14	1.0 – 20.0	2.16	2.0 – 30.0	2.18
ER-DM	2.75 – 7.00	2.22	3.0 – 10.0	2.24	3.0 – 10.0	2.26	6.0 – 16.0	2.28	6.0 – 20.0	2.30	6.0 – 26.0	2.32
ER-MB	0.2 – 0.9	2.8	0.2 – 0.9	2.10	-	-	-	-	-	-	-	-
ER-GB	2.8 – 6.0	3.4	4.0 – 9.0	3.4	4.0 – 11.2	3.4	4.0 – 16.0	3.4	4.0 – 20.0	3.4	6.0 – 22.0	3.4
ET 1*	1.4 – 3.55	3.8	1.4 – 6.3	3.8	2.2 – 7.0	3.8	2.5 – 10.0	3.8	4.5 – 12.5	3.8	6.0 – 17.0	3.8

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



Colletholders

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]
CYL 1/2" x 070 / ER 11	2613.11141	19	12.7	28.5	70	M6
CYL 1/2" x 100 / ER 16	2613.11661	28	12.7	36.0	100	M6
CYL 1/2" x 100 / ER 20	2613.12061	34	12.7	44.5	100	M6
CYL 14 x 060 / ER 16	2614.11630	28	14	36.5	60	M6
CYL 16 x 060 / ER 16	2616.11630	28	16	36.5	60	M 8x1
CYL 5/8" x 060 / ER 16	2616.11631	28	15.875	36.5	60	M 8x1
CYL 5/8" x 100 / ER 20	2616.12061	34	15.875	44.5	100	M 8x1
CYL 3/4" x 050 / ER 16	2619.11621	28	19.05	30.5	50	M 12x1
CYL 3/4" x 100 / ER 16	2619.11661	28	19.05	30.5	100	M 12x1
CYL 3/4" x 060 / ER 20	2619.12031	34	19.05	36.5	60	M 12x1
CYL 3/4" x 050 / ER 25	2619.12521	42	19.05	47.0	50	M 12x1
CYL 20 x 050 / ER 16	2620.11620	28	20	30.5	50	M 12x1
CYL 20 x 100 / ER 16	2620.11660	28	20	30.5	100	M 12x1
CYL 20 x 030 / ER 20	2620.12010	34	20	36.5	30	M 12x1
CYL 20 x 060 / ER 20	2620.12030	34	20	36.5	60	M 12x1
CYL 20 x 050 / ER 25	2620.12520	42	20	47.0	50	M 12x1
CYL 20 x 100 / ER 25	2620.12560	42	20	47.0	100	M 12x1
CYL 20 x 050 / ER 32	2620.13220	50	20	54.0	50	M 12x1
CYL 20 x 100 / ER 32	2620.13260	50	20	54.0	100	M 12x1
CYL 1" x 100 / ER 20	2625.12061	34	25.40	39.5	100	M 12x1
CYL 1" x 050 / ER 25	2625.12521	42	25.40	47.0	50	M 18x1.5
CYL 1" x 100 / ER 25	2625.12561	42	25.40	47.0	100	M 18x1.5
CYL 1" x 050 / ER 32	2625.13221	50	25.40	53.0	50	M 18x1.5
CYL 1" x 050 / ER 40	2625.14021	63	25.40	60.0	50	M 18x1.5
CYL 25 x 050 / ER 25	2625.12520	42	25	47.0	50	M 18x1.5
CYL 25 x 100 / ER 25	2625.12560	42	25	47.0	100	M 18x1.5
CYL 25 x 050 / ER 32	2625.13220	50	25	54.0	50	M 18x1.5
CYL 25 x 050 / ER 40	2625.14020	63	25	60.0	50	M 18x1.5
CYL 30 x 050 / ER 25	2630.12520	42	30	42.0	50	M 18x1.5
CYL 30 x 050 / ER 32	2630.13220	50	30	53.0	50	M 22x1.5
CYL 1 1/4" x 060 / ER 32	2632.13231	50	31.75	53.0	60	M 22x1.5



Drawings with detailed dimensions see

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Matching Products

Clamping Nuts | Collets | Spanners

Clamping Nut and Spanner	ER 8	ER 11	ER 16	ER 20	ER 25	Page	Standard	With Friction Bearing	Balanced	For Coolant Through Tools	Collet Locking System*	Mini-Nut	Nut with External Thread	Spanner
Hi-Q/ERM	3508.00000	3511.00000	3516.00000	3520.00000	3525.00000	4.12			■		■	■		
Hi-Q/ERMC	–	3511.20300 – 3511.20700	3516.20000	3520.20000	3525.20000	4.12 4.14			■	■	■	■		
EM	7113.08000	7113.11000	7113.16000	7113.20000	7113.25000	12.1								■
ER MS	3208.50000	3211.50000	3216.50000	3220.50000	3225.50000	4.16			■			■		
E MS	7114.08000	7114.11000	7114.16000	7114.20000	7114.25000	12.2								■

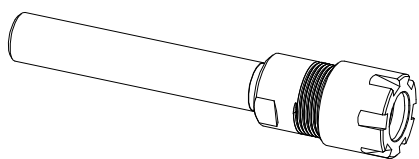
*Collet Locking System gilt nicht für Hi-Q®/ERM 8.

