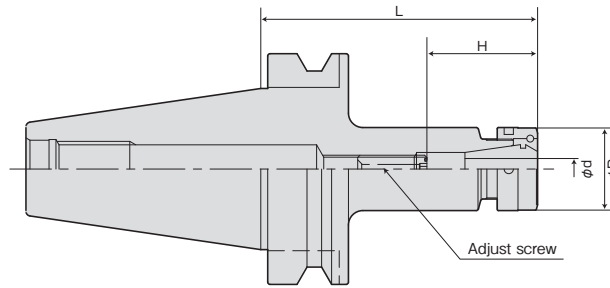


# COLLET CHUCK

FEATURES p.9-10

BT (No) -RSC (D) MAX-L

- ▶▶▶ Thru-the-tool Coolant Available
- ▶▶▶ Thru-the-groove Coolant Available
- ▶▶▶ BBT Available



MODEL	CODE	$\phi d$ (GRIPPING RANGE)	$\phi D$	L	H	COLLET	NUT	ADJUST SCREW	
Max. 12,000 min <sup>-1</sup>									
BT30 BBT30	RSC07N-060	200660	0.5~7	24	60	24~40	CR07-(D)	RSN07NB	M6×20L-CTW
	-075	200661			75				
	-090	200662			90				
	-120	200664			120				
	RSC10N-060	200666	0.5~10	30	60	31~48	CR10-(D)	RSN10NB	RAS10-25-2.5
	-075	200667			75				
	-090	200668			90				
	-120	200670			120				
	RSC13N-060	200672	0.5~13	36	60	35~52	CR13-(D)	RSN13NB	RAS13-25-2.5
	-075	200673			75				
	-090	200674			90				
	-120	200676			120				
RSC16N-060	200678	1~16	42	60	38~50	CR16-(D)	RSN16NB	RAS16-25-5	
-075	200679			75					
-090	200680			90	38~72				
-120	200682			120					
RSC20N-075	200684	1.5~20	50	75	44~56.5	CR20-(D)	RSN20NB		
-090	200686			90					
-120	200688			120					
BT40 BBT40	RSC07N-060	221100	0.5~7	24	60	24~40	CR07-(D)	RSN07NB	M6×20L-CTW
	-075	221101			75				
	-090	221102			90				
	-120	221104			120				
	-150	221106			150				
	RSC10N-060	221108	0.5~10	30	60	31~48	CR10-(D)	RSN10NB	RAS10-25-2.5
	-075	221109			75				
	-090	221110			90				
	-120	221112			120				
	-150	221114			150				
	RSC13N-060	221116	0.5~13	36	60	35~52	CR13-(D)	RSN13NB	RAS13-25-2.5
	-075	221117			75				
	-090	221118			90				
	-120	221120			120				
	-150	221122			150				
	RSC16N-060	221124	1~16	42	60	38~70	CR16-(D)	RSN16NB	RAS16-25-5
	-075	221125			75				
	-090	221126			90	38~77			
	-120	221128			120				
	-150	221130			150				
RSC20N-060	221132	1.5~20	50	60	44~70	CR20-(D)	RSN20NB	RAS20-25-5	
-075	221133			75					
-090	221134			90	44~72				
-120	221136			120					
-150	221138			150	44~82				

