

HIGH PRECISION COLLETS & GUIDE BUSHES

FOR SWISS TYPE CNC AUTOMATIC LATHES

VERSION 23.04



**Manufacturer of High-Precision collets,
carbide lined guide bushes for swiss type automatic lathes**

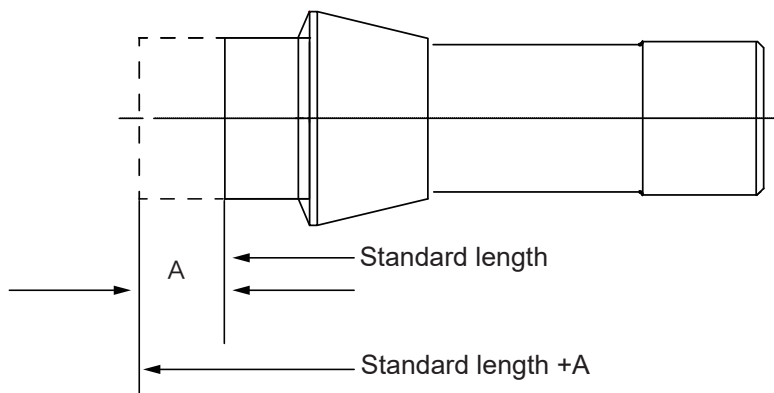


CITIZEN, STAR, TSUGAMI, HANWHA, TORNOS, TORNOS(CAM), NOMURA, TRAUB,
KSI, NEXTURN, KITAMURA, EGURO , METHODS (CAM) , PETERMANN (CAM) ,
STROHM (CAM) , Hardinge, Bechler (CAM), MAIER, JINN FA, RIKEN, TAKAMAZ,
TUAUB, INDEX, LI CO, MIYNO, CHIAH CHYUN

Technical Information

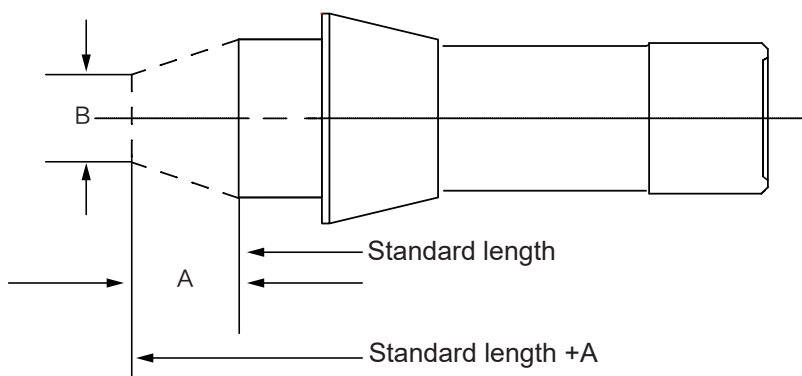
● Extended Nose Collets:

When ordering extended nose collets or bushings, please refer to the diagrams as below. It is helpful to us in insuring accuracy if you supply the "A" dimensions when ordering.



Straight nose

"A" must be given when collet is ordered.



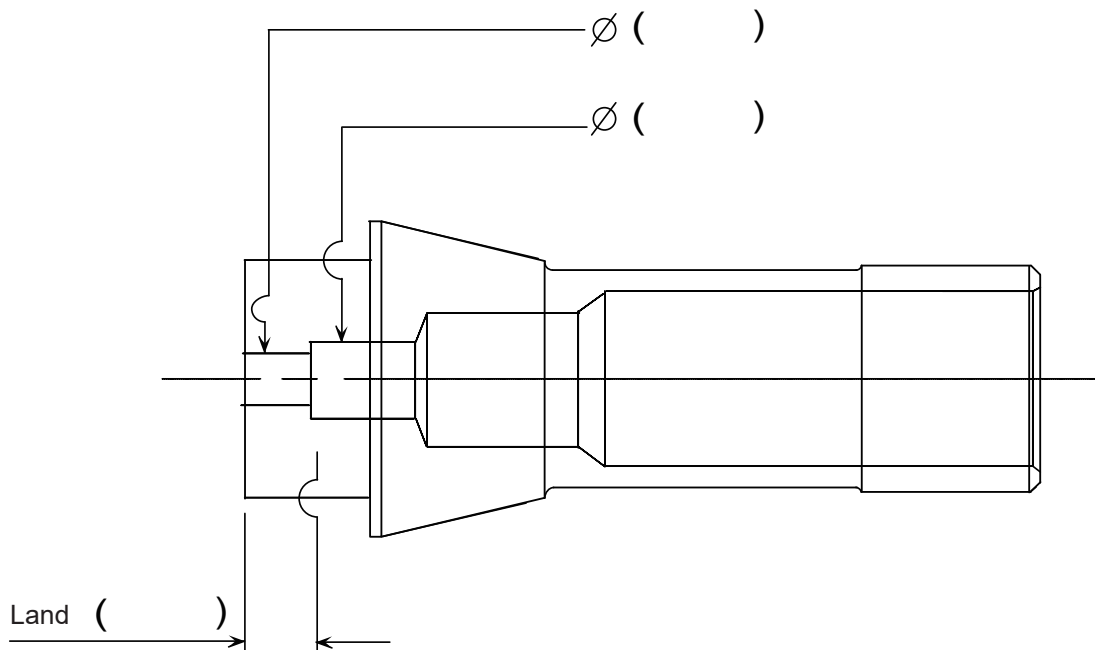
Tapered nose

"A" must be given when collet is ordered.
and give B if you have specific requirement
or go with our standard.

● Overgrip Collets:

Overgrip collets are used when the collet must be sprung open to clear a larger diameter and grip on a smaller diameter behind that larger diameter.

EXAMPLE: the threads of a screw measure 6.5mm and the shank of the screw between the threads and the head of the screw is 6.0mm. You are inserting the screw "thread end first" into the sub-spindle collet. The collet would have to open up enough to clear the 6.5mm and grip on the 6.0. Since the shank of the screw is a given length, the 6.0mm bore of the collet must have a specific length assigned to it. We call that the "**LAND**". Since the machine has limited stroke when opening and closing a collet, you may want to contact the machine manufacturer to see if your specific application would be possible....



When ordering, please supply the following information:

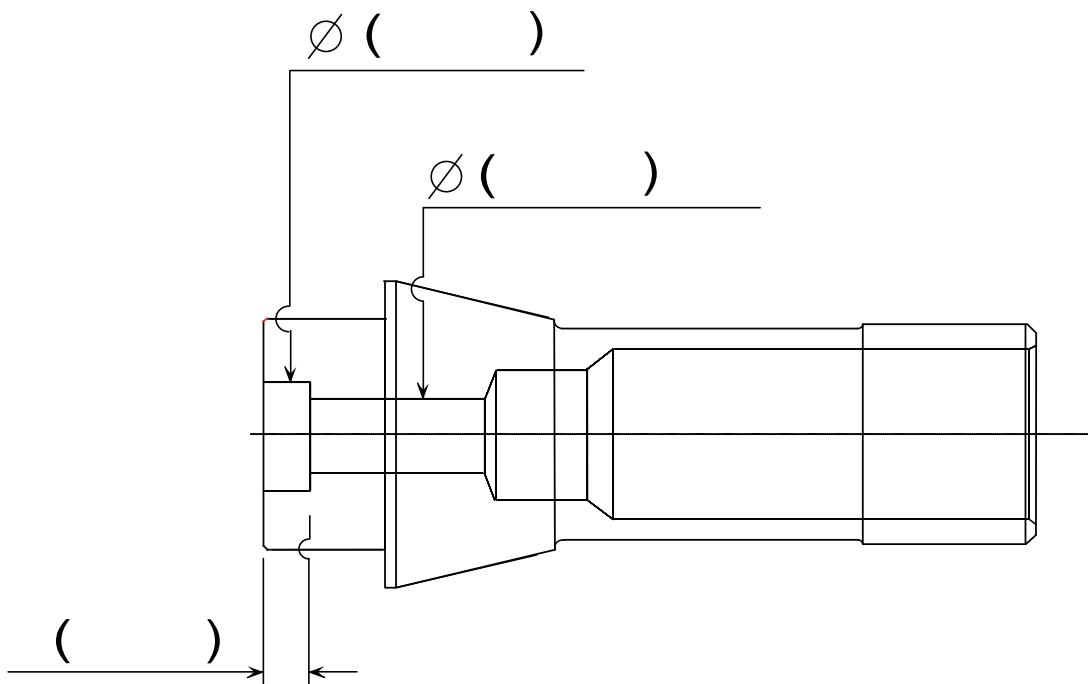
Bore diameter

Overgrip diameter

Land

● Step Bore Collets:

Step bore collets are used when the collet must hold 2 or more different diameters of a given part. **EXAMPLE:** A part has a diameter of 6.35mm for 3.8 in length, then steps down to 5.08mm. You are inserting the 5.08mm diameter into the sub spindle first and you need to grip both the 5.08 and the 6.35 diameters. The collet would have both bores in it, the 6.35 at the face of the collet and into the collet for a length of 3.8. The 5.08 bore behind the 6.35 bore would run into the backbore of the collet.