Recommended tightening torque on page 13.3/13.4.

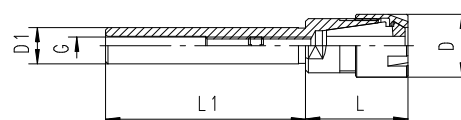
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Collet	ER 8		ER 11/ET1-12		ER 16/ET1-16		ER 20/ET1-20		ER 25/ET1-25	
	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Spannbereich [mm]	Seite
ER	0.5 – 0.5	2.6	0.5 – 0.5	2.6	0.5 – 7.0	2.8	0.5 – 10.0	2.10	0.5 – 13.0	2.12
ER-UP	0.5 – 0.5	2.6	0.5 – 0.5	2.6	0.5 – 7.0	2.8	0.5 – 10.0	2.10	0.5 – 13.0	2.12
ER-DM	–	–	–	–	2.75 – 7.00	2.22	3.0 – 10.0	2.24	3.0 – 10.0	2.26
ER-MB	0.2 – 0.9	2.6	0.2 – 0.9	2.6	0.2 – 0.9	2.8	0.2 – 0.9	2.10	–	–
ER-GB	–	–	–	–	2.8 – 6.0	3.4	4.0 – 9.0	3.4	4.0 – 11.2	3.4
ET 1**	–	–	–	–	1.4 – 3.55	3.8	1.4 – 6.3	3.8	2.2 – 7.0	3.8

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



Colletholders



Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]	For Manurhin	For Tornos
CYL 06 x 045 / ER 11 M	2606.21120	16	6	26.5	45	-		
CYL 07 x 045 / ER 11 M	2607.21120	16	7	26.5	45	-		
CYL 08 x 080 / ER 8 M	2608.20850	12	8	26.0	80	-		
CYL 08 x 056 / ER 11 M	2608.21130	16	8	26.5	56	-	■	
CYL 3/8" x 070 / ER 8 M	2609.20841	12	9.52	23.0	70	M 5		
CYL 10 x 060 / ER 16 M	2610.21630	22	10	38.5	60	-		
CYL 12 x 080 / ER 8 M	2612.20850	12	12	17.0	80	-		
CYL 12 x 080 / ER 16 M	2612.21650	22	12	38.5	80	-		
CYL 1/2" x 140 / ER 11 M	2613.21191	16	12.7	29.5	140	M 6		
CYL 1/2" x 140 / ER 16 M	2613.21691	22	12.7	37.0	140	M 6		
CYL 15 x 100 / ER 20 M	2615.22060	28	15	42.5	100	-		
CYL 16 x 150 / ER 11 M	2616.21190	16	16	21.0	150	M 8x1		
CYL 16 x 100 / ER 20 M	2616.22060	28	16	42.5	100	-		
CYL 5/8" x 150 / ER 11 M	2616.21191	16	15.87	22.5	150	M 8x1		
CYL 3/4" x 155 / ER 16 M	2619.21691	22	19.05	26.5	155	M 12x1		
CYL 3/4" x 100 / ER 25 M	2619.22561	35	19.05	47.0	100	M 12x1		
CYL 20 x 155 / ER 16 M	2620.21690	22	20	26.5	155	M 12x1		■
CYL 25 x 155 / ER 20 M	2625.22090	28	25	26.5	155	M 14x1		■
CYL 1" x 155 / ER 20 M	2625.22091	28	25.5	26.5	155	M 14x1	■	

Supplied: Colletholder, clamping nut.

For back-up screw details see search.rego-fix.ch.

Drawings with detailed dimensions see

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Matching Products

Clamping Nuts | Collets | Spanners

Clamping Nut and Spanner	ER 8	ER 11	ER 16	ER 20	ER 25	Page	Standard	With Friction Bearing	Balanced	For Coolant Through Tools	Collet Locking System	Mini-Nut	Nut with External Thread	Spanner
Hi-Q/ERM	3508.00000	3511.00000	3516.00000	3520.00000	3525.00000	4.12			■		■	■		
Hi-Q/ERMC	–	3511.20300 – 3511.20700	3516.20000	3520.20000	3525.20000	4.12 4.14			■	■	■	■		
EM	7113.08000	7113.11000	7113.16000	7113.20000	7113.25000	12.1								■
ER MS	3208.50000	3211.50000	3216.50000	3220.50000	3225.50000	4.16			■			■		
E MS	7114.08000	7114.11000	7114.16000	7114.20000	7114.25000	12.2								■

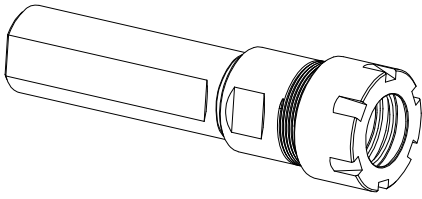
*Collet Locking System not for Hi-Q®/ERM 8.

Recommended tightening torque on page 13.3/13.4.

