

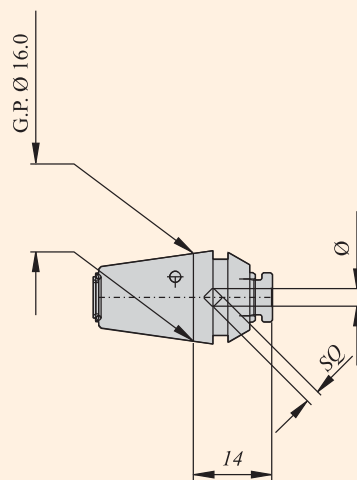
## QUICK CHANGE TAPPING COLLETS WITH AXIAL COMPENSATION (ERT)

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 COLLET

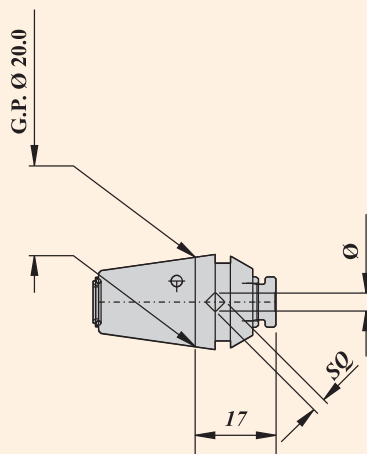


FOR ERT 16 COLLET CHUCKS

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

ONLY EXPANSION 7 mm

### ERT 20 COLLET



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