



ER_{SYSTEM}

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powRgrip_{SYSTEM}

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Tapping Holders with Length Compensation





Swiss
Precision
Tools

ER

Cylindrical Shank Toolholders

Features | Benefits

Swiss Quality

Made in Switzerland to ISO 9001/ISO 14001.

1

Marking

Type and part number (reduces selection error).

2

Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

Original REGO-FIX®

Our extensive experience results in a well-engineered system. Original only with the REGO-FIX® quality symbol \triangle . Guarantees the best quality.

Sizes

ER 8 – ER 40

T.I.R. < 0.0001" (3 μ m)

I.D. to O.D.

Surface Finish max. Ra 0.25

Higher clamping force and higher transferable torque.

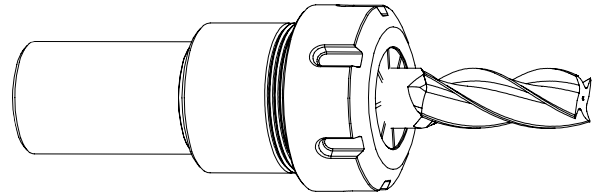


10

CYL/ER Toolholders

Applications

Cylindrical REGO-FIX® toolholders are designed for various automatic machines and can be utilized in conjunction with other holders to extend cutting tools. They are available in different types.



CYL/ER

Straight shank toolholders with a standard nut.
Detailed information see page 10.03

CYL/ER M

Straight shank toolholders with a Mini-nut. This type is suited for Swiss screw machines, machining centers and conventional machines.
Detailed information see page 10.04

CYL/ER MF

Straight shank toolholders with a Mini-nut and clamping flat. This holder is suited for Swiss screw machines, machining centers, conventional machines as well as CNC-machines such as Citizen, Manurhin, Star and Tornos, etc.
Detailed information see page 10.05

These toolholders accept collets of ER, ER-UP, ER-GB, ER-DM and ET1 type.

CYL/ER MF

Double ended toolholders with clamping flat for CNC machines such as Citizen, Manurhin, Star and Tornos and offers the possibility to hold two cutting tools on the same toolholder.
Detailed information see page 10.06

CYL/ER NC

Used on CNC-turning machines and on conventional turning machines as well.
Detailed information see page 10.07

CYL SSY/ERC

Softsynchro® tap holders are designed to compensate pitch differences between synchronous spindles and tapping tools.
Detailed information see page 10.09

CYL GSF/ERC

Tap holders with length compensation in compression and tension directions are used on machines without synchronization of spindle feed and the pitch of the thread.
Detailed information see page 10.11



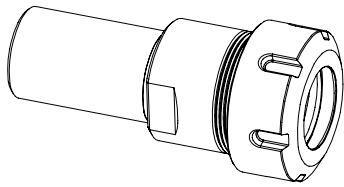
We recommend tightening the clamping nuts with a torque wrench. The maximum torque should not be more than 25% above the recommended tightening torque.



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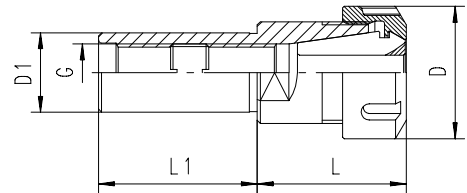
Cylindrical Shank Toolholders



CYL | ER

Toolholders (Straight Shank with Standard Hi-Q Nut)

