

# DNA

## "DEAD NUTS ACCURATE" ER SIZE COLLETS

**Small tools causing BIG headaches?**

Techniks DNA  
"Dead Nuts Accurate"  
collets solve the small  
tool dilemma

Don't invest in a new  
tool holding system, get  
the right collet instead!

# AHB

TOOLING & MACHINERY

COMPLETE METALWORKING SOLUTIONS

ER collet

DNA collet

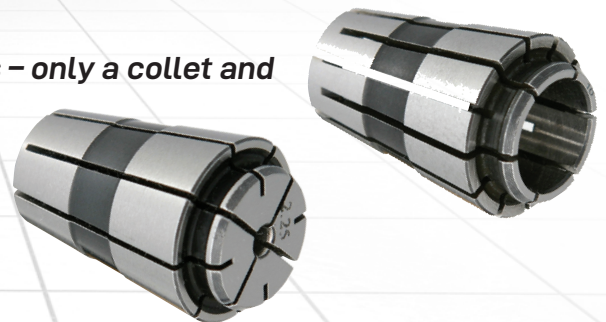
### The ER Dilema

- Traditional ER collets project about 30% of the collet outside the collet pocket
- Less rigidity, excessive vibration, and inconsistent run-out
- Shorter tool-life and/or broken tools

### The DNA Solution

- DNA collets have a much shorter projection outside of the collet pocket
- More rigid hold for small diameter tools and repeatable accuracy
- Longer tool-life and superior tool performance!

- DNA collets work in standard ER collet chucks – only a collet and nut required
- 0.0002" max. T.I.R.
- Coolant nuts available for coolant-thru tooling



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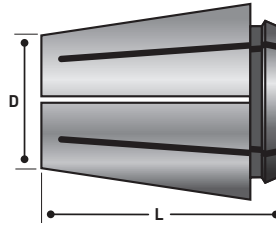
# See why we call this collet system DNA - "Dead Nuts Accurate"!



## FEATURES

- Compatible with ER collet chucks and extensions
- 0.0002" T.I.R. extends tool life
- More rigid and more accurate than ER for small diameter shanks

Use the table for selecting your replacement collets. DNA collets all have unique length and diameter measurements.



## DNA DIMENSIONS

Collet	L	D
DNA 11	.673	.460
DNA 16	.945	.654
DNA 20	1.201	.815
DNA 25	1.339	1.010
DNA 32	1.571	1.301
DNA 40	1.776	1.617

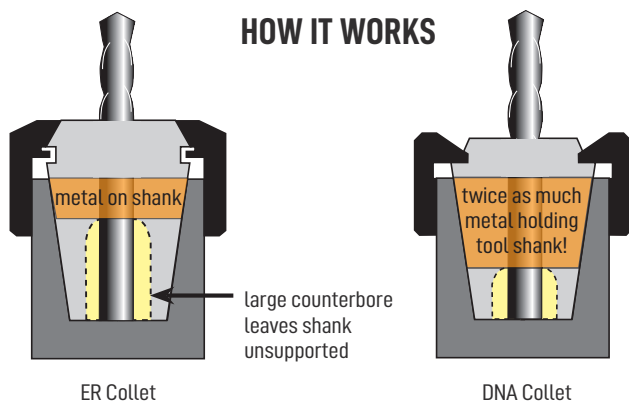
## DNA 11 COLLETS & ACCESSORIES

Part No.	Shank Size inch/mm	Collapse Range inch/mm
05952-02	5/64" / 1.5 - 2mm	.059" - .079" / .5mm
05952-03	7/64" / 2.5 - 3mm	.098" - .118" / .5mm
05952-03.5	1/8" / 3 - 3.5mm	.118" - .138" / .5mm
05952-04	5/32" / 3.5 - 4mm	.138" - .157" / .5mm
05952-05	3/16" / 4.5 - 5mm	.177" - .197" / .5mm
05952-06	15/64" / 5.5 - 6mm	.216" - .236" / .5mm
05952-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05952-3/16	exact size collet: 3/16"	.167" - .187" / .5mm
05952-1/4	exact size collet: 1/4"	.230" - .250" / .5mm
2011.0000	DNA 11 nut M14 x .75"	
04608	DNA 11 collet wrench	
DNA11TWA	DNA 11 torque wrench adapter	

