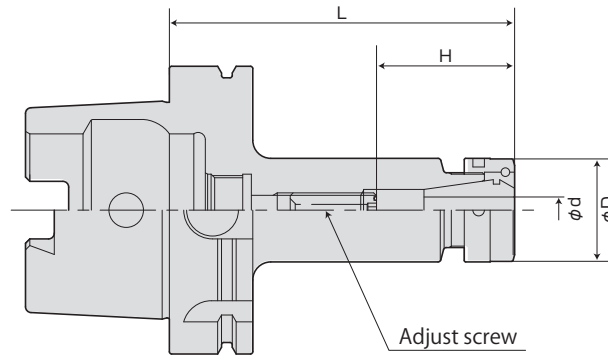


COLLET CHUCK

FEATURES P.9-10

HSKA^(No)-RSC^(D)MAX-L

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



MODEL	CODE	STOCK	ød	øD	L	H (Adjust)	COLLET	NUT	ADJUST SCREW	
Max. 20,000min⁻¹										
HSKA50	RSC07-090	300074	○	0.5~7	24	90	24~40	CR07-(D)	RSN07NB	M6×20L-CTW
	RSC10-090	300065	○	0.5~10	30	90	31~43	CR10-(D)	RSN10NB	RAS10-25-2.5
	-120	300066	○			120	31~48			
	RSC13-090	300067	○	0.5~13	36	90	35~43	CR13-(D)	RSN13NB	RAS13-25-2.5
	-120	300068	○			120	35~52			
	RSC16-090	300070	○	1~16	42	90	38~43	CR16-(D)	RSN16NB	RAS16-25-5
-120	300071	○	120			38~66				
RSC20-090	300072	○	1.5~20	50	90	68	CR20-(D)	RSN20NB	(M24×25L-CTW) RAS20-25-5	
-120	300073	○			120	44~67				
HSKA63	RSC07-090	320170	○	0.5~7	24	90	24~40	CR07-d	RSC07NB	M6×20L-CTW
	RSC10-090	320172	○	0.5~10	30	90	31~40	CR10-d	RSC10NB	RAS10-25-2.5
	RSC10-120	320174	○			120	31~48			
	RSC10-150	320175	△			150				
	RSC13-090	320176	○	0.5~13	36	90	35~40	CR13-d	RSC13NB	RAS13-25-2.5
	RSC13-120	320178	○			120	35~52			
	RSC13-150	320179	△			150				
	RSC16-090	320180	○	1~16	42	90	38~40	CR16-d	RSC16NB	RAS16-25-5
	RSC16-120	320181	○			120	38~66			
	RSC16-150	320161	△			150				
	RSC20-090	320182	○	1.5~20	50	90	66	CR20-d	RSC20NB	(M24×25L-CTW) RAS20-25-5
	RSC20-120	320184	○			120	44~61			
RSC20-150	320185	△			150					
Max. 8,000min⁻¹										
HSKA100	RSC07-105		○	0.5~7	24	105	24~40	CR07-d	RSC07NB	M6×20L-CTW
	RSC10-105	350330	○			105	31~43			
	RSC10-135	350332	○	0.5~10	30	135	31~48	CR10-d	RSC10NB	RAS10-25-2.5
	RSC10-165	350333	△			165				
	RSC10-195	350311	△			195				
	RSC10-225	350312	△			225				
	RSC10-255	350313	△			255				
	RSC10-285	350314	△			285				
	RSC13-105	350334	○	0.5~13	36	105	35~48	CR13-d	RSC13NB	RAS13-25-2.5
	RSC13-135	350336	○			135				
	RSC13-165	350337	△			165				
	RSC13-195	350315	△			195				
	RSC13-225	350316	△			225				
	RSC13-255	350317	△			255				
	RSC13-285	350318	△			285				
	RSC16-105	350338	○	1~16	42	105	38~48	CR16-d	RSC16NB	RAS16-25-5
	RSC16-135	350340	○			135				
	RSC16-165	350341	△			165				
	RSC16-195	350319	△			195				
	RSC16-225	350320	△			225				
	RSC16-255	350321	△			255				
	RSC16-285	350322	△			285				
	RSC20-105	350342	○	1.5~20	50	105	44~48	CR20-d	RSC20NB	RAS20-25-5
	RSC20-135	350344	○			135				
	RSC20-165	350345	△			165				
	RSC20-195	350346	△			195				
	RSC20-225	350347	△			225				
	RSC20-255	350348	△			255				
RSC20-285	350349	△			285					