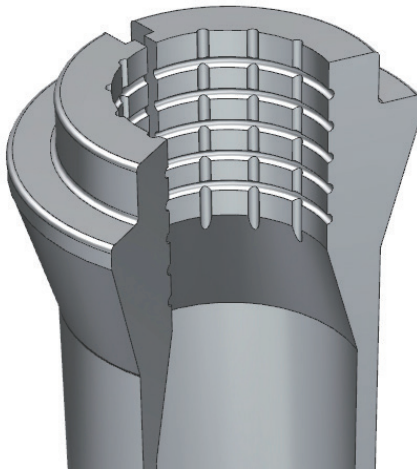


When ordering, please specify Step bore collet
And supply the following information:
Bore diameter
Depth of bore
Thru bore diameter

● Powerful Groove

Available from Bore Ø 8.00mm above.

Collets with Powerful Groove are used for extra gripping force. We wire slots along the bore length to provide a **waffle pattern**. When ordering, please specify "Powerful Groove"



● Collet Bores (Smooth / Groove):

Please note:

Headstock collet bore diameters within 6 mm are normally smooth. Bore diameters 6.0mm and larger are normally grooved.

IF YOU ARE ORDERING A PICKOFF COLLET (sub-spindle collet), it is imperative that you specify smooth bore if that is what you need. Many machines use the same collet in the pick-off attachment that is used in the headstock. While pick-off collets generally require a smooth bore. For this reason, if you require a collet for a pick-off operation (sub spindle collet), please specify smooth bore when ordering.

●Extra long carbide lined Max for Guide bushing

As the bore diameter gets larger, the bore length will increase by bore group. Please see table below.

Bore size(mm)	Standard carbide lined length(mm)	Max Carbide lined length (3*STD mm)
$\Phi < 0.8$	OA	
$0.8 \leq \Phi \leq 1$	5.7	OA
$1 < \Phi \leq 1.5$	2	6
$1.5 < \Phi \leq 2$	5	15
$2 < \Phi \leq 3$	7	21
$3 < \Phi \leq 5$	10	30
$5 < \Phi \leq 8$	11	33
$8 < \Phi \leq 10$	13	39
$10 < \Phi \leq 14$	14	42
$14 < \Phi \leq 17$	16	48
$17 < \Phi \leq 20$	18	54
$20 < \Phi \leq 23$	22	66
$23 < \Phi \leq 24$	24	72
$24 < \Phi \leq 32$	25	75

When ordering please supply Carbide lined length you need or go with our standard.

●PVC collets and bushings

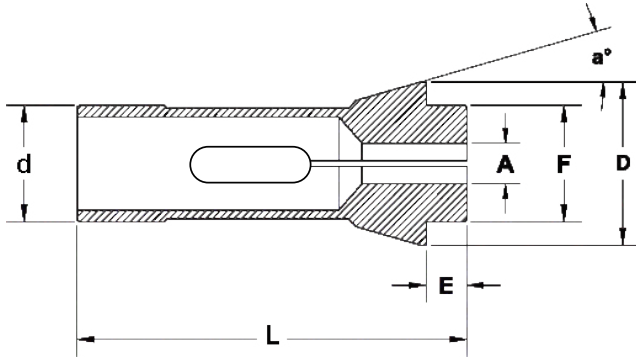
PVC inserted collets and bushings are now available for those parts that require minimal scratching. More other bore material option: Carbide,brass.

●V-SLOT,S-SLOT

We offer S/V slotting on the finish slots to help prevent scratching. Collets and bushings ordered with S/V slotting must have an even number of slots.

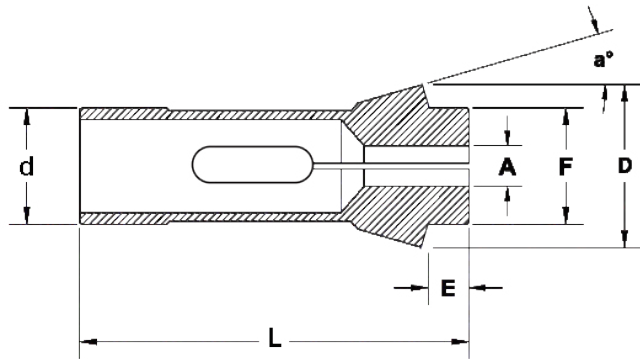
For more option please see Page 22

COLLETS(HEADSTOCK,PICK-OFF) STRAIGHT SHOULDER



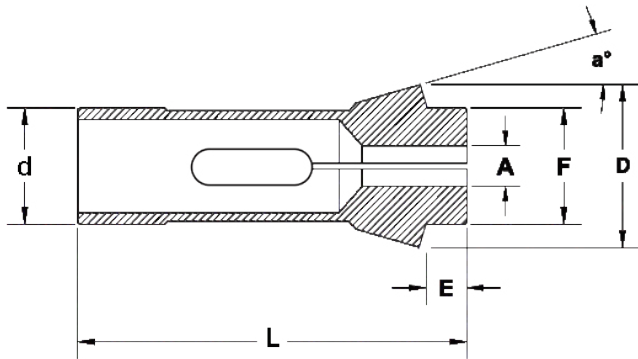
Order Code	d	D	L	E	F	α	A Max			US code	Swiss code	
							Round	Hexagon	Square			
ININSF6/76	6	10	30			15°	4.5				100E	F6 76-599
INSF7/66	7	10.7	26	2.9	7	15°	4.5	3	3		1020E	F7 76-66
INSF7/206	7	10.5	26	3	7	15°	4.5	3	3			
INSF8/577	8	12	42	4.5	8	16°	5.5	4	3	TF8	101E	F8 76-577
INSF8/1079	8	12	41	3.5	8	16°	4.5	3	3			
INSF8/102	8	13.7	30		8	21°	6				102E	
INSF8/103	8	14	35		8	15°	5				103E	
INSF8/36	8	11.6	36	3	8	15°						
INSF10/86	10	15.5	47.5	5.5	10	20°	7	5	4	TF10	109E	F10 76-86
INSF10/1178	10	16	46	4	10	20°	7	5	4		111E	F10 76-1178
INSF10/9054	10	16	47	5	10	20°	7	6	5			
INSF10/9096	10	15	43	5	10	15°	6.5	5	4		110E	F10 76-720
INSF12/78	12	18.1	44.5	4.3	12	15°	8	6	5		1155E	F12 76-78
INSF12/578	12	18	64	6	12	16°	8	6	5	TF12	114E	F12 76-578
INSF13/357	13	19	64	6	13	16°	10	8	7	TF13	116E	F13 76-357
INSF14/99	14	20	47	4	14	20°	10	8	7			
INSF15/358	15	22	47	5	15	20°	10.5	9	7		121E	F15 76-358
INSF15/580	15	21	64	6	15	16°	11	9	8	TF15	120E	F15 76-580
INSF15/9005	15	20	45.5	2.5	15	15°	10	8	7			
INSF15/9012	15	21	64	6	17.5	16°	11.5	9	8			
INSF16/104	16	22	55	5	16	15°	12	10	8		123E	F16 76-104
INSF16/1076	16	21	64	6	16	16°	12	10	8	TF16	EF16/1212E	F16 76-1076
INSF16/9070	16	21	62	4	16	16°	12	10	8			
INP10C	16	22	50			15.5°				P1053C		P10C
INSF18/85	18	25	67	7	19.5	15°	14	11	9		127E	F18 76-85
INSF18/579	18	24	64			16°				TF18	128E	F18 76-579
INSF20/87	20	28	67	7	21	16°	16	13	11	TF20	138E	F20 76-87
INSF20/102	20	27.5	60	5	20	15°	16	13	11		1299E	F20 76-02
INSF20/108	20	27.5	69			15°					137E	
INSF20/201	20	26	54	5	19	15°	16	13	11		136E	F20 76-201
INSF20/9026	20	26	67	3	19	16°	16	13	11			
INP16C	20	26	68			13°40'				P1653C		P16C
INSF22/727	22	32	66	7	25	16°	17	15	12		F22 727	
INSF22/88	22	28	67			13°					139E	F22 76-88
INSF23.8/9020	23.8	28	62	7	22	15°	18	15	12	TF24	ETF 24	S16HMS
INSF24/9003	24	28	62	7	22	15°	17	15	12			
INSF25/64	25	35	77	10	27	16°	20	17	14	TF25	145E	F25 76-64
INSF25/91	25	34	65	6	25	15°	20	17	14	0156	144E	F25 76-91
INSF25/581	25	31	54			15°	20	14	14		143E	F25 76-581
INSF25/9015	25	35	85	18	27	16°	20	17	14			
INSF25/9091	25	35	72	5	27	16°	20	17	14			
INSF26/90	26	32	67	7	27.5	13°	20.5	17	14		146 E	F26 76-90
INSF26/9021	26	36	67	7	28	15°	20.5	17	14			
INP20C	26		72			15°				NN20KFC		P20C
INSF27/22	27	38	72.7	8	30	15°	23	19	16	TF27	147E	F27 76-22
INSF28/9004	28	35	77	10	27.5	16°	22.5	19	16	BS20	S20-HM	
INSF30/63	30	42	80	10	34	16°	25	21	17	TF30	157E	F30 76-63
INSF30/101	30	38	65	6	32	15°	25	21	17	0161	EF30/1446E	F30 76-101
INSF30/9044	30	42	80	12	32	16°	25	22	18		S25-HS	
INSF30/9066	30	42	78	10	32	16°	25	22	18			
INSF32/1023	32	40	65	6	34	15°	26	22	18	0166	0166	F32 1023
INP25C	32	42	85			13°				P2553C		P25C
INSF33/9043	33	40	80	12	32	16°	28	24	20		S25-HM	
INSF34/77	34	44	80			16°				TF34	165E/1497E	F34 76-77
INSF37/740	37	47	92	10	40	16°	32	27	22	TF37	EF37/1536E	F37 76-740
INSF37SP	36.98	47	92	10	40	16°7'	32	27	22	TF37SP		
INSF39/1208	39	46	80			15°	32	27	22		EF39/1208E	
INSF40/9074	40	50	92	10	43	16°	35	30	24	TF40	ETF40	
INSF40/47	40	47	92			16°	36			EF40		F40
INP30C	42	52	85			13°				NN30TC		P30C
INSF44/9082	44	52	92	10	44	16°30'	38	32	27	TF44		F44 76-92
INSF44.4/9061	44.4	54.5	64	8.5	42	15°	37	31	26			