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Collets	ER 8/ET1-8		ER 11/ET1-12		ER 16/ET1-16		ER 20/ET1-20		ER 25/ET1-25	
	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page
ER	0.5–0.5	2.6	0.5–7.0	2.8	0.5–10.0	2.10	0.5–13.0	2.12	0.5–16.0	2.14
ER-UP	0.5–0.5	2.6	0.5–7.0	2.8	0.5–10.0	2.10	0.5–13.0	2.12	0.5–16.0	2.14
ER-DM	–	–	2.75–7.00	2.22	3.0–10.0	2.24	3.0–10.0	2.26	6.0–16.0	2.26
ER-MB	0.2–0.9	2.6	0.2–0.9	2.8	0.2–0.9	2.10	–	–	–	–
ER-GB	–	–	2.8–6.0	3.4	4.0–9.0	3.4	4.0–11.2	3.4	4.0–16.0	3.4
ET 1**	–	–	1.4–3.55	3.8	1.4–6.3	3.8	2.2–7.0	3.8	2.5–10.0	3.8

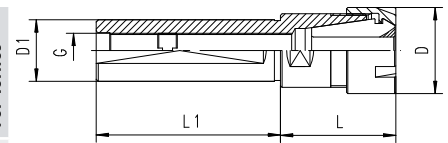
**Not for coolant through tools and not for applications with sealing disks.



CYL | ER MF

Colletholders

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]	For Citizen	For Manurhin	For Schütte	For Star	For Tornos
CYL 5/8" x 043 / ER 8 MF	2616.20811	12	15.875	15	43	M5	■				
CYL 16 x 038 / ER 11 MF	2616.21112	16	16	20	38	M 8x1				■	
CYL 16 x 140 / ER 11 MF	2616.21192	16	16	60	140	M 8x1					
CYL 16 x 035 / ER 16 MF	2616.21612	22	16	38	35	M 8x1				■	
CYL 3/4" x 115 / ER 11 MF	2619.21173	16	19.05	20	115	M 8x1	■				
CYL 3/4" x 038 / ER 16 MF	2619.21613	22	19.05	28	38	M 12x1	■				
CYL 3/4" x 050 / ER 16 MF	2619.21623	22	19.05	28	50	M 12x1	■				
CYL 3/4" x 070 / ER 16 MF	2619.21643	22	19.05	28	70	M 12x1	■				
CYL 3/4" x 120 / ER 16 MF	2619.21683	22	19.05	28	120	M 12x1	■				
CYL 3/4" x 140 / ER 16 MF	2619.21693	22	19.05	28	140	M 12x1	■				
CYL 20 x 050 / ER 16 MF	2620.21622	22	20	28	50	M 12x1	■	■			
CYL 20 x 070 / ER 16 MF	2620.21642	22	20	28	70	M 12x1	■				
CYL 20 x 060 / ER 11 MF	2620.21132	16	20	20	60		■				
CYL 20 x 120 / ER 16 MF	2620.21682	22	20	28	120	M 12x1	■				
CYL 20 x 140 / ER 16 MF	2620.21692	22	20	8	140	M 12x1	■	■			
CYL 22 x 038 / ER 16 MF	2622.21612	22	22	28	38	M 12x1				■	
CYL 22 x 070 / ER 16 MF	2622.21642	22	22	28	70	M 12x1				■	
CYL 22 x 100 / ER 16 MF	2622.21662	22	22	28	100	M 12x1				■	
CYL 22 x 080 / ER 20 MF	2622.22052	28	22	39	80	M 12x1				■	
CYL 22 x 070 / ER 25 MF	2622.22542	35	22	47	70	M 12x1				■	
CYL 25 x 065 / ER 16 MF	2625.21642	22	25	28	65	M 12x1					
CYL 25 x 100 / ER 20 MF	2625.22062	28	25	28	100	M 14x1					■
CYL 25 x 154 / ER 20 MF	2625.22002	28	25	28	154	M 14x1					■
CYL 25 x 075 / ER 25 MF	2625.22552	35	25	47	75	M 14x1		■			
CYL 25 x 145 / ER 25 MF	2625.22592	35	25	36	145	M 14x1		■			■
CYL 1" x 033 / ER 16 MF	2625.21613	22	25.4	28	33	M 12x1					
CYL 1" x 065 / ER 16 MF	2625.21643	22	25.4	28	65	M 12x1		■			
CYL 1" x 075 / ER 16 MF	2625.21653	22	25.4	28	75	M 12x1	■				
CYL 1" x 100 / ER 16 MF	2625.21663	22	25.4	28	100	M 12x1	■				
CYL 1" x 100 / ER 20 MF	2625.22063	28	25.4	28	100	M 14x1	■	■			
CYL 1" x 140 / ER 20 MF	2625.22093	28	25.4	28	140	M 14x1	■				
CYL 32 x 070 / ER 25 MF	2632.22542	35	32	30	70	M 18x1.5			■		



Drawings with detailed dimensions see

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Hi-Q/ERM	3508.00000	3511.00000	3516.00000	3520.00000	4.12			■		■	■		
Hi-Q/ERMC	–	3511.20300 – 3511.20700	3516.20000	3520.20000	4.12 4.14			■	■	■	■		
EM	7113.08000	7113.11000	7113.16000	7113.20000	12.1								■
ER MS	3208.50000	3211.50000	3216.50000	3220.50000	4.16			■			■		
E MS	7114.08000	7114.11000	7114.16000	7114.20000	12.2								■

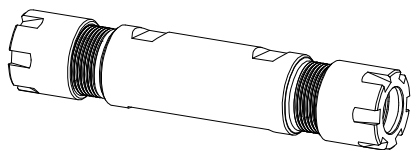
*Collet Locking System not for Hi-Q®/ERM 8.