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]	Wrenches
CYL 1/2" x 070 / ER 11	2613.11141	19	12.7	28.5	70	M6	7112.11010
CYL 1/2" x 100 / ER 16	2613.11661	28	12.7	36.0	100	M6	7112.16010
CYL 1/2" x 100 / ER 20	2613.12061	34	12.7	44.5	100	M6	7112.20010
CYL 14 x 060 / ER 16	2614.11630	28	14	36.5	60	M6	7112.16010
CYL 16 x 060 / ER 16	2616.11630	28	16	36.5	60	M 8x1	7112.16010
CYL 5/8" x 060 / ER 16	2616.11631	28	15.875	36.5	60	M 8x1	7112.16010
CYL 5/8" x 100 / ER 20	2616.12061	34	15.875	44.5	100	M 8x1	7112.20010
CYL 3/4" x 050 / ER 16	2619.11621	28	19.05	30.5	50	M 12x1	7112.16010
CYL 3/4" x 100 / ER 16	2619.11661	28	19.05	30.5	100	M 12x1	7112.16010
CYL 3/4" x 060 / ER 20	2619.12031	34	19.05	36.5	60	M 12x1	7112.20010
CYL 3/4" x 050 / ER 25	2619.12521	42	19.05	47.0	50	M 12x1	7111.25000
CYL 20 x 050 / ER 16	2620.11620	28	20	30.5	50	M 12x1	7112.16010
CYL 20 x 100 / ER 16	2620.11660	28	20	30.5	100	M 12x1	7112.16010
CYL 20 x 030 / ER 20	2620.12010	34	20	36.5	30	M 12x1	7112.20010
CYL 20 x 060 / ER 20	2620.12030	34	20	36.5	60	M 12x1	7112.20010
CYL 20 x 050 / ER 25	2620.12520	42	20	47.0	50	M 12x1	7111.25000
CYL 20 x 100 / ER 25	2620.12560	42	20	47.0	100	M 12x1	7111.25000
CYL 20 x 050 / ER 32	2620.13220	50	20	54.0	50	M 12x1	7111.32000
CYL 20 x 100 / ER 32	2620.13260	50	20	54.0	100	M 12x1	7111.32000
CYL 22 x 100 / ER 25	8020.22000	42	22	47.0	100	M12 x 1	7111.25000
CYL 1" x 100 / ER 20	2625.12061	34	25.40	39.5	100	M 18 x1.5	7112.20010
CYL 1" x 050 / ER 25	2625.12521	42	25.40	47.0	50	M 18 x1.5	7111.25000
CYL 1" x 100 / ER 25	2625.12561	42	25.40	47.0	100	M 18 x1.5	7111.25000
CYL 1" x 050 / ER 32	2625.13221	50	25.40	53.0	50	M 18 x1.5	7111.32000
CYL 1" x 050 / ER 40	2625.14021	63	25.40	60.0	50	M 18 x1.5	7111.40000
CYL 25 x 050 / ER 25	2625.12520	42	25	47.0	50	M 18 x1.5	7111.25000
CYL 25 x 100 / ER 25	2625.12560	42	25	47.0	100	M 18 x1.5	7111.25000
CYL 25 x 050 / ER 32	2625.13220	50	25	54.0	50	M 18 x1.5	7111.32000
CYL 25 x 050 / ER 40	2625.14020	63	25	60.0	50	M 18 x1.5	7111.40000
CYL 30 x 050 / ER 25	2630.12520	42	30	42.0	50	M 18 x1.5	7111.25000
CYL 30 x 050 / ER 32	2630.13220	50	30	53.0	50	M 22x1.5	7111.32000
CYL 1 1/4" x 060 / ER 32	2632.13231	50	31.75	53.0	60	M 22x1.5	7111.32000

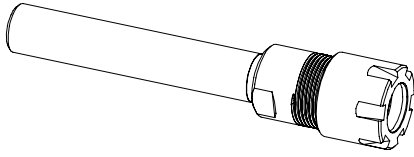


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Related Items	
Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00
Torque Wrench	See Section 13.00
Coolant Fittings	See Section 13.00

For drawings with detailed dimensions see:

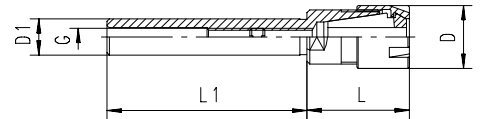
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CYL | ER M

Toolholders (Straight Shank with Mini-Style Hi-Q Nut)

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]	Wrenches
CYL 06 x 045 / ER 11 M	2606.21120	16	6	26.5	45	3mm	7113.11000
CYL 07 x 045 / ER 11 M	2607.21120	16	7	26.5	45	3mm	7113.11000
CYL 08 x 080 / ER 8 M	2608.20850	12	8	26.0	80	3mm	7113.08000
CYL 08 x 056 / ER 11 M	2608.21130	16	8	26.5	56	4mm	7113.11000
CYL 3/8" x 070 / ER 8 M	2609.20841	12	9.52	23.0	70	M 5	7113.08000
CYL 10 x 060 / ER 16 M	2610.21630	22	10	38.5	60	4mm	7113.16000
CYL 12 x 080 / ER 8 M	2612.20850	12	12	17.0	80	4mm	7113.08000
CYL 12 x 080 / ER 16 M	2612.21650	22	12	38.5	80	4mm	7113.16000
CYL 1/2" x 140 / ER 11 M	2613.21191	16	12.7	29.5	140	M 6	7113.11000
CYL 1/2" x 140 / ER 16 M	2613.21691	22	12.7	37.0	140	M 6	7113.16000
CYL 15 x 100 / ER 20 M	2615.22060	28	15	42.5	100	7mm	7113.20000
CYL 16 x 150 / ER 11 M	2616.21190	16	16	21.0	150	M 8x1	7113.11000
CYL 16 x 100 / ER 20 M	2616.22060	28	16	42.5	100	7mm	7113.20000
CYL 5/8" x 150 / ER 11 M	2616.21191	16	15.87	22.5	150	M 8x1	7113.11000
CYL 3/4" x 155 / ER 16 M	2619.21691	22	19.05	26.5	155	M 12x1	7113.16000
CYL 3/4" x 100 / ER 25 M	2619.22561	35	19.05	47.0	100	M 12x1	7113.25000
CYL 20 x 155 / ER 16 M	2620.21690	22	20	26.5	155	M 12x1	7113.16000
CYL 25 x 155 / ER 20 M	2625.22090	28	25	26.5	155	M 14x1	7113.20000
CYL 1" x 155 / ER 20 M	2625.22091	28	25.5	26.5	155	M 14x1	7113.20000