COLLETS(HEADSTOCK,PULL TYPE) TAPERED SHOULDER



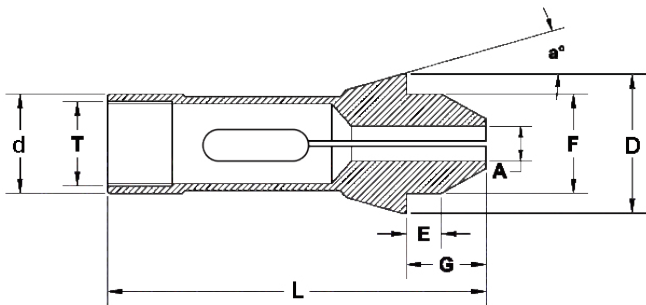
Order Code	d	D	L	E	F	α	A Max			US code	Swiss code	
							Round	Hexagon	Square			
INSF14/98	14	18	46	4	14	13°	10	8	7		117E	F14 76-98
ININSF22/71	22	30	55			15°	16	15	10		140E	F22 71
INSF28/93	28	38	70	7	28	15°	23	19	16		148E	F28 76-93
INSF32/221	32	45	75	8	34	15°	26	22	18	TF32	161E	F32 76-221
INSF35/67	35	43	70			15°	30	24	20		162E	F35 76-67
INSF35/94	35	48	80	8	38	15°	30	25	21		163E	F35 76-94
INSF37/9087	37	44	91	5.7	38	16°	32	27	22			
INSF38/72	38.08	49	107.5	9	38	15°	32	27	22		164E	F38 76-72
INSF42/99	42	55	94	9	42	15°	36	30	25		171E	F42 76-99
INSF40/01	40	54.5	104			18°						
INSF43/37	43	53	92	10	46	16°	38	33	27	TF43	TF43	
INSF43/9078	43	53	92	10	42	15°	35	30	25			
INSF48/38	48	54	100	10	44	15°	39	34	28	BS38	BS38	
INSF48/81	48	60	94	9	50	15°	42	36	29	TF48	173E	F48 76-81
INSF54/01	54	87	68			19°						
INSF58/355	58	70	94	9	60	15°	51	44	36		177E	F58 17-355
INSF60/01	60	89	72			16°						
INSF66/359	66	84	110	9	73	15°	59	48	39		185E	F66 76-59
INSF72/187	72	90	142			15°					187E	
INSF75/01	75	100	93			15°						
INSF84/188	84	100	142			15°					188E	
INSF88/190	88	106	115			15°					190E	
INSF90/193	90	107	130			15°					193E	
INSF95/194	95	116	200			15°					194E	
INSF105/195	105	125	172			15°					195E	
INSF112/196	112	138	120			15°					196E	
INSF44 4/BNC34	44.4	54.2	108			15°						
INSF30/AD25	30	43	66	5.5	33	15°						
INSF48/AD40	48	66	84			15°						
INSF56/AD50	56	68	94		58	15°						
INSF75/AD65	75	93	100	9	79	15°						
INSF40/C32	40	54	104			18°						
INSF54/C44	54	68	87			19°						
INSF60/C50	60	72	89			16°						
INSF75/C60	75	93	100			15°						
INSF85/C75	85	98	110									

COLLETS - OVER GRIPPING



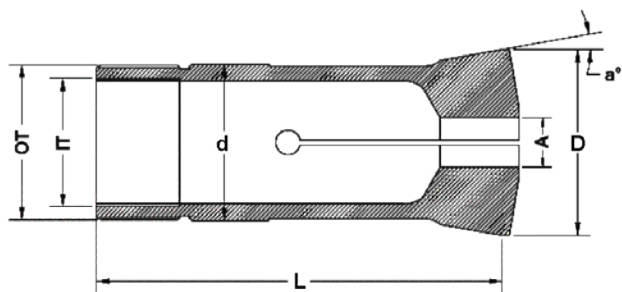
Order Code	d	D	L	E	F	α
INSF25/9089	25	35	77	10	24	48°
INSF37/9112	37	44	91	6	36	16°

LONG NOSE COLLETS WITH INTERNAL THREAD



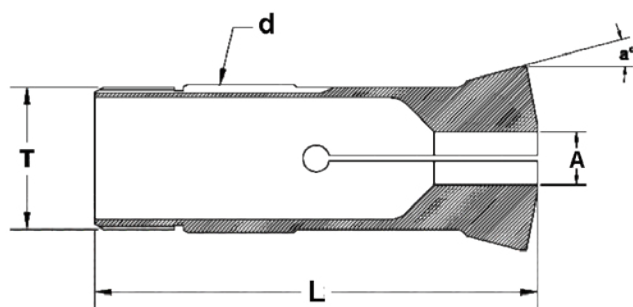
Order Code	d	D	L	G	E	F	α	T	A Max		
									Round	Hexagon	Square
INSF13/2014	13	19	70	12	6	13	16°	M11x0.75	9.5	8	6
INSF16/830	16	21	66	8	6	16	16°	M14x0.75	12.5	10	8
INSF16/2015	16	21	71	13	6	16	16°	M14x0.75	12.5	10	8
INSF20/2016	20	26	62	13	5	19	15°	M18x1	15.5	13	11
INSF25/2018	25	35	85	18	9	27	16°	M22x1	20	17	14

MACHINED COLLETS



Order Code	d	D	L	OT	IT	A Max			α
						Round	Hexagon	Square	
5C	1.250"	1.468	3.281"	1.238"*20TPI	1.041"*24TPI	26.99	23.02	19.05	10°
16C	1.889"	2.265"	4.312"	1.870"*1.75TPI	1.687"*20TPI	41.28	35.72	28.97	10°
20C	2.378"	2.880"	6.250"	2.359"*1.5TPI	M53*1mm	50.8	44.45	36.11	10°
25C	2.930"	3.470"	6.480"	2.871"*1.5TPI	25 / 8"*24 TPI	65	56.29	45.92	10°
3J	2.000"	2.205"	3.750"	1.988"*20	1.79"*24TPI	44.45	38.89	31.75	10°

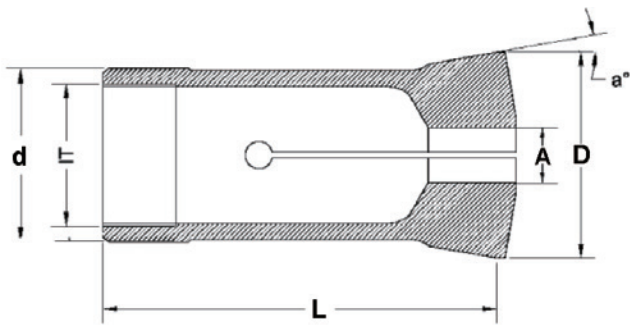
EXTERNAL THREADED PULL TYPE COLLETS



Order Code	d	L	α	D	A Max			T(Outside threaded)
					Round	Hexagon	Square	
INSF19/9018	19	77	15°	26.5	13.5	11	9	M18.5x1.2
INSF19/9019	19	76	15°	26	13.5	11	9	M18.5x1.2
INSF33/9017	33	100	15°	41	27	23	19	M32x1.5
IN359E	23	93.8	20°	32	18	15	12	Tr23x1.5
IN363E	25	89	16°	/	18	15	12	M23x1
IN366E	28	106.5	18.5°	/	21	17	14	Tr27x20TPI
IN367E	28	104.4	20°	/	22	19	15	Tr28x1.5
IN386E	32	115	20°	45	27	23	19	Tr32x1.5
IN390E	47	115	20°	/	38	32	26	Tr47x1.5
INSF25/EGURO20	25	102	15°	33				M24x1.5
INSF25/TAK20	25	102.5		35				M25x1.25
INSF32/EGURO25	32	118	15°	42				M32x1.5
INSF26/KL20	26	92	15°	34				M25x1.25
INSF36/TAK25	36	131		52				M36x2
INSF36/XKC30F	36	109	15°	44				M35x1.25
INSF36/RIKEN25	36	88	10°	44				M32x1.5
INSF55/RIKEN40	55	110	10°	66				M50x1.5
INSF83/RIKEN60	83	132	10°	97				M78x2.0
INSF37/850	37	101	15°	46				M32x1.5