Recommended tightening torque on page 13.3/13.4.

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Collet	ER 8		ER 11/ET1-12		ER 16/ET1-16		ER 20/ET1-20	
	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page
ER	0.5–0.5	2.6	0.5–0.5	2.6	0.5–7.0	2.8	0.5–10.0	2.10
ER-UP	0.5–0.5	2.6	0.5–0.5	2.6	0.5–7.0	2.8	0.5–10.0	2.10
ER-DM	–	–	–	–	2.75–7.00	2.22	3.0–10.0	2.24
ER-MB	0.2–0.9	2.6	0.2–0.9	2.6	0.2–0.9	2.8	0.2–0.9	2.10
ER-GB	–	–	–	–	2.8–6.0	3.4	4.0–9.0	3.4
ET 1**	–	–	–	–	1.4–3.55	3.8	1.4–6.3	3.8

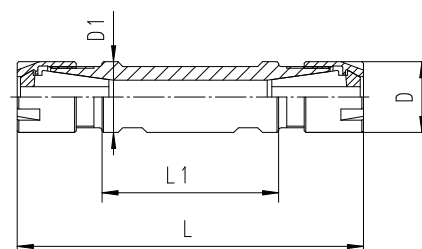
**Not for coolant through tools and not for applications with sealing disks.



Colletholders

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	For Citizen	For Manurhin	For Star
CYD 5/8" x 015 / ER 8 MF	2616.20805	12	15.875	45	15	■		
CYD 5/8" x 025 / ER 8 MF	2616.20895	12	15.875	55	25	■		
CYD 16 x 040 / ER 11 MF	2616.21114	16	16	79	40		■	
CYD 16 x 050 / ER 11 MF	2616.21124	16	16	90	50		■	
CYD 3/4" x 040 / ER 11 MF	2619.21125	16	19.05	80	40	■		
CYD 3/4" x 070 / ER 11 MF	2619.21145	16	19.05	110	70	■		
CYD 3/4" x 090 / ER 11 MF	2619.21165	16	19.05	130	90	■		
CYD 3/4" x 055 / ER 16 MF	2619.21635	22	19.05	107	55	■		
CYD 20 x 030 / ER 11 MF	2620.21114	16	20	70	30	■		
CYD 20 x 050 / ER 11 MF	2620.21124	16	20	90	50	■		
CYD 20 x 055 / ER 16 MF	2620.21634	22	20	107	55	■		
CYD 22 x 055 / ER 16 MF	2622.21634	22	22	111	55			■
CYD 22 x 075 / ER 16 MF	2622.21654	22	22	131	75			■
CYD 25 x 062 / ER 16 MF	2625.21634	22	25	117	62		■	
CYD 1" x 030 / ER 16 MF	2625.21615	22	25.4	85	30	■		
CYD 1" x 062 / ER 16 MF	2625.21635	22	25.4	118	62		■	
CYD 32 x 055 / ER 20 MF	2632.22034	28	32	111	55			■
CYD 32 x 075 / ER 20 MF	2632.22054	28	32	131	75			■

Supplied: Colletholder and two clamping nuts.



Drawings with detailed dimensions see

search.rego-fix.ch



Swiss
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Tools

ER

Toolholders

Matching Products

Clamping Nuts | Collets | Spanners

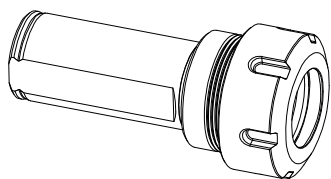
Clamping Nut and Spanner	ER 25	ER 32	ER 40	Page	Standard	With Friction Bearing	Balanced	For Coolant Through Tools	Collet Locking System	Mini-Nut	Nut with External Thread	Spanner
Hi-Q/ER	3425.00000	3432.00000	3440.00000	4.4	■		■		■			
Hi-Q/ERC	3425.20000	3432.20000	3440.20000	4.6			■	■	■			
Hi-Q/ERB	3425.30000	3432.30000	3440.30000	4.10		■	■		■			
Hi-Q/ERBC	3425.40000	3432.40000	3440.40000	4.10		■	■	■	■			
E	7111.25000	7111.32000	7111.40000	12.1								■

Recommended tightening torque on page 13.3/13.4.

