



'ERT' QUICK CHANGE TAPPING COLLETS WITH AXIAL COMPENSATION

- ♦ 'ERT' Tapping Collet is with Axial expansion.
- ♦ Tap can be Changed very quickly.
- ♦ Best suitable for any CNC machines



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'ERT' Tapping Collet :

External dimensions as per 'ER' Collets DIN - 6499.

'T' stands for tension or expansion.

'ERT' has no compression, so it has always rigid start. Best suitable for depth control in tapping.

'ERT' is best suitable for,

- ◆CNC turning centers
- ◆CNC Turn - Mill centers with rotating tool holders.
- ◆CNC machining centers & any CNC machine where tapping is involved.

This is available in ER 16, 20, 25, 32, 40, & 50 sizes. To be used with standard 'ER' Collet chucks. Need not to have any special Holding device.

The information in this catalog is believed to be correct . KTA Spindle Toolings, however, assumes no responsibility for any errors , inaccuracies or omissions that may appear in this catalog.

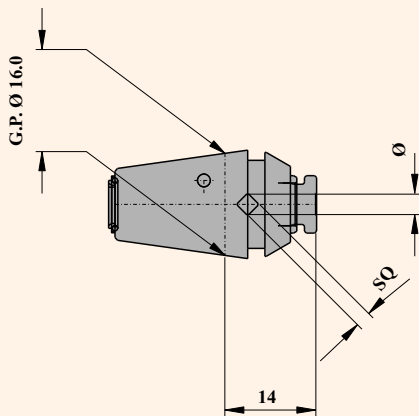
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This system is to be used along with 'ER' Collet chucks on CNC machines & SPM's Recommendations

Rapid approach, then feed the Tap with approximately 95% of the pitch value, this gives positive start to the Tapping. This uses 20% to 30% of the compensation stroke.

When the spindle rotation & the feed movement are simultaneously reversed. Return feed must be made 100% of the pitch value. Which maintains the sleeve of the Tapping collet in the expansion stroke upto the Tap disengagement. When Tapping with very high speed, an appropriate programming, compensation may be necessary to balance the differences of inertia between the spindle & the feed movement on reverse. Never disturb the axial compensation. Use external coolant supply only.