## DNA 16 COLLETS & ACCESSORIES

Part No.	Shank Size inch/mm	Range inch/mm
05954-0.3	.2 - .3mm	.007" - .011" / .10mm
05954-0.4	1/64" / .3 - .4mm	.011" - .015" / .10mm
05954-0.5	.4 - .5mm	.015" - .019" / .10mm
05954-0.6	.5 - .6mm	.019" - .023" / .10mm
05954-0.8	1/32" / .7 - .8mm	.027" - .031" / .10mm
05954-1.0	.9 - 1.0mm	.035" - .039" / .10mm
05954-1.2	3/64" / 1.1 - 1.2mm	.043" - .047" / .10mm
05954-1.25	1.0 - 1.25mm	.039" - .049" / .25mm
05954-1.5	1.25 - 1.5mm	.049" - .059" / .25mm
05954-1.75	1/16" / 1.5 - 1.75mm	.059" - .068" / .25mm
05954-02	5/64" / 1.75 - 2mm	.068" - .078" / .25mm
05954-2.25	2 - 2.25mm	.078" - .088" / .25mm
05954-2.5	3/32" / 2.25 - 2.5mm	.088" - .098" / .25mm
05954-03	2.5 - 3mm	.098" - .118" / .5mm
05954-3.5	1/8" / 3 - 3.5mm	.118" - .138" / .5mm
05954-04	5/32" / 3.5 - 4mm	.137" - .157" / .5mm
05954-4.5	4 - 4.5mm	.157" - .177" / .5mm
05954-05	3/16" / 4 - 5mm	.157" - .197" / 1.0mm
05954-06	7/32" / 5 - 6mm	.196" - .236" / 1.0mm
05954-07	1/4" / 6 - 7mm	.236" - .275" / 1.0mm
05954-08	5/16" / 7 - 8mm	.275" - .314" / 1.0mm
05954-09	11/32" / 8 - 9mm	.314" - .354" / 1.0mm
05954-10	3/8" / 9 - 10mm	.354" - .392" / 1.0mm
05954-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05954-3/16	exact size collet: 3/16"	.147" - .187" / 1.0mm
05954-1/4	exact size collet: 1/4"	.210" - .25" / 1.0mm
05954-3/8	exact size collet: 3/8"	.335" - .375" / 1.0mm

## HOW IT WORKS



DNA collets hold small tools with greater rigidity and more accuracy (T.I.R.) for greatly improved tool life.



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# DNA - "Dead Nuts Accurate" Collets

## DNA 20 COLLETS & ACCESSORIES

Part No.	Shank Size inch/mm	Range inch/mm
05956-03	2.5 - 3mm	.098" - .118" / .5mm
05956-3.5	1/8" / 3 - 3.5mm	.118" - .138" / .5mm
05956-04	5/32" / 3.5 - 4mm	.137" - .157" / .5mm
05956-05	3/16" / 4 - 5mm	.157" - .197" / 1.0mm
05956-06	7/32" 5 - 6mm	.197" - .236" / 1.0mm
05956-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05956-3/16	exact size collet: 3/16"	.147" - .187" / 1.0mm
05956-1/4	exact size collet: 1/4"	.210" - .250" / 1.0mm
05956-3/8	exact size collet: 3/8"	.335" - .375" / 1.0mm
2020.0000	DNA 20 nut, M25 x 1.5" O.D. 32mm	
2020.0000C	DNA 20 coolant nut, uses ER20 rings on page 60	
DNA20W	DNA 20 collet wrench	
DNA20TWA	DNA 20 torque wrench adapter	



DNA Sealed Nut



DNA 16 Nut

DNA nuts feature PowerCOAT for 75% more holding power and best tool life.

## DNA 32 COLLETS & ACCESSORIES

Part No.	Shank Size inch/mm	Range inch/mm
05958-03	2.5 - 3mm	.098" - .118" / .5mm
05958-3.5	1/8" / 3 - 3.5mm	.118" - .138" / .5mm
05958-04	5/32" / 3.5 - 4mm	.137" - .157" / .5mm
05958-05	3/16" / 4 - 5mm	.157" - .197" / 1.0mm
05958-06	7/32" 5 - 6mm	.197" - .236" / 1.0mm
05958-1/8	exact size collet: 1/8"	.105" - .125" / .5mm
05958-3/16	exact size collet: 3/16"	.147" - .187" / 1.0mm
05958-1/4	exact size collet: 1/4"	.210" - .250" / 1.0mm
05958-3/8	exact size collet: 3/8"	.335" - .375" / 1.0mm
05958-1/2	exact size collet: 1/2"	.460" - .5" / 1.0mm
05958-3/4	exact size collet: 3/4"	.710" - .75" / 1.0mm
05958-13	exact size collet: 13mm	.472" - .512" / 1.0mm
05958-20	exact size collet: 20mm	.748" - .787" / 1.0mm
1132.0000	DNA 32 nut, M40 x 1.5" O.D. 47.5mm	
1132.0000C	DNA 32 coolant nut, uses ER25 rings on page 60	
DNA32W	DNA 32 collet wrench	
DNA32TWA	DNA 32 torque wrench adapter	

## DNA 16 NUTS & ACCESSORIES

Part No.	Description
2016-2000	DNA16 Mini Nut - M19 x 1.0" x O.D. 25mm
27116	M22 x 1.5 nut, , O.D. 27mm
27116-30	3.0 - 2.5mm sealed nut, O.D. 27mm
27116-40	4.0 - 3.5mm sealed nut, O.D. 27mm
27116-45	4.5 - 4.0mm sealed nut, O.D. 27mm
27116-50	5.0 - 4.5mm sealed nut, O.D. 27mm
27116-55	5.5 - 5mm sealed nut, O.D. 27mm
27116-60	6.0 - 5.5mm sealed nut, O.D. 27mm
27116-65	6.5 - 6mm sealed nut, O.D. 27mm
DNA16W	DNA 16 collet wrench
DNA16TWA	DNA 16 torque wrench adapter
894-22	DNA 16 mini nut wrench



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