



8.01 Forms and Characteristics

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powRgrip SYSTEM

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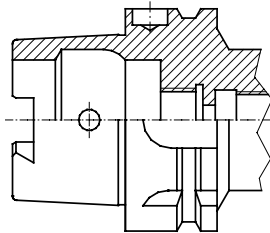
8.13 HSK-A/PG

8.14 HSK-E/PG and HSK-F/PG

8.16 HSK-A SSY/PG
Softsynchro® Tapping Holders



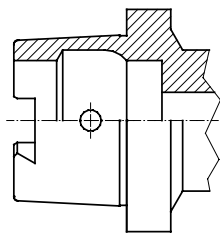
Forms | Characteristics



FORM A*

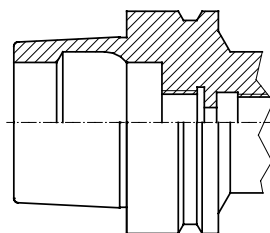
- Standard type for machining centers and milling machines
- For automatic tool change
- Coolant supply through center via coolant tube
- Drive keys at the end of HSK taper
- Hole for data carrier DIN STD 69873 in the flange

*Also usable in Form C applications with side hole for manual tool change.



FORM C

- For transfer lines, special machines and modular tooling systems
- For manual tool change
- Coolant supply through center
- Drive keys at the end of HSK taper

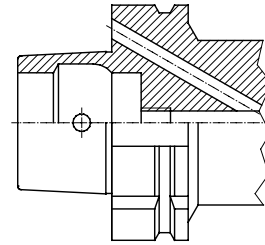


FORM E

- For high-speed applications
- For automatic tool change
- Coolant supply through center via coolant tube is possible
- Without any drive keys for absolute symmetry

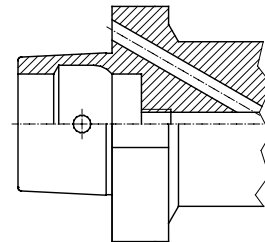
FORM B

- For machining centers, milling and turning machines
- With enlarged flange size for rigid machining
- For automatic tool change
- Coolant supply through the flange
- Drive keys at the flange
- Hole for data carrier DIN STD 69873 at the flange



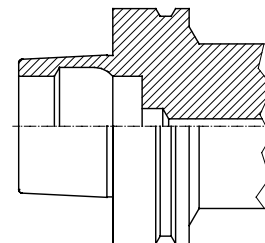
FORM D

- For special machines
- With enlarged flange size for rigid machining
- For manual tool change
- Coolant supply through the flange
- Drive keys at the flange



FORM F

- For high-speed applications mainly in woodworking industries
- With enlarged flange size for rigid machining
- For automatic tool change
- Coolant supply through center via coolant tube is possible
- Without any drive keys for absolute symmetry





Swiss
Precision
Tools

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 Δ . Guarantees the best quality.

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.

Q+® Balancing

100% balanced to G 2.5 @ 25'000 min⁻¹.

Hi-Q® Balancing System

Ready to accept Hi-Q® balancing rings, which will allow for the offset of the imbalance introduced by the cutting tool up to 80'000 min⁻¹.

Hi-Q® Clamping Nut Included

Guarantees highest clamping force and best balancing by design.

Vibration Dampening

For best machining results.

ID Chip Hole

Per DIN 69873 with 10 mm diameter.

8



HSK/ER Toolholder

Applications

CNC-milling machines of the latest generation.

Coolant

For coolant through tools these toolholders can be equipped with a coolant tube (KSR) that ducts the coolant directly to the cutting tool, avoiding any coolant entering the HSK taper area.

Matching coolant tubes (KSR) see page 13.12

Balancing

REGO-FIX® Q+® System HSK/ER toolholders are balanced by design to G 2.5 @ 25'000 min⁻¹. Type H toolholders are ready to accept Hi-Q® balancing rings which allow precision balancing of the system up to 80'000 min⁻¹ depending on the balancing rings used.

