





ER *SYSTEM*

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- 3.02 Information on ER GB Rigid Tap Collets**
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powRgrip *SYSTEM*

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Swiss
Precision
Tools

ER

Rigid Tap Collets

Features | Benefits

Swiss Quality

Made in Switzerland to ISO 9001/ISO 14001.

1

Marking

Type and size (reduces collet selection errors).

2

Traceability

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

3

Original REGO-FIX®

REGO-FIX® is the inventor of the worldwide standardized ER collet system. Our extensive experience results in a well-engineered system. When buying ER collets, please note the REGO-FIX® quality symbol \triangle on the front of the collet.

Interchangeable

With standard ER collet DIN 6499/ISO 15488. No additional toolholders and clamping nuts are necessary.

Wide Product Range

Sizes: ER-GB 11 to 50

Standards: DIN, ISO, JIS, (ANSI on request)

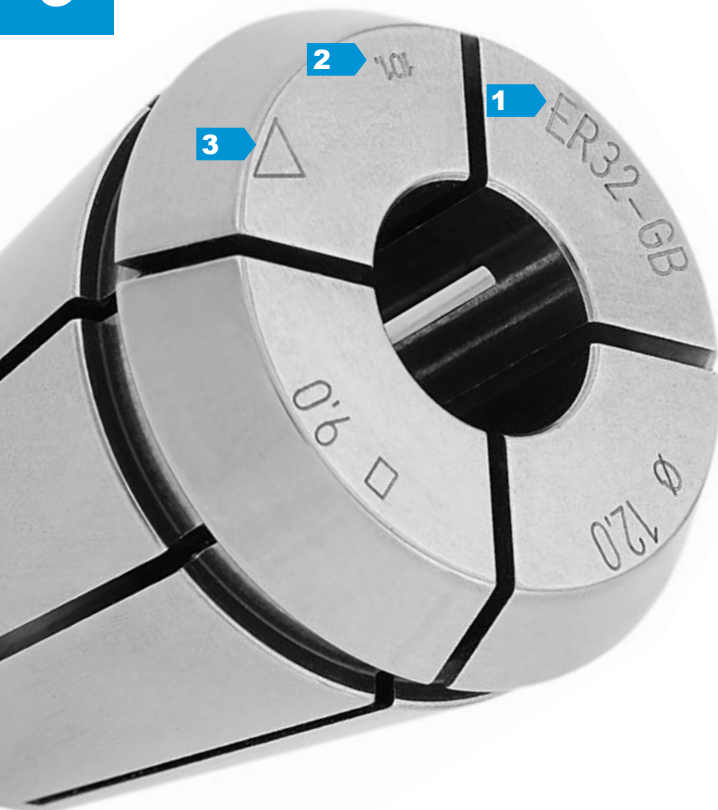
Strength: Square for tight grip of tap

Eliminates tap slippage in collets.

Matched Tooling System

All REGO-FIX® components such as collets, toolholders, clamping nuts and spanners are manufactured by REGO-FIX®. The compatibility of the whole system results in maximum precision, balance and tool life.

3



ER-GB Rigid Tap Collets without Axial Compensation

These rigid tap collets are compatible with taps according to DIN, ISO, JIS and ANSI standards.

The REGO-FIX® ER-GB tap collets are manufactured with an internal square. They are intended for use on CNC machines that have synchronized machine spindle speed and feed rate.

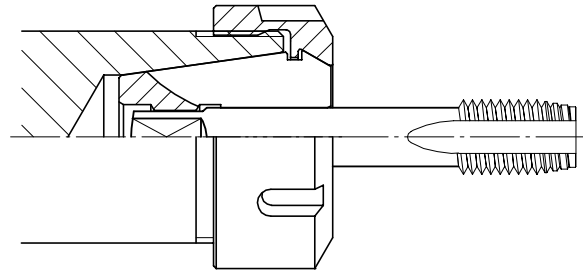
We recommend the use of our SSY Softsynchro® tap holders because they compensate for minimal synchronizing differences of CNC machines.

See chapter 8 (HSK tapping toolholders), page 8.09 and chapter 10 (cylindrical tapping toolholders), page 10.09

For machines without a synchronized tapping option we recommend the use of our axial compensating GSF tap holders.