Supplied with: clamping nut and back-up screw

10

Related Items	
Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00
Torque Wrench	See Section 13.00
Coolant Fittings	See Section 13.00

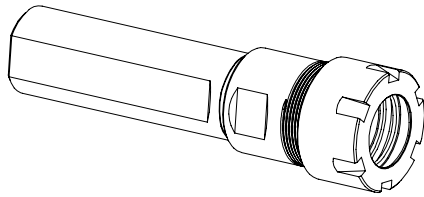
For drawings with detailed dimensions see:
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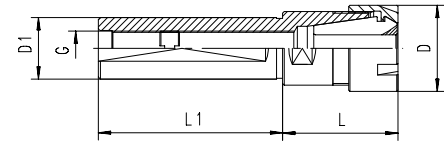
ER

Cylindrical Shank Toolholders



CYL | ER MF

Toolholders (Straight Shank with Flat and Mini-Style Hi-Q Nut)



Type	Part. No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]	Wrenches
CYL 5/8" x 043 / ER 8 MF	2616.20811	12	15.875	15	43	M5	7113.08000
CYL 16 x 038 / ER 11 MF	2616.21112	16	16	20	38	M 8x1	7113.11000
CYL 16 x 140 / ER 11 MF	2616.21192	16	16	60	140	M 8x1	7113.11000
CYL 16 x 035 / ER 16 MF	2616.21612	22	16	38	35	M 8x1	7113.16000
CYL 3/4" x 115 / ER 11 MF	2619.21173	16	19.05	20	115	M 8x1	7113.11000
CYL 3/4" x 038 / ER 16 MF	2619.21613	22	19.05	28	38	M 12x1	7113.16000
CYL 3/4" x 050 / ER 16 MF	2619.21623	22	19.05	28	50	M 12x1	7113.16000
CYL 3/4" x 070 / ER 16 MF	2619.21643	22	19.05	28	70	M 12x1	7113.16000
CYL 3/4" x 120 / ER 16 MF	2619.21683	22	19.05	28	120	M 12x1	7113.16000
CYL 3/4" x 140 / ER 16 MF	2619.21693	22	19.05	28	140	M 12x1	7113.16000
CYL 20 x 050 / ER 16 MF	2620.21622	22	20	28	50	M 12x1	7113.16000
CYL 20 x 070 / ER 16 MF	2620.21642	22	20	28	70	M 12x1	7113.16000
CYL 20 x 120 / ER 16 MF	2620.21682	22	20	28	120	M 12x1	7113.16000
CYL 20 x 140 / ER 16 MF	2620.21692	22	20	8	140	M 12x1	7113.16000
CYL 22 x 038 / ER 16 MF	2622.21612	22	22	28	38	M 12x1	7113.16000
CYL 22 x 070 / ER 16 MF	2622.21642	22	22	28	70	M 12x1	7113.16000
CYL 22 x 100 / ER 16 MF	2622.21662	22	22	28	100	M 12x1	7113.16000
CYL 22 x 080 / ER 20 MF	2622.22052	28	22	39	80	M 12x1	7113.20000
CYL 22 x 070 / ER 25 MF	2622.22542	35	22	47	70	M 12x1	7113.25000
CYL 25 x 065 / ER 16 MF	2625.21642	22	25	28	65	M 12x1	7113.16000
CYL 25 x 100 / ER 20 MF	2625.22062	28	25	28	100	M 14x1	7113.20000
CYL 25 x 154 / ER 20 MF	2625.22002	28	25	28	154	M 14x1	7113.20000
CYL 25 x 075 / ER 25 MF	2625.22552	35	25	47	75	M 14x1	7113.25000
CYL 25 x 145 / ER 25 MF	2625.22592	35	25	36	145	M 14x1	7113.25000
CYL 1" x 033 / ER 16 MF	2625.21613	22	25.4	28	33	M 12x1	7113.16000
CYL 1" x 065 / ER 16 MF	2625.21643	22	25.4	28	65	M 12x1	7113.16000
CYL 1" x 075 / ER 16 MF	2625.21653	22	25.4	28	75	M 12x1	7113.16000
CYL 1" x 100 / ER 16 MF	2625.21663	22	25.4	28	100	M 12x1	7113.16000
CYL 1" x 100 / ER 20 MF	2625.22063	28	25.4	28	100	M 14x1	7113.20000
CYL 1" x 140 / ER 20 MF	2625.22093	28	25.4	28	140	M 14x1	7113.20000
CYL 32 x 070 / ER 25 MF	2632.22542	35	32	30	70	M 18x1.5	7113.25000

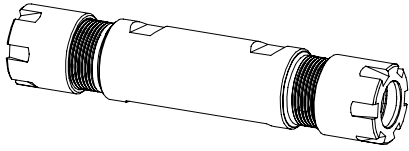
Supplied with: clamping nut and back-up screw