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Collet	ER 25/ET1-25		ER 32/ET1-32		ER 40/ET1-40	
	Clamping Range [mm]	Page	Clamping Range [mm]	Page	Clamping Range [mm]	Page
ER	0.5 – 16.0	2.14	1.0 – 20.0	2.16	2.0 – 30.0	2.18
ER-UP	0.5 – 16.0	2.14	1.0 – 20.0	2.16	2.0 – 30.0	2.18
ER-DM	6.0 – 16.0	2.26	6.0 – 20.0	2.28	–	–
ER-MB	–	–	–	–	–	–
ER-GB	4.0 – 16.0	3.04	4.0 – 20.0	3.04	6.0 – 22.0	3.04
ET 1*	2.5 – 10.0	3.08	4.5 – 12.5	3.08	6.0 – 17.0	3.08

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

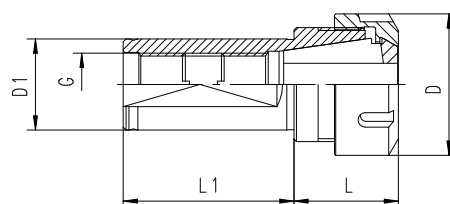


CYL | ER NC

Colletholders

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]
CYL 32 x 060 / ER 25 NC	2632.12532	42	32	32	60	M 18x1.5
CYL 32 x 060 / ER 32 NC	2632.13232	50	32	38	60	M 22x1.5
CYL 40 x 080 / ER 32 NC	2640.13252	50	40	33	80	M 22x1.5
CYL 40 x 075 / ER 40 NC	2640.14052	63	40	55	75	M 22x1.5

Supplied: Colletholder, clamping nut and back-up screw.



Drawings with detailed dimensions see

search.rego-fix.ch



Swiss
Precision
Tools

ER

Toolholders

Features | Benefits



Quality

Made to ISO 9001/ISO 14001 standards.

1 Marking

Type and part number.

2 Traceability

Lot number marking on all products for traceability through the entire manufacturing process.

3 Quality Seal

The REGO-FIX® seal Δ marked on the products guarantees for best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Absorbing Link

Acts as absorbing link between the synchronous spindle and the tap/cold forming tap and compensates pitch differences between threading tool and synchronous spindle.

Minimal Length Adjustment

In push and pull direction.

Tool Shanks

For all tapping tools with h9 shanks.

Secure Clamping

Secure clamping of the tap/cold forming tap by ER-GB tapping collets with internal square.

For Coolant Through Tools

Up to 50 bar coolant pressure.

Process Reliability

Increases process reliability of synchronous tap manufacturing.

CYL SSY|ERC DIN 1835 B+E

CYL SSY/ERC Softsynchro® Tapping Holder

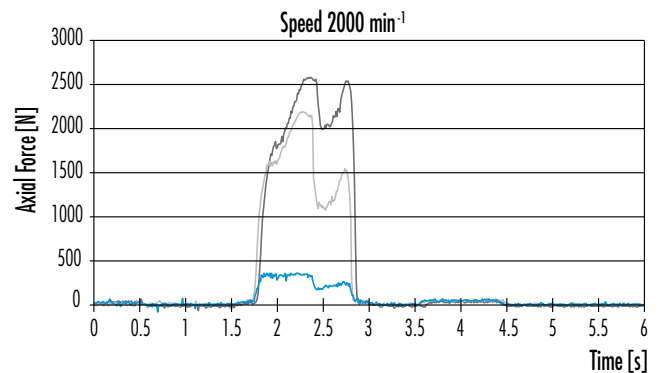
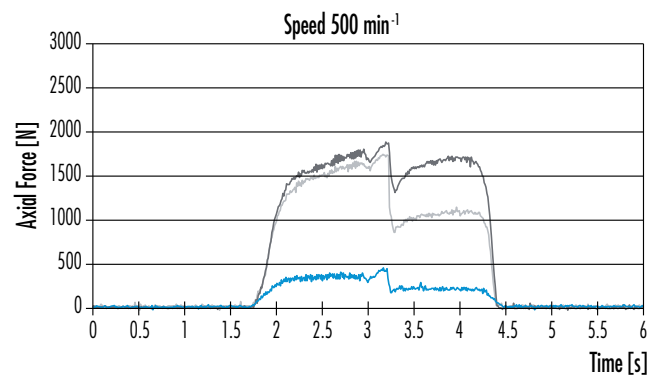
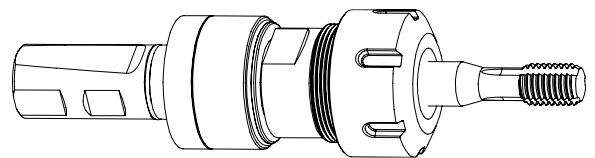
Applications

REGO-FIX® Softsynchro® tapping holders are used on machines that are designed for direct tapping. Many of the newer CNC machines feature synchronization between spindle feed and tap pitch. This allows to use rigid tapping holders. However due to the dynamics of spindle and linear motors synchronization errors occur. To compensate for these synchronization errors Softsynchro® tapping holders with minimal length adjustment are necessary. Depending on the application Softsynchro® tapping holders increase tool life up to 150%.

Comparison Tests

The two diagrams show the axial forces when cold-forming M10 threads in St37 steel.

Conclusion: Axial forces increase with increasing rpm. With REGO-FIX® Softsynchro® tapping holders the forces are considerably lower than when using rigid tapping toolholders. Therefore the surface quality and tool life is optimized when using Softsynchro® tapping holders on a synchronized machine spindle.