See chapter 10 (cylindrical tapping toolholders), page 10.11

For additional technical information and dimensions of taps on ER-GB see page 14.05 and 14.11

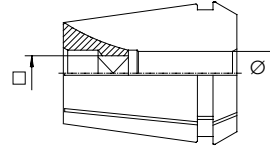
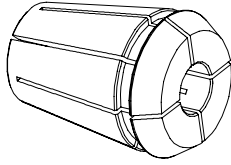




Swiss
Precision
Tools

ER

Rigid Tap Collets

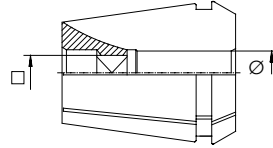
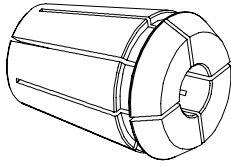


ER | GB

Rigid Tapping Collets Metric Sizes (DIN, ISO, JIS)

Shank (∅) [mm]	Square (□) [mm]	Standard	ER 11-GB Part No.	ER 16-GB Part No.	ER 20-GB Part No.	ER 25-GB Part No.	ER 32-GB Part No.	ER 40-GB Part No.	ER 50-GB Part No.
2.8	2.1	DIN	1411.02800	–	–	–	–	–	–
3.5	2.7	DIN	1411.03500	–	–	–	–	–	–
4.0	3.0	DIN	1411.04000	–	–	–	–	–	–
4.0	3.15/3.2	ISO, JIS	1411.04002	1416.04002	1420.04002	1425.04002	1432.04002	–	–
4.5	3.4	DIN	1411.04500	1416.04500	1420.04500	1425.04500	1432.04500	–	–
5.0	4.0	ISO, JIS	1411.05002	1416.05002	1420.05002	1425.05002	1432.05002	–	–
5.5	4.3	DIN	–	1416.05500	1420.05500	1425.05500	1432.05500	–	–
5.5	4.5	JIS	–	1416.05501	1420.05501	1425.05501	1432.05501	–	–
6.0	4.5	JIS	–	1416.06001	1420.06001	1425.06001	1432.06001	1440.06001	–
6.0	4.9	DIN	1411.06000	1416.06000	1420.06000	1425.06000	1432.06000	1440.06000	–
6.2	5.0	JIS	–	1416.06201	1420.06201	1425.06201	1432.06201	1440.06201	–
6.3	5.0	ISO	–	1416.06302	1420.06302	1425.06302	1432.06302	1440.06302	–
7.0	5.5	DIN, JIS	–	1416.07000	1420.07000	1425.07000	1432.07000	1440.07000	–
7.1	5.6	ISO	–	1416.07102	1420.07102	1425.07102	1432.07102	1440.07102	–
8.0	6.2/6.3	DIN, ISO	–	1416.08000	1420.08000	1425.08000	1432.08000	1440.08000	–
8.5	6.5	JIS	–	1416.08501	1420.08501	1425.08501	1432.08501	1440.08501	–
9.0	7.0/7.1	DIN, ISO	–	1416.09000	1420.09000	1425.09000	1432.09000	1440.09000	–
10.0	8.0	DIN, ISO	–	–	1420.10000	1425.10000	1432.10000	1440.10000	–
10.5	8.0	JIS	–	–	1420.10501	1425.10501	1432.10501	1440.10501	–
11.0	9.0	DIN	–	–	1420.11000	1425.11000	1432.11000	1440.11000	–
11.2	9.0	ISO	–	–	1420.11202	1425.11202	1432.11202	1440.11202	–
12.0	9.0	DIN	–	–	1420.12000	1425.12000	1432.12000	1440.12000	–
12.5	10.0	ISO, JIS	–	–	–	1425.12502	1432.12502	1440.12502	–
14.0	11.0/11.2	DIN, ISO, JIS	–	–	–	1425.14000	1432.14000	1440.14000	–
15.0	12.0	JIS	–	–	–	1425.15001	1432.15001	1440.15001	–
16.0	12.0	DIN	–	–	–	1425.16000	1432.16000	1440.16000	–
17.0	13.0	JIS	–	–	–	–	1432.17001	1440.17001	–
18.0	14.0/14.5	DIN, ISO	–	–	–	–	1432.18000	1440.18000	–
20.0	16.0	DIN, ISO	–	–	–	–	1432.20000	1440.20000	–
22.0	18.0	DIN	–	–	–	–	–	1440.22000	1450.22000
25.0	20.0	DIN	–	–	–	–	–	–	1450.25000
28.0	22.0	DIN	–	–	–	–	–	–	1450.28000
32.0	24.0	DIN	–	–	–	–	–	–	1450.32000

