

Toolholder Torque Chart For CNC Routers

Follow the tightening specifications listed below for smoother, faster, and safer cutting performance.

Recommended Collet & Retention Knob Tightening Torque

Collet.	Nut Type	Collets I.D. OVER 1/16" (2mm)	Collets I.D. UNDER 1/16" (2mm)	Order Torque Wrench Adapter
ER 16	slotted	42 ft/lbs	30 ft/lbs	04580-16
ER 16	hex	42 ft/lbs	30 ft/lbs	04601-16
ER 20	slotted	59 ft/lbs	24 ft/lbs	04580-20
ER 20	hex	59 ft/lbs	24 ft/lbs	04602-20
ER 25	slotted	70 ft/lbs	77 ft/lbs	04503-25
ER 25	mini nut	25 ft/lbs	25 ft/lbs	04587
ER 32	slotted	100 ft/lbs	100 ft/lbs	04604-32
ER 40	slotted	130 ft/lbs	130 ft/lbs	04605-40
SYOZ 25	hook	90 ft/lbs	90 ft/lbs	03690-25
TG 75	hook	90 ft/lbs	90 ft/lbs	04018-TWA
TG 100	hook	90 ft/lbs	90 ft/lbs	03690-25

Retention Knobs	Wrench Flats	Drive	Torque	Order Socket
BT 30 Taper	0.535"	1/4"	36 ft/lbs	PSS-30BT
ISO 30 Taper	0.535"	3/8"	36 ft/lbs	PSS-30ISO
Any 40 Taper	0.750"	3/8"	76 ft/lbs	PSS-40
BT 50 Taper	1.187"	1/2"	99 ft/lbs	PSS-50
CAT 50 Taper	1.250"	1/2"	99 ft/lbs	PSSC-50

Auto-Locking Stand

- Fastest tool changes possible
- Simply drop holder into stand and tighten or loosen



Benchtop Stand for HSK

Part No.	Description
17844B	HSK50A, 50E, 50F, C5
17846B	HSK63A, 63E, 63F, C6

How to Properly Assemble a Collet and Nut Toolholder

1. Snap collet into nut.
2. Insert cutter into collet. Collets without counter bore require shank to extend to the bottom of the collet.
3. Hand tighten collet nut assembly into toolholder.
4. Insert toolholder assembly into tightening fixture and secure it.
5. Tighten collet nut to recommended torque using a torque wrench and adapter.

Incorrect torque can cause cracked collets, poor cutting performance, and loosen tooling during operation; resulting in an increasingly dangerous work environment.

