

# Quick-Change Tap Chucks and Collets

**New!**

## MicroFLOAT Modular Tapping

*Uses a compression float to compensate for sensitive taps and hard to start taps. Extensions for tapping at extended lengths.*

**Increase Tap Life 295%**



## Tired of Breaking Taps?

*Our Tension-Compression tap holders automatically compensate for machine feed rates to improve results.*



## Rigid Tap Chucks

*Easy to use and reliable tap holders for general tapping applications.*



## ANSI Clutch Drive & Rigid Tap Collets

*Clutch drive automatically stops spinning if tap reaches bottom of hole preventing broken taps.*



**Built for Speed.**

Quick-Change Tap Holders and Collets

# Introducing! – MicroFLOAT Tapping System



Up to 9" of extension with all MicroFLOAT modular parts

MicroFLOAT is the most flexible, modular tapping system available.

## MicroFLOAT Modular Tapping System For Extended Lengths

The MicroFLOAT Tapping System was designed to increase tap life, decrease scrap and reduce tap breakage. This revolutionary idea was born out of Techniks' many years of experience in tapping adapters. We created a system that uses the best features of all tapping systems: long tool life, quick change, thread accuracy for extended time and reduced tap breakage.

Techniks MicroFLOAT tap adapters feature 0.008" of compression for hard to start or sensitive taps, and 0.040" of tension (extension) to compensate for any inaccuracy in the machine, taps, or associated tooling and fixturing.

Optimal tapping performance is achieved when the tap follows the exact same path out as it did when it cut the threads. Any deviation causes the tap to "drag" resulting in premature tap wear and the possibility of the threads being out of tolerance. Techniks MicroFLOAT provides improved tap life and threading results.

## How the System Works

This system works much like the other high quality quick change tap adapters in our catalog. To change taps, pull the outside sleeve away from the v-flange to release the tap adapter in the toolholder so it can be changed or extensions can be added.



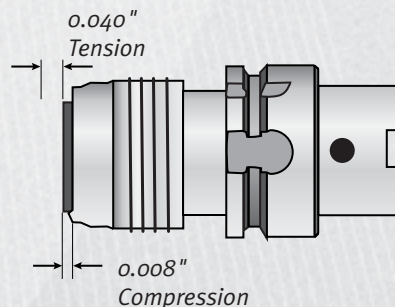
MicroFLOAT Tap Chuck (CAT40 shown)

ER16/25 Quick Change Adapter

## Advantages

- Great for older machines with backlash in spindle
- Great for production tapping
- Great for high tolerance tapping

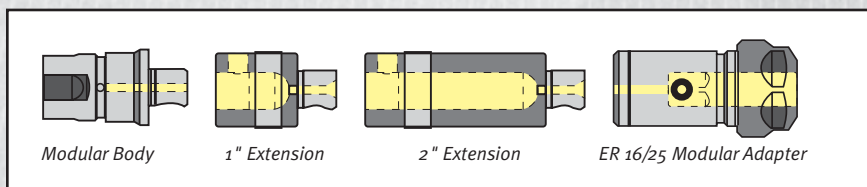
## MicroFLOAT Tension / Compression



## High-Pressure Coolant Enabled



coolant-thru tool



Modular Body

1" Extension

2" Extension

ER 16/25 Modular Adapter

NOTE:

ER16 adapter takes up to 3/8" tap.

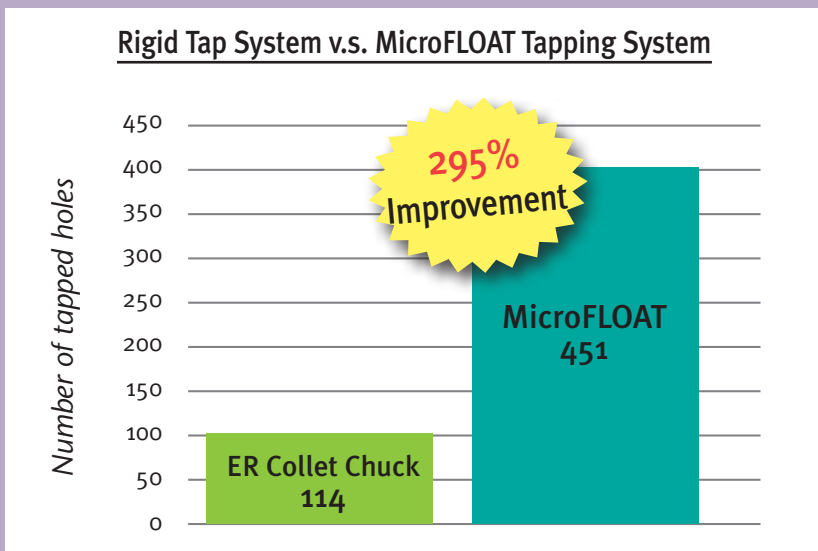
ER25 takes up to 3/4" tap.

