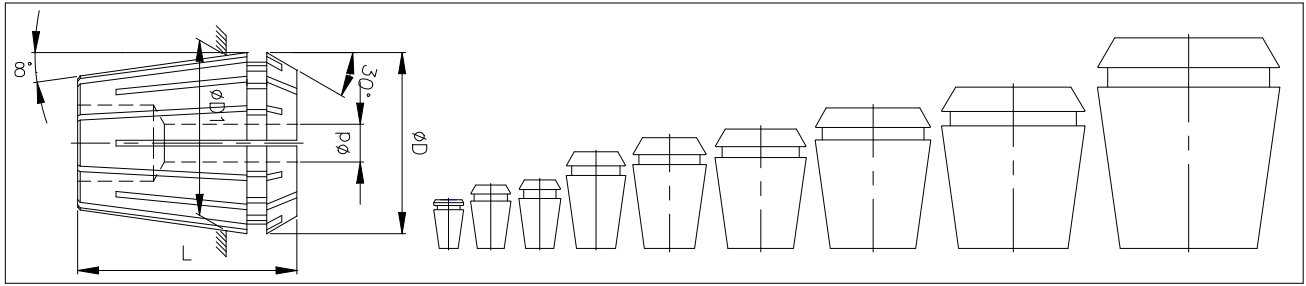


RD COLLETS—FORM B

DIN 6499—FORM B



Type of Collet	ØD	ØD1	L	BORE				Collet		
				ød		In step of		Type	Collapses by	
				mm	Inch	mm	Inch		mm	Inch
				From – To	From – To					
RD8 **	8.5	8.0	13.8	0.5–2.5	1/32–7/64	0.5	1/64	C/B *	0.5	1/64
				3.0–5.0	1/8–13/64					
RD11	11.5	11.0	18.0	0.5–2.5	1/32–7/64	0.5	1/64	C/B	0.5	1/64
				3.0–7.0	1/8–9/32					
RD12	12.0	12.0	19.5	0.5–3.0	1/32–9/64	0.5	1/64	C/B	0.5	1/64
				4.0–7.0	5/32–9/32					
RD16	17.0	16.0	27.5	1.0–4.0	3/64–3/16	1.0	1/64	C/B	1.0	1/32
				5.0–10.0	13/64–13/32					
RD20	21.0	20.0	31.5	1.0–5.0	3/64–7/32	1.0	1/64	C/B	1.0	1/32
				6.0–13.0	15/64–33/64					
RD25	26.0	25.0	34.0	1.0–5.0	3/64–7/32	1.0	1/64	C/B	1.0	1/32
				6.0–16.0	15/64–41/64					
RD32	33.0	32.0	40.0	1.0–7.0	3/64–19/64	1.0	1/64	C/B	1.0	1/32
				8.0–20.0	5/16–51/64					
RD40	41.0	40.0	46.0	2.0–9.0	5/64–3/8	1.0	1/64	C/B	1.0	1/32
				10.0–30.0	25/64–1 3/16					
RD50	52.0	50.0	60.0	6.0–10.0	15/64–15/32	2.0	5/64	C/B	2.0	5/64
				12.0–34.0	31/64–1 11/32					

** RD8 collet is without 30° nose taper

* C/B = Counterbore, T/B = Throughbore

Also available are:

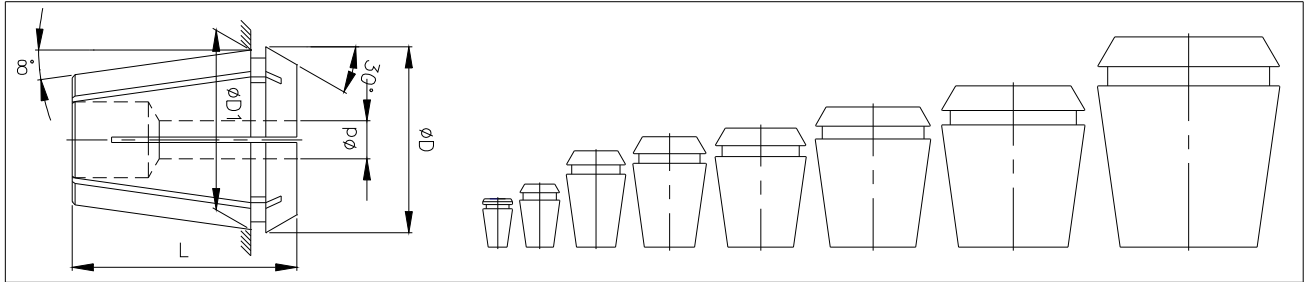
1. Any other bore size on request at extra cost
2. High precision/Ultra precision collet on request at extra cost

Note: 1. For Runout details refer page no. 3

Ordering Instruction:

RD32 – 12 – HP

Collet type
Bore size
Tolerance range
 (Refer page no.5)



Type of Collet	ØD	ØD1	L	BORE				Type
				Ød		In step of		
				mm	Inch	mm	Inch	
				From - To	From - To			
RD8 **	8.5	8.0	13.8	0.5-2.5	1/32-7/64	0.5	1/64	C/B *
				3.0-4.5	1/8-3/16			T/B *
RD11	11.6	11.0	18.0	0.5-2.5	1/32-7/64	0.5	1/64	C/B
				3.0-7.0	1/8-9/32			T/B
RD16	17.1	16.0	27.5	0.5-4.0	3/64-3/16	1.0	1/32	C/B
				5.0-10.0	13/64-13/32			T/B
RD20	21.1	20.0	31.5	1.0-6.0	3/64-17/64	1.0	1/32	C/B
				7.0-13.0	15/64-33/64			T/B
RD25	26.1	25.0	34.0	2.0-7.0	3/64-19/64	1.0	1/32	C/B
				8.0-16.0	5/16-41/64			T/B
RD32	33.1	32.0	40.0	2.0-7.0	3/64-19/64	1.0	1/32	C/B
				8.0-20.0	5/16-51/64			T/B
RD40	41.1	40.0	46.0	3.0-8.0	1/8-11/32	1.0	1/32	C/B
				9.0-30.0	23/64-1 3/16			T/B
RD50	52.1	50.0	60.0	12.0-34.0	31/64-1 11/32	2.0	5/64	T/B

** RD8 collet is without 30° nose taper

* C/B = Counterbore, T/B = Throughbore

Also available are:

1. Sealed collets for coolant through application (For details refer page no.9)
2. Any other bore size on request at extra cost
3. High precision/Ultra precision collet on request at extra cost

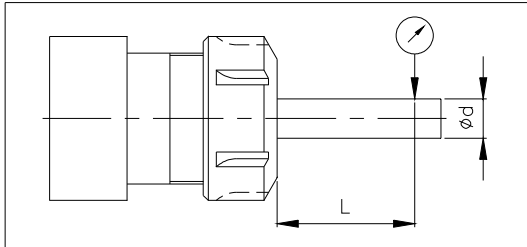
Note:

1. To be used for nominal dia shank only
2. For Runout details refer page no. 3

Ordering Instruction:

RD32 A - 12 - HP

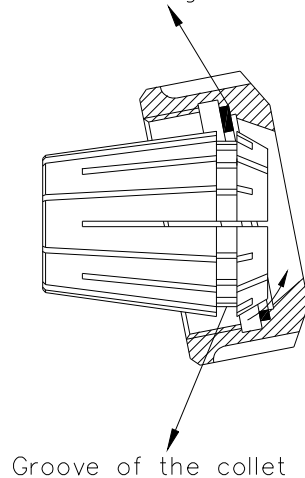
Collet type
Bore size
Tolerance range
 (Refer page no.5)

RUNOUT DETAILS:

Dia—d mm	Length—L mm (Min.)	# Tolerance mm—TIR (Max.)		
		Precision(-)	High Precision(HP)	Ultra Precision(UP)
0.5—<1.0	6.0	0.015	0.010	0.005
1.0—1.6	6.0	0.015	0.010	0.005
>1.6—3.0	10.0	0.015	0.010	0.005
>3.0—6.0	16.0	0.015	0.010	0.005
>6.0—10.0	25.0	0.015	0.010	0.005
>10.0—18.0	40.0	0.020	0.015	0.005
>18.0—26.0	50.0	0.020	0.015	0.005
>26.0—40.0	60.0	0.020	0.015	0.005

METHOD OF INSERTION & RELEASE OF RD COLLETS

Eccentric ring of nut

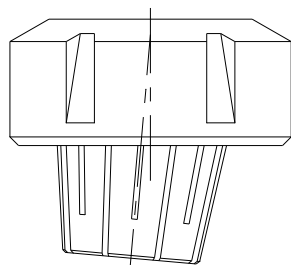


INSERTION: Introduce collet into the clamping nut at an angle as shown in the sketch and turn the nut till it snaps into the groove of the collet.

Insert the tool to be gripped into the collet and screw the nut on to the collet holder with collet securely in the nut.

Important: Never screw the nut on to the collet holder unless collet is properly seated in the nut.

Groove of the collet

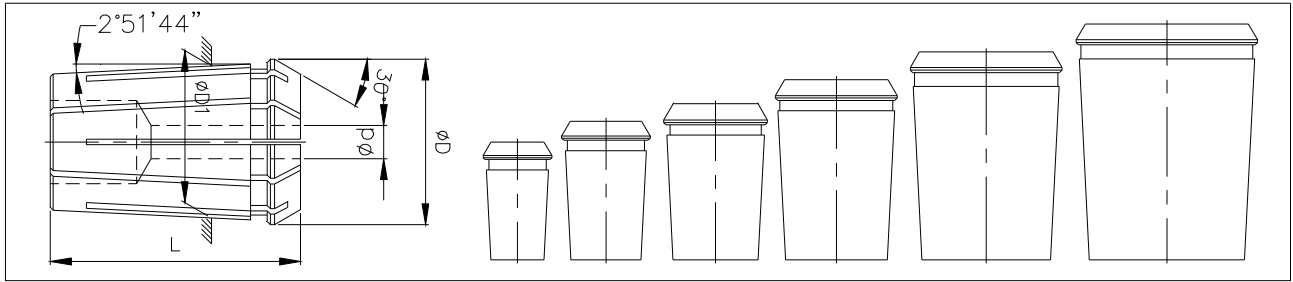


RELEASE: By unscrewing the clamping nut from the collet holder the collet is pulled automatically by means of the eccentric ring in the nut.

Hold the nut in the vertical position and remove nut at an angle.

RDO COLLETS—FORM B

DIN 6388—FORM B



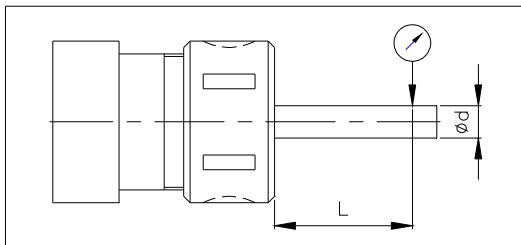
Type of Collet	ØD	ØD1	L	BORE				Collet Collapses by		
				Ød		In step of		Type	mm	Inch
				mm From - To	Inch From - To	mm	Inch			
RDO20	19.80	17.75	34.0	1.0-4.5	1/32-3/16	0.50	1/64	C/B*	0.50	1/64
				5.0-12	13/64-1/2					
RDO25	25.50	22.65	40.0	2.0-7.5	5/64-19/64	0.50	1/64	C/B	0.50	1/64
				8.0-16.0	5/16-41/64					
RDO30	29.80	27.40	45.0	2.0-8.5	5/64-11/32	0.50	1/64	C/B	0.50	1/64
				9.0-20.0	23/64-51/64					
RDO35	35.05	32.90	52.0	2.0-9.5	5/64-3/8	0.50	1/64	C/B	0.50	1/64
				10.0-26.0	25/64-1					
RDO44	43.70	41.30	60.0	4.0-11.5	5/32-29/64	0.50	1/64	C/B	0.50	1/64
				12.0-32.0	15/32-1 1/4					
RDO52	52.20	49.70	68.0	12.0-30.5	1/2-1 11/64	0.50	1/64	C/B	0.50	1/64
				31.0-40.0	1 3/16-1 37/64					