- NOTE: 1. Coolant pipe is included.
 2. Collet and chuck wrench are sold separately.
 3. CROH collet is used for thru-the-tool coolant application.
 4. The above-mentioned maximum speed will vary depending rigidity of the machine and balance of cutter.
 An adequate cutting condition should be selected for each case.

ORDERING EXAMPLE

① HSKA50 - ② RSC - ③ 07 - ④ 090

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

ACCESSORIES
 P.122-125 COLLETS

ACCESSORIES
 P.126 NUT, ADJUST SCREW, CHUCK WRENCH

BT series

HSK series

ST series

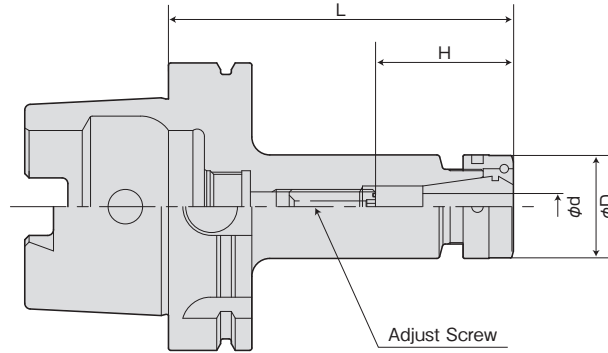
Versatile Tool

Cutting Tool

Accessories

▶▶▶ Thru-the-tool Coolant Available

▶▶▶ Thru-the-groove Coolant Available



Max 27,000min⁻¹

MODEL	CODE	φd (GRIPPING RANGE)	φD	L	H	COLLET	NUT	ADJUST SCREW	
HSKA50	RSC07-090G	300040	0.5~7	24	90	24~40	CR07-(D)	RSN07NB	M6×20L-CTW
	RSC10-090G	300042	0.5~10	30	90	31~43	CR10-(D)	RSN10NB	RAS10-25-2.5
	-120G	300043		120	31~48				
	RSC13-090G	300044	0.5~13	36	90	35~43	CR13-(D)	RSN13NB	RAS13-25-2.5
	-120G	300045		120	35~52				
	RSC16-090G	300046	1~16	42	90	38~43	CR16-(D)	RSN16NB	RAS16-25-5
	-120G	300047		120	38~66				
	RSC20-090G	300048	1.5~20	50	90	68	CR20-(D)	RSN20NB	(M24×25L-CTW)
-120G	300049	120		44~67	RAS20-25-5				
HSKA63	RSC07-090G	320150	0.5~7	24	90	24~40	CR07-(D)	RSN07NB	M6×20L-CTW
	RSC10-090G	320152	0.5~10	30	90	31~40	CR10-(D)	RSN10NB	RAS10-25-2.5
	-120G	320153		120	31~48				
	RSC13-090G	320154	0.5~13	36	90	35~40	CR13-(D)	RSN13NB	RAS13-25-2.5
	-120G	320155		120	35~52				
	RSC16-090G	320156	1~16	42	90	38~40	CR16-(D)	RSN16NB	RAS16-25-5
	-120G	320157		120	38~66				
	RSC20-090G	320158	1.5~20	50	90	66	CR20-(D)	RSN20NB	(M24×25L-CTW)
-120G	320159	120		44~61	RAS20-25-5				

- NOTE : 1. Coolant pipe is included.
 2. Collet and chuck wrench are sold separately.
 3. CROH collet is used for thru-the-tool coolant application.
 4. The above-mentioned maximum speed will vary depending rigidity of the machine and balance of cutter.
 An adequate cutting condition should be selected for each case.