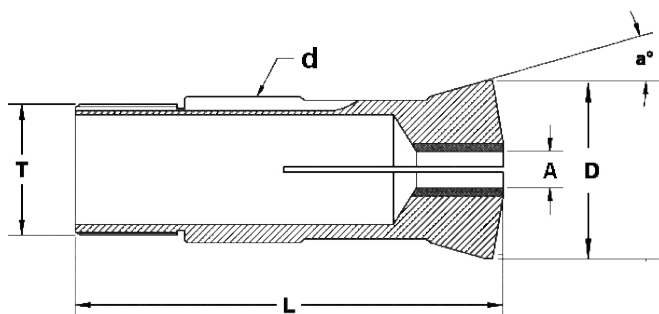
Order Code	d	L	α	D	A Max			T(Outside threaded)
					Round	Hexagon	Square	
INSF32/YB25	32	104		39				31.5x20f"
INSF39/YB32	39	119		49				38x18f"
INSF52/YB42	52	137		64				50x16f"
INSF16/0825	16	72		24				M15x0.85
INSF28/1820	28	100		36				M25x1.5
INSF35/1825	35	124		49				M33x1.5
INSF43/1832	43	137		57.5				M40x1.75
INSF15/DAIWA10	15	60		20				M15x1.0
INSF17/DAIWA102	17	69		24				M17x1.0
INSF22/DAIWA15	22	85		28				M21x1.0
INSF25/DAIWA20	25	102.5		35				M25x1.25
INSF36/DAIWA25	36	131		52				M36x2.0
INSF34/SD25	34	84		41.5				29x20f"
INSF42/SD32	42	95		49				38x20f"
INSF42/SD34	42	95.5		51				36x1.5
INSF56/SD45	56	120		68				51x20f"
INSF61/SD52	61	120		68				56x20f"

INTERNAL THREADED PULL TYPE COLLETS



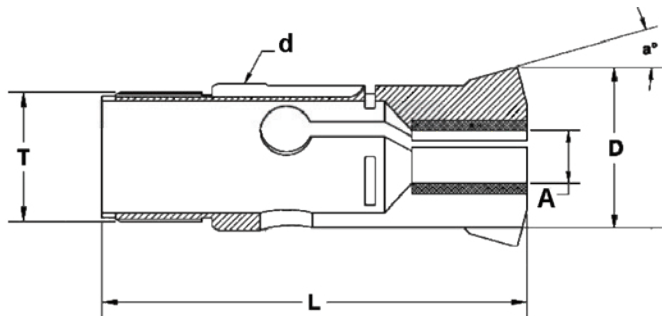
Order Code	d	L	α	D	IT(internal threaded)	A Max		
						Round	Hexagon	Square
INSF30/9019	30	75	15°	38	M25X1.5	22.5	19	16
INTI-58/01	58	105	15°	70	M50X1.5	41	35	29
INSF30/SC20	30	79	15°	38	M26X1.0	22.5	19	16

CARBIDE LINED GUIDE BUSH -DRAWN TYPE



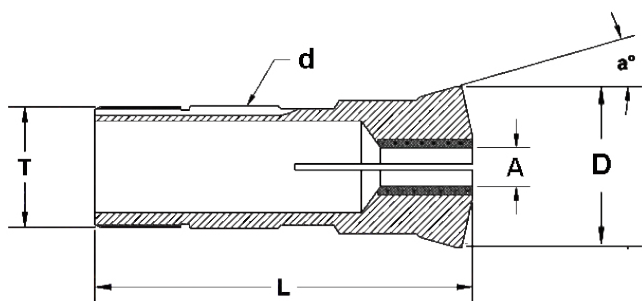
Order Code	d	L	D	α	T	A Max			US code	Swiss code	
						Round	Hexagon	Square			
INR9/01	9	44	12	16°	M8x0.5	5	4	3	TD4	3077E	
INR9/03	9	38.5	12.5	16°	M8x0.75	5	4	3			
INR9/09	9	44	12.5	16°	M8x0.75	5	4	3	PD4	T9-44/J3	
INR11/02	11	53	14.5	16°	M10x0.75	7	5	4	TD7		
INR11/12	11	53	14.5	16°	M10x0.80	7	5	4		T11-53-M10.080	
INR12/01	12	52		30°	M12x1	7	6	5	TSD7		
INR12/07	12	50	15	30°	M12x1	7.5	6	5		T12-50-M12.1	
INR13/01	13	41.5	16	15°	M12x0.75	8	6	5		T13-41.5	
INR14/02	14	64	18	16°	M13x0.75	8.5	7	6		T14-64	
INR14/03	14	61.5	20	15.5°	M14x1	8.5	7	6	P853D		
INR15/02	15	54	19	16°	M14x1	10	8	7			
INR16/03	16	60		30°	M14x1	10	8	7	SD125		
INR16/06	16	59		16°	M16x1	10	8	7	TD10TXP		
INR16/07	16	63	20	15°30'	M14x1	10	8	7	P1053D		P10D
INR16/12	16	59	20.5	16°	M14x1	10	8	7	TD10	T16-59	3260E
INR18/01	18	59	21.8	30°	M16x1	12	10	8	SD125R-16	T18-59-M16.1	
INR18/02	18	60	21.8	30°	M18x1	13	10	9	SD125R	T18-59-M18.1	
INR20/01	20	55	55	30°	M20x1	13	11	9		T20-55	
INR21/03	21	57.5	24	12.5°	M18x1	14	11	9	SNC15	T21-75.4	
INR22/01	22	68	29	16°	M19x1	16	12	10	TD20	T22-68-M19.1	
INR22/03	22	70	26	15°	M20x1	15.5	13	11	P1653D		P16D
INR23/01	23	72	28	16°	M22x1	16.5	14	11	TSG20R	T23-72	
INR24/03	24	61	29.5	30°	M24x1	16	13	11	0201	T24-61	
INR26/02	26	77	29	16°	M25x1	20	17	14	TD26	T26-77	
INR28/02	28	81	38	30°	M25x1	20.5	17	14	TD25/167	T28-81	
INR28/04	28	82	34	16°	M25x1	20.5	17	14	TD25S	T28-82-M25.1	
INR28/05	28	82	34	16°	M27x1	22	18	15		T28-82-M27.1	
INR30/01	30	70	36	16°	M28x1	20.5	17	14	S20HGB	T30-70	
INR30/05	30	59	35	15.75°	M30x1	22	19	16		510.001 / B230	
INR30/06	30	68	35	15.5°	M30x1	22	19	16	NN20KD		P20D
INR32/02	32	71	39.8	30°	M32x1	23	19	16	TSD20	T32-71	
INR33/01	33	70		16°	M30x1	26	22	18	TD33		
INR34/02	34	87.5	41	10°	M34x1	27.5	23	19	CD25	T34-87.5	
INR34/26	34	87.5	41	16°	M34x1						
INR36/02	36	90	44	13°	M36x1	25	21	18	P2553D		P25D
INR40/03	40	71.5	48	30°	M36x1	29	25	21	SD255-36	T40-72-M36.1	
INR40/05	40	73	48	30°	M40x1	30	25	21	SD255	T40-72-M40.1	
INR41/01	41	54		10°	M38x1	32	27	22	BS32B		
INR41/02	41	82	46	10°	M38x1	32	27	22			
INR42/01	42	82	49	16°	M40x1	33	28	23	TD32S	T42-82-C16	
INR42/02	42	82	48	20°	M40x1	33	28	23	TD32	T42-82-C20	
INR42/04	44	87.5	53	20°	M40x1	33	28	23		3835E	
INR44/01	44	90	50	13°	M40x1	33	28	23	NN30TD		P30D
INR45/01	45	82	52	16°	M42x1	36	30	25	TD45		
INR46/01	46	92	53	16°	M45x1	38	32	26	TD38	T46-92	
INR46/02	46	82	53	16°	M45x1	38	32	26	H38D/SL38	T46-82	
INR48/02	48	81	56	30°	M48x1.25	38	33	27		T48-81-C30	
INR48/04	48	82	54	16°	M46x1	38	33	27	STM38	T48-82	
INR48/06	48	81	54	10°	M46x1	38	33	27		T48-81-C10	
INR52/01	52	95	59		M50X1						

CARBIDE LINED GUIDE BUSH - TRAUB



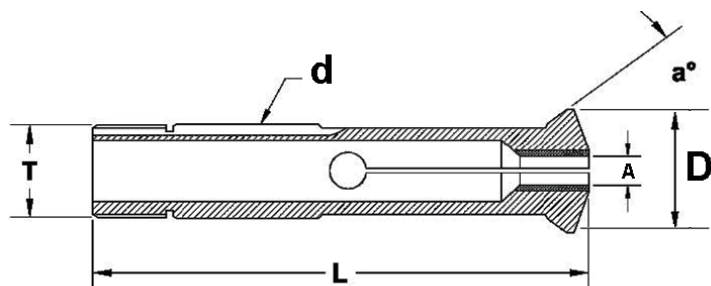
Order Code	d	L	D	α	T	A Max			US Code
						Round	Hexagon	Square	
INR21/07	21	65.5	24	12°	M18x1	13.5	11	9	TRB468
INR27/01	27	67.5	30	12°	M24x1	18	15	13	
INR28/06	28	81.2	34	16°	M25x1	21	18	15	
INR34/03	34	87.5	41	10°	M34x1	26			TRB761
INR42/07	42	81.2	49	16°	M40x1	33	28	23	

CARBIDE LINED GUIDE BUSH - WITH REINFORCED SHANK



Order Code	d	L	D	α	T	A Max			US code	Swiss code	
						Round	Hexagon	Square			
INR22/05	22	68	29	16°	M22x1	16	13	11	TD20R	T22-68-M22.1	
INR34/06	34	150	42	20°	M32x1.50	27	22	19	T200XP		

CARBIDE LINED GUIDE BUSH - MAGIC TYPE



Order Code	d	L	D	α	T	A Max			US code	Swiss code	
						Round	Hexagon	Square			
INR10/02	10	58		36°	M10x1	5.5	4	3	TD4SA		
INR13/02	13	68	17	36°	M13x1	8	6	5	TD7SA		
INR18/05	18	68	24	36°	M18x1	13	10	9	TD10SA		