BT series

HSK series

ST series

Versatile Tool

Cutting Tool

Accessories

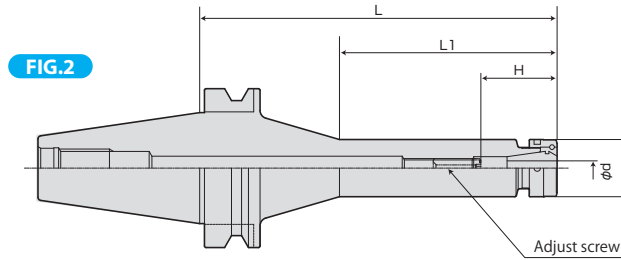
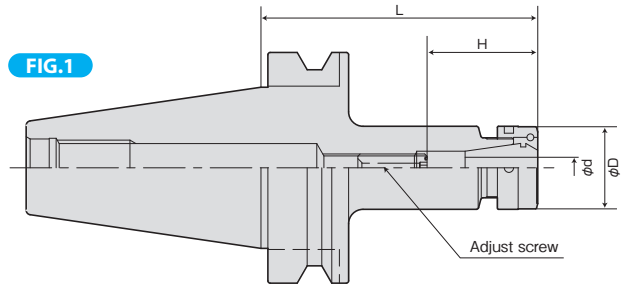
- NOTE: 1. Collet and chuck wrench are sold separately.  
 2. CROH collet is used for thru-the-tool coolant application.  
 3. The above-mentioned maximum speed will vary depending on rigidity of machine and balance of cutter.  
 An adequate cutting condition should be selected for each case.  
 4. Only BT shank tools are coated. BBT shank tools are not coated.

**ORDERING EXAMPLE**

① **BT30** - ② **RSC** ③ **07** - ④ **090**

- ① Shank Size
- ② Holder's Name
- ③ Max.  $\phi D$
- ④ G.L. Length

- ▶▶▶ Thru-the-tool Coolant Available
- ▶▶▶ Thru-the-groove Coolant Available
- ▶▶▶ BBT Available



MODEL	CODE	FIG	φd (GRIPPING RANGE)	φD	L	L1	H	COLLET	NUT	ADJUST SCREW	
Max. 8,000 min <sup>-1</sup>											
BT50 BBT50	RSC07N-090	251230	0.5~7	24	90	-	24~40	CR07-(D)	RSN07NB	M6×20L-CTW	
	-135	251232			135						
	-165	251234			165						
	-195	251235			195						
	RSC10N-075	251238	0.5~10	30	75	-	31~48	CR10-(D)	RSN10NB	RAS10-25-2.5	
	-105	251240			105						
	-135	251242			135						
	-165	251244			165						
	-195	251246			195						
	-225	251248			225						150
	-255	251250			255						180
	-285	251252			285						190
	RSC13N-075	251254	0.5~13	36	75	-	35~52	CR13-(D)	RSN13NB	RAS13-25-2.5	
	-105	251256			105						
	-135	251258			135						
	-165	251260			165						
	-195	251262			195						
	-225	251264			225						150
	-255	251266			255						180
	-285	251268			285						190
	RSC16N-075	251270	1~16	42	75	-	38~95	CR16-(D)	RSN16NB	RAS16-25-5	
	-105	251272			105						
	-135	251274			135						
	-165	251276			165						
	-195	251278			195						
	-225	251280			225		150				
	-255	251282			255		180				
	-285	251284			285		190				
RSC20N-075	251286	1.5~20	50	75	-	44~82	CR20-(D)	RSN20NB	RAS20-25-5		
-105	251288			105							
-135	251290			135							
-165	251292			165							
-195	251294			195							
-225	251296			225						150	
-255	251298			255						180	
-285	251300			285						190	

- NOTE : 1. Collet and chuck wrench are sold separately.  
 2. CROH collet is used for thru-the-tool coolant application.  
 3. The above-mentioned maximum speed will vary depending on rigidity of machine and balance of cutter.  
 An adequated cutting condition should be selected for each case.  
 4. Only BT shank tools are coated. BBT shank tools are not coated.

