



AHB

TOOLING & MACHINERY

COMPLETE METALWORKING SOLUTIONS

(800) 991-4225

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Solid ER Collets
Screw-on and Thermolock®

Screw-on Solid ER Collets

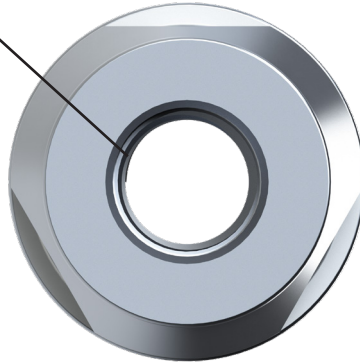
- ▶ Quick changes are now possible through the development of the screw-on solid ER collets. With the threaded I.D. feature in the new screw-on solid ER collets, install your screw-on cutting tools in a matter of seconds! Our collets have been designed to work with all ER25, ER32, & ER40 systems. Expect great results with runout and repeatability with the new screw-on solid ER collets.



Screw-on Solid ER Collet Features

- ▶ All solid ER collets are manufactured out of S7 steel for corrosion resistance, strength, and superior durability.

Precision I.D.
Less than .0001" runout



Access Flats
Allows easy
installation of the
collet nut

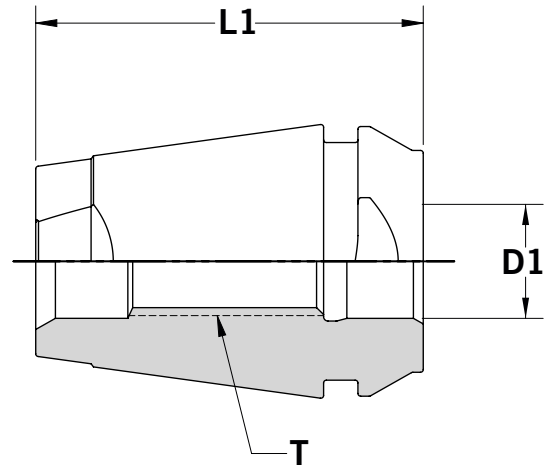


Wrench Flats
Clamping surface
to remove screw-on
cutting tools



Screw-on Solid ER Collets

- Available screw-on solid ER collet sizes: ER25, ER32, & ER40



ER25 Solid Collet - MM	Part Number	Size	D1	L1	T
	ER25ST0801	ER25	8.5mm	35mm	M8X1.25 Threads
	ER25ST1001	ER25	10.5mm	35mm	M10X1.50 Threads
	ER25ST1201	ER25	12.5mm	35mm	M12X1.75 Threads
ER32 Solid Collet - MM	Part Number	Size	D1	L1	T
	ER32ST0801	ER32	8.5mm	41mm	M8X1.25 Threads
	ER32ST1001	ER32	10.5mm	41mm	M10X1.50 Threads
	ER32ST1201	ER32	12.5mm	41mm	M12X1.75 Threads
	ER32ST1601	ER32	17mm	41mm	M16X2.00 Threads
ER40 Solid Collet - MM	Part Number	Size	D1	L1	T
	ER40ST0801	ER40	8.5mm	47mm	M8X1.25 Threads
	ER40ST1001	ER40	10.5mm	47mm	M10X1.50 Threads
	ER40ST1201	ER40	12.5mm	47mm	M12X1.75 Threads
	ER40ST1601	ER40	17mm	47mm	M16X2.00 Threads

Thermolock® Solid ER Collets

- ▶ Quick changes are now possible through the development of the Thermolock® solid ER collets. With the induced expansion and contraction feature, install your cutting tools in a matter of seconds! Our collets have been designed to work with all ER20, ER25, ER32, & ER40 systems. Expect great results with runout and repeatability while using the new Thermolock® solid ER collets.

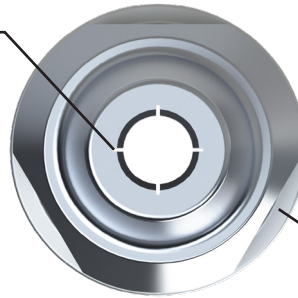


Thermolock® Solid ER Collet Features

- ▶ All Thermolock® solid ER collets are manufactured out of S7 steel for corrosion resistance, strength, and superior durability.

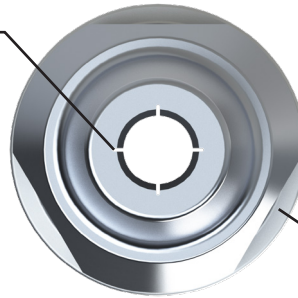
Coolant Cuts

Allows coolant to pass through I.D.