QUICK REFERENCE FOR SWISS TYPE MACHINE

CITIZEN

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
R04	TF8 (F8/76 - 511 / 101E)	INSF8/577	PD4 (T9 / 3077E / 1.001)	INR9/01	TF8	INSF8/577
R07	TF15 (F15 / 120E / 40.003)	INSF15/580	TD7 (T11/34 / 3134E / 3.001)	INR11/02	TF15	INSF15/580
D10,F10	TF15 (F15 / 120E / 40.003)	INSF15/580	TD10 (T16/J6R / 3260E / 8.001)	INR16/12		
L10	TF15 (F15 / 120E / 40.003)	INSF15/580	TD10	INR16/12	TF8	INSF8/577
B12,B12I,B12II,	TF16 (F16/1076 / 1212E /	INSF16/1076	SD125R (T18 / 3319E / 174.001)	INR18/02		
F12,B12V,B12VI,M12	TF16 (F16/1076 / 1212E /	INSF16/1076	SD125R	INR18/02	TF16	INSF16/1076
BL12	BL12	INSF19/9018				
K16,A16,C16,M16	TF20 (F20/87 / 138E / 40.004)	INSF20/87	0201 (T24/B238 / 3507E / 61.002)	INR24/03	TF20	INSF20/87
L20,L20VII,M20,B20,B20IV,A20,A320,E16I,E216,E220	TF25 (F25/64 / 145E)	INSF25/64	TD25NS (T28/B261 / 3602E / 22.001)	INR28/04	TF25	INSF25/64
A20(Non-Guide Bushing model)	BL25	INSF33/9017			TF25	INSF25/64
D16	TF25	INSF25/64				
G16,L16	TF25	INSF25/64	0201	INR24/03		
L16V/L.16VII	TF25	INSF25/64	0201	INR24/03	TF25	INSF25/64
L20I,L20III	TF25	INSF25/64	TD25NS	INR28/04		
BL25	BL25	INSF33/9017			TF30	INSF30/63
20#	511.001	INSF26/9021	510.001	INR30/05	511.001	INSF26/9021
L25,E225,E225I,F25	TF30 (F30/63 / 157E / 40.006)	INSF30/63	CD25 (T34/B227 / 3733E / 451.001)	INR34/02	TF30	INSF30/63
A32,C32,E232,E32/32IV,E32K,G32,L32,M32	TF37 (F37/740 / 1536E)	INSF37/740	TD32 (T42 / 28.01)	INR42/02	TF37	INSF37/740
FL32	TF37SP	OA			TF37SP	OA
L32 UPGRADE 38mm	TF43 (F43 / 511.024)	INSF43/37			TF43	INSF43/37
BNA-42GT	TF48 (F48/81 173E 231.009)	INSF48/81				
FL42	TF48	INSF48/81			TF48	INSF48/81

QUICK REFERENCE FOR SWISS TYPE MACHINE

STAR

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
JNC16,RNC10/10B,SNC10DX	TF15	INSF15/580	TD10	INR16/12		
SH7	TF15	INSF15/580	SW7	INOA		
SR10J	TF15	INSF15/580	TD10	INR16/12	TF15	INSF15/580
SW7	TF15	INSF15/580	SW7	INOA	TF15	INSF15/580
			TD10	INR16/12	TF10	INSF10/86
SB12/12R,SW12RZ	TF18	INSF18/579	SNC15	INR21/03	TF18	
ECAS16,KJR16B,SA16,SB16,SR16,SV12,VNC12	TF20	INSF20/87	TD20R	INR22/05	TF20	INSF20/87
JNC16	TF20	INSF20/87	TD20R	INR22/05		
			SNC15	INR21/03		
RNC16/16B,SE16,SH16,SNC15DX	TF20	INSF20/87	TD20R	INR22/08		
SA12	TF20	INSF20/87	SNC15	INR21/03	TF20	INSF20/87
SH12,SE12	TF20	INSF20/87	SNC15	INR21/03		
SI12	TF20	INSF20/87	SNC15	INR21/03	TF15	INSF15/580
SST16	TF20	INSF20/87	TD20R	INR22/05	TF10	INSF10/86
					TF20	INSF20/87
ECAS20,KNC16/20B,SW20,SR20,SV20	TF25	INSF25/64	TD25S	INR28/04	TF25	INSF25/64
VNC20	TF25	INSF25/64	TD25S	INR28/04	TF20	INSF20/87
SNC25DX	TF34	INSF34/77	TD32S	INR42/01	CD25	
ECAS32,KNC25/32B,SR32,SV32J	TF37	INSF37/740	TD32S	INR42/01	TF37	INSF37/740
STM32,JNC25/32	TF37	INSF37/740	TD32S	INR42/01		
VNC32	TF37	SF37/740	TD32S	INR42/01	TF30	SF30/63
SF25	TF37	INSF37/740			0161	INSF30/101
SG42	TF48	INSF48/81			TF48	INSF48/81
STM38	TF48	INSF48/81	STM38	INR48/04		
SV38R,ST38	TF48	INSF48/81	STM38	INR48/04	TF48	INSF48/81
MAF42	TF48	INSF48/81				
SC-20(Non-Guide Bushing model)		INSF30/SC20				

TSUGAMI

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
B007/BW07/BO75-III	TF10	INSF10/86	TD7	INR11/02	TF10	INSF10/86
NT11/NT11S	TF15	INSF15/580	SD125R	INR18/02		
NP11	TF15	INSF15/580	SD125R	INR18/02	TF15	INSF15/580
NT12	TF20	INSF20/87	TD20	INR22/01		
			TD20R	INR22/08		
NP16/NMP1611	TF20	INSF20/87	TD25	INR28/02	TF20	INSF20/87
NT16	TF20	INSF20/87	TD25	INR28/02		
BS12/BO12/BS12V/BO12V/BE12III/B	TF24	INSF23.8/9020	TSG20R	INR23/01	TF24	INSF23.8/9020
NT17/NT17S	TF24	INSF23.8/9020	TSG20R	INR23/01		
BS19/BE19/NP201/NP20II/NP20III/S2OP/BS20A/S20D/BH20/S20H/BE20III	TF25	INSF25/64	TD25	INR28/02	TF25	INSF25/64
S205-II/S206-II	TF25	INSF25/64	TD26	INR26/02	TF25	INSF25/64
NT20	TF25	INSF25/64	TD25	INR28/02		
BO206-III/BO205-III/BO206/BW299Z/BE20V	TF25	INSF25/64	TD26	INR26/02	TF25	INSF25/64
			TD25	INR28/02		
BU26S/SY,MU26S/SY,SS26,S25P,S25D,S25H,BS26,BA26	0166	INSF32/1023	CD25	INR34/02	0166	INSF32/1023
NT25/NT32/NP32	TF37	INSF37/740	TD32	INR42/02		
S205-II 1", S206-II 1"	TF37	INSF37/740	TD33	INR33/01	TF25	INSF25/64
BO325-III/BO326-	TF43	INSF43/37	TD32	INR42/02	TF37	INSF37/740
BO386-C	BS38	INSF48/38			BS38	INSF48/38
BU38S/SY,BH38S,MU38S/SY,TMU1,B O38S,BO38T	TF43	INSF43/37	STM38	INR48/04	BS38	INSF48/38

QUICK REFERENCE FOR SWISS TYPE MACHINE

HANWHA

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
XD12 III/XE12/XP12, XD10	TF16 (F16 / 1212E / 40.012)	INSF16/1076	SD125R	INR18/02	TF16	INSF16/1076
XD12 III/XE12/XP12 (Europe), XD10 (Europe)	TF15 (F15 / 120E / 40.003)	INSF15/580	SD125R16	INR18/01	TF15	INSF15/580
XD16 III/XE16/XP16	TF22 (F22 / 140E / 231.002)	ININSF22/71	TD20R	INR22/08	TF22	ININSF22/71
XD20 II /XE20 /XP20/XD20V	TF25 (F25 / 145E / 40.005)	INSF25/64	TD25NS		TF25	INSF25/64
HANEX25	TF30 (F30 / 157E)	INSF30/63	CD25		TF30	INSF30/63
XD26 II /XE26 /XP26, XD126	TF32 (F32 / 161E / 231.005)	INSF32/221	CD25		TF32	INSF32/221
XD32	TF37 (F37 / 1536E / 40.008)	INSF37/740	TD45		TF37	INSF37/740
XD32 II /STL32 (S)/XP32	TF37	INSF37/740	TD32S		TF37	INSF37/740
XD35 II /XE35	TF40 / F40	INSF40/9074	TD45		F40	INSF40/9074
XD38 II (F)	TF44 (F44 / 511.026)	INSF44/9082	H38D / SL38 / T46-82		TF44	INSF44/9082
XD38 II -H (F, Ø40mm)	TF48 (F48 / 173E /231.009)	INSF48/81			TF48	INSF48/81
XD38 II -H (S), R (F,S)	TF48	INSF48/81			TF48	INSF48/81
XD38 II -N (S)	TF44	INSF44/9082			TF44	INSF44/9082
STL38H (S) / Standard, Y3	TF48	INSF48/81	H38D / SL38 / T46-82		TF48	INSF48/81
STL38H (S) / none Y3	TF48	INSF48/81	H38D / SL38 / T46-82		TF48	INSF48/81
STL42	TF48	INSF48/81			TF48	INSF48/81