3



Rigid Tapping Collets Inch Sizes (ANSI)

Shank (Ø) [inch]	Square (□) [inch]	Pipe Tap	ER 11-GB Part No.	ER 16-GB Part No.	ER 20-GB Part No.	ER 25-GB Part No.	ER 32-GB Part No.	ER 40-GB Part No.
0.141	0.110		1411.03585	1416.03585				
0.168	0.131			1416.04275	1420.04275	1425.04275	1432.04275	
0.194	0.152			1416.04935	1420.04935	1425.04935	1432.04935	
0.220	0.165			1416.05595	1420.05595	1425.05595	1432.05595	
0.255	0.191			1416.06485	1420.06485	1425.06485	1432.06485	1440.06485
0.318	0.238			1416.08085	1420.08085	1425.08085	1432.08085	1440.08085
0.323	0.242				1420.08215	1425.08215	1432.08215	1440.08215
0.367	0.275				1420.09325	1425.09325	1432.09325	1440.09325
0.381	0.286				1420.09685	1425.09685	1432.09685	1440.09685
0.429	0.322					1425.10905	1432.10905	1440.10905
0.437	0.328	•				1425.11104	1432.11104	1440.11104
0.480	0.360					1425.12195	1432.12195	1440.12195
0.542	0.406						1432.13775	1440.13775
0.562	0.421	•					1432.14274	1440.14274
0.590	0.442					1425.14995	1432.14995	1440.14995
0.652	0.489						1432.16565	1440.16565
0.687	0.515	•						1440.17454
0.697	0.523							1440.17705
0.700	0.531	•						1440.17784
0.760	0.570							1440.19305
0.800	0.600							1440.20325

Additional technical information on page 14.05

Tap Size	Shank	Square
No 0 -6	0.141	0.110
1/16	0.141	0.110
3/32	0.141	0.110
1/8	0.141	0.110
5/32	0.168	0.131
No 8	0.168	0.131
3/16	0.194	0.152
No 9	0.194	0.152

Tap Size	Shank	Square
No 10	0.194	0.152
1/4	0.255	0.191
5/16	0.318	0.238
3/8	0.381	0.286
7/16	0.323	0.242
1/2	0.367	0.275
9/16	0.429	0.322

Tap Size	Shank	Square
5/8	0.480	0.360
11/16	0.542	0.406
3/4	0.590	0.442
13/16	0.652	0.489
7/8	0.697	0.523
15/16	0.760	0.570
1	0.800	0.600



Swiss
Precision
Tools

ET1

Axial Compensating Tap Collets

Features | Benefits

3



Swiss Quality

Made in Switzerland to ISO 9001/ISO 14001.

Interchangeable

With REGO-FIX® standard ER collet
DIN 6499/ISO 15488.

Compatible

ET1-12 is compatible with all ER11 colletholders.

Cost Saving

No expensive tapping tools are necessary.

Spring Tension

Adapted to tap size.

Compact

Robust design with a small space requirement.

ET1 Axial Compensation Tap Collets

ET1 tap collets with axial compensation offer a smart and cost-effective tool holding option for machines which need axial compensation for tapping.

Directions for Use

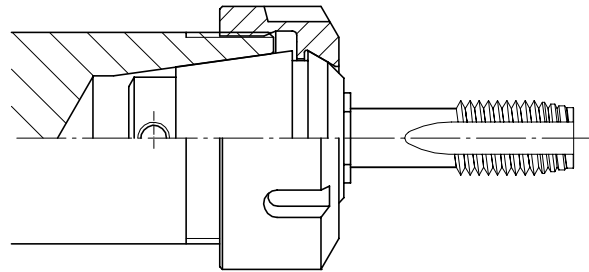
The following tapping process is recommended for ET1 tap collets:

Fast approach, then tapping should be programmed (when possible) to approximately 95% of the pitch value, which uses 20-30% of the compensation stroke when the spindle rotation and the feed movement are simultaneously reversed.