Access Flats

Allows easy installation of the collet nut



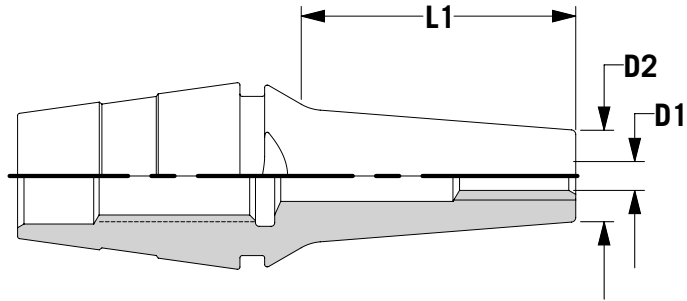
Precision I.D.

Less than .0001" runout



Thermolock® Solid ER Collets Inch

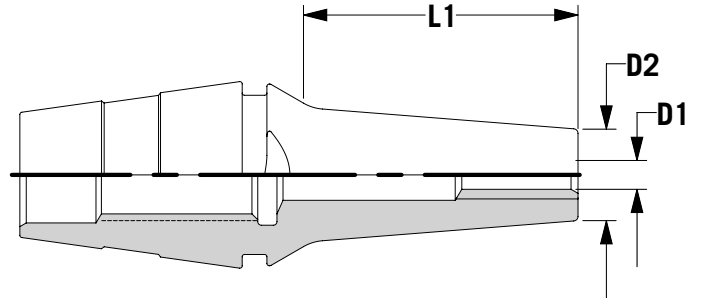
► Available Thermolock® solid ER collet sizes: ER20, ER25, ER32, & ER40



ER20 Collet Shrink - IN	Part Number	Size	D1	D2	L1
	ER20SF300125	ER20	0.125"	0.787"	1.181"
ER25 Collet Shrink - IN	Part Number	Size	D1	D2	L1
	ER25SF350125	ER25	0.125"	0.984"	1.378"
	ER25SF350250	ER25	0.250"	0.984"	1.378"
ER32 Collet Shrink - IN	Part Number	Size	D1	D2	L1
	ER32SF400125	ER32	0.125"	1.260"	1.575"
	ER32SF400250	ER32	0.250"	1.260"	1.575"
	ER32SF400375	ER32	0.375"	1.260"	1.575"
ER40 Collet Shrink - IN	Part Number	Size	D1	D2	L1
	ER40SF450125	ER40	0.125"	1.575"	1.772"
	ER40SF450250	ER40	0.250"	1.575"	1.772"
	ER40SF450375	ER40	0.375"	1.575"	1.772"
	ER40SF450500	ER40	0.500"	1.575"	1.772"

Thermolock® Solid ER Collets Metric

► Available Thermolock® solid ER collet sizes: ER20, ER25, ER32, & ER40



ER20 Collet Shrink - MM	Part Number	Size	D1	D2	L1
	ER20SF300003	ER20	3mm	10mm	30mm
ER25 Collet Shrink - MM	Part Number	Size	D1	D2	L1
	ER25SF350003	ER25	3mm	10mm	35mm
	ER25SF350006	ER25	6mm	14mm	35mm
ER32 Collet Shrink - MM	Part Number	Size	D1	D2	L1
	ER32SF400003	ER32	3mm	10mm	40mm
	ER32SF400006	ER32	6mm	14mm	40mm
	ER32SF400010	ER32	10mm	16mm	40mm
ER40 Collet Shrink - MM	Part Number	Size	D1	D2	L1
	ER40SF450003	ER40	3mm	10mm	45mm
	ER40SF450006	ER40	6mm	14mm	45mm
	ER40SF450010	ER40	10mm	16mm	45mm
	ER40SF450012	ER40	12mm	21mm	45mm

Thermolock® Tool Installation

- ▶ Thermolock® solid ER collets offer excellent clamping ability by operating on the principle of thermal induced expansion and contraction. The collet nose is heated, expanding the nose I.D., to accept a cutting tool. When cooled, the nose I.D. shrinks resulting in incredible gripping power over the full length of the collet / cutting tool interface.



Step 1: Mounting

Mount the collet and desired cutting tool into your heat shrink machine. A collet chuck holder or fixture will be needed to hold the collet in place.



Step 2: Heating

Heat the collet and apply slight pressure to the cutting tool simultaneously. The cutting tool should fall into place.



Step 3: Cooling

After cutting tool is in place, the tool will need to cool down. Most machines use liquid or air to speed this process up. Some machines may even do this step automatically.



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