Related Items	
Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00
Torque Wrench	See Section 13.00
Coolant Fittings	See Section 13.00

For drawings with detailed dimensions see:

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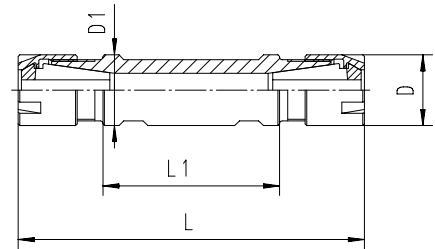
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CYD | ER MF

Toolholders (Double Ended Straight Shank with Flat and Mini-Style Hi-Q Nut)

Type	Part. No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	Wrenches
CYD 5/8" x 015 / ER 8 MF	2616.20805	12	15.875	45	15	7113.08000
CYD 5/8" x 025 / ER 8 MF	2616.20895	12	15.875	55	25	7113.08000
CYD 16 x 040 / ER 11 MF	2616.21114	16	16	79	40	7113.11000
CYD 16 x 050 / ER 11 MF	2616.21124	16	16	90	50	7113.11000
CYD 3/4" x 040 / ER 11 MF	2619.21125	16	19.05	80	40	7113.11000
CYD 3/4" x 070 / ER 11 MF	2619.21145	16	19.05	110	70	7113.11000
CYD 3/4" x 090 / ER 11 MF	2619.21165	16	19.05	130	90	7113.11000
CYD 3/4" x 055 / ER 16 MF	2619.21635	22	19.05	107	55	7113.16000
CYD 20 x 030 / ER 11 MF	2620.21114	16	20	70	30	7113.11000
CYD 20 x 050 / ER 11 MF	2620.21124	16	20	90	50	7113.11000
CYD 20 x 055 / ER 16 MF	2620.21634	22	20	107	55	7113.16000
CYD 22 x 055 / ER 16 MF	2622.21634	22	22	111	55	7113.16000
CYD 22 x 075 / ER 16 MF	2622.21654	22	22	131	75	7113.16000
CYD 25 x 062 / ER 16 MF	2625.21634	22	25	118	62	7113.16000
CYD 1" x 030 / ER 16 MF	2625.21615	22	25.4	85	30	7113.16000
CYD 1" x 062 / ER 16 MF	2625.21635	22	25.4	118	62	7113.16000
CYD 32 x 055 / ER 20 MF	2632.22034	28	32	111	55	7113.20000
CYD 32 x 075 / ER 20 MF	2632.22054	28	32	131	75	7113.20000



Supplied with: two clamping nuts

10

Related Items	
Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00
Torque Wrench	See Section 13.00

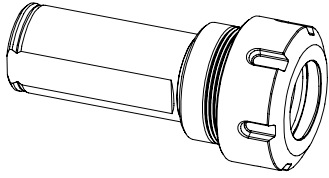
For drawings with detailed dimensions see:
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Cylindrical Shank Toolholders

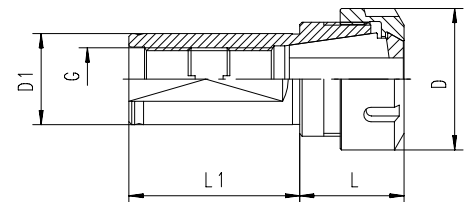


CYL | ER NC

Toolholders (Straight Shank with Flat and Standard Hi-Q Nut)

Type	Part. No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	G [mm]	Wrenches
CYL 32 x 060 / ER 25 NC	2632.12532	42	32	32	60	M 18 x 1.5	7111.25000
CYL 32 x 060 / ER 32 NC	2632.13232	50	32	38	60	M 22 x 1.5	7111.32000
CYL 40 x 080 / ER 32 NC	2640.13252	50	40	33	80	M 22 x 1.5	7111.32000
CYL 40 x 075 / ER 40 NC	2640.14052	63	40	55	75	M 22 x 1.5	7111.40000
CYL 1" x 100 / ER 20 NC	2625.12063	28	1"	24	100	M14 x 1	7112.20010
CYL 1 1/4" x 060 / ER 25 NC	2632.12533	42	1 1/4"	32	60	M18 x 1.5	7111.25000
CYL 1 1/4" x 060 / ER 32 NC	2632.13233	50	1 1/4"	38	60	M22 x 1.5	7111.32000
CYL 1 1/4" x 060 / ER 40 NC	2632.14033	63	1 1/4"	60	60	M22 x 1.5	7111.40000
CYL 1 1/2" x 080 / ER 32 NC	2638.13253	50	1 1/2"	33	80	M22 x 1.5	7111.32000
CYL 1 1/2" x 075 / ER 40 NC	2638.14053	63	1 1/2"	55	75	M22 x 1.5	7111.40000