'ERT' 16 TAPPING COLLET

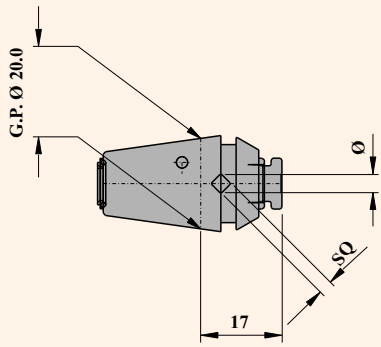


FOR ERT 16 COLLET CHUCKS

HOLDING RANGE
FROM Ø 2.8 X □ 1.8 mm
TO Ø 5.0 X □ 4.0 mm

ONLY EXPANSION 7 mm

ERT 20 TAPPING COLLETS

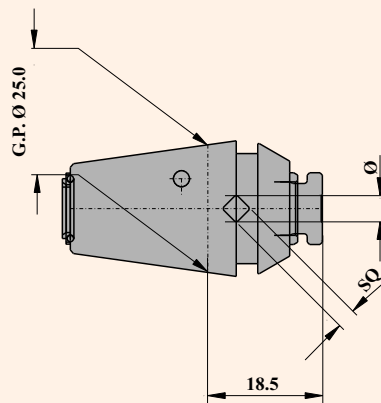


FOR ERT 20 COLLET CHUCKS

HOLDING RANGE
FROM Ø 2.8 X □ 1.8 mm
TO Ø 7.1 X □ 5.6 mm

ONLY EXPANSION 7.5 mm

ERT 25 TAPPING COLLETS

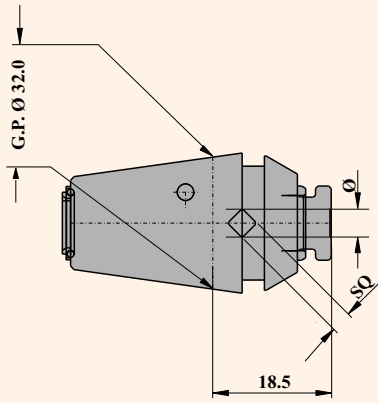


FOR ERT 25 COLLET CHUCKS

HOLDING RANGE
FROM Ø 2.8 X □ 1.8 mm
TO Ø 9.0 X □ 7.3 mm

ONLY EXPANSION 8 mm

ERT 32 TAPPING COLLETS

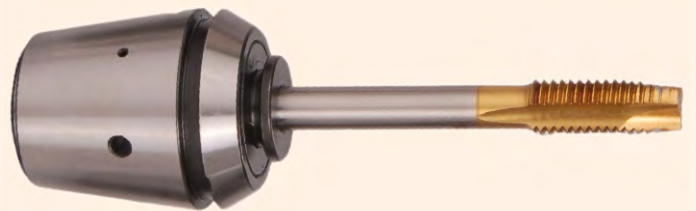
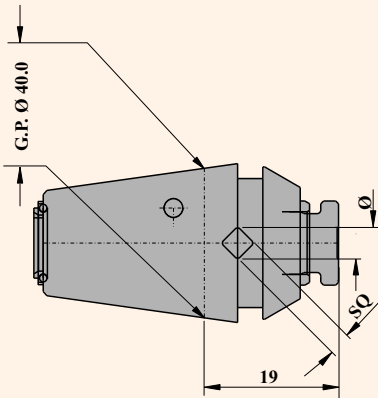


FOR ERT 32 COLLET CHUCKS

HOLDING RANGE
FROM Ø 2.8 X □ 1.8 mm
TO Ø 12.0 X □ 9.0 mm

ONLY EXPANSION 10 mm

ERT 40 TAPPING COLLETS

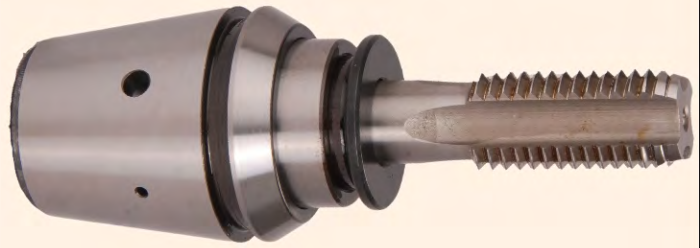
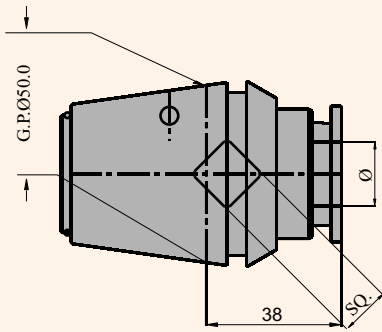