**ORDERING EXAMPLE**

①      ②      ③      ④

**BT50 - RSC 10 - 225**

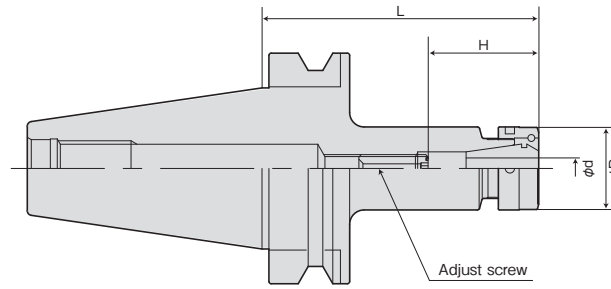
- ① Shank Size
- ② Holder's Name
- ③ Max. φD
- ④ G.L. Length

# COLLET CHUCK G Type

FEATURES P.9-10

BT(No)-RSC(Ⓧ)MAX-(L)G

- ▶▶▶ Thru-the-tool Coolant Available
- ▶▶▶ Thru-the-groove Coolant Available
- ▶▶▶ BBT Available



MODEL	CODE	$\phi d$ (GRIPPINGRANGE)	$\phi D$	L	H	COLLET	NUT	ADJUST SCREW	
Max. 25,000 min <sup>-1</sup>									
BT30 BBT30	RSC07N-060G	200700	0.5~7	24	60	24~40	CR07-(D)	RSN07NB	M6×20L-CTW
	-075G	200701			75				
	-090G	200702			90				
	-120G	200704			120				
	RSC10N-060G	200706	0.5~10	30	60	31~48	CR10-(D)	RSN10NB	RAS10-25-2.5
	-075G	200707			75				
	-090G	200708			90				
	-120G	200710			120				
	RSC13N-060G	200712	0.5~13	36	60	35~52	CR13-(D)	RSN13NB	RAS13-25-2.5
	-075G	200713			75				
	-090G	200714			90				
	-120G	200716			120				
RSC16N-060G	200718	1~16	42	60	38~50	CR16-(D)	RSN16NB	RAS16-25-5	
-075G	200719			75					
-090G	200720			90	38~72				
-120G	200722			120					
RSC20N-075G	200724	1.5~20	50	75	44~56.5	CR20-(D)	RSN20NB		
-090G	200726			90					
-120G	200728			120					
				150					
BT40 BBT40	RSC07N-060G	221150	0.5~7	24	60	24~40	CR07-(D)	RSN07NB	M6×20L-CTW
	-075G	221151			75				
	-090G	221152			90				
	-120G	221154			120				
	-150G	221156			150				
	RSC10N-060G	221158	0.5~10	30	60	31~48	CR10-(D)	RSN10NB	RAS10-25-2.5
	-075G	221159			75				
	-090G	221160			90				
	-120G	221162			120				
	-150G	221164			150				
	RSC13N-060G	221166	0.5~13	36	60	35~52	CR13-(D)	RSN13NB	RAS13-25-2.5
	-075G	221167			75				
	-090G	221168			90				
	-120G	221170			120				
	-150G	221172			150				
	RSC16N-060G	221174	1~16	42	60	38~70	CR16-(D)	RSN16NB	RAS16-25-5
	-075G	221175			75				
	-090G	221176			90	38~77			
	-120G	221178			120				
	-150G	221180			150				
RSC20N-060G	221182	1.5~20	50	60	44~70	CR20-(D)	RSN20NB	RAS20-25-5	
-075G	221183			75					
-090G	221184			90	44~72				
-120G	221186			120					
-150G	221188			150					

- NOTE : 1. Collet and chuck wrench are sold separately.  
 2. CROH collet is used for thru-the-tool coolant application.  
 3. The above-mentioned maximum speed will vary depending on rigidity of machine and balance of cutter.  
 An adequated cutting condition should be selected for each case.  
 4. Only BT shank tools are coated. BBT shank tools are not coated.