Supplied with: clamping nut and back-up screw



10

Related Items

Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00
Torque Wrench	See Section 13.00

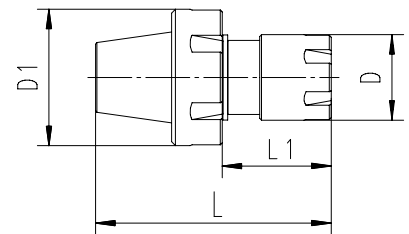
For drawings with detailed dimensions see:
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SwissQuick Collet Reductions

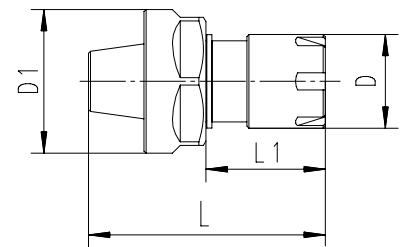
Type	Part No.	L [mm]	L1 [mm]	D [mm]	D1 [mm]	Wrenches
Mini-Nut Reductions						
ER 11 M / ER 8 M	7161.11080	33	16.5	12	16	7113.11000 / 7113.08000
ER 16 M / ER 11 M	7161.16110	42.5	18.5	16	23	7113.16000 / 7113.11000
ER 20 M / ER 16 M	7161.20160	55.5	28	22	28	7113.20000 / 7113.16000
ER 25 M / ER 16 M	7161.25160	60.5	28	22	35	7113.25000 / 7113.16000
ER 25 M / ER 20 M	7161.25200	60.5	28	28	35	7113.25000 / 7113.20000
Standard Nut Reductions						
ER 11 / ER 8 M	7162.11080	33	16.5	12	19	7112.11010 / 7113.08000
ER 20 / ER 16 M	7162.20160	55.5	28	22	34	7112.20010 / 7113.16000
ER 25 / ER 16 M	7162.25160	60.5	28	22	42	7111.25000 / 7113.16000
ER 25 / ER 20 M	7162.25200	60.5	28	28	42	7111.25000 / 7113.25000

Please call for availability of new products within this line.

Type ERM/ERM
with Mini-Thread



Type ER/ERM
with Standard-Thread



Related Items	
Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00

For drawings with detailed dimensions see:
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Swiss
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Tools

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Cylindrical Shank Tap Toolholders

Features | Benefits



Quality

Made to ISO 9001/ISO 14001 standards.

1

Marking

Type and part number (reduces selection error).

2

Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

Quality Seal

The REGO-FIX® symbol Δ marked on the products guarantees the best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Absorbing Link

Acts as absorbing link between the synchronous spindle and the tap, compensating for pitch differences between the tap and spindle.

Minimal Length Adjustment

In compensation and tension direction.

Secure Clamping

Secure clamping of the tap/cold forming tap by ER-GB collets with internal square.

For Coolant Through Tools

Up to 750 psi (50 bar) coolant pressure.

Process Reliability

Increases process reliability of synchronous tap manufacturing.

CYL SSY/ERC Softsynchro® Tap Holder

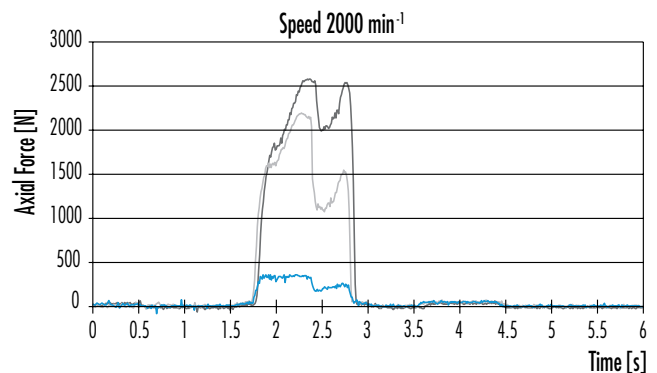
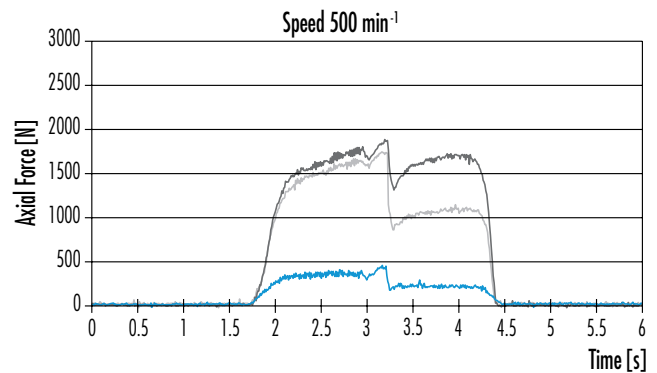
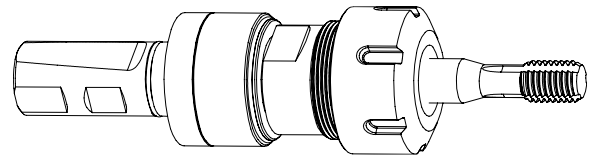
Applications

REGO-FIX® Softsynchro® tap holders are used on machines that are designed for rigid tapping. Many of the newer CNC machines feature synchronization between spindle feed and tap pitch. This allows use of rigid tapping holders. However, due to the dynamics of the spindle and linear motors, synchronization errors can occur. To compensate for these synchronization errors, Softsynchro® tap holders with minimal length adjustment are necessary. Depending on the application, Softsynchro® tap holders increase tool life up to 150%.