Special Applications

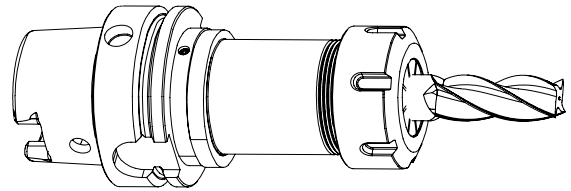
When additional clamping force is needed, e.g. when tapping with ER-GB or milling we recommend to use our friction bearing clamping nuts, Hi-Q®/ERB and Hi-Q®/ERBC.

Matched Tooling System for Best Fit

For highest precision and best results the whole system counts. For that reason REGO-FIX® components are carefully matched for optimum fit and accuracy. This guarantees the best run-out and balance.

For the influence of run-out on tool life see the graph page 2.03

Recommended tightening torque see page 14.03/14.04



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

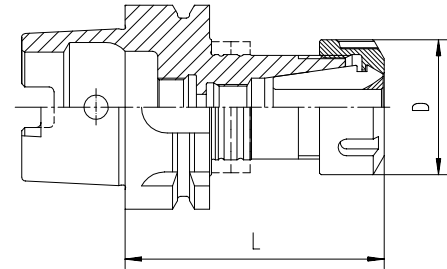
ER Toolholders

Type	Part No.	D [mm]	L [mm]	Balancing Rings	Wrenches
HSK-A 32 / ER 11 x 050*	2532.11110	19	50	–	7112.11010
HSK-A 32 / ER 16 x 060*	2532.11620	28	60	–	7112.16010
HSK-A 32 / ER 20 x 060*	2532.12020	34	60	–	7112.20010
HSK-A 32 / ER 25 x 065*	2532.12520	42	65	–	7111.25000
HSK-A 40 / ER 16 x 080 H	4540.11640	28	80	FWR 225	7112.16010
HSK-A 40 / ER 25 x 080 H	4540.12540	42	80	FWR 325	7111.25000
HSK-A 50 / ER 16 x 100 H	4550.11650	28	100	FWR 325	7112.16010
HSK-A 50 / ER 25 x 080 H	4550.12540	42	80	FWR 325	7111.25000
HSK-A 50 / ER 32 x 100 H	4550.13250	50	100	FWR 405	7111.32000
HSK-A 63 / ER 11 x 100 H	4563.11150	19	100	FWR 325	7112.11010
HSK-A 63 / ER 16 x 080 H	4563.11640	28	80	FWR 325	7112.16010
HSK-A 63 / ER 16 x 100 H	4563.11650	28	100	FWR 325	7112.16010
HSK-A 63 / ER 16 x 160 H	4563.11680	28	160	FWR 325/225	7112.16010
HSK-A 63 / ER 25 x 080 H	4563.12540	42	80	FWR 325	7111.25000
HSK-A 63 / ER 25 x 160 H	4563.12580	42	160	FWR 325	7111.25000
HSK-A 63 / ER 32 x 080 H	4563.13240	50	80	FWR 405	7111.32000
HSK-A 63 / ER 32 x 100 H	4563.13250	50	100	FWR 405	7111.32000
HSK-A 63 / ER 32 x 160 H	4563.13280	50	160	FWR 405	7111.32000
HSK-A 63 / ER 40 x 080*	2563.14040	63	80	–	7111.40000
HSK-A 63 / ER 40 x 120 H	4563.14060	63	120	FWR 405	7111.40000
HSK-A 63 / ER 40 x 160 H	4563.14080	63	160	FWR 505	7111.40000

Supplied with: clamping nut and back-up screw

*Not for use with balancing rings.

Matching coolant tubes (KSR) see page 13.10



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:

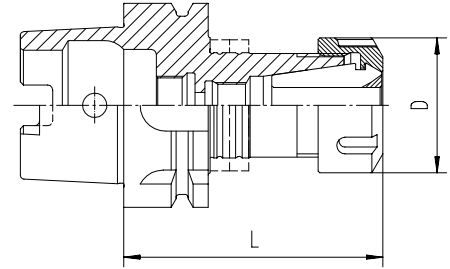
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ER Toolholders