ORDERING EXAMPLE				
①	②	③	④	⑤
BT30	- RSC	07	- 090	G
① Shank Size	② Holder's Name	③ Max. $\phi D$	④ G.L. Length	⑤ G Type

BT series

HSK series

ST series

Versatile Tool

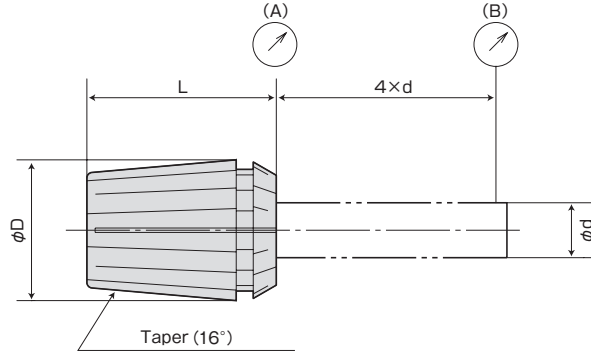
Cutting Tool

Accessories



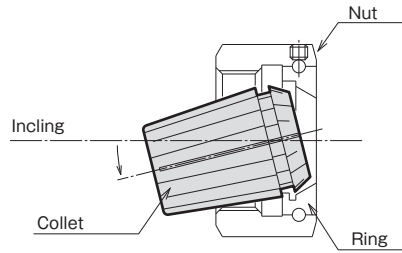
# CR COLLET

CR<sup>NO.</sup>-D



### Easy collet setting

- A half of ID of the ring is enlarged. Collet can be mounted easily by inclining it.



GRADE	RUNOUT (MAX. μm)	
	NOSE (A)	POINT (B)
(AA)	1	3
(A)	2	5
(STD)	5	15

Grade	application
AA grade · A grade	Reamer · Center drill Carbide small diameter drill, Endmill Whetstone for internal cylindrical grinding, Tool for high frequency motors Carbide drill Rotating tool for lathes ( the tool rotation )
Standard	General drill, tap Rotating tool for lathes (Work rotating )

CHUCK COLLET CODE	RSC07		RSC10		RSC13		RSC16		RSC20	
	CR07-d	GRADE	CR10-d	GRADE	CR13-d	GRADE	CR16-d	GRADE	CR20-d	GRADE
φd	φd	RANGE	φd	RANGE	φd	RANGE	φd	RANGE	φd	RANGE
	1.0	0.5~1.0	1.0	0.5~1.0	1.0	0.5~1.0	1.5	1.0~1.5	2.0	1.5~2.0
	1.5	1.0~1.5	1.5	1.0~1.5	1.5	1.0~1.5	2.0	1.5~2.0	2.5	2.0~2.5
	2.0	1.5~2.0	2.0	1.5~2.0	2.0	1.5~2.0	2.5	2.0~2.5	3.0	2.5~3.0
	2.5	2.0~2.5	2.5	2.0~2.5	2.5	2.0~2.5	3.0	2.5~3.0	4.0	3.0~4.0
	3.0	2.5~3.0	3.0	2.5~3.0	3.0	2.5~3.0	4.0	3.0~4.0	5.0	4.0~5.0
	3.5	3.0~3.5	4.0	3.0~4.0	4.0	3.0~4.0	5.0	4.0~5.0	6.0	5.0~6.0
	4.0	3.5~4.0	5.0	4.0~5.0	5.0	4.0~5.0	6.0	5.0~6.0	7.0	6.0~7.0
	4.5	4.0~4.5	6.0	5.0~6.0	6.0	5.0~6.0	7.0	6.0~7.0	8.0	7.0~8.0
	5.0	4.5~5.0	7.0	6.0~7.0	7.0	6.0~7.0	8.0	7.0~8.0	9.0	8.0~9.0
	5.5	5.0~5.5	8.0	7.0~8.0	8.0	7.0~8.0	9.0	8.0~9.0	10.0	9.0~10.0
	6.0	5.5~6.0	9.0	8.0~9.0	9.0	8.0~9.0	10.0	9.0~10.0	11.0	10.0~11.0
	6.5	6.0~6.5	10.0	9.0~10.0	10.0	9.0~10.0	11.0	10.0~11.0	12.0	11.0~12.0
	7.0	6.5~7.0			11.0	10.0~11.0	12.0	11.0~12.0	13.0	12.0~13.0
					12.0	11.0~12.0	13.0	12.0~13.0	14.0	13.0~14.0
					13.0	12.0~13.0	14.0	13.0~14.0	15.0	14.0~15.0
						15.0	14.0~15.0	16.0	15.0~16.0	
						16.0	15.0~16.0	17.0	16.0~17.0	
								18.0	17.0~18.0	
								19.0	18.0~19.0	
								20.0	19.0~20.0	
φD	11		16		20		25		32	
L	18		27		31		35		40	

Collet for through the groove (produce by order) are also available.