# 295% Productivity Increase / MicroFLOAT Case-Study



## Case-Study Shows MicroFLOAT System Increases Tap Life by 295%

Techniks recently conducted a case-study comparing tapping using a rigid tap system and the new MicroFLOAT Tapping System.



## Case-Study Working Parameters

**Material:** AISI 304

### Speeds and Feeds:

$V_t = 12 \text{ m/min}$

$A_v = 1 \text{ mm/rev}$

$\text{prof} = 12 \text{ mm}$

### Test Results:

Tapped holes with rigid tap system until tap breakage: 114

Tapped holes MicroFLOAT until tap breakage: 451

**295% Improvement!**

## Directions for Use

1. Select the MicroFLOAT chuck required for your machine spindle (see page 136)
2. Select the ER adapter size and number of extensions needed for your tapping application. (see page 137)
3. To change taps, pull the outside sleeve away from the v-flange to release the tap adapter in the toolholder so it can be changed or extensions added.
4. Start tapping at 100% of pitch feed. If issues occur, program 3-5% below the pitch feed. This will engage more tension to ensure the tap does not "drag" coming out.

# CAT, BT, HSK, MicroFLOAT Tap Chucks and ER Adapters



Use MicroFLOAT chucks with ER Tap Adapters

## Features & Benefits

- Compensates for sensitive and hard to start taps
- Great for high pressure coolant applications
- Decreases cost by increasing tap life, decreasing scrap, and reducing tap breakage



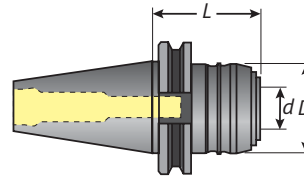
Tightening  
Stands  
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Retention  
Knobs  
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Wrenches  
pg. 204



## CAT40 & 50 MicroFLOAT Tap Chucks

Part No.	Description	L	D	d
23400-40CAT	CAT40 MicroFLOAT #1	2.75"	1.7"	0.79"
23600-40CAT	CAT40 MicroFLOAT #2	3.54"	2.36"	1.26"
23400-50CAT	CAT50 MicroFLOAT #1	2.75"	1.7"	0.79"
23600-50CAT	CAT50 MicroFLOAT #2	3.54"	2.36"	1.26"

## BT30 & 40 MicroFLOAT Tap Chucks

Part No.	Description	L	D	d
23400-30BT	BT30 MicroFLOAT #1	2.09"	1.7"	0.79"
23400-40BT	BT40 MicroFLOAT #1	2.40"	1.7"	1.26"
23600-40BT	BT40 MicroFLOAT #2	3.22"	2.36"	1.26"

## HSK63A MicroFLOAT Tap Chucks

Part No.	Description	L	D	d
23400-H63A	HSK63A MicroFLOAT #1	2.52"	1.7"	.79"

## Straight Shank MicroFLOAT Chucks

Part No.	Description	L	D	d
23400-INC1	1" SS MicroFLOAT # 1	1.3"	1.7"	0.79"
23600-INC1	1" SS MicroFLOAT # 2	2.13"	2.36"	1.26"

## ER Tap Adapter – Required

Part No.	Description	L	D	d
23410-ER16	ER16 MicroFLOAT 1 Adapter	2.16"	1.10"	.79"
23610-ER25	ER25 MicroFLOAT 2 Adapter	3.39"	1.65"	1.27"

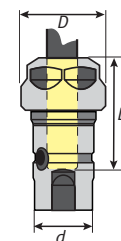
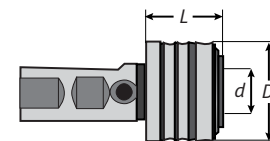
## High-Pressure Coolant Enabled



Coolant-thru tool is a standard feature on MicroFLOAT tap chucks



MicroFLOAT straight shank chuck



ER16 adapter takes up to 3/8" tap  
ER25 takes up to 3/4" tap

# MicroFLOAT Modular Tap Extensions



Use modular extensions to build gage lengths up to 9".