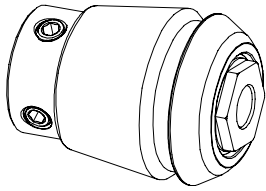
Return feed must be made with 100% of the pitch, which maintains the sleeve of the tapping collet in the compensation stroke up to the tap disengagement; quick return can then be programmed with usual stroke security. The relatively long axial compensation assists easy programming.

When tapping with very high speed, an appropriate programming compensation may be necessary to balance the differences of inertia between the spindle and the feed movement on reverse.

Table with current dimensions of taps on page 14.11
Additional technical information on page 14.06

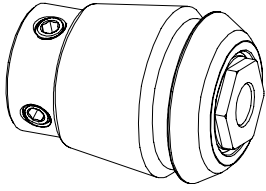


Use external coolant only with ET1 tap collets. ET1 tap collets can be damaged in coolant through operations.



ET-1 Axial Compensating Tap Collets Metric Sizes (DIN, ISO, JIS)

Shank Ø [mm]	Standard	ET1-12 Part No.	ET1-16 Part No.	ET1-20 Part No.	ET1-25 Part No.	ET1-32 Part No.	ET1-40 Part No.
1.40	DIN	1512.01400	1516.01400	–	–	–	–
1.60	DIN	1512.01600	1516.01600	–	–	–	–
1.80	DIN	1512.01800	1516.01800	–	–	–	–
2.00	ISO	1512.02000	1516.02000	–	–	–	–
2.20	DIN	1512.02200	1516.02200	1520.02200	–	–	–
2.24	ISO	1512.02240	1516.02240	1520.02240	–	–	–
2.50	DIN, ISO	1512.02500	1516.02500	1520.02500	1525.02500	–	–
2.80	DIN, ISO	1512.02800	1516.02800	1520.02800	1525.02800	–	–
3.00	JIS	1512.03000	1516.03000	1520.03000	1525.03000	–	–
3.15	ISO	1512.03150	1516.03150	1520.03150	1525.03150	–	–
3.50	DIN	1512.03500	1516.03500	1520.03500	1525.03500	–	–
3.55	ISO	1512.03550	1516.03550	1520.03550	1525.03550	–	–
4.00	DIN, ISO, JIS	–	1516.04000	1520.04000	1525.04000	–	–
4.50	DIN, ISO	–	1516.04500	1520.04500	1525.04500	1532.04500	–
5.00	ISO, JIS	–	1516.05000	1520.05000	1525.05000	1532.05000	–
5.50	DIN, ISO	–	1516.05500	1520.05500	1525.05500	1532.05500	–
5.60	ISO	–	1516.05600	1520.05600	1525.05600	1532.05600	–
6.00	DIN, JIS	–	1516.06000	1520.06000	1525.06000	1532.06000	1540.06000
6.20	JIS	–	1516.06200	1520.06200	1525.06200	1532.06200	1540.06200
6.30	ISO	–	1516.06300	1520.06300	1525.06300	1532.06300	1540.06300
7.00	DIN, JIS	–	–	1520.07000	1525.07000	1532.07000	1540.07000
7.10	ISO	–	–	–	1525.07100	1532.07100	1540.07100
8.00	DIN, ISO, JIS	–	–	–	1525.08000	1532.08000	1540.08000
8.50	JIS	–	–	–	1525.08500	1532.08500	1540.08500
9.00	DIN, ISO	–	–	–	1525.09000	1532.09000	1540.09000
10.00	DIN, ISO	–	–	–	1525.10000	1532.10000	1540.10000
10.50	JIS	–	–	–	–	1532.10500	1540.10500
11.00	DIN	–	–	–	–	1532.11000	1540.11000
11.20	ISO	–	–	–	–	1532.11200	1540.11200
12.00	DIN	–	–	–	–	1532.12000	1540.12000
12.50	ISO, JIS	–	–	–	–	1532.12500	1540.12500
14.00	DIN, ISO, JIS	–	–	–	–	–	1540.14000
15.00	JIS	–	–	–	–	–	1540.15000
16.00	DIN, ISO	–	–	–	–	–	1540.16000
17.00	JIS	–	–	–	–	–	1540.17000



ET1

ET-1 Axial Compensating Tap Collets Inch Sizes (ANSI)