- REGO-FIX® Softsynchro®-Tapping holders
- Competitor synchronous collet holder
- Rigid synchronous collet holder

CYL SSY/ERC Softsynchro® Tapping Holders

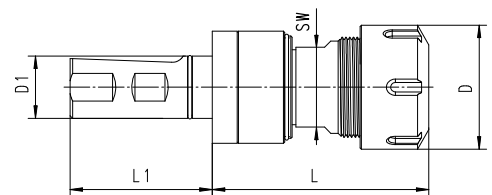
Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Com- pression [mm]	Tension [mm]	SW [mm]
CYL 25 SSY / ERC 20	2625.62000	34	25	73	57	0.5	0.5	19
CYL 25 SSY / ERC 32	2625.63200	50	25	87.5	57	0.5	0.5	32

Supplied: Tapping holder with Hi-Q®/ERC clamping nut.
Matching tapping collets see page 3.4.

For adapting the tapping holders to different steep tapers, please use the appropriate WELDON toolholders.

TC/WD collets (DIN 69871) see page 5.11.

BT/WD collets (MAS 403) see page 6.19.



Please order the sealing disks separately.
See page 4.22/4.24.



Swiss
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Tools

ER

Toolholders

Features | Benefits



Quality

Made to ISO 9001/ISO 14001 standards.

1 Marking

Type and part number.

2 Traceability

Lot number marking on all products for traceability through the entire manufacturing process.

3 Quality Seal

The REGO-FIX® seal Δ marked on the products guarantees for best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Length Compensation

In compression and tension directions.

Pressure-point Mechanism

Guarantees proper start of thread cutting/forming.

Secure Clamping

Secure clamping of the tap/cold forming tap by ER-GB collets with internal square.

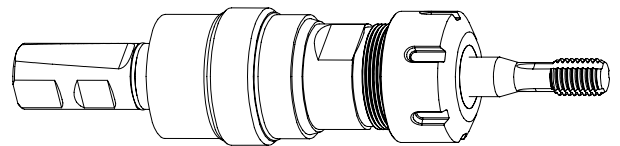
For Coolant Through Tools

Up to 50 bar coolant pressure.

Process Reliability

Increases process reliability of non-synchronous thread manufacturing.

CYL GSF/ERC Tapping Holder with Length Compensation



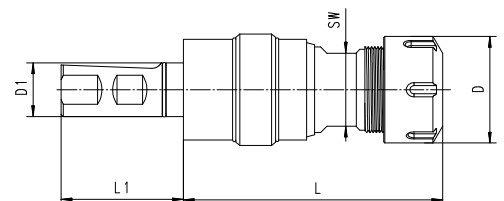
Applications

REGO-FIX® tapping holders with length compensation are used on machines without synchronization of spindle feed and the pitch of the thread. These machines require tapping holders with compression and tension compensation to compensate for the difference in spindle feed and thread pitch.

REGO-FIX® tapping holders with length compensation feature a pressure-point mechanism. This guarantees the proper start of the thread cutting or forming and also allows to produce reproducible thread depth. A special design allows to feed coolant up to 50 bar to the tap without affecting the function of the length compensation. The compact design and the short extension allow a very flexible use of REGO-FIX® tapping holders.

CYL/ERC Tapping Holders with Length Compensation

Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Com- pression [mm]	Tension [mm]	SW [mm]
CYL 25 GSF / ERM C 20	2625.62001	28	25	85	57	5.0	7.5	24
CYL 25 GSF / ERC 32	2625.63201	50	25	115	57	7.0	10.0	34



Supplied: Tapping holder with Hi-Q®/ERC clamping nut.
Matching tapping collets see page 3.4.

For adapting the tapping holders to different steep tapers, please use the appropriate WELDON toolholders.

TC/WD colletholders (DIN 69871) see page 5.11.

BT/WD colletholders (MAS 403) see page 6.19.



Swiss
Precision
Tools

PG

powRgrip® Toolholders

Features | Benefits

Swiss Quality

Made in Switzerland to ISO 9001/ISO 14001.

1 Marking

Type and part number.

2 Traceability

Lot number marking on all products for traceability through the entire manufacturing process.

3 Original REGO-FIX®

Original only with the REGO-FIX® quality seal Δ . Guarantee for best quality.

T.I.R of the whole System <3 μm

Highest clamping force and best runout in one.

Surface Finish max. Ra 0.25

Higher clamping force and higher transferable torque.

Minimal Outside Dimensions

Slim design provides more processing flexibility.

Fast

Tool clamping with hydraulic press in less than 10 seconds.

Excellent at Small Diameters

Clamping of small diameter tools from \varnothing 0.2 mm.

Presetable Tooling System

Repeatability <10 μm



Information

CYL/PG Toolholders

Applications

Cylindrical PG collet holders are designed for light load extensions of the powRgrip® collet holders.

CYL SSY/PG Softsynchro® Tapping Holders

Softsynchro® tapping holders are designed to compensate pitch differences between synchronous spindles and thread pitch.

For more details see page 9.22.

CYL GSF/PG Tapping Holders

Tapping holders with length compensation in compression and tension directions are used on machines without synchronization of spindle feed and thread pitch.

For more details see page 9.24.





