

Collets

Continued 

Clamping range mm	Shank Ø mm	Length mm	Mount	Chuck extensions		Clamping sleeves	
				21698	...	Clamping sleeve Ø mm	21699
1-6	14 h6	100	DIN 6535-HA straight shank		101	1	101
1-6	14 h6	150	DIN 6535-HA straight shank		102	2	102
1-6	20 h6	100	DIN 6535-HB Weldon		104	3	103
1-6	20 h6	150	DIN 6535-HB Weldon		105	4	104
						5	105
						6	106

21519 - 21525

ER collets



Design

- Fully hardened and ground
- Ground, concentricity accuracy 0.015 mm

Applications

In standard collet chucks.

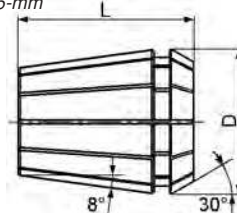
21519

Set in plastic case

Note:

The clamping bridge is up to 1 mm smaller, e.g. 9-8 mm, except in the case of 1-mm and 1.5-mm collet chucks (then only 0.5 mm).

Plastic collet chuck box, see AQURADO bearing system HHW catalogue Volume 2 (tools + machines) art. no. 84134.



21520 - 21525

Individual parts Clamping diameter mm	Type ER 11/4008 E D x L 11.5 x 18mm		Type ER 16/426 E D x L 17 x 27.5 mm		Type ER 20/428 E D x L 21 x 31.5 mm		Type ER 25/430 E D x L 26 x 34 mm		Type ER 32/470 E D x L 33 x 40 mm		Type ER 40/472 E D x L 41 x 46 mm	
	21520	...	21521	...	21522	...	21523	...	21524	...	21525	...
1.0		101		101								
1.5		102		102								
2.0		103		103		103		103				
2.5		104		104								
3.0		105		105		105		105			105	
3.5		106										
4.0		107		107		107		107		107		107
4.5		108										
5.0		109		109		109		109		109		109
5.5		110										
6.0		111		111		111		111		111		111
6.5		112										
7.0		113		113		113		113		113		113
8.0				114		114		114		114		114
9.0				115		115		115		115		115
10.0				116		116		116		116		116
11.0						117		117		117		117
12.0						118		118		118		118
13.0						119		119		119		119
14.0								120		120		120
15.0								121		121		121
16.0								122		122		122
17.0										123		123
18.0										124		124
19.0										125		125
20.0										126		126
21.0												127
22.0												128
23.0												129
24.0												130
25.0												131
26.0												132

Set

Type	D x L mm	Contents	Clamping range mm	Increasing by mm	21519	...
ER 11/4008 E	11.5 x 18.0	13 pieces	1-7	0.5		100
ER 16/426 E	17.0 x 27.5	10 pieces	1-10	1.0		101
ER 20/428 E	21.0 x 31.5	12 pieces	2-13	1.0		105
ER 25/430 E	26.0 x 34.0	15 pieces	2-16	1.0		102
ER 32/470 E	33.0 x 40.0	18 pieces	3-20	1.0		103
ER 40/472 E	41.0 x 46.0	23 pieces	4-26	1.0		104

21519 103



FAHRION®
PRÄZISION**Design**

- Fully hardened and ground
- **Protective coating for longer precision and quality**, concentric accuracy 0.005 mm

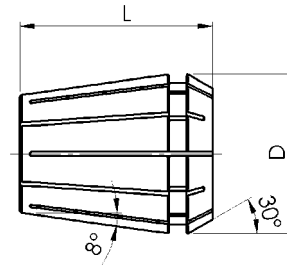
Applications

In standard collet chucks.

Note:

The clamping bridge is up to 1 mm smaller, e.g. 9–8 mm, except in the case of 1-mm and 1.5-mm collet chucks (then only 0.5 mm).

Plastic collet chuck box, see *AQURADO* bearing system *HHW* catalogue Volume 2 (tools + machines) art. no. 84134.