### ORDERING EXAMPLE

① **CR07** - ② **1.5** ③ **AA**

- ① Chuck Type
- ② φd
- ③ Grade

ACCESSORIES for COLLET CHUCK

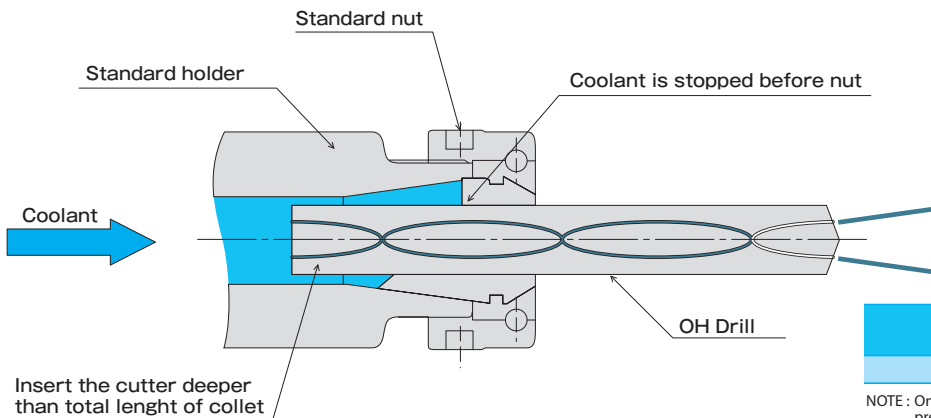


# OIL HOLE CR COLLET

CROH<sup>®</sup>-D

## FEATURES

- For thru-the-tool coolant application.
- High pressure up to 7 Mpa is acceptable.
- Standard holders and nuts can be used.
- Bearing of nut is not affected by coolant.



GRADE	RUNOUT (MAX. $\mu\text{m}$ ) 4 $\times$ d
(AA)	5 $\mu\text{m}$

NOTE : Only super precious grade (AA) is available for sale only ultra precision grade (AA) type.