Also available are:

1. Sealed collets for coolant through application (For details refer page no. 9)
2. Any other bore size on request at extra cost
3. High precision/Ultra precision collet on request at extra cost

* C/B = Counterbore, T/B = Throughbore

RUNOUT DETAILS:



Dia-d mm	Length-L mm (Min.)	# Tolerance mm-TIR (Max.)		
		Precision(-)	High Precision(HP)	Ultra Precision(UP)
1.0-1.6	6.0	0.015	0.010	0.005
>1.6-3.0	10.0	0.015	0.010	0.005
>3.0-6.0	16.0	0.015	0.010	0.005
>6.0-10.0	25.0	0.015	0.010	0.005
>10.0-18.0	40.0	0.020	0.015	0.005
>18.0-24.0	50.0	0.020	0.015	0.005
>24.0-30.0	60.0	0.020	0.015	0.005
>30.0-50.0	80.0	0.030	0.020	0.005

Ordering Instruction:

RDO35-1/4"-HP

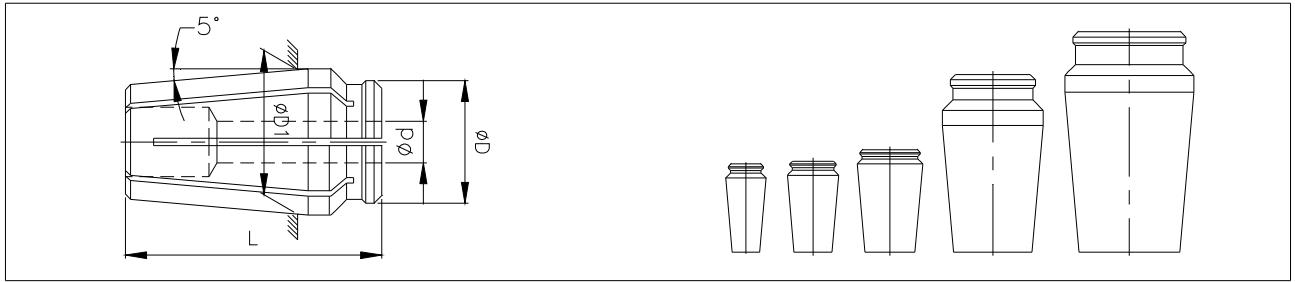
Collet type

Bore size

Tolerance range

RDF COLLETS

Interchangeable with Universal
Acura-Flex Style collet



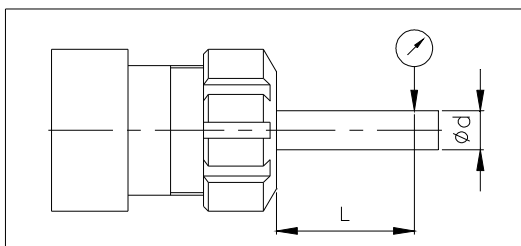
Type of Collet	ØD	ØD1	L	BORE				Collet		
				Ød		In step of		Type	Collapses by	
				Inch	mm	Inch	mm		Inch	mm
RDF25	10.19	11.112	25.40	1/32-1/16	0.5-1.5	1/64	0.50	C/B*	1/64	0.50
				5/64-1/4	2.0-6.5					
RDF38	13.36	14.275	26.20	5/64-3/8	2.0-9.5	1/64	0.50	T/B	1/64	0.50
RDF50	17.43	18.288	29.46	5/64-13/64	2.0-5.0	1/64	0.50	C/B	1/64	0.50
				5/64-1/2	2.0-12.5					
RDF75	24.54	28.727	51.20	5/64-3/8	2.0-9.5	1/64	0.50	C/B	1/64	0.50
				5/64-25/32	2.0-20.0					
RDF100	32.54	36.728	63.50	3/16-3/8	5.0-9.5	1/64	0.50	C/B	1/64	0.50
				3/16-1	5.0-25.0					