Type	Part No.	D [mm]	L [mm]	Balancing Rings	Wrenches
HSK-A 80 / ER 16 x 100 H	4580.11650	28	100	FWR 325	7112.16010
HSK-A 80 / ER 16 x 160 H	4580.11680	28	160	FWR 325/225	7112.16010
HSK-A 80 / ER 32 x 100 H	4580.13250	50	100	FWR 405	7111.32000
HSK-A 80 / ER 40 x 120 H	4580.14060	63	120	FWR 505	7111.40000
HSK-A 100 / ER 16 x 100 H	4500.11650	28	100	FWR 405	7112.16010
HSK-A 100 / ER 16 x 160 H	4500.11680	28	160	FWR 405/225	7112.16010
HSK-A 100 / ER 32 x 100 H	4500.13250	50	100	FWR 405	7111.32000
HSK-A 100 / ER 32 x 160 H	4500.13280	50	160	FWR 405	7111.32000
HSK-A 100 / ER 40 x 120 H	4500.14060	63	120	FWR 505	7111.40000

Supplied with: clamping nut and back-up screw

Matching coolant tubes (KSR) see page 13.10

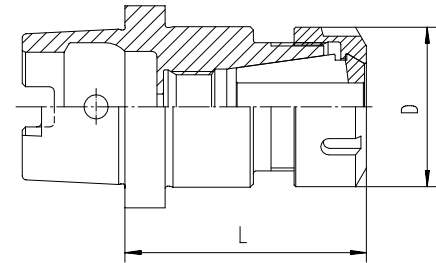


Related Items	
Collets (Std & UP)	See Section 2.00
Collets (Tapping)	See Section 3.00
Nuts	See Section 4.00
Torque Wrench	See Section 13.00

For drawings with detailed dimensions see:
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ER Toolholders

Type	Part No.	D [mm]	L [mm]	Wrenches
HSK-C 32 / ER 16 x 060	2532.11622	28	60	7112.16010
HSK-C 32 / ER 20 x 060	2532.12022	34	65	7112.20010
HSK-C 32 / ER 25 x 070	2532.12532	42	70	7111.25000
HSK-C 40 / ER 20 x 060	2540.12022	34	60	7112.20010
HSK-C 40 / ER 25 x 070	2540.12532	42	70	7111.25000
HSK-C 40 / ER 32 x 075	2540.13232	50	75	7111.32000
HSK-C 50 / ER 25 x 070	2550.12532	42	70	7111.25000
HSK-C 50 / ER 32 x 075	2550.13232	50	75	7111.32000
HSK-C 50 / ER 40 x 080	2550.14042	63	80	7111.40000
HSK-C 63 / ER 32 x 075	2563.13232	50	75	7111.32000
HSK-C 63 / ER 40 x 080	2563.14042	63	80	7111.40000



8

Supplied with: clamping nut and back-up screw
 Matching coolant tubes (KSR) see page 13.10

Type	Part No.	D [mm]	L [mm]	Wrenches
HSK-F 25 / ER 11 MS x 035	2525.11109	16	35	7114.11000
HSK-F 32 / ER 11 MS x 038	2532.11109	16	38	7114.11000
HSK-F 40 / ER 11 MS x 040	2540.11109	16	40	7114.11000

Supplied with: clamping nut and back-up screw
 Matching coolant tubes (KSR) see page 13.10

HSK / ER MS Toolholders for Micro Machining

These holders are designed to give a 0.0001" TIR (3 micron) when used with the ER 11 ND collets from page 2.06.

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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ER Toolholders