COLLET CODE/CHUCK	RSC07 CROH07-d GRADE		RSC10 CROH10-d GRADE		RSC13 CROH13-d GRADE		RSC16 CROH16-d GRADE		RSC20 CROH20-d GRADE	
$\phi d$	$\phi d$	RANGE	$\phi d$	RANGE	$\phi d$	RANGE	$\phi d$	RANGE	$\phi d$	RANGE
	2.0	1.9~2.0	2.0	1.9~2.0	3.0	2.9~3.0	3.0	2.9~3.0	3.0	2.9~3.0
	2.5	2.4~2.5	2.5	2.4~2.5	3.5	3.4~3.5	3.5	3.4~3.5	3.5	3.4~3.5
	3.0	2.9~3.0	3.0	2.9~3.0	4.0	3.9~4.0	4.0	3.9~4.0	4.0	3.9~4.0
	4.0	3.9~4.0	4.0	3.9~4.0	4.5	4.4~4.5	4.5	4.4~4.5	4.5	4.4~4.5
	4.5	4.4~4.5	4.5	4.4~4.5	5.0	4.9~5.0	5.0	4.9~5.0	5.0	4.9~5.0
	5.0	4.9~5.0	5.0	4.9~5.0	5.5	5.0~5.5	5.5	5.4~5.5	5.5	5.4~5.5
	5.5	5.4~5.5	5.5	5.0~5.5	6.0	5.5~6.0	6.0	5.5~6.0	6.0	5.9~6.0
	6.0	5.9~6.0	6.0	5.5~6.0	6.5	6.0~6.5	6.5	6.0~6.5	6.5	6.4~6.5
	6.5	6.4~6.5	6.5	6.0~6.5	7.0	6.5~7.0	7.0	6.5~7.0	7.0	6.9~7.0
	7.0	6.9~7.0	7.0	6.5~7.0	7.5	7.0~7.5	7.5	7.0~7.5	7.5	7.4~7.5
			7.5	7.0~7.5	8.0	7.5~8.0	8.0	7.5~8.0	8.0	7.5~8.0
			8.0	7.5~8.0	8.5	8.0~8.5	8.5	8.0~8.5	8.5	8.0~8.5
			8.5	8.0~8.5	9.0	8.5~9.0	9.0	8.5~9.0	9.0	8.5~9.0
			9.0	8.5~9.0	9.5	9.0~9.5	9.5	9.0~9.5	9.5	9.0~9.5
			9.5	9.0~9.5	10.0	9.5~10.0	10.0	9.5~10.0	10.0	9.5~10.0
			10.0	9.5~10.0	10.5	10.0~10.5	10.5	10.0~10.5	10.5	10.0~10.5
					11.0	10.5~11.0	11.0	10.5~11.0	11.0	10.5~11.0
					11.5	11.0~11.5	11.5	11.0~11.5	11.5	11.0~11.5
					12.0	11.5~12.0	12.0	11.5~12.0	12.0	11.5~12.0
					12.5	12.0~12.5	12.5	12.0~12.5	12.5	12.0~12.5
					13.0	12.5~13.0	13.0	12.5~13.0	13.0	12.5~13.0
							13.5	13.0~13.5	13.5	13.0~13.5
							14.0	13.5~14.0	14.0	13.5~14.0
							14.5	14.0~14.5	14.5	14.0~14.5
							15.0	14.5~15.0	15.0	14.5~15.0
							15.5	15.0~15.5	15.5	15.0~15.5
							16.0	15.5~16.0	16.0	15.5~16.0
								16.5	16.0~16.5	
								17.0	16.5~17.0	
								17.5	17.0~17.5	
								18.0	17.5~18.0	
								18.5	18.0~18.5	
								19.0	18.5~19.0	
								19.5	19.0~19.5	
								20.0	19.5~20.0	
$\phi D$		11		16		20		25		32
L		18		27		31		35		40

- NOTE : 1. Applicable for drill with oil hole.  
 2. When in use insert a drill to the end from the rear of the collet.  
 3. Do not use smaller sized cutting tools than inner diameter of collet, or coolant may leak out of a collet.  
 4. If flat-face shank cutting tool is used, sealing function of collet does not work.

**ORDERING EXAMPLE**

① CROH10 - ② 10 ③ AA

① Chuck Type  
 ②  $\phi d$   
 ③ Grade

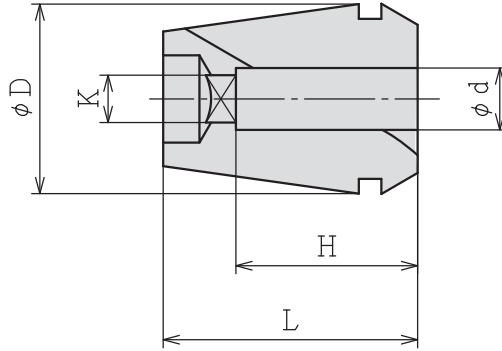


# CR TAP COLLET

CR<sup>®</sup>GB-<sup>Ⓧ</sup>



CR collet with square hole for shank end of tap (for synchro tap).