21534 - 21539

Individual parts	Type GERC 11-B/4008 E		Type GERC 16-B/426 E		Type GERC 20-B/428 E		Type GERC 25-B/430 E		Type GERC 32-B/470 E		Type GERC 40-B/472 E	
	D x L 11.3 x 18.0 mm		D x L 17 x 27.5 mm		D x L 21 x 31.5 mm		D x L 26 x 34 mm		D x L 33 x 40 mm		D x L 41 x 46 mm	
Clamping diameter mm	21534	...	21535	...	21536	...	21537	...	21538	...	21539	...
1.0		201		201								
1.5		202		202								
2.0		203		203		203		203				
2.5		204		204								
3.0		205		205		205		205		205		207
3.5		206										
4.0		207		207		207		207		207		208
4.5		208										
5.0		209		209		209		209		209		209
5.5		210										
6.0		211		211		211		211		211		211
6.5		212										
7.0		213		213		213		213		213		213
8.0				214		214		214		214		214
9.0				215		215		215		215		215
10.0				216		216		216		216		216
11.0						217		217		217		217
12.0						218		218		218		218
13.0						219		219		219		219
14.0								220		220		220
15.0								221		221		221
16.0								222		222		222
17.0										223		223
18.0										224		224
19.0										225		225
20.0										226		226
21.0												227
22.0												228
23.0												229
24.0												230
25.0												231
26.0												232

21519

Set supplied in wooden case

21519 205

Set						
Type	D x L mm	Contents	Clamping range mm	Increasing by mm	21519	...
GERC 11-B/4008 E	11.3 x 18.0	13 pieces	1–7	0.5		201
GERC 16-B/426 E	17.0 x 27.5	10 pieces	1–10	1.0		202
GERC 20-B/428 E	21.0 x 31.5	12 pieces	2–13	1.0		203
GERC 25-B/430 E	26.0 x 34.0	15 pieces	2–16	1.0		204
GERC 32-B/470 E	33.0 x 40.0	18 pieces	3–20	1.0		205
GERC 40-B/472 E	41.0 x 46.0	23 pieces	4–26	1.0		206



Collets

21546 - 21550 GERC-HP precision collet chucks

DIN
6499

B



21546 - 21550

FAHRION®
PRÄZISION

Design

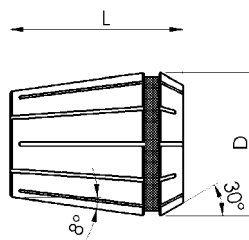
- Fully hardened and ground
- **Protective coating for longer precision and quality**, concentric accuracy 0.002 mm
- System accuracy and repeatability in conjunction with CENTRO|P 0.003 mm
- Without clamping bridge

Applications

For CENTRO|P collet chucks and ATORN precision collet chucks.

Note:

For sealing washers, see art. no. 21513 (only available online).
Plastic collet chuck box, see AQURADO bearing system HHW catalogue Volume 2 (tools + machines) art. no. 84134.



Clamping Ø mm	Type GERC 11-HP/4008 E D x L 11.3 x 18mm		Type GERC 16-HP/426 E D x L 17 x 27.5 mm		Type GERC 25-HP/430 E D x L 26 x 34 mm		Type GERC 32-HP/470 E D x L 33 x 40 mm	
	21546	...	21547	...	21549	...	21550	...
1.0		201		201				
1.5		202		202				
2.0		203		203		203		
2.5		204		204				
3.0		205		205		205		205
3.5		206						
4.0		207		207		207		207
4.5		208						
5.0		209		209		209		209
5.5		210						
6.0		211		211		211		211
6.5		212						
7.0		213		213		213		213
8.0				214		214		214
9.0				215		215		215
10.0				216		216		216
11.0						217		217
12.0						218		218
13.0						219		219
14.0						220		220
15.0						221		221
16.0						222		222
17.0								223
18.0								224
19.0								225
20.0								226



21561 - 21566

GERC-HPD sealed precision collet chucks for CENTRO|P



Design

- Protective coating for longer precision and quality, fully hardened, ground and sealed
- Concentricity 0.002 mm
- Without clamping bridge

Applications

For internally cooled tools in CENTRO|P collet chuck and ATORN precision collet chuck.

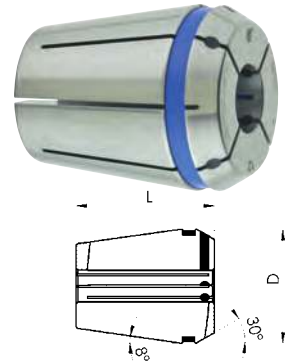
Note:

Plastic collet chuck box, see AQUARADO bearing system HHW catalogue Volume 2 (tools + machines) art. no. 84134.