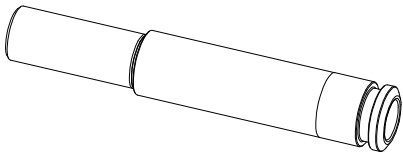
Swiss
Precision
Tools

Matching Products

powRgrip® Collets

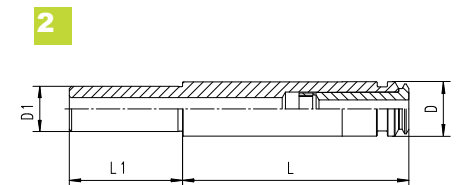
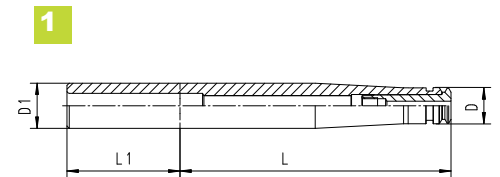
Ø [mm]	Ø [Inch]	Ø [Inch]	PG 10 Part No.	PG 10-CF Part No.	PG 15 Part No.	PG 15-CF Part No.
0.200 – 1.5875 mm powRgrip® microbore collets (PG 10-MB) see page 2.36.						
2.000	0.0787	–	1710.02000	–	–	–
2.500	0.0984	–	1710.02500	–	–	–
3.000	0.1181	–	1710.03000	1710.03002	1715.03000	1715.03002
3.175	0.1250	1/8"	1710.03181	1710.03183	1715.03181	1715.03183
3.500	0.1378	–	1710.03500	–	1715.03500	–
4.000	0.1575	–	1710.04000	1710.04002	1715.04000	1715.04002
4.500	0.1969	–	1710.04500	–	1715.04500	–
4.763	0.1875	3/16"	1710.04761	1710.04763	1715.04761	1715.04763
5.000	0.1969	–	1710.05000	1710.05002	1715.05000	1715.05002
5.500	0.2165	–	1710.05500	–	1715.05500	–
6.000	0.2362	–	1710.06000	1710.06002	1715.06000	1715.06002
6.350	0.2500	1/4"	1710.06351	1710.06353	1715.06351	1715.06353
7.000	0.2756	–	–	–	1715.07000	1715.07002
7.938	0.3125	5/16"	–	–	1715.07941	1715.07943
8.000	0.3150	–	–	–	1715.08000	1715.08002
9.000	0.3543	–	–	–	1715.09000	1715.09002
9.525	0.3750	3/8"	–	–	1715.09521	1715.09523
10.000	0.3937	–	–	–	1715.10000	1715.10002

powRgrip® clamping units and further powRgrip® accessories see page 12.7/12.8.



powRgrip® Colletholders

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	Drawing
CYL 10 / PG 10 x 120	2610.71020	16	10	120	40	2
CYL 20 / PG 10 x 120	2620.71020	16	20	120	50	1
CYL 20 / PG 10 x 160	2620.71040	16	20	160	50	1
CYL 20 / PG 10 x 200	2620.71060	16	20	200	50	1
CYL 20 / PG 15 x 120	2620.71520	24	20	120	50	2



Drawings with detailed dimensions see
search.rego-fix.ch



Swiss
Precision
Tools

PG

powRgrip® Toolholders

Features | Benefits



Quality

Made to ISO 9001/ISO 14001 standards.

1 ▶ Marking

Type and part number.

2 ▶ Traceability

Lot number marking on all products for traceability through the entire manufacturing process.

3 ▶ Quality Seal

The REGO-FIX® seal \triangle marked on the products guarantees for best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Absorbing Link

Acts as absorbing link between the synchronous spindle and the tap/cold forming tap and compensates pitch differences between threading tool and synchronous spindle.

Minimal Length Adjustment

In push- and pull direction.

Tool Shanks

All taps / cold forming taps with tool shanks in h9 tolerance can be clamped.

Secure Clamping

Secure clamping of the tap/cold forming tap by PG-TAP tapping collets with internal square.

For Coolant Through Tools

Up to 50 bar coolant pressure.

Process Reliability

Increases process reliability of synchronous tap manufacturing.

CYL SSY/PG Softsynchro® Tapping Holder

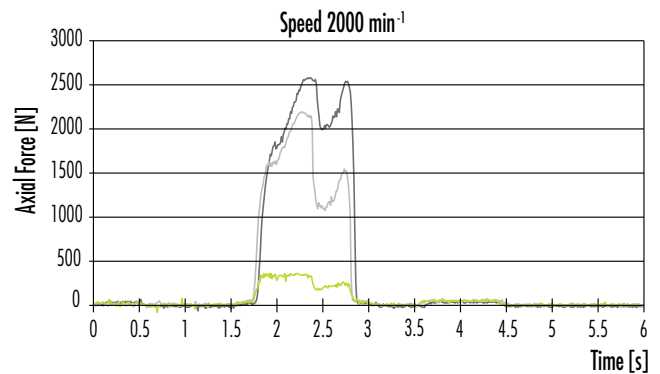
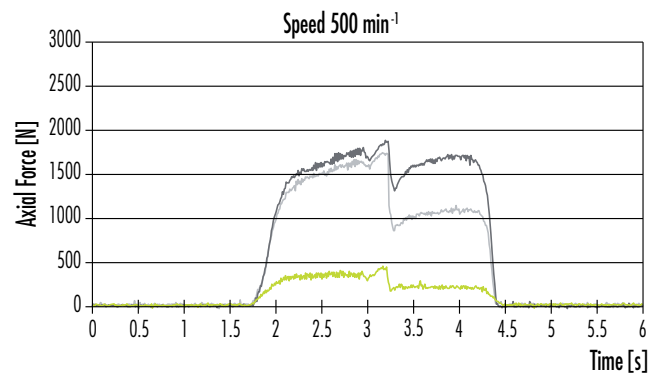
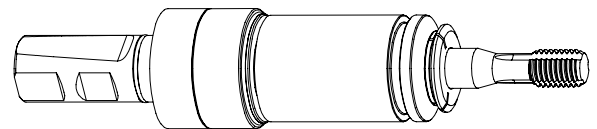
Applications