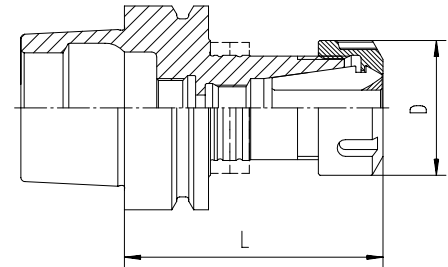
Type	Part No.	D [mm]	L [mm]	Balancing Rings	Wrenches
HSK-E 25 / ER 16 M x 043*	2525.11618	22	43	–	7113.16000
HSK-E 32 / ER 16 M x 060*	2532.11628	22	60	–	7113.16000
HSK-E 32 / ER 20 M x 060*	2532.12028	28	60	–	7113.20000
HSK-E 40 / ER 16 x 060 H	4540.11624	28	60	FWR 225	7112.16010
HSK-E 40 / ER 20 M x 075 H	4540.12038	28	75	FWR 285	7113.20000
HSK-E 40 / ER 25 M x 080 H	4540.12548	35	80	FWR 325	7113.25000
HSK-E 50 / ER 16 x 100 H	4550.11654	28	100	FWR 325	7112.16010
HSK-E 50 / ER 20 x 070 H	4550.12034	34	70	FWR 325	7112.20010
HSK-E 50 / ER 25 x 080 H	4550.12544	42	80	FWR 325	7111.25000
HSK-E 50 / ER 32 x 100 H	4550.13254	50	100	FWR 405	7111.32000
HSK-E 63 / ER 32 x 090*	2563.13244	50	90	–	7111.32000
HSK-E 63 / ER 40 x 120*	2563.14064	63	120	–	7111.40000
HSK-F 63 / ER 16 x 100 H	4563.11655	28	100	FWR 325	7112.16010
HSK-F 63 / ER 32 x 100 H	4563.13255	50	100	FWR 405	7111.32000

Supplied with: clamping nut and back-up screw.

*Not for use with balancing rings.

M - Supplied with Mini-nut

Matching coolant tubes (KSR) see page 13.10



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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ER

HSK Tapping Holders

Features | Benefits



8

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/cold forming tap and compensates pitch differences between threading tool and synchronous spindle.

Minimal Length Adjustment

In push and pull direction.

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 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 thread manufacturing.

HSK-A SSY/ERC Softsynchro® Tapping Holder

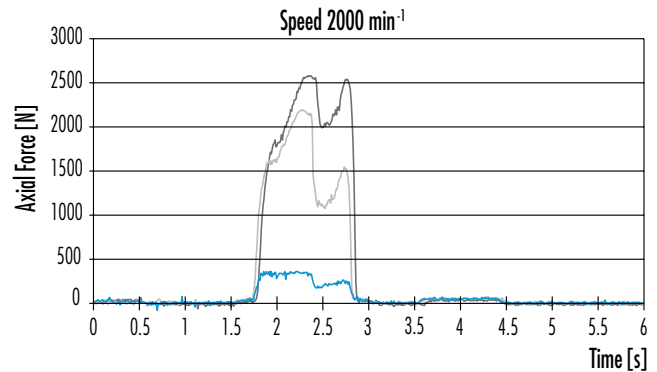
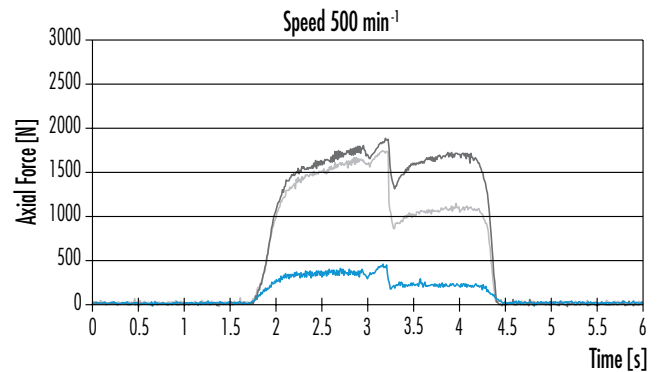
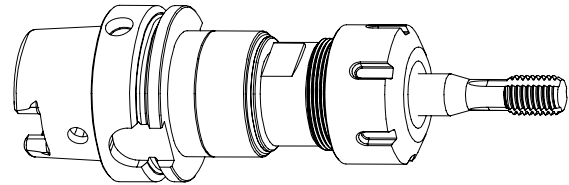
Applications

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

Comparison Tests

The 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® tapping holders the forces are considerably lower than when using rigid tapping toolholders. Therefore, the surface quality and tool life are optimized when using Softsynchro® tapping holders on a synchronized machine spindle.