Comparison Tests

These two diagrams show the axial forces when cold forming M10 threads in St37 steel.

Conclusion: Axial forces increase with increasing rpm. With REGO-FIX® Softsynchro® tap holders these forces are considerably lower than when using rigid tap toolholders. Therefore, the surface quality and tool life is optimized when using Softsynchro® tap holders on a synchronized machine spindle.

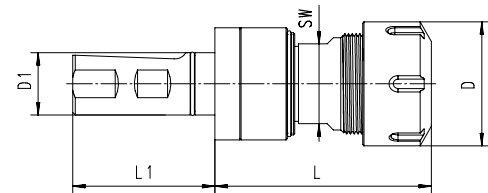


— REGO-FIX® Softsynchro®-Tapping holders
— Competitor synchronous collet holder
— Rigid synchronous collet holder

10

CYL/ERC Softsynchro® Tap Holders

Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Compression [mm]	Tension [mm]	SW [mm]
CYL 25 SSY / ERC 20	2625.62000	34	25	73	57	0.5	0.5	19
CYL 25 SSY / ERC 32	2625.63200	50	25	87.5	57	0.5	0.5	32



Supplied: Tapping holder with Hi-Q/ERC clamping nut.
Matching tapping collets see page 3.03/3.04
Softsynchro is a registered trademark of Emuge



Sealing disks can be ordered separately.
See page 4.21/4.22



Swiss Precision Tools

ER

Cylindrical Shank Tap Toolholders

Features | Benefits



Quality

Made to ISO 9001/ISO 14001 standards.

1

Marking

Type and part number (reduces selection error).

2

Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

Quality Seal

The REGO-FIX® symbol Δ marked on the products guarantees the best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Length Compensation

In compression and tension directions.

Pressure-point Mechanism

Guarantees proper start of thread cutting/forming.

Secure Clamping

Secure clamping of the tap/cold forming tap by ER-GB collets with internal square.

For Coolant Through Tools

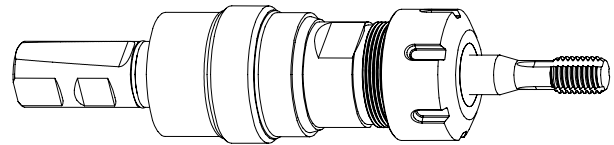
Up to 750 psi (50 bar) coolant pressure.

Process Reliability

Increases process reliability of non-synchronous thread manufacturing.

10

CYL GSF/ERC Tapping Holder with Length Compensation



Applications

REGO-FIX® tap holders with length compensation are used on machines without synchronization of spindle feed and the pitch of the thread. These machines require tap holders with compression and tension compensation to compensate for the difference in spindle feed and thread pitch.

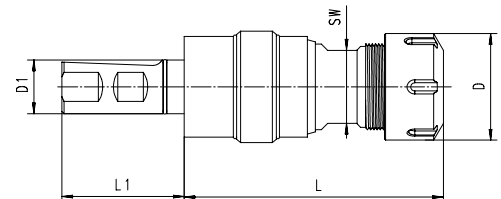
REGO-FIX® tap holders with length compensation feature a pressure-point mechanism. This guarantees the proper start of the thread cutting or forming and allows reproducible thread depth. A special design allows coolant up to 750 psi (50 bar) to feed the tap without affecting the function of the length compensation. The compact design and the short extension allows flexibility when using the REGO-FIX® tap holders.

CYL/ERC Tapping Holders with Length Compensation

Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Compression [mm]	Tension [mm]	SW [mm]
CYL 25 GSF / ERMC 20	2625.62001	28	25	85	57	5.0	7.5	24
CYL 25 GSF / ERC 32	2625.63201	50	25	115	57	7.0	10.0	34

Supplied with: clamping nut.

Matching tapping collets see page 3.03/3.04



10

Related Items

Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00



Sealing disks can be ordered separately.
See page 4.21/4.22



Swiss Precision Tools

PG

Cylindrical Shank Toolholders

Features | Benefits

PGU or PGC required for toolholder assembly.
See page 13.07 for machine details.



Swiss Quality

Made in Switzerland to ISO 9001/ISO 14001.

1

Marking

Type and part number (reduces selection error).

2

Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

Original REGO-FIX®

Original only with the REGO-FIX® quality symbol Δ .
Guarantees the best quality.