21566 120

21561 - 21566



Individual Clamping Ø mm	Type GERC11-HPD/4008 E D x L 11.3 x 18.0 mm		Type GERC16-HPD/425 E D x L 17 x 27.5 mm		Type GERC25-HPD/429 E D x L 26 x 34 mm		Type GERC32-HPD/469 E D x L 33 x 40 mm	
	21561	...	21563	...	21565	...	21566	...
3		101		101				
4		102		102		101		101
5		103		103		102		102
6		104		104		103		103
7				105		104		104
8				106		105		105
9				107		106		106
10				108		107		107
11						108		108
12						109		109
13						110		110
14						111		111
15						112		112
16						113		113
17								114
18								115
19								116
20								117

Set Contents	Clamping Ø mm	Type GERC16-HPD/425 E D x L 17 x 27.5 mm		Type GERC25-HPD/429 E D x L 26 x 34 mm		Type GERC32-HPD/469 E D x L 33 x 40 mm	
		21563	...	21565	...	21566	...
Six pieces	3 - 4 - 5 - 6 - 8 - 10		120				
Seven pieces	4 - 6 - 8 - 10 - 12 - 14 - 16				120		
Eight pieces	4 - 6 - 8 - 10 - 12 - 14 - 16 - 20						120

21567 - 21569

GERC-HPDD sealed precision collet chucks with spray nozzle for CENTRO|P



Design

- Protective coating for longer precision and quality, completely hardened and ground, sealed with spray nozzle
- Concentricity 0.002 mm
- Without clamping bridge

Applications

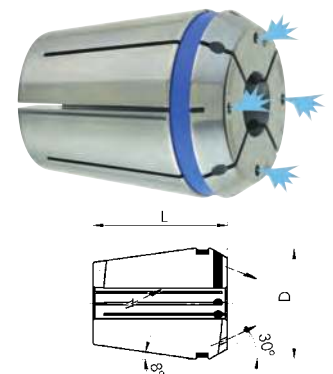
For tools without internal cooling in CENTRO|P collet chuck and ATORN precision collet chuck.

Note:

Plastic collet chuck box, see AQUARADO bearing system HHW catalogue Volume 2 (tools + machines) art. no. 84134.

Clamping Ø mm	Type GERC16-HPDD/425 E D x L 17.0 x 27.5 mm		Type GERC25-HPDD/429 E D x L 26 x 34 mm		Type GERC32-HPDD/469 E D x L 33 x 40 mm	
	21567	...	21567	...	21569	...
4		201		101		101
6		202		102		102
8		203		103		103
10				104		104
12				105		105
14				106		106
16						107
18						108
20						109

21567 - 21569



21526 - 21528 ER collet chucks for thread cutting



Design

Square drive for driving the screw tap. Without length compensation.

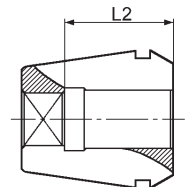
Applications

For clamping screw taps in collet chucks. Use only on synchronous machines.

Note:

Plastic collet chuck box, see AQURADO bearing system HHW catalogue Volume 2 (tools + machines) art. no. 84134. **21528**

Shank diameter mm	Square mm	L2 mm	ER 16/4031 E		ER 25/4282 E		ER 32/4537 E	
			21526	...	21527	...	21528	...
3.5	2.7	18			201		201	
4.5	3.4	18			202		202	202
5.5	4.3	18			203		203	203
6.0	4.9	18			204		204	204
7.0	5.5	18			205		205	205
8.0	6.2	22			206		206	206
9.0	7.0	22			207		207	207
10.0	8.0	25			208		208	208
11.0	9.0	25					209	209
12.0	9.0	25					210	210
14.0	11.0	25					211	211
16.0	12.0	25					212	212



21552 - 21554 OZ collets

Design

- Spring steel, completely hardened and ground
- Through hole to increase the clamping force

Advantages:

- Improved concentricity
- Higher clamping force due to increased contact ratio
- Higher system rigidity and tool life

Note:

Plastic collet chuck box, see AQURADO bearing system HHW catalogue Volume 2 (tools + machines) art. no. 84134.

21552 - 21554



Clamping Ø mm	Type 415 E For chuck size 2-16 mm D x L 25.5 x 40 mm		Type 462 E For chuck size 3-25 mm D x L 35.05 x 52 mm		Type 467 E For chuck size 4-32 mm D x L 44 x 60 mm	
	21552	...	21553	...	21554	...
2	101					
3	102		102			
4	103		103		103	
5	104		104		104	
6	105		105		105	
7	106		106		106	
8	107		107		107	
9	108		108		108	
10	109		109		109	
11	110		110		110	
12	111		111		111	
13	112		112		112	
14	113		113		113	

Clamping Ø mm	Type 415 E For chuck size 2-16 mm D x L 25.5 x 40 mm		Type 462 E For chuck size 3-25 mm D x L 35.05 x 52 mm		Type 467 E For chuck size 4-32 mm D x L 44 x 60 mm	
	21552	...	21553	...	21554	...
15	114		114		114	
16	115		115		115	
17					116	
18					117	
19					118	
20					119	
22					120	
24					121	
25					122	
26					123	
28					124	
30					125	
32					126	

21581 - 21582 Reducing sleeves



21581 Design

Sealed for hydraulic expansion chucks.