TORNOS

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
DECO 2000 10,ENC74	TF13	INSF13/357	TD10	INR16/12	TF13	INSF13/357
ENC16,	F20-201,136E	INSF20/201	0201	INR24/03	TF20	INSF20/87
Elector16	F20-201,136E		0201	INR24/03		
ENC164	TF15,		0201	INR24/03	TF15	
	F20-201,136E	INSF20/201			F20-201,136E	INSF20/201
ENC162	TF15		0201	INR24/03		
	F20-201,136E	INSF20/201				
TOP-100	TF16	INSF16/1076	TD10TXP	INR16/06	TF13	INSF13/357
R125	TF16	INSF16/1076	TD10SA	INR18/05		
R10	TF15	INSF15/580	TD10SA	INR18/05		
DECO-7	TF10	INSF10/86	TD7	INR11/02	TF10	INSF10/86
TOP200	0161	INSF30/101	T200XP	INR34/06	TF25	INSF25/64
					0161	INSF30/101
EVODECO 16A	F20-201,136E		0201	INR24/03	TF20	INSF20/87
DECO 2000 1"	0161	INSF30/101	CD25	INR34/02	0161	INSF30/101
SIGMA 20	0161	INSF30/101	CD25	INR34/02		
DECO 2000 25/32,ENC167	TF25	INSF25/64	TD25/167	INR28/02	TF25	INSF25/64
TMB26,	F32-221,TF32	INSF32/221	SD255-36	INR40/03		
DECO 2000 26/32	TF37	INSF37/740	TD32S	INR42/01	TF37	INSF37/740
MR32	TF37	INSF37/740	TD32	INR42/02		
DELTA 20	TF24	INSF23.8/9020	TD26	INR26/02		

QUICK REFERENCE FOR SWISS TYPE MACHINE

TORNOS(CAM)

Collet Model No.	NSIGHT Part NO.	Machine		Bushing Model No.	NSIGHT Part NO.	Machine
		Headstock	Attach.			
TF6 / F6 76-599 / 100E	INSF6/76		M7 R10/R125	TD4	INR9/01	M4
TF7 / F7 76-576 / 1010E	INSF7/66		R10/R125	TD7	INR11/02	M7
TF8 / F8 76-577 / 101E	INSF8/577	M4	M7 R10/R125	TD10	INR16/12	R10,R125,M10
TF10 / F10 76-86 / 109E	INSF10/86	M7	M15 R16	SD125R	INR18/02	R10,R125,M10
TF12 / F12 76-578 / 114E	INSF12/578		M15 R16/20	SD125R-16 Rev.Holder	OA	R10,R125
TF13 / F13 76-357 / 116E	INSF13/357	MS7	M7 CT. HSK.	TD20	INR22/01	R16,R20,RR20,M15
TF15 / F15 76-580 / 120E		R10		TD25	INR28/02	R20,RR20,M20,M25,M28
TF16 / F16 76-1076 / EF16	INSF16/1076	R125	M20/25/28 MR32	TD32	INR42/02	MR32
TF20 / F20 76-87 / 138E	INSF20/87	M15 R16				
TF25 / F25 76-64 / 145E	INSF25/64	M20 R/RR20				
TF34 / F34 76-77 / 165E / 1497E	INSF34/77	M25/28				
TF37 / F37 76-740 / EF37 / 1536E	INSF37/740	MR32				

NOMURA

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
NN16T	P1053C	INP10C	P853D	INR14/03		
			P1053D	INR16/07		
			P1653D	INR22/03		
NN16K,NN16KF,NN12K,P1053,P1253,P1653	P1053C	INP10C	P853D	INP1053D		
	P1653C	INP16C	P1053D	INR16/07		
			P1653D	INR22/03		
NN13SB,NN13TB,NN16BII,NN16B III,NN16HB,NN16UB	P1653C	INP16C	P1653D	INR22/03	P1653C	INP16C
NN13S,NN13SII,NN13T,NN16H,NN16H III,NN16HA,NN16UII,SN-160,SN-160A,SN-160C,SN-160D	P1653C	INP16C	P1653D	INR22/03		
NN20BII,NN20BIII,NN20J,NN20UB	P1653C	INP16C	P1653D	INR22/03	P1653C	INP16C
	NN20KFC	INP20C	NN20KD	INR30/06	NN20KFC	INP20C
NN20F	P1653C	INP16C	P1653D	INR22/03		
			NN20KD	INR30/06		
NN20H,NN20HIII,NN20HA,NN20R,NN20UII,NN25R,NN25RY,NN25RYA,NN30TC,NN30TD	P1653C	INP16C	P1653D	INR22/03		
	NN20KFC	INP20C	NN20KD	INR30/06		
NN20K	P2553C	INP25C	P1653D	INR22/03		
			NN20KD	INR30/06		
NN20KF	NN20KFC	INP20C	P1653D	INR22/03		
			NN20KD	INR30/06		
NN32YB	P1653C	INP16C	P1653D	INR22/03	P1653C	INP16C
	P2553	INP25C	P2553D	INR36/02	P2553C	INP25C
	NN30TC	INP30C	NN30TD	INR44/01	NN30TC	INP30C

QUICK REFERENCE FOR SWISS TYPE MACHINE

TRAUB

Machine model	Headstock collet		Sub spindle collet		Carbide bushing	
	Collet Model No.	INSIGHT Part NO.	Sub Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.
TNL12	TF16	INSF16/1076	TF16	INSF16/1076	TRB468	INR21/07
TNL16G	TF20	INSF20/87	TF20	INSF20/87	TD20R	INR22/05
TNL16G	0156	INSF25/91	0156	INSF25/91	TD25S	INR28/04
TNL26	TF30	INSF30/63	TF30	INSF30/63	TRB761	INR34/03

KSI

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
SA12	TF16	INSF16/1076	SD125R	INR18/02	TF16	INSF16/1076
SA20/SM20	TF25	INSF25/64	TD25NS, TD25S	INR28/04	TF25	INSF25/64
SA26	F32-221 TF32	INSF32/221	CD25	INR34/02	F32-221 TF32	INSF32/221
SA32	TF37	INSF37/740	TD32S	INR42/01	TF37	INSF37/740
SA38	TF44	INSF44/9082	TD38	INR46/01	TF37	INSF37/740
SQC20	TF25	INSF25/64	TD25-NS, TD25S	INR28/04	TF25	INSF25/64
SQC32	TF44	INSF44/9082	TD32S	INR42/01	TF37	INSF37/740
SQC38	TF48	INSF48/81	TD38	INR46/01	TF44	INSF44/9082

NEXTURN

Machine model	Headstock collet		Guide bushing		Pick-off collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
SA12/12A	TF16	INSF16/1076	SD125R	INR18/02	TF16	INSF16/1076
SA18A	TF25	INSF25/64	TD25NS, TD25S	INR28/04	TF25	INSF25/64
SA20/20E	TF25	INSF25/64	TD25NS	INR28/04	TF25	INSF25/64
SA26/26E	TF32	INSF32/221	CD25	INR34/02	TF32	INSF32/221
SA32	TF37	INSF37/740	TD32S	INR42/01	TF37	INSF37/740
SA38	TF44	INSF44/9082	TD38	INR46/01	TF37	INSF37/740
					TF44	INSF44/9082

KITAMURA

Machine model	Headstock collet		Sub collet	
	Collet Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
XKNC-204,XKNC-20G	EDA-8	INSF25/EGURO20		
XKNG100GL,XKNC50GL	EDA-10	INSF32/EGURO25	EDA-8	INSF25/EGURO20
XKNG-50G	INSF36/XKC30F OA*	INSF36/XKC30F		

* XKNG-50G machine Collet use INSIGHT Part No : INSF36/XKC30F, Dimension(Head part Outside Dia : 44mm, Total length : 109mm. $\alpha=15^\circ$),Please provide 3-view drawing to customize.

EGURO

Machine model	Pull Collet(steel/carbide) JP code	
	Collet Model No.	INSIGHT Part NO.
SANAX-6,LB6,SANATURN-6/6B	EDA-6	INSF19/9019
NUCSET-8,NUCBOY-8EX,EXP,SANAX-8,SANFLEX-	EDA-8	INSF25/EGURO20
SANAX-10,SANATURN-10,NUCLET-10EX,EXP,NUCLET-10w,NUCPAL-10EX,NUCMAX-10,NUMPAL-10w,EB10,NUCLET-10LL/10A,NUCROBO-101,NUCJET-102/103	EDA-10	INSF32/EGURO25

QUICK REFERENCE FOR SWISS TYPE MACHINE

METHODS (CAM)

Machine model	Collet		Guide bushing	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.
SS20	TF25	INSF25/64	TSD20	INR32/02
SS25	TF30	INSF30/63	TD25	INR28/02
SS32	TF37	INSF37/740	TD32	INR42/02

PETERMANN (CAM)