REGO-FIX® Softsynchro® tapping holders are used on machines that are designed for direct tapping. Many of the newer CNC machines feature synchronization between spindle feed and thread pitch. This allows to use rigid tapping holders. However due to the dynamics of spindle and linear motors synchronization errors occur. To compensate for these synchronization errors Softsynchro® tapping holders with minimal length adjustment are necessary. Depending on the application Softsynchro® tapping holders increase tool life up to 150%.

Comparison Tests

The two diagrams show the axial forces when cold-forming M10 threads in St37 steel.

Conclusion: Axial forces increase with increasing rpm. With REGO-FIX® Softsynchro® tapping holders the forces are considerably lower than when using rigid tapping toolholders. Therefore the surface quality and tool life is optimized when using Softsynchro® tapping holders on a synchronized machine spindle.



— REGO-FIX® Softsynchro®-Tapping holders
— Competitor synchronous collet holder
— Rigid synchronous collet holder

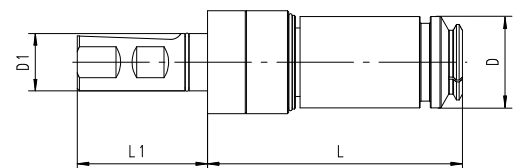
9

CYL SSY/PG Softsynchro® Tapping Holders

Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Com- pression [mm]	Tension [mm]
CYL 25 SSY / PG 15	2625.61507	24	25	92	57	0.5	0.5
CYL 25 SSY / PG 25	2625.62507	40	25	109.5	57	0.5	0.5

Matching tapping collets see page 3.12.

For adapting the tapping holders to different steep tapers, please use the appropriate WELDON toolholders.
TC/WD colletholders (DIN 69871) see page 5.11.
BT/WD colletholders (MAS 403) see page 6.19.





Swiss
Precision
Tools

PG

powRgrip® Toolholders

Features | Benefits



Quality

Made to ISO 9001/ISO 14001 standards.

1

Marking

Type and part number.

2

Traceability

Lot number marking on all products for traceability through the entire manufacturing process.

3

Quality Seal

The REGO-FIX® seal Δ marked on the products guarantees for best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Length Compensation

In compression and tension directions.

Pressure-point Mechanism

Guarantees proper start of thread cutting/forming.

Tool Shanks

All taps / cold forming taps with tool shanks in h9 tolerance can be clamped.

Secure Clamping

Secure clamping of the tap/cold forming tap by PG-TAP tapping collets with internal square.

For Coolant Through Tools

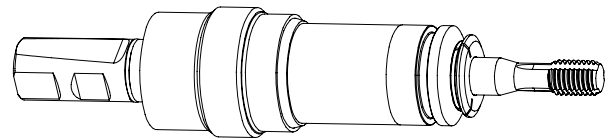
Up to 50 bar coolant pressure.

Process Reliability

Increases process reliability of non-synchronous thread manufacturing.

CYL GSF | PG DIN 1835 B+E

CYL GSF/PG Tapping Holder with Length Compensation



Applications

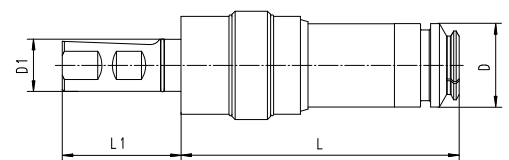
REGO-FIX® tapping holders with length compensation are used on machines without synchronization of spindle feed and the pitch of the thread. These machines require tapping holders with compression and tension compensation to compensate for the difference in spindle feed and thread pitch.

REGO-FIX® tapping holders with length compensation feature a pressure-point mechanism. This guarantees the proper start of the thread cutting or forming and also allows to produce reproducible thread depth. A special design allows to feed coolant up to 50 bar to the tap without affecting the function of the length compensation. The compact design and the short extension allow a very flexible use of REGO-FIX® tapping holders.

9

CYL GSF/PG Tapping Holders with Length Compensation

Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Com- pression [mm]	Tension [mm]
CYL 25 GSF / PG 15	2625.61508	24	25	99.5	57	5.0	7.5
CYL 25 GSF / PG 25	2625.62508	40	25	134	57	7.0	10.0



Matching tapping collets see page 3.12.

For adapting the tapping holders to different steep tapers, please use the appropriate WELDON toolholders.
TC/WD collets (DIN 69871) see page 5.11.
BT/WD collets (MAS 403) see page 6.19.