Shank Ø [inch]	Shank Ø [mm]	ET1-12 Part No.	ET1-16 Part No.	ET1-20 Part No.	ET1-25 Part No.	ET1-32 Part No.	ET1-40 Part No.
0.141	3.580	1512.03581	1516.03581	1520.03581	1525.03581		
0.168	4.270		1516.04271	1520.04271	1525.04271	1532.04271	
0.194	4.930		1516.04931	1520.04931	1525.04931	1532.04931	
0.220	5.590		1516.05591	1520.05591	1525.05591	1532.05591	
0.255	6.480			1520.06481	1525.06481	1532.06481	1540.06481
0.318	8.080				1525.08081	1532.08081	1540.08081
0.323	8.205				1525.08211	1532.08211	1540.08211
0.367	9.320				1525.09321	1532.09321	1540.09321
0.381	9.680				1525.09681	1532.09681	1540.09681
0.429	10.900					1532.10901	1540.10901
0.437	11.113					1532.11111	1540.11111
0.480	12.192					1532.12191	1540.12191
0.542	13.770						1540.13771
0.562	14.290						1540.14291
0.590	14.990						1540.14991
0.652	16.560						1540.16561
0.697	17.700						1540.17701

3

Tap Size	Shank	Square
No 0 -6	0.141	0.110
1/16	0.141	0.110
3/32	0.141	0.110
1/8	0.141	0.110
5/32	0.168	0.131
No 8	0.168	0.131
3/16	0.194	0.152
No 9	0.194	0.152

Tap Size	Shank	Square
No 9	0.194	0.152
No 10	0.194	0.152
1/4	0.255	0.191
5/16	0.318	0.238
3/8	0.381	0.286
7/16	0.323	0.242
1/2	0.367	0.275
9/16	0.429	0.322

Tap Size	Shank	Square
5/8	0.480	0.360
11/16	0.542	0.406
3/4	0.590	0.442
13/16	0.652	0.489
7/8	0.697	0.523
15/16	0.760	0.570
1	0.800	0.600



Swiss Precision Tools

PG

powRgrip Tap Collets

Features | Benefits

Swiss Quality

Made in Switzerland to ISO9001/ISO14001.

1 Marking

With type and size (reduces collet selection error).

2 Product Traceability

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

3 Original REGO-FIX®

When buying PG collets, look for the REGO-FIX® quality symbol Δ on the front of the collet.

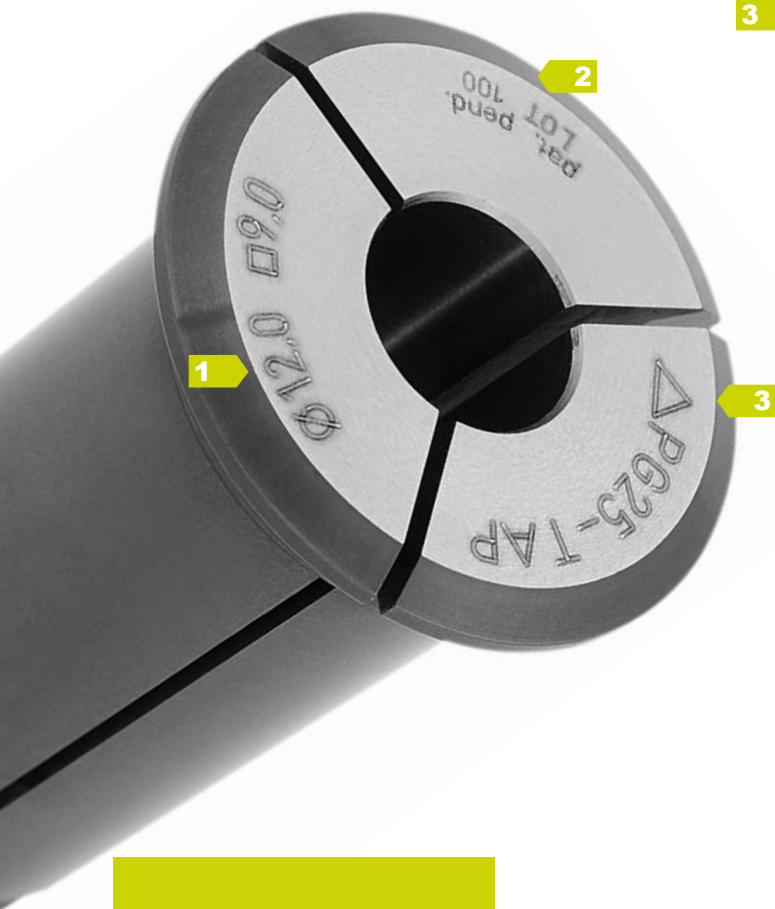
Coolant Through Tools

Metallic-sealed for coolant through tools.