T.I.R of the whole System <0.0001" (3 μ m)

Highest clamping force and lowest run-out in one.

Surface Finish max. Ra 0.25

Higher clamping force and higher transferable torque.

Minimal Outside Dimensions

Slim design provides more machining flexibility.

Fast

Tool clamping with hydraulic press in less than 10 seconds.

Excellent at Small Diameters

Clamping of small diameter tools from \varnothing 0.2 mm.

Prestable Tooling System

Repeatability <0.0004" (10 μ m)

10



CYL/PG Toolholders

Applications

Cylindrical PG toolholders are designed for light milling or finishing and to extend the reach of standard powRgrip® toolholders.

CYL SSY/PG Softsynchro® Tapping Holders

Softsynchro® tap holders are designed to compensate pitch differences between synchronous spindles and thread pitch.

For more details see page 10.15

CYL GSF/PG Tapping Holders

Tap holders with length compensation in compression and tension directions are used on machines without synchronization of spindle feed and thread pitch.

For more details see page 10.17

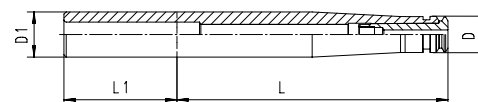
powRgrip® Cylindrical Shank Toolholders

Type	Part No.	D [mm]	D1 h6 [mm]	L [mm]	L1 [mm]	Drawing
CYL 10 / PG 10 x 120	2610.71020	15.5	10	120	40	2
CYL 20 / PG 10 x 120	2620.71020	15.5	20	120	50	1
CYL 20 / PG 10 x 160	2620.71040	15.5	20	160	50	1
CYL 20 / PG 10 x 200	2620.71060	15.5	20	200	50	1
CYL 20 / PG 15 x 120	2620.71520	22	20	120	50	2
CYL 25 / PG 25 x 80	8020.25080	40	25	80	50	2
CYL 25 / PG 25 x 100	8020.25100	40	25	100	50	2
CYL 25 / PG 25 x 120	8020.25120	40	25	120	50	2

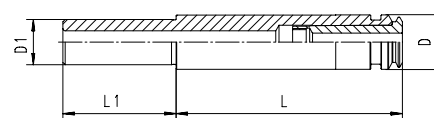


CYL | PG

1



2



10

Related Items

Collets (Std & CF)	See Section 2.00
Collets (Tapping)	See Section 3.00
Accessories	See Section 13.00

For drawings with detailed dimensions see:

search.rego-fix.com



Swiss Precision Tools

PG

Cylindrical Shank Tap Toolholders

Features | Benefits

PGU or PGC required for toolholder assembly.
See page 13.07 for machine details.



10

Quality

Made to ISO 9001/ISO 14001 standards.

1

Marking

Type and part number (reduces selection error).

2

Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

Quality Seal

The REGO-FIX® symbol Δ marked on the products guarantees the best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Absorbing Link

Acts as an absorbing link between the synchronous spindle and the tap/cold forming tap and compensates pitch differences between the threading tool and synchronous spindle.

Minimal Length Adjustment

In tension and compression movements.

Tool Shanks

All taps/cold forming taps with tool shanks in h9 tolerance can be clamped.

Secure Clamping

Secure clamping of the tap/cold forming tap by PG-TAP collets with internal square.

For Coolant Through Tools

Up to 750 psi (50 bar) coolant pressure.

Process Reliability

Increases process reliability of synchronous tap manufacturing.

CYL SSY/PG Softsynchro® Tap Holder

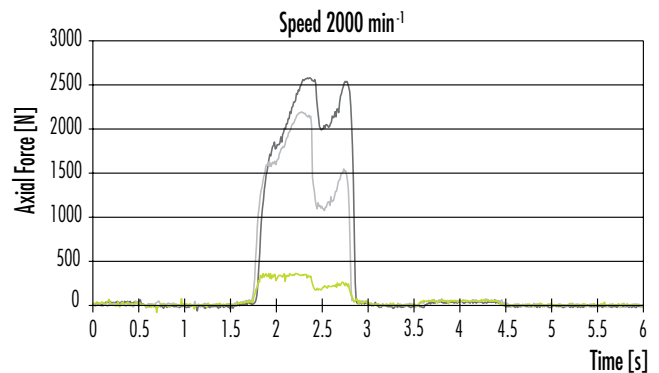
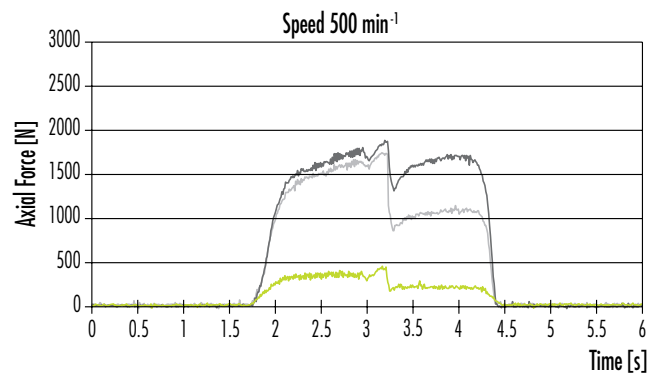
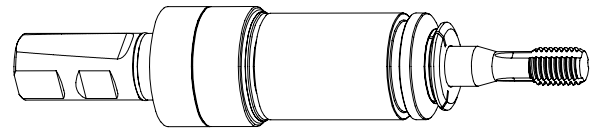
Applications

