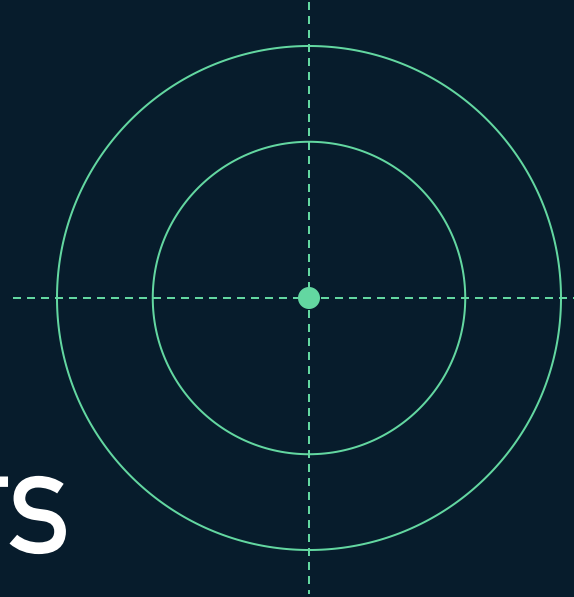


ER PRECISION COLLETS (METRIC)



High-precision round-shank collets for
drilling, milling and reaming

1–36 mm

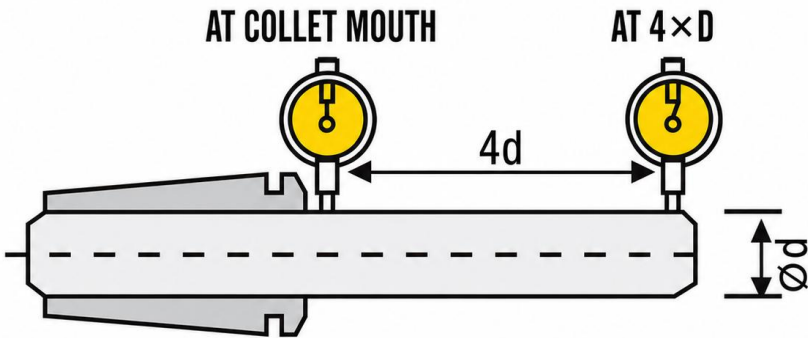
ER GRIPPING RANGE

100% inspected

VERIFIED PRECISION

**Batch inspection
report provided**

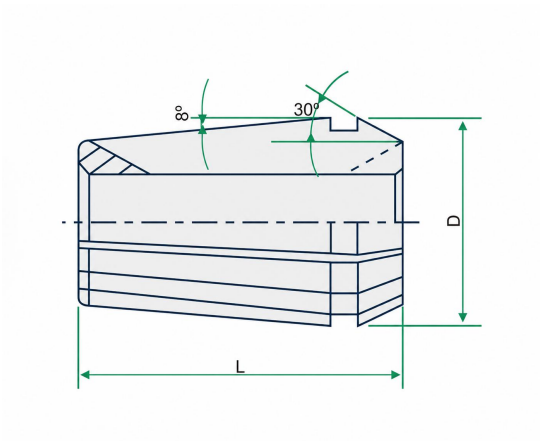




SPECIFICATION	STANDARD	AAAA	ULTRA PRECISION
Material	65Mn	65Mn	Imported SUJ2
Max. runout	8 μm	5 μm	5 μm
Hardness	HRC 46–48	HRC 46–48	HRC 56–58
Main machining use	General machining	High precision	High precision
DIN 6499 / ISO 15488 Form B	B	B	B
ER size	8–50	8–50	11–32
Shank diameter range	1.0–36.0 mm	1.0–36.0 mm	1.0–20.9 mm
Clamping range or tolerance	1.0 mm	1.0 mm	1.0 mm
Anti-corrosion coating	Available on request	Available on request	—

Seven series cover 0.5–26 mm

Dimensions are in millimetres. The nominal marking is the upper end of the published gripping range for that collet.



AVAILABLE RANGE / ER8 → ER50

SERIES	D	L	PUBLISHED NOMINAL SIZES	GRIPPING RANGE
ER8	8.5	13.5	0.5-5.0	0.5-5.0
ER11	11.5	18	1-7	0.5-7.0
ER16	17	27.5	1-10	0.5-10.0
ER20	21	31.5	1-13	0.5-13.0
ER25	26	34	2-16	1.0-16.0
ER32	33	40	2-20	1.0-20.0
ER40	41	46	2-26	1.0-26.0
ER50	41	46	2-26	4.5-36.0

Built for accurate, repeatable round-shank gripping



01

HIGH CLAMPING FORCE

Concentricity / Runout: 5 μ m
Stable accuracy helps extend tool life by up to 20%.

02

MARTENSITIC HEAT TREATMENT

One quenching cycle, two tempering cycles & one cryogenic treatment, Helps reduce deformation and cracking while improving service life, toughness and elasticity.



03

WIDE APPLICATION RANGE

Compatible with CNC machines, gang-tool lathes, grinding and milling machines, machining centers, precision engraving machines and high-gloss machining equipment.

Nominal sizes 2–10 mm

The marked size is the upper end of the published gripping range. Select from the tool’s actual round-shank diameter.

NOMINAL SIZE	CLAMPING RANGE	ORDER CALL-OUT
2	1.0–2.0	ER32 / Ø2
3	2.0–3.0	ER32 / Ø3
4	3.0–4.0	ER32 / Ø4
5	4.0–5.0	ER32 / Ø5
6	5.0–6.0	ER32 / Ø6
7	6.0–7.0	ER32 / Ø7
8	7.0–8.0	ER32 / Ø8
9	8.0–9.0	ER32 / Ø9
10	9.0–10.0	ER32 / Ø10

Nominal sizes 11–20 mm

Example: a 9.5 mm round shank requires ER32 / Ø10, with a published clamping range of 9.0–10.0 mm.