Machine Builders' Model No.		Collet Model No.	NSIGHT Part NO.	Bushing Model No.	NSIGHT Part NO.
Headstock	Attachments				
	P4	0131(d4.5 - L17.25 $\alpha=15^\circ$)	OA	0100(d9 - L25 $\alpha=30^\circ$ M6*0.5)	OA
				PD4	INR9/09
P0/P3	P7	0136(d7 - L26 $\alpha=15^\circ$)	OA		
P4	P7R	TF8	INSF8/577		
P7	P10	TF10	INSF10/86	TD7	INR11/02
	P16	TF10	INSF10/86		
P7R		0146(d15 - L47 $\alpha=20^\circ$)	OA		
P10	P16	0147(d16 - L55 $\alpha=15^\circ$)	OA		
	P25	0147	INOA		
P10R	P16	0151(d20 - L60 $\alpha=15^\circ$)			
	P25	0151			
P16		0152(d22 - L66 $\alpha=16^\circ$)	OA	0201	INR24/03
2A		0156(d25 - L65 $\alpha=15^\circ$)	OA		
P25		0166	SF32/1023	0200(d40 - L73 $\alpha=30^\circ$ M40*1)	OA

*OA : Costomized According to drawing

STROHM (CAM)

Machine Builders' Model No.		Collet Model No.	NSIGHT Part NO.	Bushing Model No.	NSIGHT Part NO.
Headstock	Attachments				
	M45,M125	TF5			
M45				TSD4(d9 - L52 $\alpha=30^\circ$ M9*0.7)	OA
M45	M105	TF8	INSF8/577	0100(d9 - L25 $\alpha=30^\circ$ M6*0.5)	OA
	M125	TF8	INSF8/577		
M75		TF10	INSF10/86	TSD7	INR12/01
M125	M205	TF15(Front nose Dia.15)	SF15/580	SD125R(M18*1)	INR18/02
M105	M255	TF15(Front nose Dia.15)	SF15/580		
M125		TF15R(Front nose Dia.17.5)	INSF15/580	SD125R-16(M16*1)	INR18/01
M205		TF25	INSF25/64	SD205(d26 - L74 $\alpha=30^\circ$ M24*1)	OA
M255		TF30	INSF30/63	SD255(d10 - L73 $\alpha=30^\circ$ M40*1)	OA

*OA : Costomized According to drawing

Hardinge

Machine model	Main-spindle collet		Guide bushing		Sub-spindle collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
ST16/216	S16-HMS	OA	TSG20R	INR23/01	S16-HMS	OA
ST20/220	S20-HM	INSF28/9004	S20HGB	INR30/01	TF25	INSF25/64
ST25/225	S25-HM	INSF33/9043	CD25	INR34/02	S25-HS	INSF33/9043

*OA : Costomized According to drawing

QUICK REFERENCE FOR SWISS TYPE MACHINE

Bechler (CAM)

Machine model	Collet		Guide bushing	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.
A/AS/AR-7,A/AS/AR-10	AE1670 (Guide Dia.13mm, All L41.5mm)	OA	TD10	INR16/12
			SD125	INR16/03
			SD125R	INR18/02
B/BR-12	BR1253 (Guide Dia.21mm, All L57.5mm)	OA		
B/BR-20	BR1666 (Guide Dia.27mm, All L57.5mm)	OA	TD25	INR28/02
C/CR-32	BU2235 (Guide Dia.40mm, All L65mm)	OA		

*OA : Costomized According to drawing

MAIER

Machine model	Main-spindle collet		Guide bushing		Sub-spindle collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
ML-12A/B/C/D	TF15	INSF15/580	SD125R	INR18/01	TF15	INSF15/580
ML-16A/B/C/D	TF20	INSF20/87	TD20R	INR22/05	TF20	INSF20/87
ML-20A/B/C/D/E	TF25	INSF25/64	TD25S	INR28/04	TF25	INSF25/64
ML-26A/B/C/D/E	TF32		CD25	INR34/02	TF32	
ML-32A/B/C/D/E,MLK-32	TF37	INSF37/740	TD32S	INR42/01	TF37	INSF37/740

JINN FA

Machine model	Headstock & Pick-off collet		Guide bushing		Push collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.	Collet Model No.	INSIGHT Part NO.
JSL-20	BS20	INSF28/9004	S20HGB	INR30/01		
JSL-26	TF30	INSF30/63	CD25	INR34/02		
JSL-32	TF37	INSF37/740	TD32	INR42/02		
JSL-42	173E F48	INSF48/81		ININR52/01		
JCL32						INSF40/01
JCL44						INSF54/01
JCL50						INSF60/01
JCL60						INSF75/01

RIKEN

Machine model	Pull collet		Push collet	
	Collet Model No.	INSIGHT Part NO.	Bushing Model No.	INSIGHT Part NO.
PULL-25	PULL-25	INSF36/RIKEN25		
PULL-40	PULL-40	INSF55/RIKEN40		
PULL-60	PULL-60	INSF83/RIKEN60		
SAD-25			SAD-25	INSF30/AD25
SAD-40			SAD-40	INSF48/AD40
SAD-50			SAD-50	INSF56/AD50
SAD-65			SAD-65	INSF75/AD65

TAKAMAZ

Machine model	Pull collet	
	Collet Model No.	INSIGHT Part NO.
20#		INSF25/TAK20
25#		INSF36/TAK25
850(CD37)		INSF37/850

QUICK REFERENCE FOR SWISS TYPE MACHINE

TUAUB

Machine model	Push collet	
	Collet Model No.	INSIGHT Part NO.
TRAUB A-15	140E	INSF22/71
TRAUB A-15	148E	INSF28/93
TRAUB A-15	161E	INSF32/221

INDEX

Machine model	Push collet	
	Collet Model No.	INSIGHT Part NO.
INDEX 25	162E	INSF35/67
INDEX 30	163E	INSF35/94
INDEX 36	171E	INSF42/99
INDEX 42	173E	INSF48/81
INDEX 52	177E	INSF58/355
INDEX 60	185E	INSF66/359
INDEX 80	193E	INSF90/193

LI CO

Machine model	Push collet	
	Collet Model No.	INSIGHT Part NO.
LI CO 32	164E	INSF35/67
LI CO 42	173E	INSF35/94
LI CO 52	177E	INSF42/99
LI CO 65	187E	INSF48/81

MIYNO

Machine model	Push collet	
	Collet Model No.	INSIGHT Part NO.
BNC20	147E	INSF35/67
148E	148E	INSF28/93
161E	161E	INSF32/221
BNC34		INSF44.4/BNC34
BND42	164E	INSF42/99
BNA42	173E	INSF48/81
171E	171E	INSF42/99
BND54	177E	INSF58/355
BND64	185E	INSF66/359

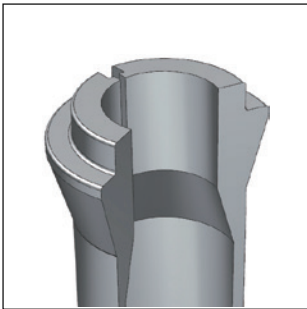
CHIAH CHYUN

Machine model	Push collet	
	Collet Model No.	INSIGHT Part NO.
32#	164E	INSF38/72
36#	171E	INSF42/99
42#	173E	INSF48/81
52#	177E	INSF58/355