ORDERING EXAMPLE				
①	②	③	④	⑤
HSKA50	RSC	07	090	G
① Shank Size	② Holder's Name	③ Max. φD	④ G.L. Length	⑤ G Type



ACCESSORIES

➔ P.110-113 COLLETS



ACCESSORIES

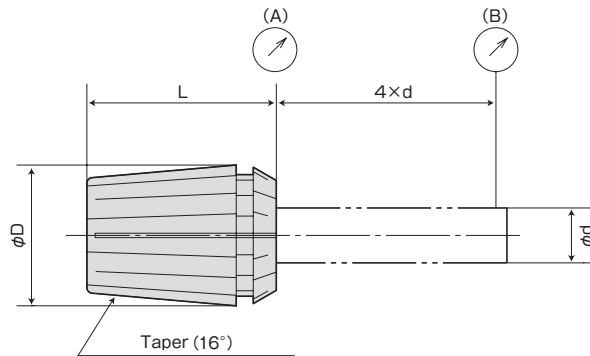
➔ P.114 NUT, ADJUST SCREW, CHUCK WRENCH

ACCESSORIES for COLLET CHUCK



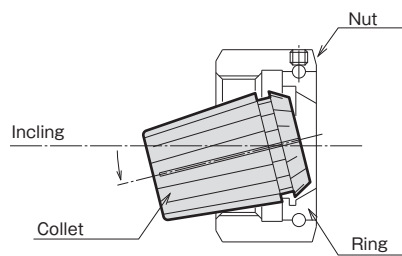
CR COLLET

CR[Ⓜ]-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 CR07-d GRADE		RSC10 CR10-d GRADE		RSC13 CR13-d GRADE		RSC16 CR16-d GRADE		RSC20 CR20-d GRADE		
φd	RANGE	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	2.0	1.5~2.0
1.5	1.0~1.5	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	2.0	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	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	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	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	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	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	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	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	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	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

BT series

HSK series

ST series

Versatile Tool

Cutting Tool

Accessories

ACCESSORIES for COLLET CHUCK

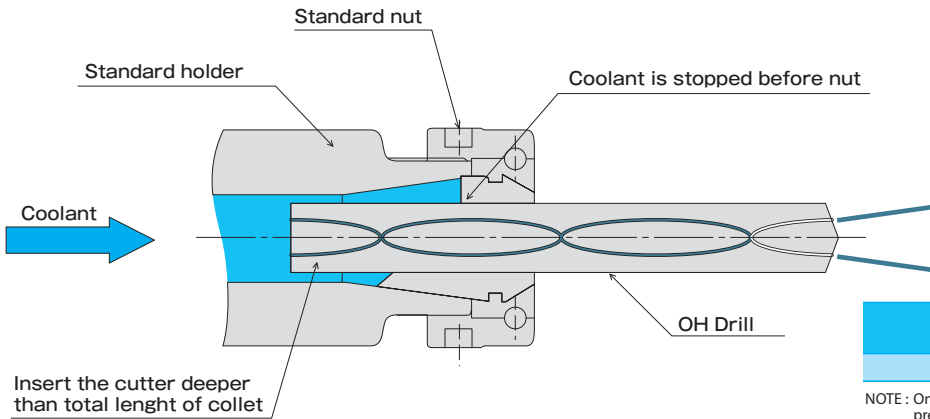


OIL HOLE CR COLLET

CROH[®]-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. μm) 4 \times d
(AA)	5 μm

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	
ϕd	ϕd	RANGE	ϕd	RANGE	ϕd	RANGE	ϕd	RANGE	ϕd	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	
ϕD		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 ϕd
- ③ Grade