MODEL	CODE	TAP SIZE	$\phi d$	K	H	$\phi D$	L	TAP HOLDER	COLLET CHUCK	
CR10GB	-M4	84700	M4	5	4	16	27	-	RSC10	
	-M5	84702	M5	5.5	4.5					
	-M6	84704	M6	6	4.5					
	-M8	84706	M8	6.2	5					
	-M10	84708	M10	7	5.5					
-P1/8	84710	P1/8	8	6	20					
CR13GB	-M4	84712	M4	5	4	20	31	SYFN12	RSC13	
	-M5	84714	M5	5.5	4.5					
	-M6	84716	M6	6	4.5					
	-M8	84718	M8	6.2	5					
	-M10	84720	M10	7	5.5					
	-P1/8	84722	P1/8	8	6					20
-M12	84724	M12	8.5	6.5	20					
CR16GB	-M4	84726	M4	5	4	25	35	SYFN16S	RSC16	
	-M5	84728	M5	5.5	4.5					
	-M6	84730	M6	6	4.5					
	-M8	84732	M8	6.2	5					
	-M10	84734	M10	7	5.5					
	-P1/8	84736	P1/8	8	6					20
	-M12	84738	M12	8.5	6.5					20
	-M14	84740	M14	10.5	8					25
	-P1/4	84742	P1/4	11	9					17
-M16	84744	M16	12.5	10	25					
-P3/8	84746	P3/8	14	11	18					
CR20GB	-M4	84748	M4	5	4	32	40	SYFN20	RSC20	
	-M5	84750	M5	5.5	4.5					
	-M6	84752	M6	6	4.5					
	-M8	84754	M8	6.2	5					
	-M10	84756	M10	7	5.5					
	-P1/8	84758	P1/8	8	6					20
	-M12	84760	M12	8.5	6.5					20
	-M14	84762	M14	10.5	8					25
	-P1/4	84764	P1/4	11	9					17
	-M16	84766	M16	12.5	10					25
	-P3/8	84768	P3/8	14	11					18
	-M18	84770	M18	14	11					30
	-M20	84772	M20	15	12					30

NOTE : 1. Above table is for a tap of JIS standard shank.  
2. Run-out accuracy is subject to ordinary (STD) class.

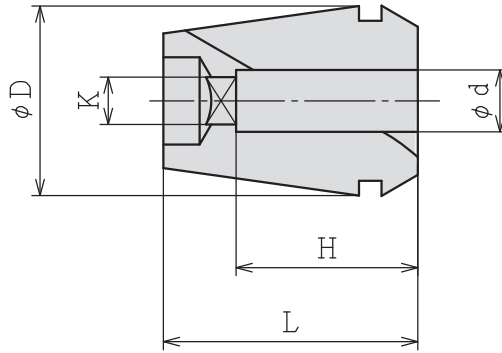
ACCESSORIES for COLLET CHUCK



# OIL HOLE CR TAP COLLET

CR<sup>10</sup>GH-<sup>⊕</sup>

OH-type collet with square hole is for high-pressure centre-through coolant feeding (for synchro tapping) .



MODEL	CODE	TAP SIZE	$\phi d$	K	H	$\phi D$	L	TAP HOLDER	COLLET CHUCK
CR10GH	-M6	84800	M6	6	4.5	16	27	-	RSC10
	-M8	84802	M8	6.2	5				
	-M10	84804	M10	7	5.5				
	-P1/8	84806	P1/8	8	6				
CR13GH	-M6	84808	M6	6	4.5	20	31	SYFN12	RSC13
	-M8	84810	M8	6.2	5				
	-M10	84812	M10	7	5.5				
	-P1/8	84814	P1/8	8	6				
CR16GH	-M6	84818	M6	6	4.5	25	35	SYFN16S	RSC16
	-M8	84820	M8	6.2	5				
	-M10	84822	M10	7	5.5				
	-P1/8	84824	P1/8	8	6				
	-M12	84826	M12	8.5	6.5				
	-M14	84828	M14	10.5	8				
	-P1/4	84830	P1/4	11	9				
CR20GH	-M6	84836	M6	6	4.5	32	40	SYFN20	RSC20
	-M8	84838	M8	6.2	5				
	-M10	84840	M10	7	5.5				
	-P1/8	84842	P1/8	8	6				
	-M12	84844	M12	8.5	6.5				
	-M14	84846	M14	10.5	8				
	-P1/4	84848	P1/4	11	9				
	-M16	84850	M16	12.5	10				
	-P3/8	84852	P3/8	14	11				
	-M18	84854	M18	14	11				
-M20	84856	M20	15	12					