Use modular bodies when you use extensions.

## Modular Body

Part No.	Description	L	D	d
23411-MOD	Modular Body MicroFLOAT #1	.20"	.91"	.79"
23611-MOD	Modular Body MicroFLOAT #2	.28"	1.38"	1.26"



1" extension



2" extension

## Modular Extensions

Part No.	Description	L	D	Chuck
42150-25	1" Modular Extension MicroFLOAT #1	.98"	.91"	23400-..
42150-50	1" Modular Extension MicroFLOAT #1	1.97"	.91"	23400-..
42250-50	2" Modular Extension MicroFLOAT #2	1.97"	1.38"	23600-..
42250-100	2" Modular Extension MicroFLOAT #2	3.94"	1.38"	23600-..



ER16 Modular Adapter

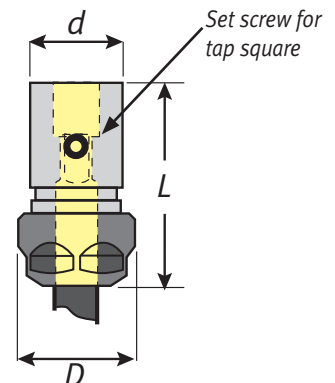
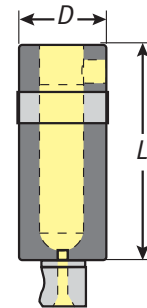
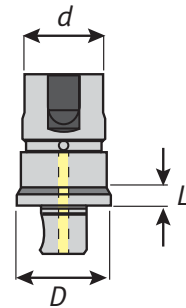
ER16 adapter takes up to 3/8" tap  
ER25 takes up to 3/4" tap

## ER Modular Adapter

Part No.	Description	L	D	d
42147-ER16	ER16 Modular Adapter MicroFLOAT #1	1.97"	1.10"	.91"
42247-ER25	ER25 Modular Adapter MicroFLOAT #2	3.11"	1.65"	1.38"

## Directions for Use

1. Select the MicroFLOAT chuck required for your machine spindle (see previous page)
2. Select the modular adapter size and number of extensions needed for your tapping application.
3. Start tapping at 100% of pitch feed. If issues occur, program 3-5% below the pitch feed. This will engage more tension to ensure the tap does not "drag" coming out.



# CAT, BT Tension / Compression Tap Holders



## Techniks Quality Features

- Adjustable compression helps start difficult taps
- Taper ground to AT<sub>3</sub> accuracy or better
- Quick-Change Style



ANSI Tap  
Collets  
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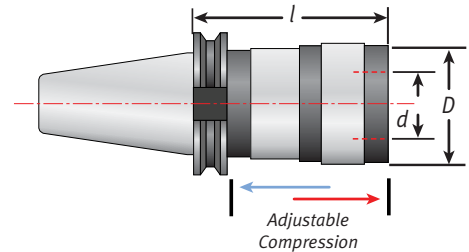
Tightening  
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Knobs  
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Wrenches  
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## CAT Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap	Compensation	
						Capacity	Tension	Compression
32400/40CAT	CAT40 T/C Holder, Size 1	0.748"	1.5"	2.36"	1	0 – 9/16"	0.35"	0.35"
32400/50CAT	CAT50 T/C Holder, Size 1	0.748"	1.5"	2.44"	1	0 – 9/16"	0.35"	0.35"
32600/40CAT	CAT40 T/C Holder, Size 2	1.220"	2.17"	3.94"	2	5/16 – 7/8"	0.59"	0.59"
32600/50CAT	CAT50 T/C Holder, Size 2	1.220"	2.17"	3.27"	2	5/16 – 7/8"	0.59"	0.59"
32800/40CAT	CAT40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50CAT	CAT50 T/C Holder, Size 3	1.890"	3.11"	5.24"	3	1/2 – 1 3/8"	0.94"	0.94"
32900/40CAT	CAT40 T/C Holder, Size 4	2.362"	3.86"	6.06"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50CAT	CAT50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