Internal Square for Tap Shanks and Length Adjustment

Internal square for tight grip, integrated length adjustment screw, accepts h9 tool shanks.

3



5 Year
WARRANTY
20,000
CYCLES

PG-TAP Tap Collets without Axial Compensation

The PG-TAP tap collets are compatible with DIN standard taps.

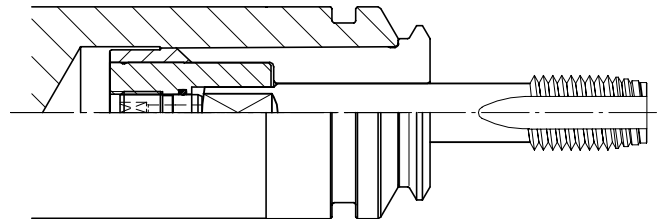
The REGO-FIX® powRgrip® tap collets are manufactured with an internal square. They are intended for use on CNC machines that have a synchronized machine spindle speed and feed rate.

We recommend the use of our SSY Softsynchro® tap holders because they compensate for the minimal synchronizing differences of CNC machines.

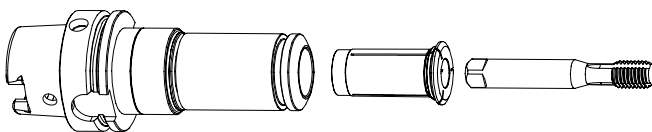
See chapter 8 (HSK tapping toolholders), page 8.15 and chapter 10 (cylindrical tapping toolholders), page 10.15

For machines without a synchronized tapping option, we recommend the use of our axial compensating GSF tap holders.

See chapter 10 (cylindrical tapping toolholders), page 10.17



3



powRgrip® toolholder
different types available

exchangeable
powRgrip®
tapping collet

h9 cutting tool



Clamp h9-tolerance tool shanks only!

Never clamp tapping collet without tool.

Collet will be damaged!

When buying PG tapping collets, please note the REGO-FIX® quality symbol \triangle on the front of the tapping collet.

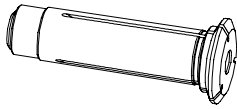
Table with current dimensions of taps on page 14.11



Swiss
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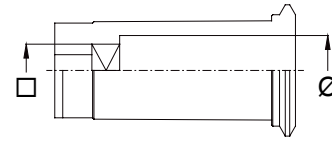
PG

powRgrip Tap Collets



PG 15-TAP

PG 15-TAP Tap Collets

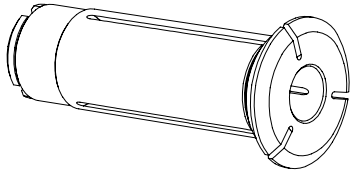


3

Shank (Ø) [mm]	Square (□) [mm]	Standard DIN	PG 15-TAP Part No.
3.500	2.700	371/376	1715.03505
4.500	3.400	371/376	1715.04505
6.000	4.900	371/376	1715.06005
7.000	5.500	371/376	1715.07005
8.000	6.200	371/376	1715.08005
9.000	7.000	371/376	1715.09005
10.000	8.000	371	1715.10005

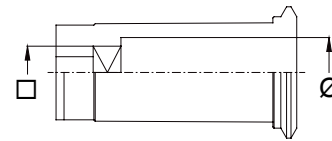
See on page 8.15 for HSK tapping toolholders and
on pages 10.15/10.17 for cylindrical tapping toolholders

For inch size tap collets, please call for availability.



PG 25-TAP

PG 25-TAP Tap Collets Metric



3

Shank (∅) [mm]	Square (□) [mm]	Standard DIN	PG 25-TAP Part No.
8.000	6.200	371/376	1725.08005
9.000	7.000	371/376	1725.09005
10.000	8.000	371	1725.10005
11.000	9.000	371/376	1725.11005
12.000	9.000	371/376	1725.12005
14.000	11.000	371/376	1725.14005
16.000	12.000	371/376	1725.16005

See on page 8.15 for HSK tapping toolholders and
on pages 10.15/10.17 for cylindrical tapping toolholders

For inch size tap collets, please call for availability.