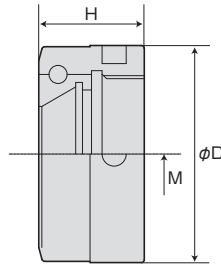
- NOTE :
1. Above table is for a tap of JIS standard shank.
  2. Run-out accuracy is subject to ordinary (STD) class.
  3. In the case of OSG Corporation synchro tap, shank diameter, square end dimensions are different from others so that there is the case that you can not use it even if tap size is the same.
  4. Gap-through collet is also available. Please order separately.

ACCESSORIES for COLLET CHUCK



# NUT FOR COLLET CHUCK

RSN (No.) - TYPE



for BT, ST

Through-Coolant use

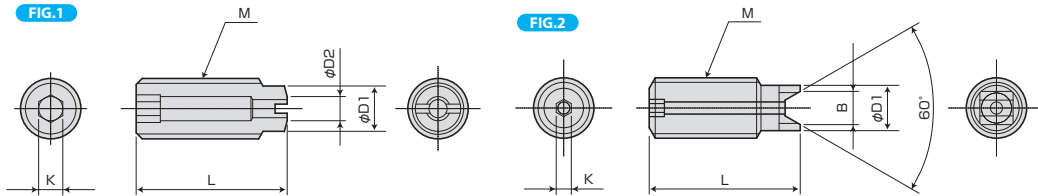
CODE	M	φD	H	CHUCK
RSN07NB (Ni) 30891	M16×1.0	24	11.5	RSC07
RSN10NB (Ni) 30892	M21×1.0	30	15.5	RSC10
RSN13NB (Ni) 30893	M26×1.0	36	17.5	RSC13
RSN16NB (Ni) 30894	M32×1.0	42	17.5	RSC16
RSN20NB (Ni) 30895	M40×1.0	50	17.5	RSC20

CODE	M	φD	H	CHUCK
RSN10NB-OH 30870	M21×1.0	30	15.5	RSC10
RSN13NB-OH 30871	M26×1.0	36		RSC13
RSN16NB-OH 30872	M32×1.0	42	17.5	RSC16
RSN20NB-OH 30873	M40×1.0	50		RSC20

Note: Single use of OH nut can not cope with the thru-the-tool coolant.



# ADJUST SCREW (For COLLET CHUCK)



MODEL	FIG	M	L	D1	D2	K	B	HOLDER
M6×20L-CTW 1)	1	M6×1.0	20	4.5	3	3	—	RSC07
RAS10-25-2.5 2)	2	M10×1.5	25	7.5	—	2.5	5.5	RSC10
RAS13-25-2.5 2)		M12×1.5		9.5			7.2	RSC13
RAS16-25-5 2)		M18×1.5		13.5		5	9.5	RSC16
RAS20-25-5 2)		M24×1.5		17.5				RSC20

Note 1: Drill less than φ3 cannot be used for adjustment protrusion in order to enter the coolant hole.

CTW is not in the two pieces shape

Note 2: Drill less than φ2 cannot be used for adjustment protrusion in order to enter the coolant hole.



# CHUCK WRENCH (For COLLET CHUCK)

CODE	CHUCK
FP25 35844	RSC07
FP30 35845	RSC10
FP35 35846	RSC13
FP42 35847	RSC16
FP50 35848	RSC20