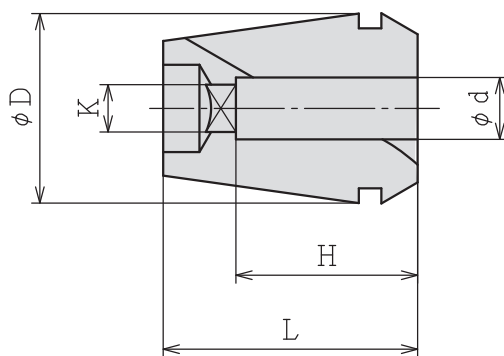
ACCESSORIES for COLLET CHUCK



CR TAP COLLET

CR^{No}GB-D

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



MODEL	CODE	TAP SIZE	ϕd	K	H	ϕD	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.

BT series

HSK series

ST series

Versatile Tool

Cutting Tool

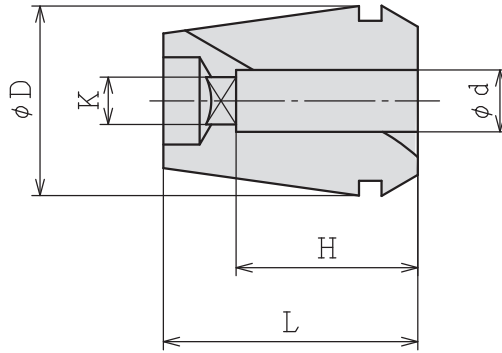
Accessories



OIL HOLE CR TAP COLLET

CR¹⁰GH-[⊕]

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



HSK series

MODEL	CODE	TAP SIZE	φd	K	H	φD	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				
	-M12	84816	M12	8.5	6.5				
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				
	-M16	84832	M16	12.5	10				
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					

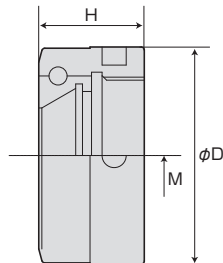
- NOTE :
- Above table is for a tap of JIS standard shank.
 - Run-out accuracy is subject to ordinary (STD) class.
 - In the case of OSG Corporation synchro tap, shank diameter, square end dimensions are different from others so that there is the case that you can not use it even if tap size is the same.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

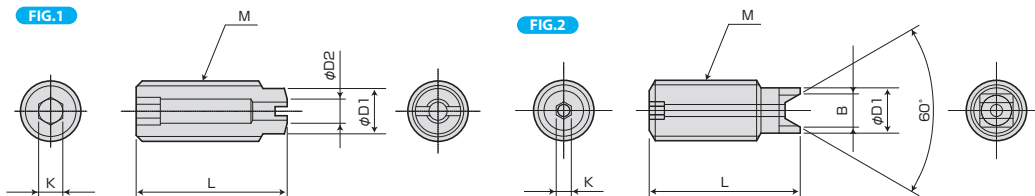
CODE	M	φD	H	CHUCK
RSN07NB(Ni) 30891	M16×1.0	24	11.5	RSC07
RSN10NB(Ni) 30892	M21×1.0	30	15.5	RSC10
RSN13NB(Ni) 30893	M26×1.0	36	17.5	RSC13
RSN16NB(Ni) 30894	M32×1.0	42	17.5	RSC16
RSN20NB(Ni) 30895	M40×1.0	50	17.5	RSC20

CODE	M	φD	H	CHUCK
RSN10NB-OH 30870	M21×1.0	30	15.5	RSC10
RSN13NB-OH 30871	M26×1.0	36	17.5	RSC13
RSN16NB-OH 30872	M32×1.0	42		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			—	RSC16
RAS20-25-5 2)		M24×1.5		17.5		5	9.5	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

BT series

HSK series

ST series

Versatile Tool

Cutting Tool

Accessories