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

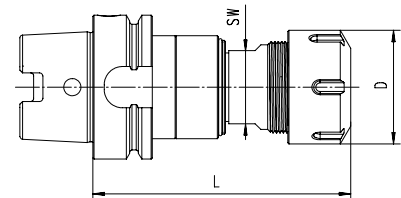
HSK-A/ERC Softsynchro® Tapping Holder

Type	Part No.	D [mm]	L [mm]	Compression [mm]	Tension [mm]	SW [mm]
HSK-A 63 SSY / ERC 20	2563.62000	34	95.5	0.5	0.5	19
HSK-A 63 SSY / ERC 32	2563.63200	50	108.8	0.5	0.5	32

Supplied with: clamping nut

Matching tapping collets see page 3.03/3.04

Softsynchro is a registered trademark of Emuge



! Please order the sealing disks separately.
 See page 4.21/4.22



Swiss Precision Tools

PG HSK Toolholders

Features | Benefits

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



8

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 runout.

Surface Finish max. Ra 0.25

Higher clamping force and higher transferable torque.

Q+® Balancing

100% balanced to G 2.5 @ 25'000 min⁻¹. Ideal for High Speed Cutting (HSC) and High Performance Cutting (HPC).

Hi-Q® Balancing System

Ready to accept Hi-Q® balancing rings, which will allow for the offset of the imbalance introduced by the cutting tool up to 80'000 min⁻¹.

Minimal Outside Dimensions

Slim design provides more processing 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 and higher.

Presetable Tooling System

Repeatability <0.0004" (10 μ m)

ID Chip Hole

Per DIN 69873 with 10 mm diameter.

HSK/PG Toolholders

Applications

CNC-milling machines of the latest generation.

Coolant

For coolant through tools these toolholders can be equipped with a coolant tube (KSR) that ducts the coolant directly to the cutting tool, avoiding any coolant entering the HSK taper area.

Matching coolant tubes (KSR) see page 13.10

Balancing

REGO-FIX® Q+® System HSK/PG toolholders are balanced by design to G 2.5 @ 25'000 min⁻¹. Type H toolholders are ready to accept Hi-Q® balancing rings which allow precision balancing of the system up to 80'000 min⁻¹ depending on the balancing rings used.

Coolant Through

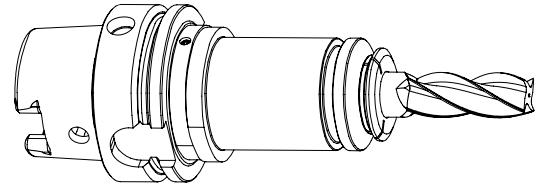
For use with coolant through tools.

Peripheral Cooling

PG-CF collets for peripheral cooling with non-coolant through tools.

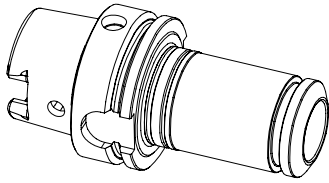
Matched Tooling System for Best Fit

For highest precision and best results the whole system counts. For that reason REGO-FIX® components are carefully matched to fit together. This guarantees best run-out and balancing.





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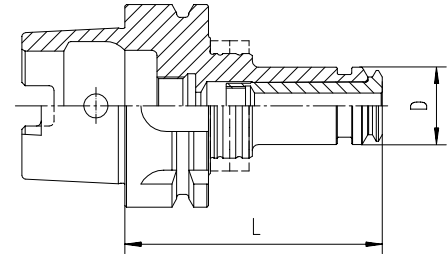
HSK-A | PG