* C/B = Counterbore, T/B = Throughbore

Also available are:

1. Sealed collets for coolant through application
2. Any other bore size on request at extra cost
3. High precision/Ultra precision collet on request at extra cost

RUNOUT DETAILS:



Dia-d Inch	Length-L mm (Min.)	# Tolerance mm-TIR (Max.)		
		Precision(-)	High Precision(HP)	Ultra Precision(UP)
0.5mm-11/64	At Nose	0.025	0.015	0.005
3/16-2	2D or 25.4	0.013	0.010	0.005

Ordering Instruction:

RDF75-1/4"-HP

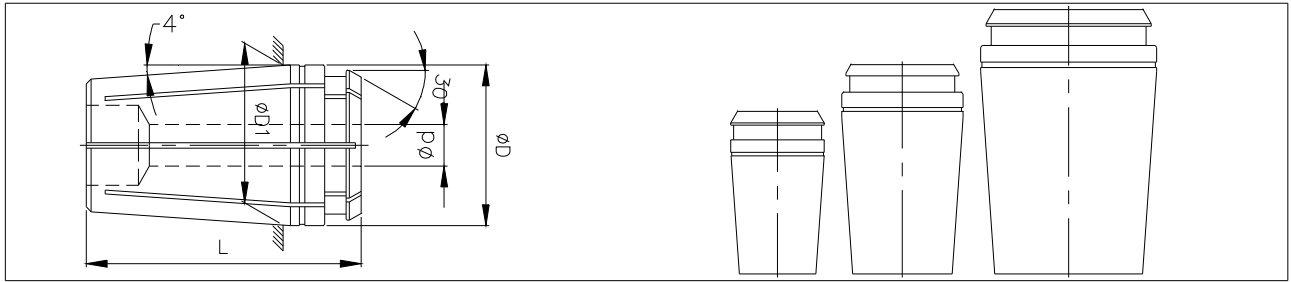
Collet type

Bore size

Tolerance range

RDG COLLETS

Interchangeable with
TG Type Collets



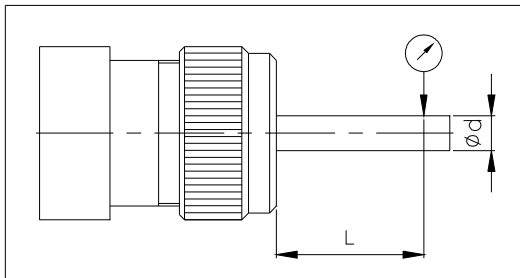
Type of Collet	ØD	ØD1	L	BORE				Collet Collapses by		
				Ød		In step of		Type	Inch	mm
				Inch	mm	Inch	mm			
RDG75	27.002	26.695	46.830	1/16-11/32	1.5-9.0	1/64	0.50	C/B*	1/64	0.50
				23/64-3/4	9.5-19.0					
RDG100	35.026	35.000	60.325	1/16-43/64	1.5-17.0	1/64	0.50	C/B	1/64	0.50
				11/16-1	17.5-25.0					
RDG150	50.825	50.698	76.200	1/2-1 13/32	12.5-35.5	1/64	0.50	C/B	1/64	0.50
				1 27/64-1 1/2	36.0-38.0					

* C/B = Counterbore, T/B = Throughbore

Also available are:

1. Sealed collets for coolant through application
2. Any other bore size on request at extra cost
3. High precision/Ultra precision collet on request at extra cost

RUNOUT DETAILS:



Dia-d mm	Length-L mm (Min.)	# Tolerance mm-TIR (Max.)		
		Precision(-)	High Precision(HP)	Ultra Precision(UP)
1.0-1.6	6.0	0.015	0.010	0.005
>1.6-3.0	10.0	0.015	0.010	0.005
>3.0-6.0	16.0	0.015	0.010	0.005
>6.0-10.0	25.0	0.015	0.010	0.005
>10.0-18.0	40.0	0.020	0.015	0.005
>18.0-26.0	40.0	0.020	0.015	0.005
>26.0-40.0	40.0	0.020	0.015	0.005

Ordering Instruction:

RDG100-1/4"-HP

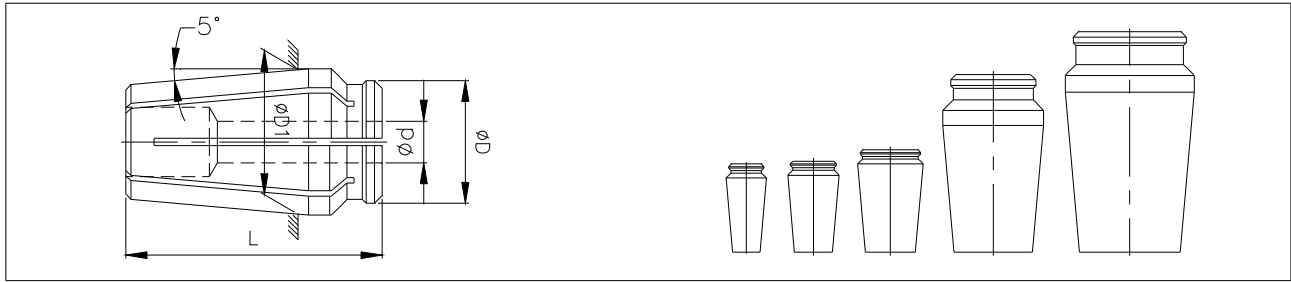
Collet type

Bore size

Tolerance range

RDF COLLETS

Interchangeable with Universal
Acura-Flex Style collet



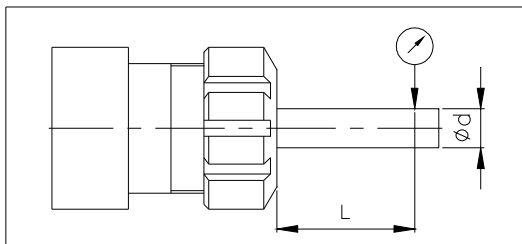
Type of Collet	ϕD	ϕD_1	L	BORE				Collet Collapses by		
				ϕd		In step of		Type	Inch	mm
				Inch	mm	Inch	mm			
				From - To	From - To					
RDF25	10.19	11.112	25.40	1/32-1/16	0.5-1.5	1/64	0.50	C/B*	1/64	0.50
				5/64-1/4	2.0-6.5					
RDF38	13.36	14.275	26.20	5/64-3/8	2.0-9.5	1/64	0.50	T/B	1/64	0.50
RDF50	17.43	18.288	29.46	5/64-13/64	2.0-5.0	1/64	0.50	C/B	1/64	0.50
				5/64-1/2	2.0-12.5			T/B		
RDF75	24.54	28.727	51.20	5/64-3/8	2.0-9.5	1/64	0.50	C/B	1/64	0.50
				5/64-25/32	2.0-20.0			T/B		
RDF100	32.54	36.728	63.50	3/16-3/8	5.0-9.5	1/64	0.50	C/B	1/64	0.50
				3/16-1	5.0-25.0			T/B		

* C/B = Counterbore, T/B = Throughbore

Also available are:

1. Sealed collets for coolant through application
2. Any other bore size on request at extra cost
3. High precision/Ultra precision collet on request at extra cost

RUNOUT DETAILS:



Dia-d Inch	Length-L mm (Min.)	# Tolerance mm-TIR (Max.)		
		Precision(-)	High Precision(HP)	Ultra Precision(UP)
0.5mm-11/64	At Nose	0.025	0.015	0.005
3/16-2	2D or 25.4	0.013	0.010	0.005

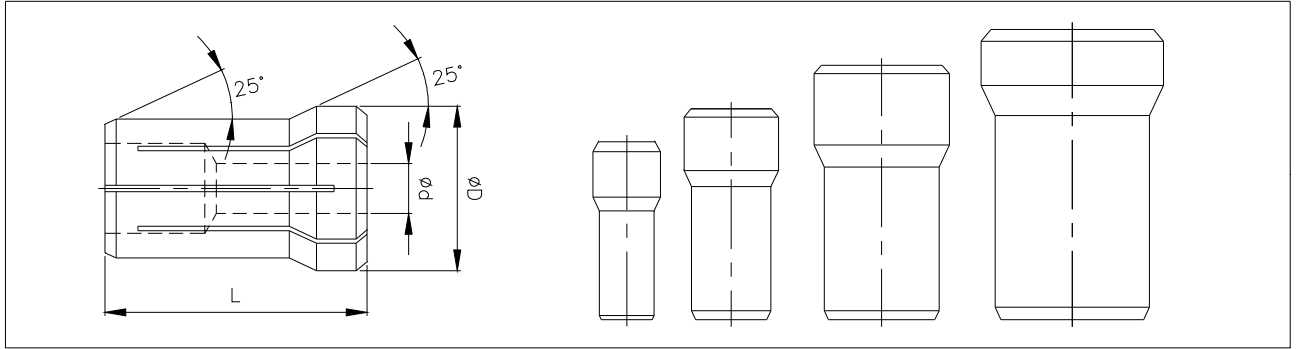
Ordering Instruction:

RDF75-1/4"-HP

Collet type RDF75 Bore size 1/4" # Tolerance range HP

RDA COLLETS

Double angle collets



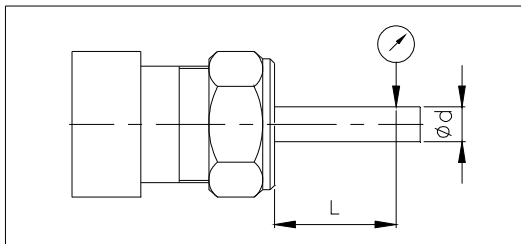
Type of Collet	øD	L	BORE				Collet		
			ød		In step of		Type	Collapses by	
			Inch	mm	Inch	mm		Inch	mm
			From - To	From - To					
RDA300	9.5	25.5	1/32-3/16	0.5-4.5	1/64	0.50	C/B*	1/64	0.50
			13/64-1/4	5.0-6.5					
RDA200	13.5	30.4	1/32-9/32	0.5-7.0	1/64	0.50	C/B	1/64	0.50
			19/64-3/8	7.5-9.5					
RDA100	19.47	36.7	1/32-7/16	0.5-11.0	1/64	0.50	C/B	1/64	0.50
			29/64-9/16	11.5-14.5					
RDA180	26.045	41.7	1/32-5/8	0.5-16.0	1/64	0.50	C/B	1/64	0.50
			41/64-3/4	16.5-19.0					

Also available are:

* C/B = Counterbore, T/B = Throughbore

1. Sealed collets for coolant through application
2. Any other bore size on request at extra cost
3. High precision/Ultra precision collet on request at extra cost

RUNOUT DETAILS:



Dia-d Inch	Length-L mm (Min.)	# Tolerance mm-TIR (Max.)		
		Precision(-)	High Precision(HP)	Ultra Precision(UP)
0.5mm-11/64	4D	0.025	0.015	0.005
3/16-3/4	25.4	0.025	0.015	0.005

Ordering Instruction:

RDA200-1/4"-HP

Collet type

Bore size

Tolerance range