FOR ERT 40 COLLET CHUCKS

HOLDING RANGE
FROM Ø 2.8 X □ 1.8 mm
TO Ø 16.0 X □ 12.5 mm

ONLY EXPANSION 12 mm

ERT 50 TAPPING COLLETS

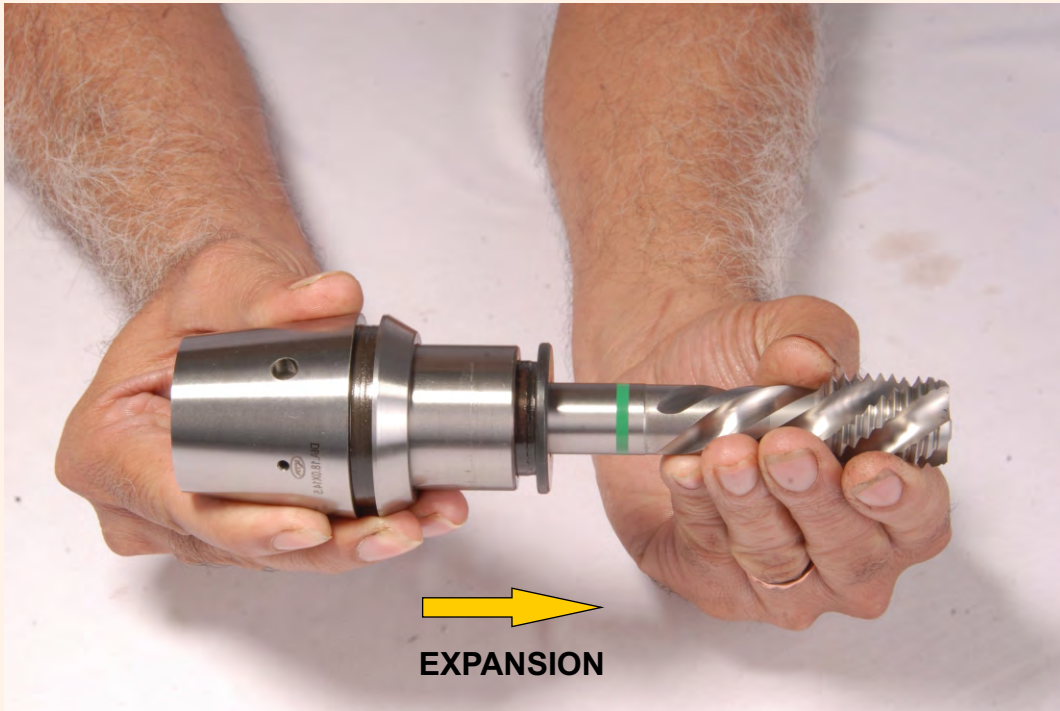


FOR ERT 50 COLLET CHUCKS

HOLDING RANGE
FROM Ø 11.0 X □ 9.0 mm
TO Ø 25.0 X □ 20.0 mm

ONLY EXPANSION 15 mm

'ERT' TAPPING COLLET IN EXPANDED CONDITION



TECHNICAL INFORMATION

Tap Shank Dimensions ISO 529 - 1975

Dimension Dia. x Square	Metric		UNC		UNF		BSW		BSF		BA	
		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged
3.15 x 2.5	M4	M3	-	No. 4-40	-	No. 4-48	-	-	-	-	-	No. 5
	-	-	No. 8-32	No. 5-40	No. 8-36	No. 5-44	-	-	-	-	No. 3	-
3.55 x 2.8	M 4.5	M 3.5	No. 10-24	No. 6-32	No. 10-32	No. 6-40	3/16"-24	-	3/16"-32	-	No. 2	No. 4
4 x 3.15	M 5	M 4	No. 12-24	-	No. 12-28	-	-	-	7/32"-28	-	No. 1	-
4.5 x 3.55	M 6	-	1/4"-20	No. 8-32	1/4"-28	No. 3-36	1/4"-20	-	1/4"-26	-	No. 0	No. 3
5 x 4	-	M 5	-	No. 10-24	-	No. 10-32	-	3/16"-24	-	3/16"-32	-	No. 2
5.6 x 4.5	-	-	-	No. 12-24	-	No. 12-28	-	-	9/32"-26	7/32"-28	-	No. 1
6.3 x 5	M 8	M 6	5/16"-18	1/4"-20	5/16"-24	1/4"-28	5/16"-18	1/4"-20	5/16"-22	1/4"-26	-	No. 0
7.1 x 5.6	-	-	3/8"-16	-	3/8"-24	-	3/8"-16	-	3/8"-20	9/32"-36	-	-
8 x 6.3	M 10	M 8	7/16"-14	5/16"-18	7/16"-20	-	7/16"-14	5/16"-18	7/16"-18	5/16"-22	-	-
9 x 7.1	M 12	-	1/2"-13	-	1/2"-20	-	1/2"-12	-	1/2"-12	-	-	-
10 x 8	-	M 10	-	3/8"-16	-	3/8"-24	-	3/8"-16	-	3/8"-20	-	-
11.2 x 9	M 14	-	9/16"-12	-	9/16"-18	-	9/16"-12	-	9/16"-16	-	-	-
12.5 x 10	M 16	-	5/8"-11	-	5/8"-18	-	5/8"-11	-	3/8"-14	-	-	-
14 x 11.2	M 18	-	3/4"-10	-	3/4"-16	-	11/16"-11	-	11/16"-14	-	-	-
	M 20	-	-	-	-	-	3/4"-10	-	3/4"-12	-	-	-
16 x 12.5	M 22	-	7/8"-9	-	7/8"-14	-	7/8"-9	-	7/8"-11	-	-	-
18 x 14	M 24	-	1"-8	-	1"-12	-	1"-8	-	1"-10	-	-	-
20 x 16	M 27	-	1 1/8"-7	-	1 1/8"-12	-	1 1/8"-7	-	1 1/8"-9	-	-	-
	M 30	-	-	-	-	-	-	-	-	-	-	-
22.4 x 18	M 33	-	1 1/4"-4	-	1 1/4"-12	-	1 1/4"-7	-	1 1/4"-9	-	-	-
25 X 20	M 36	-	1 3/8"-6	-	1 3/8"-12	-	-	-	1 3/8"-8	-	-	-
28 x 22.4	M 39	-	1 1/2"-6	-	1 1/2"-12	-	1 1/2"-6	-	1 1/2"-8	-	-	-
	M 42	-	-	-	-	-	-	-	1 5/8"-8	-	-	-
31.5 x 25	M 45	-	1 3/4"-5	-	-	-	1 3/4"-5	-	1 3/4"-7	-	-	-
	M 48	-	-	-	-	-	-	-	-	-	-	-