DIN 69893 / ISO 12164

powRgrip® Toolholders

Type	Part No.	D [mm]	L [mm]	Balancing Rings
HSK-A 32 / PG 15 x 075*	2532.71530	22	75	–
HSK-A 40 / PG 15 x 080 H	4540.71540	22	80	FWR 285
HSK-A 40 / PG 25 x 100 H	4540.72550	33	100	FWR 405
HSK-A 50 / PG 10 x 080 H	4550.71040	15.5	80	FWR 285
HSK-A 50 / PG 15 x 080 H	4550.71540	22	80	FWR 285
HSK-A 50 / PG 25 x 100 H	4550.72550	33	100	FWR 405
HSK-A 63 / PG 10 x 080 H	4563.71040	15.5	80	FWR 325
HSK-A 63 / PG 10 x 120 H	4563.71060	15.5	120	FWR 325
HSK-A 63 / PG 10 x 160 H	4563.71080	15.5	160	FWR 325
HSK-A 63 / PG 10 x 200 H	4563.71090	15.5	200	FWR 325
HSK-A 63 / PG 15 x 080 H	4563.71540	22	80	FWR 325
HSK-A 63 / PG 15 x 120 H	4563.71560	22	120	FWR 325
HSK-A 63 / PG 15 x 160 H	4563.71580	22	160	FWR 325/285
HSK-A 63 / PG 25 x 100 H	4563.72550	33	100	FWR 405
HSK-A 63 / PG 25 x 120 H	4563.72560	33	120	FWR 405
HSK-A 63 / PG 25 x 160 H	4563.72580	33	160	FWR 405/405
HSK-A 63 / PG 32 x 100*	2563.73250	43	100	–
HSK-A 63 / PG 32 x 120 H	4563.73260	43	120	FWR 505
HSK-A 80 / PG 15 x 085 H	4580.71540	22	85	FWR 325
HSK-A 80 / PG 25 x 100 H	4580.72550	33	100	FWR 505
HSK-A 80 / PG 32 x 105 H	4580.73250	43	105	FWR 505
HSK-A 100 / PG 10 x 085 H	4500.71040	15.5	85	FWR 405
HSK-A 100 / PG 10 x 160 H	4500.71080	15.5	160	FWR 405
HSK-A 100 / PG 15 x 085 H	4500.71540	22	85	FWR 405
HSK-A 100 / PG 15 x 160 H	4500.71580	22	160	FWR 405/285
HSK-A 100 / PG 25 x 100 H	4500.72550	33	100	FWR 505
HSK-A 100 / PG 25 x 160 H	4500.72580	33	160	FWR 505/405
HSK-A 100 / PG 25 x 200 H	4500.72590	33	200	FWR 505/405
HSK-A 100 / PG 32 x 106 H	4500.73250	43	106	FWR 505

* Not for use with balancing rings



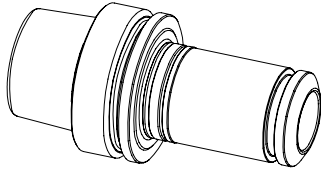
Matching coolant tubes (KSR) see page 13.10

Related Items

Collets (Std & CF)	See Section 2.00
Collets (Tapping)	See Section 3.00
Extensions (PG)	See Section 10.00
Accessories	See Section 13.00

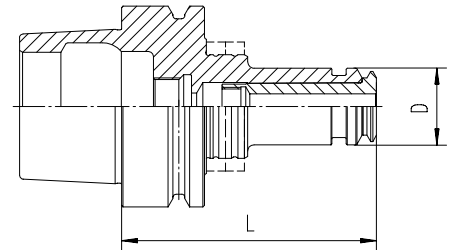
For drawings with detailed dimensions see:

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powRgrip® Toolholders

HSK-E | PG
 HSK-F | PG
 DIN 69893 / ISO 12164



Type	Part No.	D [mm]	L [mm]	Balancing Rings
HSK-E 25 / PG 10 x 055*	2525.71014	15.5	55	–
HSK-E 32 / PG 10 x 060*	2532.71024	15.5	60	–
HSK-E 32 / PG 10 x 080 H	4532.71044	15.5	80	FWR 225
HSK-E 32 / PG 15 x 075*	2532.71534	22	75	–
HSK-E 40 / PG 10 x 062*	2540.71024	15.5	62	–
HSK-E 40 / PG 10 x 080 H	4540.71044	15.5	80	FWR 225
HSK-E 40 / PG 10 x 120 H	4540.71064	15.5	120	FWR 225
HSK-E 40 / PG 10 x 160 H	4540.71084	15.5	160	FWR 285
HSK-E 40 / PG 15 x 080 H	4540.71544	22	80	FWR 285
HSK-E 40 / PG 15 x 120 H	4540.71564	22	120	FWR 285
HSK-E 40 / PG 25 x 090*	2540.72544	33	90	–
HSK-E 40 / PG 25 x 100 H	4540.72554	33	100	FWR 405
HSK-E 50 / PG 10 x 080 H	4550.71044	15.5	80	FWR 285
HSK-E 50 / PG 10 x 120 H	4550.71064	15.5	120	FWR 285
HSK-E 50 / PG 10 x 160 H	4550.71084	15.5	160	FWR 285
HSK-E 50 / PG 15 x 080 H	4550.71544	22	80	FWR 285
HSK-E 50 / PG 15 x 120 H	4550.71564	22	120	FWR 285
HSK-E 50 / PG 25 x 100 H	4550.72554	33	100	FWR 405
HSK-F 63 / PG 10 x 080 H	4563.71045	15.5	80	FWR 325
HSK-F 63 / PG 15 x 080 H	4563.71545	22	80	FWR 325
HSK-F 63 / PG 25 x 100 H	4563.72555	33	100	FWR 405
HSK-F 63 / PG 32 x 100*	2563.73255	43	100	–
HSK-F 80	Call For Availability			