21581



21582 Design

No seal for power chucks.

21582



Suitable in D ₁ mm	Reduction to D ₂ mm	21581	...	21582	...
12	3	093			
12	4	094			
12	5	095			
12	6	096			
12	8	097			
20	3	098		098	
20	4	099		099	
20	5	100		100	
20	6	101		101	
20	8	102		102	
20	10	103		103	
20	12	104		104	
20	14	105		105	

Suitable in D ₁ mm	Reduction to D ₂ mm	21581	...	21582	...
20	16		106		106
32	3				110
32	4				111
32	5				112
32	6			113	113
32	8			114	114
32	10			115	115
32	12			116	116
32	14			117	117
32	16			118	118
32	18			119	119
32	20			120	120
32	25			121	121



21509

Accessories for CENTRO|P precision collet chuck



FAHRION®
PRÄZISION

Note:

Clamping nuts CENTRO|P (art. no. 21509 102–106 and 21509 002–006) must only be used in conjunction with roller wrenches (art. no. 21509 200–206) or roller wrench adapters (no. 21509 301–306).

21509 101
Mini clamping nut

21509 200-206
Roller wrenches

21509 101

21509 102-106
Standard clamping nuts

21509 301-306
Roller torque wrench adapters



21509 102+104+106

21509 103

			Clamping nuts	
Size	For Collet chucks	Ø D mm	21509	...
HPC 11 M	ER 11/4008 E	16	101	
HPC 16	ER 16/426 E	30	102	
HPC 16C	ER 16/426 E	24	103	
HPC 25	ER 25/430 E	40	104	
HPC 32	ER 32/470 E	50	106	

			Roller wrenches	
Size	For clamping nut		21509	...
RO 16	HPC 11 M		200	
RO 24	HPC 16C		201	
RO 30	HPC 16		202	
RO 40	HPC 25		204	
RO 50	HPC 32		206	

											Roller wrench adapters		
Size	For clamping nut	Ø mm	Torque max. Nm	Ø mm	Torque max. Nm	Ø mm	Torque max. Nm	Ø mm	Torque max. Nm	Ø mm	Push-fit mount mm	21509	...
DRO 24	HPC 16C	1.0	10	1.5–3.5	15–20	4.0–10.0	25–30	-	-	-	9 x 12	301	
DRO 30	HPC 16	1.0	10	1.5–3.5	25–30	4.0–10.0	50–55	-	-	-	9 x 12	302	
DRO 40	HPC 25	1.0–3.0	25–30	3.5–6.5	35–40	7.0–10.0	55–60	10.5–16.0	80–90	-	14 x 18	304	
DRO 50	HPC 32	2.0–3.0	30–35	3.5–6.5	55–60	7.0–15.5	110–120	16.0–20.0	130–140	-	14 x 18	306	



21518

Replacement standard clamping nuts

ATORN®

Clamping range mm	Collet chuck type	Ø D mm	21518	...
1–10	AER 16	30	101	
1–16	AER 25	40	102	
2–20	AER 32	50	103	



21518

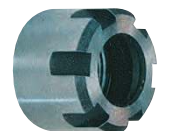
21517

Replacement mini clamping nuts

Design

For collet chucks of type ER.

Clamping range mm	Outer Ø d mm	Collet chuck type	Thread	21517	...
1–7	16	ER 11/4008 E	M 13 x 0.75	101	
1–10	22	ER 16/426 E	M 19 x 1	102	
1–13	28	ER 20/428 E	M 24 x 1	103	
2–16 of	35	ER 25/430 E	M 30 x 1	104	



21517

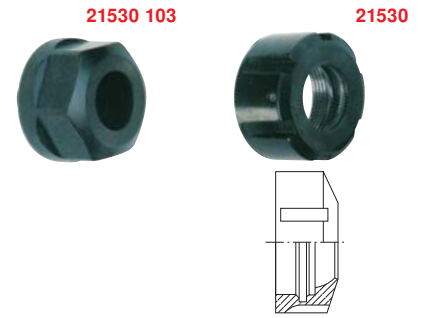
Clamping technology

21530 Spare clamping nuts

Applications
For collet chucks of type ER.