REGO-FIX® Softsynchro® tap holders are used on machines that are designed for rigid tapping. Many of the newer CNC machines feature synchronization between spindle feed and tap pitch. This allows use of rigid tapping holders. However, due to the dynamics of the spindle and linear motors, synchronization errors can occur. To compensate for these synchronization errors, Softsynchro® tap holders with minimal length adjustment are necessary. Depending on the application, Softsynchro® tap holders increase tool life up to 150%.

Comparison Tests

These two diagrams show the axial forces when cold-forming M10 threads in St37 steel.

Conclusion: Axial forces increase with increasing rpm. With REGO-FIX® Softsynchro® tap holders these forces are considerably lower than when using rigid tap toolholders. Therefore the surface quality and tool life is optimized when using Softsynchro® tap holders on a synchronized machine spindle.



— REGO-FIX® Softsynchro®-Tapping holders
— Competitor synchronous collet holder
— Rigid synchronous collet holder

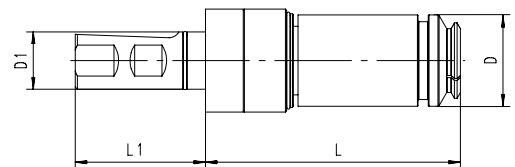
10

CYL powRgrip® Softsynchro® Tap Holders

Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Compression [mm]	Tension [mm]
CYL 25 SSY / PG 15	2625.61507	24	25	92	57	0.5	0.5
CYL 25 SSY / PG 25	2625.62507	40	25	109.5	57	0.5	0.5

Matching tap collets see page 3.11/3.12

Softsynchro is a registered trademark of Emuge





Swiss Precision Tools

PG

Cylindrical Shank Tap Toolholders

Features | Benefits

PGU or PGC required for toolholder assembly.
See page 13.07 for machine details.



Quality

Made to ISO 9001/ISO 14001 standards.

1

Marking

Type and part number (reduces selection error).

2

Traceability

Lot numbers are marked on all products for traceability throughout the entire manufacturing process.

3

Quality Seal

The REGO-FIX® symbol Δ marked on the products guarantees the best quality.

T.I.R.

Best concentricity values – equal to rigid toolholders.

Length Compensation

In compression and tension directions.

Pressure-point Mechanism

Guarantees proper start of thread cutting/forming.

Tool Shanks

All taps/cold forming taps with tool shanks in h9 tolerance can be clamped.

Secure Clamping

Secure clamping of the tap/cold forming tap by PG-TAP collets with internal square.

For Coolant Through Tools

Up to 750 psi (50 bar) coolant pressure.

Process Reliability

Increases process reliability of non-synchronous thread manufacturing.

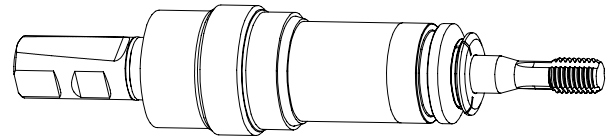
10

2

1

3

CYL GSF/PG Tapping Holder with Length Compensation



Applications

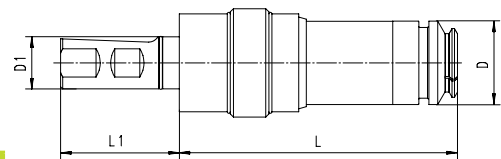
REGO-FIX® tap holders with length compensation are used on machines without synchronization of spindle feed and the pitch of the thread. These machines require tap holders with compression and tension compensation to compensate for the difference in spindle feed and thread pitch.

REGO-FIX® tap holders with length compensation feature a pressure-point mechanism. This guarantees the proper start of the thread cutting or forming and allows reproducible thread depth. A special design allows coolant up to 750 psi (50 bar) to feed the tap without affecting the function of the length compensation. The compact design and the short extension allows flexibility when using the REGO-FIX® tap holders.

powRgrip® Tapping Holders with Length Compensation

Type	Part No.	D [mm]	D1 [mm]	L [mm]	L1 [mm]	Compression [mm]	Tension [mm]
CYL 25 GSF / PG 15	2625.61508	24	25	99.5	57	5.0	7.5
CYL 25 GSF / PG 25	2625.62508	40	25	134	57	7.0	10.0

Matching tap collets see page 3.11/3.12



10

Related Items

Collets (Std & CF)	See Section 2.00
Collets (Tapping)	See Section 3.00
Accessories	See Section 13.00