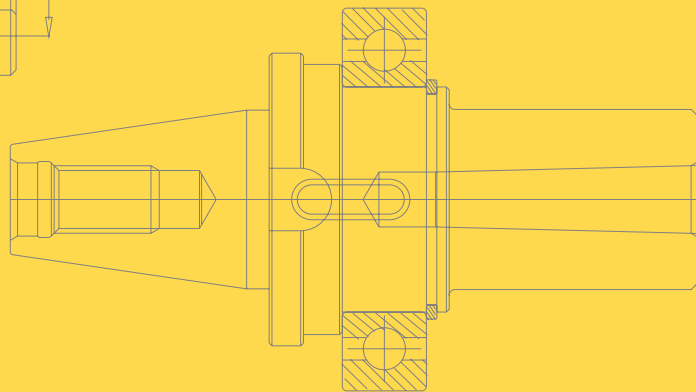
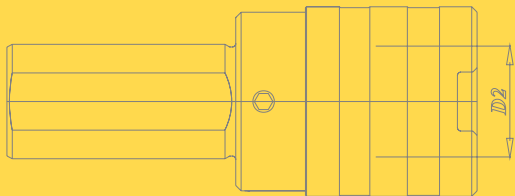
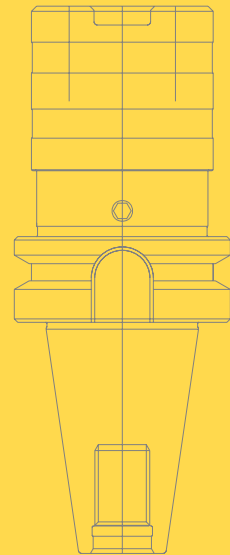
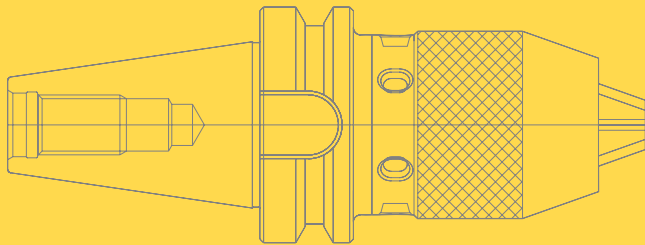
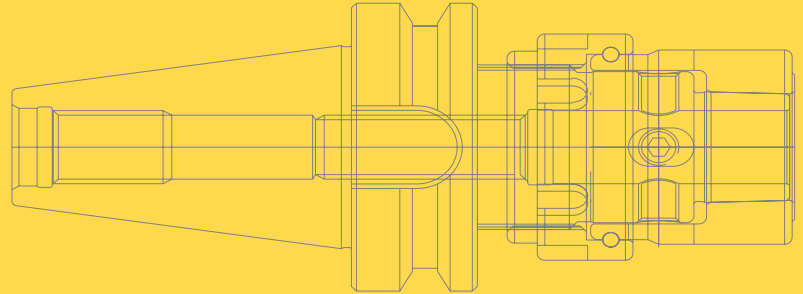
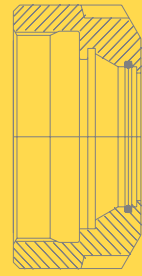
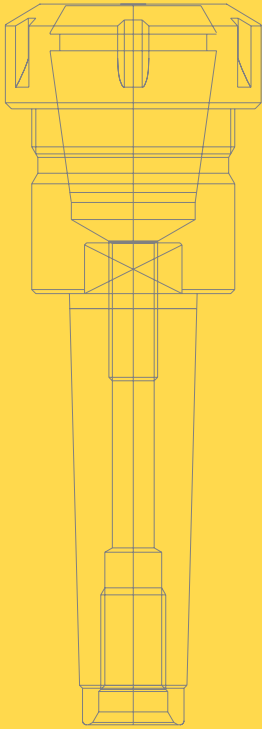
Tap Shank Dimensions DIN