Note:
Open-ended spanner for nut art. no. 21530 103 see HHW catalogue Volume 2 (tools + machines) art. no. 50113 235.

For clamping range mm	For type ER	Nuts Ø mm	21530	...
1-10	16	SW 25/28		103
1-10	16	32		104
1 - 16	25	42		105
2 - 20	32	50		106
3 - 26	40	63		107



21562 OZ clamping nuts

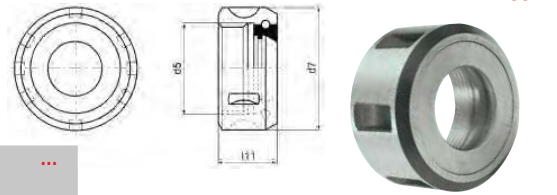


Design
Ball-bearing union nut.

Note:
Spanner, see HHW catalogue Volume 2 (tools + machines) art. no. 50650 et seq.

Applications
For collet chuck no. 21540-21545.

For clamping range mm	d5	d7	l11	21562	...
2-16	M 33 x 1.5	43	24.0		101
3-25	M 48 x 2.0	60	30.0		102
4-32	M 60 x 2.5	72	33.5		103



21516 Chuck key

Design
Special steel, bronzed, ground upright.

Applications
For collet chucks of type ER mini.

For clamping range mm	Collet chuck type	21516	...
1-7	ER 11/4008 E		101
1-10	ER 16/426 E		102
1-13	ER 20/428 E		103
1-16	ER 25/430 E		104



21532 Chuck key

Design
Made from special steel, hardened and bronzed, with hanging hole.

Applications
For collet chucks of type ER.

For clamping range mm	For type ER	For nuts Ø mm	Total length mm	21532	...
1-10	16	32	160		103
1 - 16	25	42	203		104
2 - 20	32	50	253		105
3 - 26	40	63	285		106



Clamping technology

21570 - 21571

Pressure collet chucks



21570

Design

Type 173 E, dimensions: diameter d 48 x diameter D 60 x L 94 mm, K = 30°. DIN 6343/F48.

21571

Design

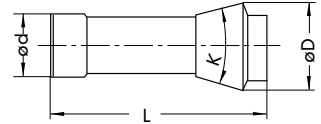
Type 185 E, dimensions: diameter d 66 x diameter D 84 x L 110 mm, K = 30°. DIN 6343/F66.

Note:

Smooth bore up to 7 mm diameter, with transverse grooves from 8 mm diameter.

Collet chucks with square or hexagonal profiles deliverable on request.

21570



Bore mm	173 E		185 E	
	21570	...	21571	...
3		101		
4		102		
5		103		103
6		104		104
7		105		105
8		106		106
9		107		107
10		108		108
11		109		109
12		110		110
13		111		111
14		112		112
15		113		113
16		114		114
17		115		115
18		116		116
19		117		117
20		118		118
21		119		119
22		120		120

Bore mm	173 E		185 E	
	21570	...	21571	...
23		121		121
24		122		122
25		123		123
26		124		124
27		125		125
28		126		126
29		127		127
30		128		128
31		129		129
32		130		130
33		131		131
34		132		132
35		133		133
36		134		134
37		135		135
38		136		136
39		137		137
40		138		138
41		139		139
42		140		140

Bore mm	173 E		185 E	
	21570	...	21571	...
43				141
44				142
45				143
46				144
47				145
48				146
49				147
50				148
51				149
52				150
53				151
54				152
55				153
56				154
57				155
58				156
59				157
60				158

21572

Emergency pressure collet chucks



Design

- Hardened to approx. 45 HRC
- Fully ground

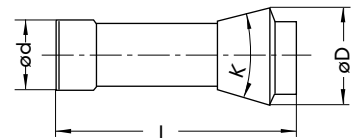
Applications

For self-machining to the desired diameter or stepped bore.

Note:

Can be machined in the chuck using three dowel pins inserted in the face end.

21572



Type	Ø D mm	Ø d mm	L mm	Pre-bored to Ø mm	21572	...
173 E	60	48	94	3		101
185 E	84	66	110	6		102

21573

Interior stops for pressure collet chucks

Applications

For pressure collet chucks in accordance with DIN 6343. As a stop for turned parts. Can also be used for hollow parts. Suitable for round, hexagonal and square collet chucks.

21573



For collet chuck type	21573	...
173 E		101
185 E		102

Clamping technology