Matching coolant tubes (KSR) see page 13.10

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Related Items	
Collets (Std & CF)	See Section 2.00
Collets (Tapping)	See Section 3.00
Extensions (PG)	See Section 10.00
Accessories	See Section 13.00

For drawings with detailed dimensions see:
search.rego-fix.com

*Not for use with balancing rings.



Swiss Precision Tools

PG HSK Tapping Holders

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 for 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/cold forming tap and compensates pitch differences between threading tool and synchronous spindle.

Minimal Length Adjustment

In push and pull direction.

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 thread manufacturing.

HSK-A SSY/PG Softsynchro® Tapping Holder

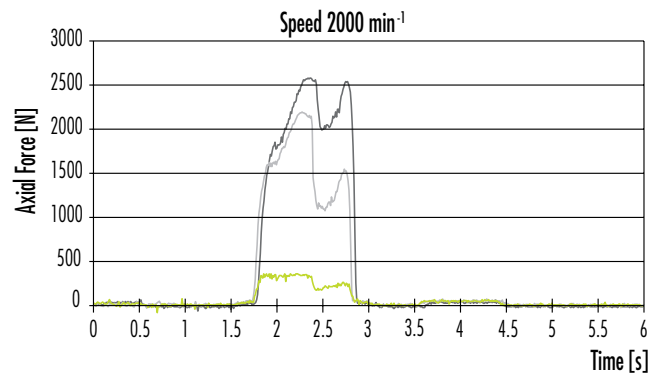
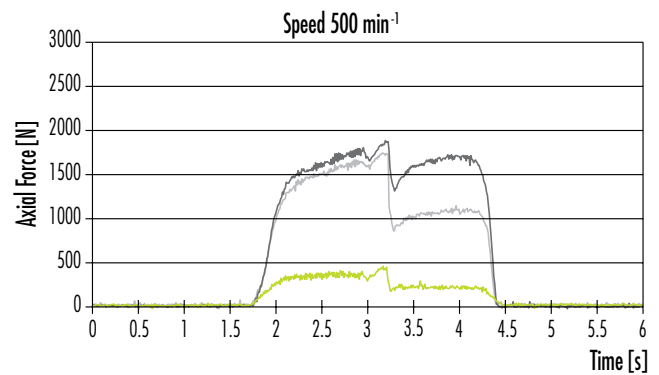
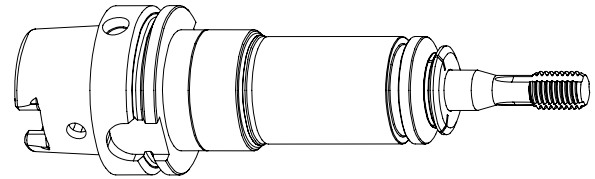
Applications

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

Comparison Tests

The 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® tapping holders the forces are considerably lower than when using rigid tapping toolholders. Therefore, the surface quality and tool life are optimized when using Softsynchro® tapping holders on a synchronized machine spindle.



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

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HSK-A powRgrip® Softsynchro® Tapping Holders

Type	Part No.	D [mm]	L [mm]	Compression [mm]	Tension [mm]
HSK-A 63 SSY / PG 15	2563.61507	24	114.5	0.5	0.5
HSK-A 63 SSY / PG 25	2563.62507	40	131	0.5	0.5

Matching tap collets see page 3.11/3.12

Softsynchro is a registered trademark of Emuge