## BT Tension / Compression Tap Holders

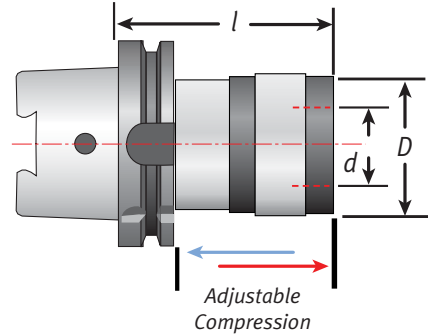
Part No.	Description	d	D	l	Size	Tap	Compensation	
						Capacity	Tension	Compression
32400/30BT	BT30 T/C Holder, Size 1	0.748"	1.5"	2.48"	1	0 – 9/16"	0.35"	0.35"
32400/40BT	BT40 T/C Holder, Size 1	0.748"	1.5"	2.68"	1	0 – 9/16"	0.35"	0.35"
32400/50BT	BT50 T/C Holder, Size 1	0.748"	1.5"	3.15"	1	0 – 9/16"	0.35"	0.35"
32600/30BT	BT30 T/C Holder, Size 2	1.220"	2.17"	3.78"	2	5/16 – 7/8"	0.59"	0.59"
32600/40BT	BT40 T/C Holder, Size 2	1.220"	2.17"	3.66"	2	5/16 – 7/8"	0.59"	0.59"
32600/50BT	BT50 T/C Holder, Size 2	1.220"	2.17"	4.02"	2	5/16 – 7/8"	0.59"	0.59"
32800/40BT	BT40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50BT	BT50 T/C Holder, Size 3	1.890"	3.11"	5.31"	3	1/2 – 1-3/8"	0.94"	0.94"
32900/40BT	BT40 T/C Holder, Size 4	2.362"	3.86"	6.18"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50BT	BT50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

# HSK & Straight Shank Tension / Compression Tap Holders



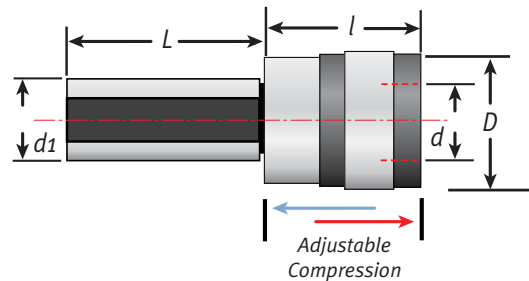
## Techniks Quality Features

- Adjustable compression helps start difficult taps
- Quick-Change Style



## HSK A Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap	Compensation	
						Capacity	Tension	Compression
34400/H40A	HSK40A T/C Holder, Size 1	0.748"	1.61"	3.14"	1	0 – 9/16"	0.295"	0.295"
34400/H50A	HSK50A T/C Holder, Size 1	0.748"	1.61"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H63A	HSK63A T/C Holder, Size 1	0.748"	1.61"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H100A	HSK100A T/C Holder, Size 1	0.748"	1.61"	3.14"	1	0 – 9/16"	0.295"	0.295"
34600/H50A	HSK50A T/C Holder, Size 2	1.22"	2.36"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H63A	HSK63A T/C Holder, Size 2	1.22"	2.36"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H100A	HSK100A T/C Holder, Size 2	1.22"	2.36"	3.94"	2	5/16 – 7/8"	0.393"	0.393"



## Straight Shank Tapping Chucks

Part No.	Description	D1	D	l	L	Tap	Compensation	
						Capacity	Tension	Compression
32400/INC1	1" shank T/C Holder, Size 1	1.00"	1.61"	1.76"	1.95"	0 – 9/16"	0.35"	0.35"
32600/INC1	1" shank T/C Holder, Size 2	1.00"	2.36"	2.52"	2.00"	5/16 – 7/8"	0.59"	0.59"
32600/INC1-1/2	1 1/2" shank T/C Holder, Size 2	1.50"	2.36"	2.52"	3.50"	5/16 – 7/8"	0.59"	0.59"
32800/INC1-1/2	1 1/2" shank T/C Holder, Size 3	1.50"	3.38"	3.85"	3.50"	1/2 – 1 3/8"	0.94"	0.94"

# CAT, BT Rigid Tap Holders



## Techniks Quality Features

- Taper ground to AT<sub>3</sub> accuracy or better
- Quick-Change Style



ANSI Tap Collets  
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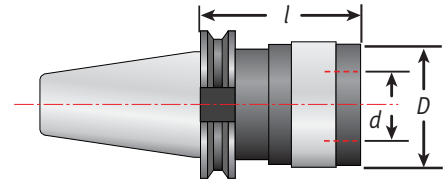
Tightening  
Stands  
pg. 206



Retention  
Knobs  
pg. 200



Wrenches  
pg. 204



## CAT Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/40CAT	CAT40 Rigid Tap Holder, Size 1	2.32"	1.31"	0.748"	1	0 – 9/16"
21480/50CAT	CAT50 Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 – 9/16"
21680/40CAT	CAT40 Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 – 7/8"
21680/50CAT	CAT50 Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 – 7/8"
21880/40CAT	CAT40 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1 3/8"
21880/50CAT	CAT50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1-3/8"

## BT Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/30BT	BT30 Rigid Tap Holder, Size 1	2.80"	1.31"	0.748"	1	0 - 9/16"
21480/40BT	BT40 Rigid Tap Holder, Size 1	2.63"	1.31"	0.748"	1	0 - 9/16"
21480/50BT	BT50 Rigid Tap Holder, Size 1	3.07"	1.31"	0.748"	1	0 - 9/16"
21680/30BT	BT30 Rigid Tap Holder, Size 2	3.70"	1.97"	1.22"	2	5/16 - 7/8"
21680/40BT	BT40 Rigid Tap Holder, Size 2	3.54"	1.97"	1.22"	2	5/16 - 7/8"
21680/50BT	BT50 Rigid Tap Holder, Size 2	3.97"	1.97"	1.22"	2	5/16 - 7/8"
21880/40BT	BT40 Rigid Tap Holder, Size 3	4.61"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/50BT	BT50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"

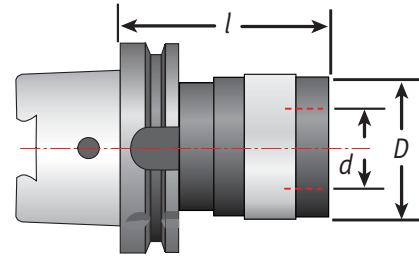


# HSK and Straight Shank Rigid Tap Holders



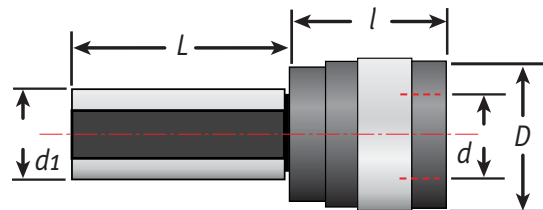
## Techniks Quality Features

- Quick-Change Style



## HSK Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/H50A	HSK50A Rigid Tap Holder, Size 1	2.30"	1.31"	0.748"	1	0 - 9/16"
21480/H63A	HSK63A Rigid Tap Holder, Size 1	2.32"	1.31"	0.748"	1	0 - 9/16"
21480/H100A	HSK100A Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 - 9/16"
21680/H50A	HSK50A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H63A	HSK63A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H100A	HSK100A Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 - 7/8"
21880/H63A	HSK63A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/H100A	HSK100A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"



## Straight Shank Rigid Tap Holders

Part No.	Description	d1	L	l	D	d	Tap Capacity
21480/INC1	1" shank, Rigid Tap Holder, Size 1	1.00"	1.95"	1.60"	1.61"	.748"	0 - 9/16"
21680/INC1	1" shank, Rigid Tap Holder, Size 2	1.00"	2.00"	2.50"	2.36"	1.22"	3/8 - 7/8"
21880/INC1-1/2	1 1/2" shank, Rigid Tap Holder, Size 3	1.50"	3.50"	3.44"	3.38"	1.89"	1/2 - 1 3/8"

# ANSI Clutch Drive Tap Collets

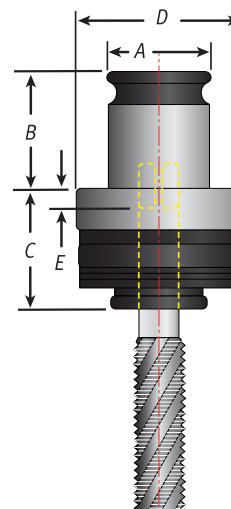


**Note:** Metric tap collets available on request. Please verify shank diameter when ordering metric tap collets.

## ANSI Clutch Drive Tap Collet Features

- Prevents broken taps
- Automatically stops spinning when bottom is reached
- Change worn taps in seconds

Dimensions	A	B	C	D	E
Size 0	.51"	.77"	.83"	.91"	.24"
Size 1	.75"	.85"	.98"	1.26"	.31"
Size 2	1.22"	1.38"	1.34"	1.97"	.16"
Size 3	1.89"	2.19"	1.77"	2.83"	.04"



## Collet Set

Part No.	Description
48/3-SET	Size 3, 16 piece set – 1/2" thru 1" NPT

## ANSI Clutch Drive Tap Collets

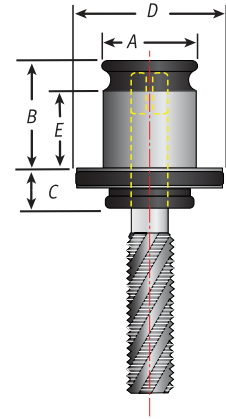
ANSI	Metric Tap / ANSI Shank	Shank	SQ	Size 0	Size 1	Size 2	Size 3
0-6"	M1.6-M3.5	0.141"	0.110"	13/0-4036	19/1-4036		
8, 5/32"	M4	0.168"	0.131"	13/0-4041	19/1-4041		
10, 3/16"	M4.5, M5	0.194"	0.152"	13/0-4048	19/1-4048		
12, 7/32"		0.220"	0.165"	13/0-4054	19/1-4054		
1/4"	M6, M6.3	0.255"	0.191"	13/0-4063	19/1-4063		
5/16"	M7, M8	0.318"	0.238"		19/1-4079	31/2-4079	
3/8"	M10	0.381"	0.286"		19/1-4095	31/2-4095	
7/16"	M11	0.323"	0.242"		19/1-4111	31/2-4111	
1/2"	M12, M12.5	0.367"	0.275"		19/1-4127	31/2-4127	48/3-4127
9/16"	M14	0.429"	0.322"		19/1-4142	31/2-4142	48/3-4142
5/8"	M16	0.480"	0.360"			31/2-4158	48/3-4158
11/16"	M18	0.542"	0.406"			31/2-4174	48/3-4174
3/4"		0.590"	0.442"			31/2-4190	48/3-4190
13/16"	M20	0.652"	0.489"			31/2-4206	48/3-4206
7/8"	M22	0.697"	0.523"			31/2-4222	48/3-4222
15/16"	M24	0.760"	0.570"				48/3-4238
1"	M25	0.800"	0.600"				48/3-4254
1 1/8, 1 1/16"	M27	0.896"	0.672"				48/3-4286
1 1/4, 1 3/16"	M30	1.021"	0.766"				48/3-4317
1 3/8, 1 5/16"	M33	1.108"	0.831"				48/3-4349
1/8" NPT		0.437"	0.328"		19/1 - 4097		
1/4" NPT		0.562"	0.421"			31/2-4131C	
3/8" NPT		0.700"	0.531"			31/2-4166C	48/3-4166C
1/2" NPT		0.687"	0.515"			31/2-4209C	48/3-4209C
3/4" NPT		0.906"	0.678"				48/3-4264C
1" NPT		1.125"	0.843"				48/3-4332C

# ANSI Rigid Tap Collets



- Change worn taps in seconds
- Quick-Change Style

Dimensions	A	B	C	D	E
Size 1	.75"	.85"	.28"	1.18"	.39"
Size 2	1.22"	1.38"	.43"	1.81"	.75"
Size 3	1.89"	2.19"	.55"	2.68"	1.18"
Size 4	2.36"	2.48"	1.65"	3.27"	1.14"



## Collet Sets

Part No.	Description
19/11-SET	Size 1, 11 piece set – 0-6" thru 9/16" & 1/8" NPT
31/13-SET	Size 2, 16 piece set – 5/16" thru 1/2" NPT
48/13-SET	Size 3, 16 piece set – 1/2" thru 1" NPT

## ANSI Rigid Tap Collets

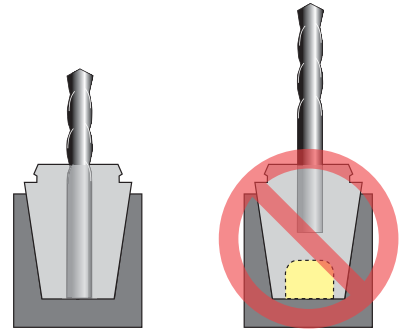
ANSI	Metric Tap / ANSI Shank	Shank	SQ	Size 1	Size 2	Size 3	Size 4
0-6"	M1.6-M3.5	0.141"	0.110"	19/11-4036			
8, 5/32"	M4	0.168"	0.131"	19/11-4041			
10, 3/16"	M4.5, M5	0.194"	0.152"	19/11-4048			
12, 7/32"		0.220"	0.165"	19/11-4054			
1/4"	M6, M6.3	0.255"	0.191"	19/11-4063			
5/16"	M7, M8	0.318"	0.238"	19/11-4079	31/12-4079		
3/8"	M10	0.381"	0.286"	19/11-4095	31/12-4095		
7/16"	M11	0.323"	0.242"	19/11-4111	31/12-4111		
1/2"	M12, M12.5	0.367"	0.275"	19/11-4127	31/12-4127	48/13-4127	
9/16"	M14	0.429"	0.322"	19/11-4142	31/12-4142	48/13-4142	
5/8"	M16	0.480"	0.360"		31/12-4158	48/13-4158	
11/16"	M18	0.542"	0.406"		31/12-4174	48/13-4174	
3/4"		0.590"	0.442"		31/12-4190C	48/13-4190	
13/16"	M20	0.652"	0.489"		31/12-4206C	48/13-4206	
7/8"	M22	0.697"	0.523"		31/12-4222C	48/13-4222	
15/16"	M24	0.760"	0.570"			48/13-4238	
1"	M25	0.800"	0.600"			48/13-4254	
1 1/8, 1 1/16"	M27	0.896"	0.672"			48/13-4286	
1 1/4, 1 3/16"	M30	1.021"	0.766"			48/13-4317	
1 3/8, 1 5/16"	M33	1.108"	0.831"			48/13-4349	
1 1/2, 1 7/16"	M36	1.233"	0.925"				60/14-4381C
1 5/8"	M39	1.305"	0.925"				60/14-4412C
1 3/4"	M42	1.430"	1.072"				60/14-4444C
1 7/8"		1.520"	1.139"				60/14-4476C
1/8" NPT		0.437"	0.328"	19/11-4097			
1/4" NPT		0.562"	0.421"		31/12-4131C		
3/8" NPT		0.700"	0.531"		31/12-4166C	48/13-4166C	
1/2" NPT		0.687"	0.515"		31/12-4209C	48/13-4209C	
3/4" NPT		0.906"	0.678"			48/13-4264C	
1" NPT		1.125"	0.843"			48/13-4332C	

# Tightening Torque Specifications Chart

## Recommended Collet & Retention Knob Tightening Torque

Collet	Nut Type	Collets I.D. OVER 1/16" (2mm)	Collets I.D. UNDER 1/16" (2mm)	Order Torque Wrench Adapter
ER16	slotted	42 ft/lbs	30 ft/lbs	04580-16
ER16	hex	42 ft/lbs	30 ft/lbs	04601-16
ER20	slotted	59 ft/lbs	24 ft/lbs	04580-20
ER20	hex	59 ft/lbs	24 ft/lbs	04602-20
ER25	slotted	77 ft/lbs	77 ft/lbs	04503-25
ER25	mini nut	25 ft/lbs	25 ft/lbs	04587
ER32	slotted	100 ft/lbs	100 ft/lbs	04604-32
ER40	slotted	130 ft/lbs	130 ft/lbs	04605-40
SYOZ 25	hook	90 ft/lbs	90 ft/lbs	03690-25
TG 75	slotted	90 ft/lbs	90 ft/lbs	04604-32
TG 100	hook	90 ft/lbs	90 ft/lbs	03690-25

Retention Knobs	Wrench Flats	Drive	Torque	Order Socket
BT30 Taper	0.535"	1/4"	36 ft/lbs	PSS-30BT
ISO 30 Taper	0.535"	3/8"	36 ft/lbs	PSS-30ISO
Any 40 Taper	0.750"	3/8"	76 ft/lbs	PSS-40
BT50 Taper	1.187"	1/2"	99 ft/lbs	PSC-50
CAT50 Taper	1.250"	1/2"	99 ft/lbs	PSC-50



For maximum holding power fill the collet all the way with the tool shank (left) and use a PowerCOAT nut.

## DIRECTIONS

1. Snap collet into nut.
2. Insert cutting tool into collet. Make sure shank extends to the bottom of the collet.
3. Hand tighten collet nut assembly into toolholder.
4. Insert toolholder assembly into tightening fixture and secure it.
5. Tighten collet nut to recommended torque using a torque wrench and adapter.