NOMINAL SIZE	CLAMPING RANGE	ORDER CALL-OUT
11	10.0–11.0	ER32 / Ø11
12	11.0–12.0	ER32 / Ø12
13	12.0–13.0	ER32 / Ø13
14	13.0–14.0	ER32 / Ø14
15	14.0–15.0	ER32 / Ø15
16	15.0–16.0	ER32 / Ø16
17	16.0–17.0	ER32 / Ø17
18	17.0–18.0	ER32 / Ø18
19	18.0–19.0	ER32 / Ø19
20	19.0–20.0	ER32 / Ø20

VERIFY HOLDER SERIES + ACTUAL SHANK DIAMETER + RUNOUT GRADE

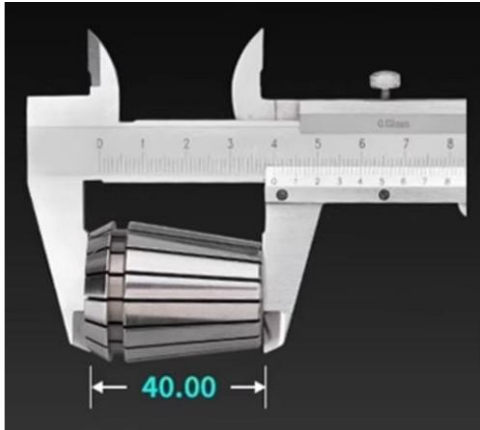
MEASURE FIRST. INSTALL CORRECTLY.

01 CONFIRM THE ER HOLDER SERIES

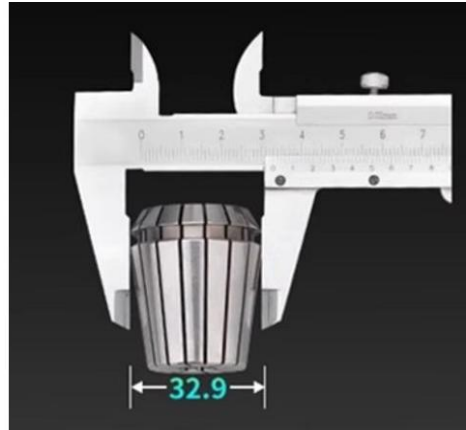
Check the ER size marked on the collet holder, chuck, or nut.

If the holder marking is unavailable

02 MEASURE OVERALL LENGTH (L)



03 MEASURE MAX. OUTSIDE DIAMETER (D)



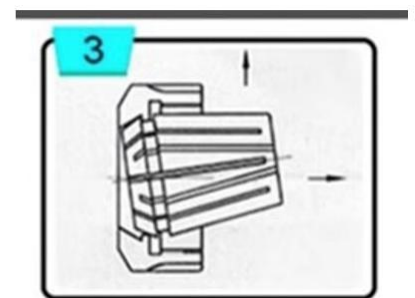
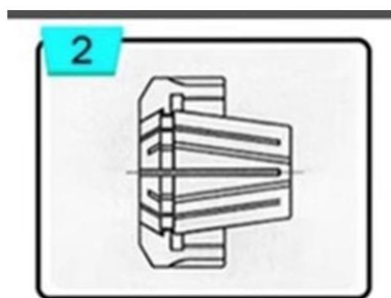
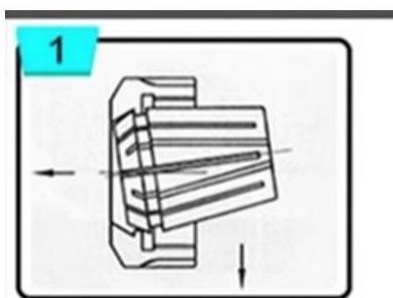
Example: L = 40mm

D ≈ 32.9 mm. These dimensions identify an ER32 collet.

04 SELECT THE NOMINAL SIZE

For best clamping and runout stability, select a nominal size close to the actual tool-shank diameter.

Ø8.0 mm → ER32 / Ø8 Ø7.6 mm → ER32 / Ø8
Ø7.0 mm → ER32 / Ø7 (PREFERRED)



INSTALL THE COLLET INTO THE NUT FIRST.

01 SNAP INTO NUT

Insert at an angle and rotate until the extraction groove seats in the nut's eccentric ring.

02 MOUNT ASSEMBLY

Mount the nut-and-collet assembly on the holder. Insert the tool, then tighten.

03 REMOVE TOGETHER

Loosen the nut with a wrench and remove the collet and tool together.

A complete request starts with the holder and tool shank

1

HOLDER SERIES

ER8 / ER11 / ER16 / ER20 / ER25 / ER32 / ER40 / ER50

2

APPLICATION

Drilling / milling / reaming; for square-drive taps request ERG

3

TOOL SHANK Ø

Actual cylindrical shank diameter in millimetres

4

COLLET SIZE

Nominal marking that covers the measured diameter

5

RUNOUT GRADE

Standard, AAAA or UP grade, subject to availability

6

QUANTITY

Individual pieces or requested set composition

ORDER EXAMPLE

ER32 / Ø10 / 9.0–10.0 mm / AAAA grade / 100 pcs

Not sure? Send the holder model and a tool-shank photo or drawing; we will verify the correct collet for you.