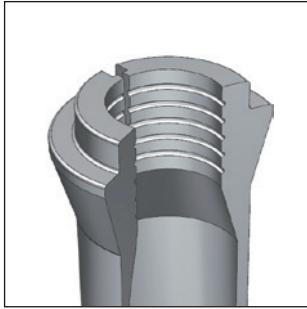
COLLET & GUIDE BUSH CLAMPING SHAPE

● Collet Clamping Shape

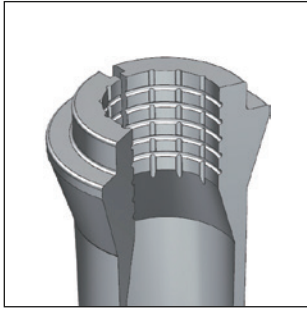
Clamping Hole Surface



Smooth Bore

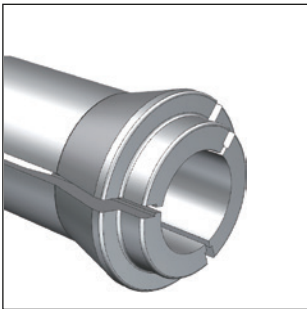


Grooved Bore

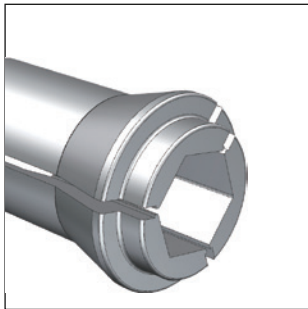


Powerful Grip

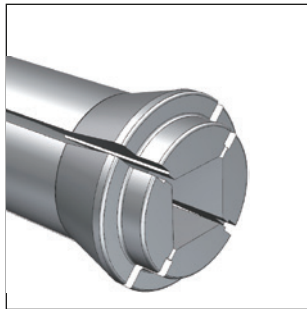
Clamping Hole Shape



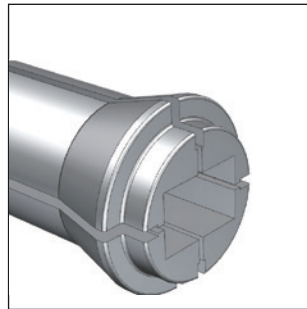
Round



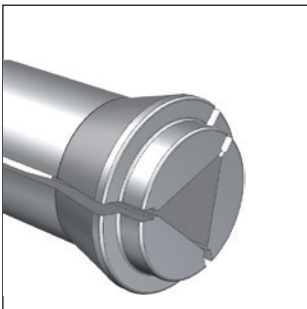
Hexagon



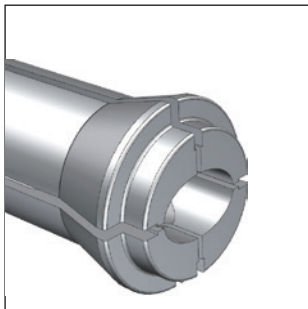
Square



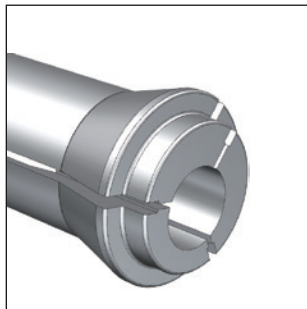
Rectangle



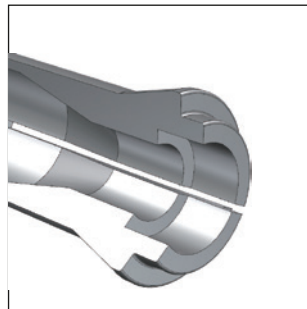
Triangle



Ellipse



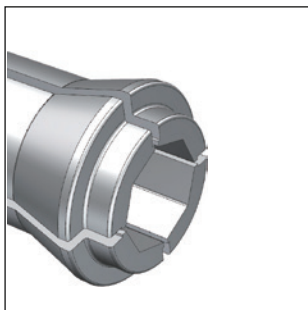
Eccentric Hole



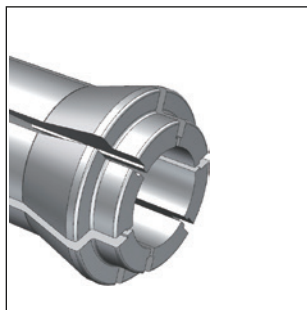
Step Hole



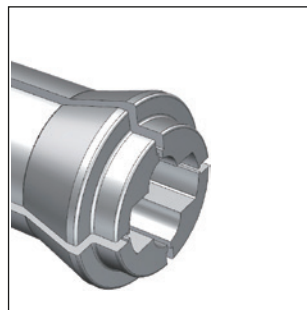
Taper Step Hole



Octagon Hole



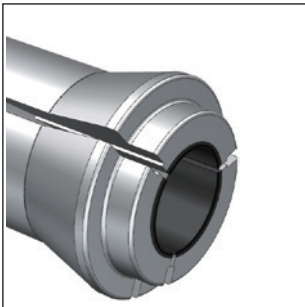
Six Slots Hole



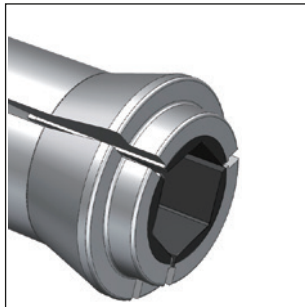
Special Hole

COLLET & GUIDE BUSH CLAMPING SHAPE

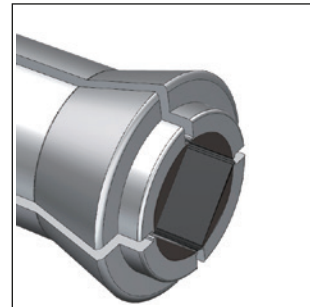
Clamping Hole With Carbide



Round



Hexagon

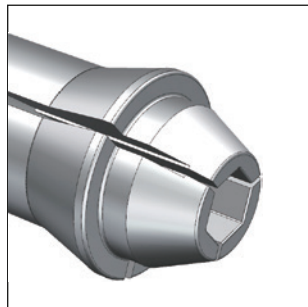


Square

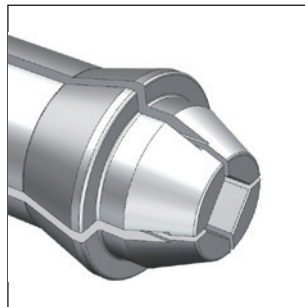
Long-nose Straight-slot Type



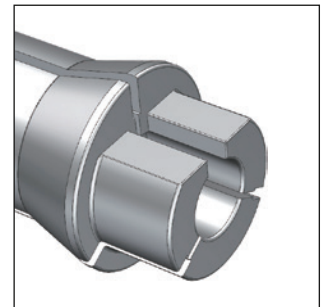
Round



Hexagon

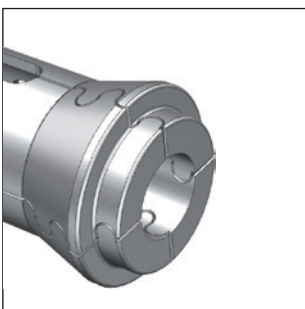


Square

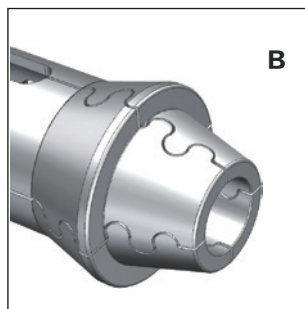
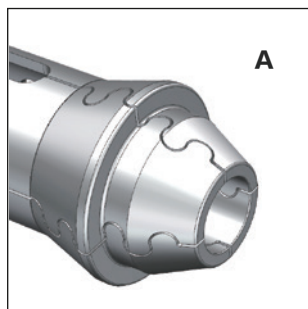


Special Hole

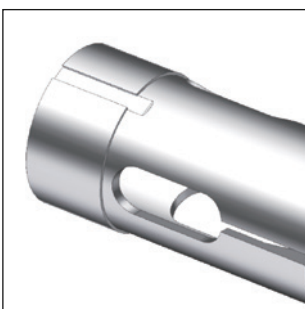
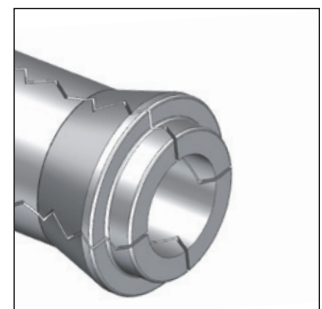
S-slots Type



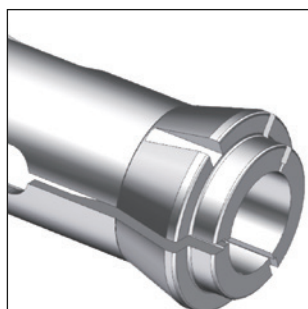
Long-nose+S-slots Type



V-slots Type



Key on Cone



Key on Guiding

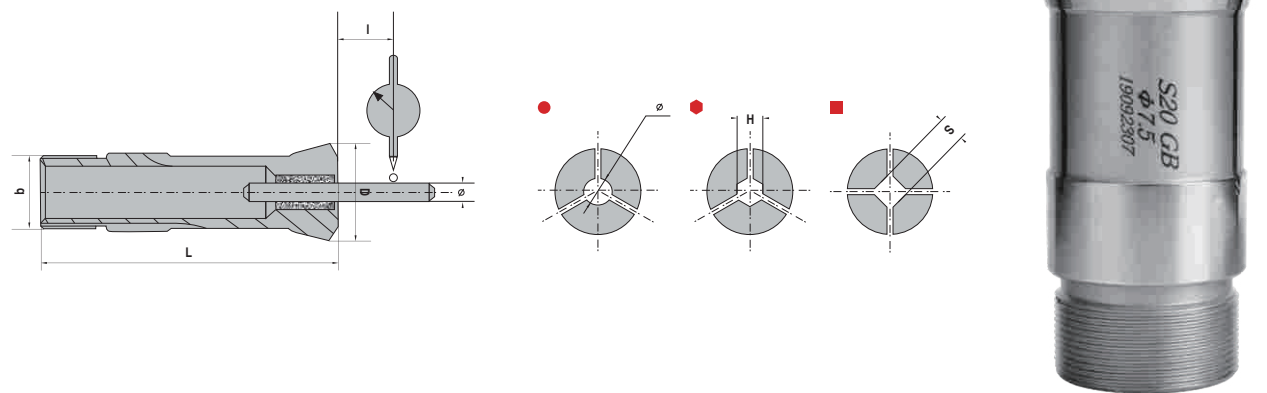


Standard Carbide



Long Carbide

QUALITY AND TESTING STANDARDS



Accuracy Chart 精度表 (单位/MM)						
Collet 夹头 ●				Collet 夹头 ■ ●		
D	I=D*3	Main S pinddle(主轴)TIR	Sub S pinddle(背轴)TIR	H&S	L=D*3	TIR
≤3	10	0.008	0.005	≤3	10	0.03
3.01-6	16	0.008	0.005	3.01-6	16	0.03
6.01-10	25	0.008	0.005	6.01-10	25	0.03
10.01-18	40	0.015	0.005	10.01-18	40	0.03
18.01-24	50	0.015	0.005	18.01-24	50	0.03
24-28	60	0.02	0.005	24-28	60	0.03
>28	80	0.02	0.005	>28	80	0.03

Accuracy Chart 精度表 (单位/MM)					
Guide Bush 中心导套 ●			Guide Bush 中心导套 ■ ●		
D	I=D*3	TIR	H&S	I=D*3	TIR
≤1.2	4	0.004	1-3	10	0.02
1.21-1.8	6	0.005	1-3	10	0.02
1.81-4	10	0.005	3.01-6	16	0.02
4.01-6	16	0.005	3.01-6	16	0.02
6.01-10	25	0.005	6.01-10	25	0.02
10.01-18	40	0.008	10.01-18	40	0.02
18.01-24	50	0.008	18.01-24	50	0.02
24.01-30	60	0.01	24-35	60	0.02
30.01-40	80	0.02		80	0.02