Dimension Dia. x Square	DIN 352	DIN 353	DIN 371	DIN 374	DIN 376	DIN 2182	DIN 2183
3.5 x 2.7	M 3	-	M 3	M 5	M 5	1/8"	-
4 x 3	M 4	-	M 3.5	-	-	-	-
4.5 x 3.4	M 4	-	M 4	M 6	M 6	5/32"	1/4"
6 x 4.9	M 5	-	M 5	-	-	7/32"	-
	M 6	-	M 6	-	-	-	-
	M 8	-	-	M 8	M 8	-	-
7 x 5.5	M 10	G 1/8"	-	M 10	M 10	1/4"	3/8"
8 x 6.2	-	-	M 8	-	-	5/16"	7/16"
9 x 7	M 12	-	-	M 12	M 12	3/8"	1/2"
10 x 8	-	-	M 10	-	-	-	-
11 x 9	M 14	G 1/4"	-	M14	M 14	-	9/16"
12 X 9	M 16	G 3/8"	-	M 16	M 16	-	5/8"
14 X 11	M 18	-	-	M 18	M 18	-	11/16"
16 X 12	M 20	G 1/2"	-	M 20	M 20	-	13/16"
18 x 14.5	M 22	G 5/8:	-	M 22	M 22	-	7/8"
	M 24	-	-	M 24	M 24	-	15/16"
20 x 16	M 27	G 3/4"	-	M 27	M 27	-	1"
22 x 18	M 30	G 7/8"	-	M 30	M 30	-	1 1/8"
25 x 20	M 33	G 1"	-	M 33	M 33	-	1 1/4"
28 x 22	M 36	G 1 1/8"	-	M 36	M 36	-	1 3/8"
32 x 24	M 39	G 1 1/8"	-	M 39	M 39	-	1 1/2"
	M 42	-	-	M 42	M 42	-	1 5/8"
36 x 29	M 45	G 3/8"	-	M 45	M 45	-	1 3/4"
	M 48	G 1 1/2"	-	M 48	M 48	-	1 7/8"
	-	G 1 3/4"	-	-	-	-	-
	-	G 2"	-	-	-	-	-

Tap Shank Dimensions ANSI (US Standards)

Tap Shank Dimensions (JIS Standards)

Dimension in Inch. Dia. x Square		Metric Conversions		Tap Size	Dimension in Inch. Dia. x Square		Metric Conversions		Tap Size	Dimension in mm. Dia. x Square		Tap Size
0.141	0.110	3.59	2.80	1/8" No.6	0.590	0.442	14.99	11.23	3/4"	4.0	3.0	M 3 & M 3.5
0.168	0.131	4.27	3.33	5/32" No.8	0.652	0.489	16.57	12.43	M 20	5.0	4.0	M 4 & M 4.5
0.194	0.152	4.93	3.87	3/16" No. 10	0.688	0.515	17.47	13.09	1/2" Ps	5.5	4.5	M 5
0.220	0.165	5.59	4.20	No. 12	0.697	0.523	17.71	13.29	7/8"	6.0	4.5	M 6
0.255	0.191	6.48	4.86	1/4" No. 14	0.700	0.531	17.78	13.49	3/8"Ps	6.2	5.0	M 7 & M 8
0.312	0.234	7.94	5.95	1/16"Ps 1/8"Ps	0.760	0.570	19.31	14.48	M 24	7.0	5.5	M 9 & M 10
0.318	0.238	8.08	6.05	5/16" 3/8"	0.800	0.600	20.32	15.24	1"	8.0	6.2	M 11
0.323	0.242	8.21	6.15	5/16" 7/16"	0.896	0.672	22.76	17.07	1 1/8"	8.5	6.5	M 12
0.367	0.275	9.33	6.99	1/2"	0.906	0.679	23.02	17.25	3/4"P	10.5	8.0	M 14
0.381	0.286	9.68	7.27	3/8"	1.021	0.766	25.94	19.46	1 1/4"	12.5	10.0	M 16
0.429	0.322	10.90	8.18	9/16"	1.108	0.833	28.15	21.11	1 3/8"	14.0	11.0	M 18
0.438	0.328	11.12	8.34	1/8"Ps	1.125	0.843	28.58	21.42	1"P	15.0	12.0	M 20
0.480	0.360	12.20	9.15	5/8"	1.233	0.925	31.32	23.50	1 1/2"	17.0	13.0	M 22
0.542	0.406	13.77	10.31	11/16"	1.132	0.984	33.34	25.00	1 1/4"P	19.0	15.0	M 24
0.563	0.421	14.29	10.70	1/4"Ps	1.430	1.072	36.33	27.23	1 3/4"	20.0	15.0	M 27
										23.0	17.0	M 30



DEALERS: