

VC COLLET CHUCKS



VC COLLET CHUCKS

VC COLLET CHUCKS



VC COLLET CHUCK FEATURES

ULTRA PERFORMANCE

Extremely Precise: 0.00012" or less concentricity guarantee with any collet

Extremely Efficient: Ideal for high-speed machining, thread milling, ultra precision reaming

Flexible: Covers sizes from 0.079" to 0.5"

Extremely Accurate: Double the accuracy over ER Collet Chucks, with ten times better repeatability

8° Versus 16° Collet Taper: Double the gripping power of ER Collet Chucks



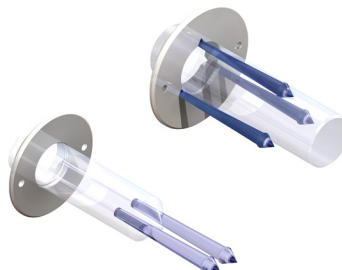
Coolant-Thru Disc

A perfect seal is formed between the nut and the coolant-thru disk. Ideal for coolant-thru tools.



Coolant-Thru Capabilities

Jet Coolant Splash with J-Type Nut



Slotted Disc

The jet coolant pressure creates a tornado effect, ensuring efficient swarf disposal.



VC COLLET CHUCKS

VC COLLET CHUCK FEATURES

The thick wall design of the VC holder body improves cutting rigidity

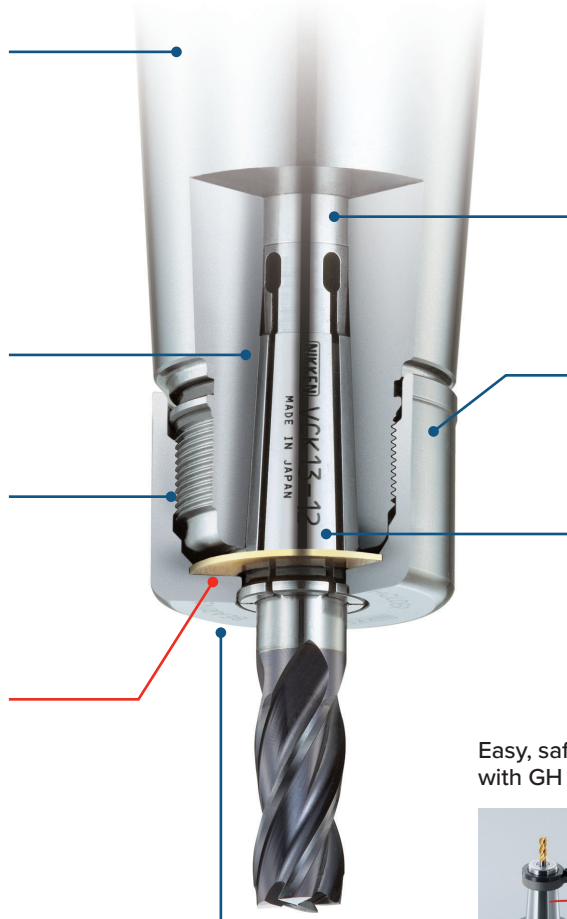
8° internal taper collet for greater accuracy and clamping capability

The ground ion nitrided thread of collet chuck highly improves the torque and accuracy

TiN Bearing Nut

(Hardness: HV2,200)
US Patent 6923451
Reduces friction to minimize runout caused by collet twisting

Collet compression force is perpendicular to the centerline of collet bore maximizing runout accuracy and gripping strength



Ground pilot helps centralize the collet while giving additional length support on the cutting tool

Symmetrical and simple external nut design without notches for ultra high speed rotation

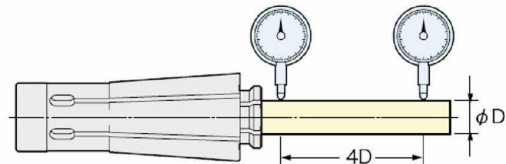
Extended Collet to minimize runout and to increase surface area contact of tooling

Easy, safe and reliable handling with GH wrench (see page 88)



High Runout Accuracy:

Within 0.00012" at 4 times the diameter of the cutting tool!
This produces better stability and improves surface finish and cutting tool life.



VC Collet Range:



VCK6: 2-6mm (1/8"-1/4")
VCK13: 3-12mm (1/8"-1/2")

VC Collet vs. Others:



VCK Collet

- Runout: 0.0001"
- 170N.m gripping power



ER Collet

- Runout: 0.0004"
- 80N.m gripping power



TG Collet

- Runout: 0.0003"
- 100N.m gripping power

CAT VC COLLET CHUCKS

FEATURES

- TiN Bearing Nut which considerably improves cutting rigidity and finish
- Extra thick body for aggressive milling
- High concentricity and repeatability
- Ideal for high-speed applications



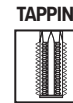
T.I.R.
<0.00012" at 4xD



Speed
Up to 30,000 rpm



Coolant-Thru
Thru-tool coolant



Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

CAT40

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | L2 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|---------------------|-------------|--------|--------|-------|-------|-------|-------|-------|---------------|----------|------|
| CAT40-VC6-60U-IDU | VCK6 | GH10 | 60 | 2.36" | 0.99" | - | 1.08" | 1.75" | VCG6-8A | 30K | 2 |
| CAT40-VC6-90U-IDU | VCK6 | GH10 | 90 | 3.54" | 0.87" | 2.17" | 1.08" | 1.75" | VCG6-8A | 30K | 1 |
| CAT40-VC6-120U-IDU | VCK6 | GH10 | 120 | 4.72" | 0.87" | 3.35" | 1.08" | 1.75" | VCG6-8A | 30K | 1 |
| CAT40-VC13-60U-IDU | VCK13 | GH16 | 60 | 2.36" | 1.14" | - | 1.59" | 1.75" | VCG13-15A | 30K | 2 |
| CAT40-VC13-90U-IDU | VCK13 | GH16 | 90 | 3.54" | 1.10" | 2.39" | 1.59" | 1.75" | VCG13-15A | 30K | 1 |
| CAT40-VC13-120U-IDU | VCK13 | GH16 | 120 | 4.72" | 1.10" | 3.65" | 1.59" | 1.75" | VCG13-15A | 30K | 1 |

Note: Wrenches are sold separately

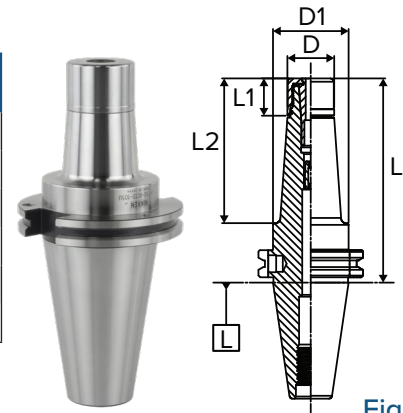


Fig. 1

CAT50

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | L2 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|---------------------|-------------|--------|--------|-------|-------|-------|-------|-------|---------------|----------|------|
| CAT50-VC6-105U-IDU | VCK6 | GH10 | 105 | 4.13" | 0.87" | 2.76" | 1.08" | 2.75" | VCG6-8A | 20K | 1 |
| CAT50-VC13-105U-IDU | VCK13 | GH16 | 105 | 4.13" | 1.10" | 2.76" | 1.59" | 2.75" | VCG13-15A | 20K | 1 |
| CAT50-VC13-135U-IDU | VCK13 | GH16 | 135 | 5.31" | 1.10" | 3.94" | 1.59" | 2.75" | VCG13-15A | 20K | 1 |
| CAT50-VC13-165U-IDU | VCK13 | GH16 | 165 | 6.50" | 1.10" | 5.12" | 1.59" | 2.75" | VCG13-15A | 20K | 1 |

Notes: Wrenches are sold separately.

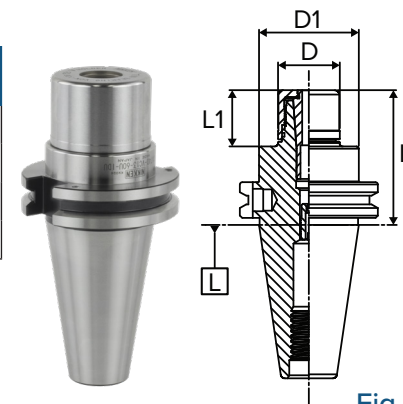
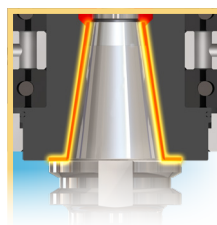


Fig. 2



Available in
TAPER PLUS
Dual-taper and flange contact

See Pages 84-85



TAPER PLUS COMBINING TAPER ACCURACY WITH FLANGE RIGIDITY!

- Outstanding Runout Accuracy for longer tool life
- Vibration Dampening for increased productivity
- High Rigidity for smooth and stable cutting



VCK Collets
Page 86



Nut Wrench
Page 88



Back-up Screw
Page 88



Coolant-thru Nut
Page 87

VC COLLET CHUCKS



BT VC COLLET CHUCKS

FEATURES

- TiN Bearing Nut which considerably improves cutting rigidity and finish
- Extra thick body for aggressive milling
- High concentricity and repeatability
- Ideal for high-speed applications



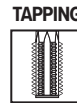
T.I.R.
<0.00012" at 4xD



Speed
Up to 40,000 rpm



Coolant-Thru
Thru-tool coolant



Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

BT30

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|---------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| BT30-VC6-45 | VCK6 | GH10 | 45 | 1.77" | 0.91" | 1.08" | 1.08" | VCG6-8A | 40K | 1 |
| BT30-VC6-60 | VCK6 | GH10 | 60 | 2.36" | 0.87" | 1.08" | 1.25" | VCG6-8A | 40K | 2 |
| BT30-VC6-90 | VCK6 | GH10 | 90 | 3.54" | 0.87" | 1.08" | 1.31" | VCG6-8A | 40K | 2 |
| BT30-VC13-60 | VCK13 | GH16 | 60 | 2.36" | 1.10" | 1.59" | 1.62" | VCG13-15A | 40K | 2 |
| BT30-VC13-90 | VCK13 | GH16 | 90 | 3.54" | 1.10" | 1.59" | 1.63" | VCG13-15A | 40K | 2 |
| BT30-VC13-120 | VCK13 | GH16 | 120 | 4.72" | 1.10" | 1.59" | 1.67" | VCG13-15A | 40K | 2 |

Note: Wrenches are sold separately



Available in **TAPER PLUS+**
Dual-taper and flange contact

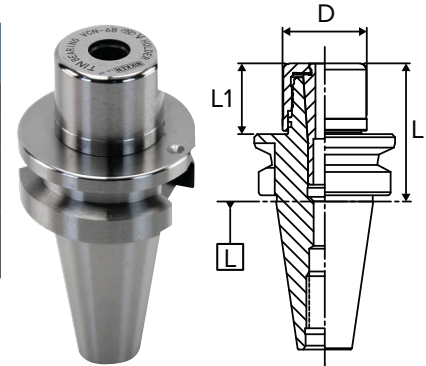


Fig. 3

BT40

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|---------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| BT40-VC6-60 | VCK6 | GH10 | 60 | 2.36" | 0.87" | 1.08" | 1.18" | VCG6-8A | 30K | 2 |
| BT40-VC6-90 | VCK6 | GH10 | 90 | 3.54" | 0.87" | 1.08" | 1.29" | VCG6-8A | 30K | 2 |
| BT40-VC6-120 | VCK6 | GH10 | 120 | 4.72" | 0.87" | 1.08" | 1.45" | VCG6-8A | 30K | 2 |
| BT40-VC13-60 | VCK13 | GH16 | 60 | 2.36" | 1.30" | 1.59" | 1.59" | VCG13-15A | 30K | 1 |
| BT40-VC13-90 | VCK13 | GH16 | 90 | 3.54" | 1.10" | 1.59" | 1.75" | VCG13-15A | 30K | 2 |
| BT40-VC13-120 | VCK13 | GH16 | 120 | 4.72" | 1.10" | 1.59" | 1.91" | VCG13-15A | 30K | 2 |

Note: Wrenches are sold separately



Available in **TAPER PLUS+**
Dual-taper and flange contact

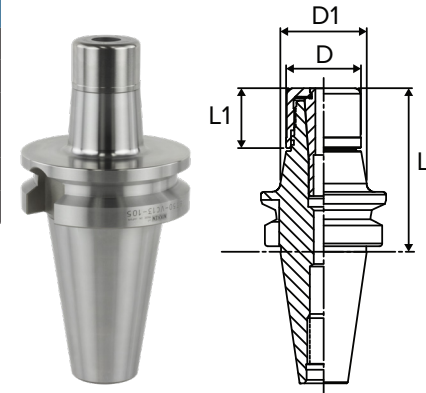


Fig. 4

BT50

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|---------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| BT50-VC6-105 | VCK6 | GH10 | 105 | 4.13" | 0.87" | 1.08" | 1.30" | VCG6-8A | 20K | 2 |
| BT50-VC6-135 | VCK6 | GH10 | 135 | 5.31" | 0.87" | 1.08" | 1.46" | VCG6-8A | 20K | 2 |
| BT50-VC6-165 | VCK6 | GH10 | 165 | 6.50" | 0.87" | 1.08" | 1.63" | VCG6-8A | 20K | 2 |
| BT50-VC13-105 | VCK13 | GH16 | 105 | 4.13" | 1.10" | 1.59" | 1.76" | VCG13-15A | 20K | 2 |
| BT50-VC13-135 | VCK13 | GH16 | 135 | 5.31" | 1.10" | 1.59" | 1.92" | VCG13-15A | 20K | 2 |
| BT50-VC13-165 | VCK13 | GH16 | 165 | 6.50" | 1.10" | 1.59" | 2.09" | VCG13-15A | 20K | 2 |

Note: Wrenches are sold separately



VCK Collets
Page 86



Nut Wrench
Page 88



Back-up Screw
Page 88



Coolant-thru Nut
Page 87

HSK VC COLLET CHUCKS

FEATURES

- TiN Bearing Nut which considerably improves cutting rigidity and finish
- Extra thick body for aggressive milling
- High concentricity and repeatability
- Ideal for high-speed applications



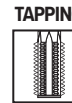
T.I.R.
<0.00012" at 4xD



Speed
Up to 40,000 rpm



Coolant-Thru
Thru-tool coolant



Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

HSK40A

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|------------------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| HSK40A-VC6-65 | VCK6 | GH10 | 65 | 2.56" | 0.87" | 1.08" | 1.32" | VCG6-8A | 40K | 1 |
| HSK40A-VC6-90 | VCK6 | GH10 | 90 | 3.54" | 0.87" | 1.08" | 1.32" | VCG6-8A | 40K | 1 |
| HSK40A-VC13-90 | VCK13 | GH16 | 90 | 3.54" | 2.76" | 1.59" | 1.59" | VCG13-15A | 40K | 2 |
| HSK40A-VC13-120 | VCK13 | GH16 | 120 | 4.72" | 3.94" | 1.59" | 1.59" | VCG13-15A | 40K | 2 |

Note: Wrench, Coolant Tubes and Coolant Tube Wrenches are sold separately. See page 88 for more details.

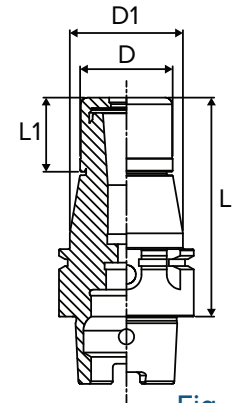


Fig. 5

HSK40E

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|------------------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| HSK40E-VC6-65 | VCK6 | GH10 | 65 | 2.56" | 0.87" | 1.08" | 1.34" | VCG6-8A | 40K | 1 |
| HSK40E-VC6-90 | VCK6 | GH10 | 90 | 3.54" | 0.87" | 1.08" | 1.34" | VCG6-8A | 40K | 1 |
| HSK40E-VC13-90 | VCK13 | GH16 | 90 | 3.54" | 2.76" | 1.59" | 1.59" | VCG13-15A | 40K | 2 |
| HSK40E-VC13-120 | VCK13 | GH16 | 120 | 4.72" | 3.94" | 1.59" | 1.59" | VCG13-15A | 40K | 2 |

Note: Wrench, Coolant Tubes and Coolant Tube Wrenches are sold separately. See page 88 for more details.

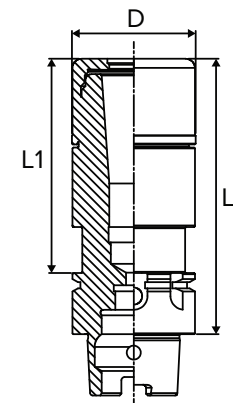


Fig. 6



VCK Collets
Page 86



Nut Wrench
Page 88



Back-up Screw
Page 88



Coolant-thru Nut
Page 87



Coolant Tube
Page 88

VC COLLET CHUCKS



HSK VC COLLET CHUCKS

FEATURES

- TiN Bearing Nut which considerably improves cutting rigidity and finish
- Extra thick body for aggressive milling
- High concentricity and repeatability
- Ideal for high-speed applications



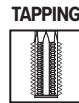
T.I.R.
<0.00012" at 4xD



Speed
Up to 30,000 rpm



Coolant-Thru
Thru-tool coolant



Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

HSK63A

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|--------------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| HSK63A-VC13-90-IDU | VCK13 | GH16 | 90 | 3.54" | 1.10" | 1.59" | 1.75" | VCG13-15A | 30K | 1 |

Note: Wrench, Coolant Tubes and Coolant Tube Wrenches are sold separately. See page 88 for more details.

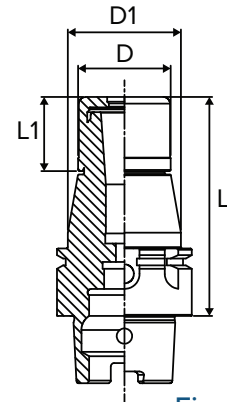


Fig. 5

HSK63F

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|-----------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| HSK63F-VC6-65 | VCK6 | GH10 | 65 | 2.56" | 1.54" | 1.08" | 1.08" | VCG6-8A | 30K | 2 |
| HSK63F-VC6-90 | VCK6 | GH10 | 90 | 3.54" | 0.87" | 1.08" | 1.29" | VCG6-8A | 30K | 1 |
| HSK63F-VC6-120 | VCK6 | GH10 | 120 | 4.72" | 0.87" | 1.08" | 1.46" | VCG6-8A | 30K | 1 |
| HSK63F-VC13-90 | VCK13 | GH16 | 90 | 3.54" | 1.10" | 1.59" | 1.75" | VCG13-15A | 30K | 1 |
| HSK63F-VC13-120 | VCK13 | GH16 | 120 | 4.72" | 1.10" | 1.59" | 1.92" | VCG13-15A | 30K | 1 |

Note: Wrench, Coolant Tubes and Coolant Tube Wrenches are sold separately. See page 88 for more details.

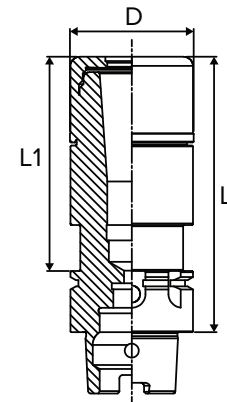


Fig. 6

HSK100A

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|------------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| HSK100A-VC13-105 | VCK13 | GH16 | 105 | 4.13" | 1.10" | 1.59" | 1.81" | VCG6-8A | 20K | 1 |

Note: Wrench, Coolant Tubes and Coolant Tube Wrenches are sold separately. See page 88 for more details.



VCK Collets
Page 86



Nut Wrench
Page 88



Back-up Screw
Page 88

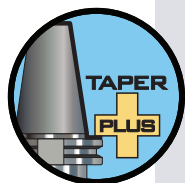


Coolant-thru Nut
Page 87



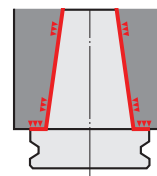
Coolant Tube
Page 88

TAPER PLUS CAT VC COLLET CHUCKS



Taper Plus (Dual Contact) Advantages

- Outstanding runout accuracy for longer tool life
- Vibration dampening for increased productivity
- High rigidity for smooth and stable cutting
- Interchangeable between standard and dual face contact spindles
- 53% more surface area contact than just the taper alone



TAPER PLUS - CAT40

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | L2 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|----------------------|-------------|--------|--------|-------|-------|-------|-------|-------|---------------|----------|------|
| NCAT40-VC6-60U-IDU | VC6 | GH10 | 60 | 2.36" | 0.98" | - | 1.08" | 1.75" | VCG6-8A | 30K | 2 |
| NCAT40-VC6-90U-IDU | VC6 | GH10 | 90 | 3.54" | 0.87" | 2.17" | 1.08" | 1.75" | VCG6-8A | 30K | 1 |
| NCAT40-VC13-60U-IDU | VC13 | GH16 | 60 | 2.36" | 1.14" | - | 1.59" | 1.75" | VCG13-15A | 30K | 2 |
| NCAT40-VC13-90U-IDU | VC13 | GH16 | 90 | 3.54" | 1.10" | 2.39" | 1.59" | 1.75" | VCG13-15A | 30K | 1 |
| NCAT40-VC13-120U-IDU | VC13 | GH16 | 120 | 4.72" | 1.10" | 3.65" | 1.59" | 1.75" | VCG13-15A | 30K | 1 |

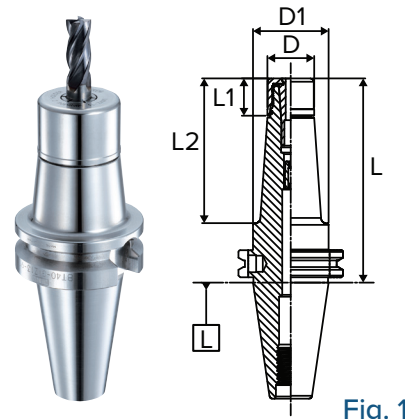


Fig. 1

TAPER PLUS - CAT50

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | L2 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|----------------------|-------------|--------|--------|-------|-------|-------|-------|-------|---------------|----------|------|
| NCAT50-VC6-135U-IDU | VC6 | GH10 | 135 | 5.31" | 0.87" | 3.94" | 1.08" | 2.75" | VCG6-8A | 20K | 1 |
| NCAT50-VC6-165U-IDU | VC6 | GH10 | 165 | 6.50" | 0.87" | 5.12" | 1.08" | 2.75" | VCG6-8A | 20K | 1 |
| NCAT50-VC13-105U-IDU | VC13 | GH16 | 105 | 4.13" | 1.10" | 2.76" | 1.59" | 2.75" | VCG13-15A | 20K | 1 |
| NCAT50-VC13-135U-IDU | VC13 | GH16 | 135 | 5.31" | 1.10" | 3.94" | 1.59" | 2.75" | VCG13-15A | 20K | 1 |
| NCAT50-VC13-165U-IDU | VC13 | GH16 | 165 | 6.50" | 1.10" | 5.12" | 1.59" | 2.75" | VCG13-15A | 20K | 1 |

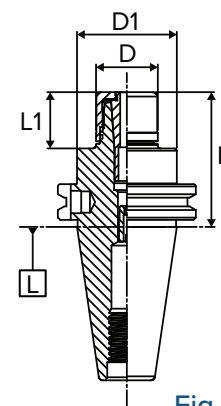


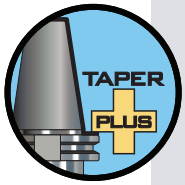
Fig. 2

Taper Plus Toolholders are interchangeable between Standard and Dual Face Contact spindles for greater flexibility!



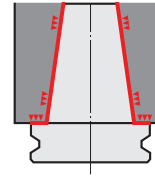
VC COLLET CHUCKS

TAPER PLUS BT VC COLLET CHUCKS



Taper Plus (Dual Contact) Advantages

- Outstanding runout accuracy for longer tool life
- Vibration dampening for increased productivity
- High rigidity for smooth and stable cutting
- Interchangeable between standard and dual face contact spindles
- 53% more surface area contact than just the taper alone



TAPER PLUS - BT30

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|-----------------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| NBT30-VC6-45 | VC6 | GH10 | 45 | 1.77" | 0.91" | 1.08" | 1.08" | VCG6-8A | 40K | 1 |
| NBT30-VC6-60 | VC6 | GH10 | 60 | 2.36" | 0.87" | 1.08" | 1.25" | VCG6-8A | 40K | 2 |
| NBT30-VC6-90 | VC6 | GH10 | 90 | 3.54" | 0.87" | 1.08" | 1.31" | VCG6-8A | 40K | 2 |
| NBT30-VC13-60 | VC13 | GH16 | 60 | 2.36" | 1.10" | 1.59" | 1.62" | VCG13-15A | 40K | 2 |
| NBT30-VC13-90 | VC13 | GH16 | 90 | 3.54" | 1.10" | 1.59" | 1.63" | VCG13-15A | 40K | 2 |
| NBT30-VC13-120 | VC13 | GH16 | 120 | 4.72" | 1.10" | 1.59" | 1.67" | VCG13-15A | 40K | 2 |

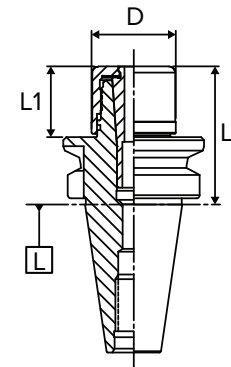


Fig. 3

TAPER PLUS - BT40

| Part Number | Collet Size | Wrench | L (mm) | L | L1 | D | D1 | Back-up Screw | Max. RPM | Fig. |
|-----------------------|-------------|--------|--------|-------|-------|-------|-------|---------------|----------|------|
| NBT40-VC6-60 | VC6 | GH10 | 60 | 2.36" | 0.87" | 1.08" | 1.18" | VCG6-8A | 30K | 2 |
| NBT40-VC6-90 | VC6 | GH10 | 90 | 3.54" | 0.87" | 1.08" | 1.29" | VCG6-8A | 30K | 2 |
| NBT40-VC6-120 | VC6 | GH10 | 120 | 4.72" | 0.87" | 1.08" | 1.45" | VCG6-8A | 30K | 2 |
| NBT40-VC6-150 | VC6 | GH10 | 150 | 5.91" | 0.87" | 1.08" | 1.62" | VCG6-8A | 30K | 2 |
| NBT40-VC13-60 | VC13 | GH16 | 60 | 2.36" | 1.30" | 1.59" | 1.59" | VCG13-15A | 30K | 1 |
| NBT40-VC13-90 | VC13 | GH16 | 90 | 3.54" | 1.10" | 1.59" | 1.75" | VCG13-15A | 30K | 2 |
| NBT40-VC13-120 | VC13 | GH16 | 120 | 4.72" | 1.10" | 1.59" | 1.91" | VCG13-15A | 30K | 2 |
| NBT40-VC13-150 | VC13 | GH16 | 150 | 5.91" | 1.10" | 1.59" | 2.08" | VCG13-15A | 30K | 2 |

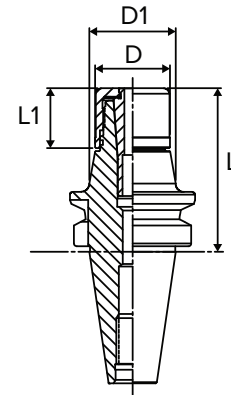


Fig. 4

Taper Plus Toolholders are interchangeable between Standard and Dual Face Contact spindles for greater flexibility!



VCK Collets
Page 86



Nut Wrench
Page 88



Back-up Screw
Page 88

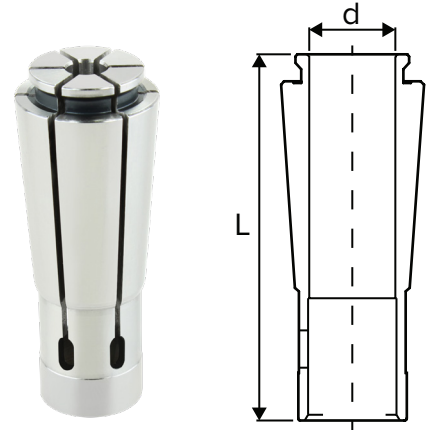


Coolant-thru Nut
Page 87

VCK COLLETS

DIMENSIONAL DATA

| Collet Series | L | Collet Range (d) |
|---------------|-----------------|--------------------------|
| VCK6 | 1.567" (39.8mm) | 1/8" - 1/4" (2mm - 6mm) |
| VCK13 | 2.126" (54mm) | 1/8" - 1/2" (3mm - 12mm) |



VC COLLET CHUCKS

VCK6 COLLETS

Size range: 1/8" - 1/4"

Size range: 2.0 - 6.0mm
(0.079 - 0.236")

VCK13 COLLETS

Size range: 1/8" - 1/2"

Size range: 3 - 12mm
(0.118 - 0.472")

INCH

| Part Number | Size | Collet Series |
|------------------|-------|---------------|
| VCK6-1/8 | 1/8" | VCK6 |
| VCK6-3/16 | 3/16" | VCK6 |
| VCK6-1/4 | 1/4" | VCK6 |

METRIC

| Part Number | Size | Collet Series |
|---------------|-------|---------------|
| VCK6-2 | 2.0mm | VCK6 |
| VCK6-3 | 3.0mm | VCK6 |
| VCK6-4 | 4.0mm | VCK6 |
| VCK6-5 | 5.0mm | VCK6 |
| VCK6-6 | 6.0mm | VCK6 |

INCH

| Part Number | Size | Collet Series |
|-------------------|-------|---------------|
| VCK13-1/8 | 1/8" | VCK13 |
| VCK13-3/16 | 3/16" | VCK13 |
| VCK13-1/4 | 1/4" | VCK13 |
| VCK13-5/16 | 5/16" | VCK13 |
| VCK13-3/8 | 3/8" | VCK13 |
| VCK13-7/16 | 7/16" | VCK13 |
| VCK13-1/2 | 1/2" | VCK13 |

METRIC

| Part Number | Size | Collet Series |
|-----------------|---------|---------------|
| VCK13-3 | 3.0mm | VCK13 |
| VCK13-4 | 4.0mm | VCK13 |
| VCK13-5 | 5.00mm | VCK13 |
| VCK13-6 | 6.00mm | VCK13 |
| VCK13-7 | 7.00mm | VCK13 |
| VCK13-8 | 8.00mm | VCK13 |
| VCK13-9 | 9.00mm | VCK13 |
| VCK13-10 | 10.00mm | VCK13 |
| VCK13-11 | 11.00mm | VCK13 |
| VCK13-12 | 12.00mm | VCK13 |

TIGHTENING TORQUE FOR VC COLLET CHUCKS

| Collet Type | Size | Nut Tightening Torque (ft/lbs) | |
|-------------|-------|--------------------------------|-----------|
| | | < Ø3mm | Ø3 - Ø6mm |
| VC | VCK6 | 7-22 | 22-37 |
| | VCK13 | 29-55 | |



Nut Wrench
Page 88



Back-up Screw
Page 88



Coolant-thru Nut
Page 88

VC COLLET CHUCKS



VC COOLANT COLLET SYSTEM



| Collet Chuck | Collet | Coolant Nut Part Number | Cutting Tool Size | Coolant-Thru Disk Part Number | Slotted Disk Part Number | Disk Wrench Part Number | Blank Disk (Machinable) Part Number |
|--------------|-------------------------------------------|-------------------------|-------------------|-------------------------------|--------------------------|-------------------------|-------------------------------------|
| VC6 | VCK6 Range: 2 - 6mm [1/8" - 1/4"] | VCN-6BJ | 2mm | SKJ10-2C | SKJ10-2 | SKJL-10 | SKJ10-BLANK |
| | | | 3mm | SKJ10-3C | SKJ10-3 | | |
| | | | 4mm | SKJ10-4C | SKJ10-4 | | |
| | | | 5mm | SKJ10-5C | SKJ10-5 | | |
| | | | 6mm | SKJ10-6C | SKJ10-6 | | |
| | | | 1/8" | SKJ10-1/8C | SKJ10-1/8 | | |
| | | | 3/16" | SKJ10-3/16C | SKJ10-3/16 | | |
| | | | 1/4" | SKJ10-1/4C | SKJ10-1/4 | | |
| VC13 | VCK13 Range: 3 - 12mm [1/8" - 1/2"] | VCN-13BJ | 3mm | SKJ16-3C | SKJ16-3 | SKJL-16 | SKJ16-BLANK |
| | | | 4mm | SKJ16-4C | SKJ16-4 | | |
| | | | 5mm | SKJ16-5C | SKJ16-5 | | |
| | | | 6mm | SKJ16-6C | SKJ16-6 | | |
| | | | 7mm | SKJ16-7C | SKJ16-7 | | |
| | | | 8mm | SKJ16-8C | SKJ16-8 | | |
| | | | 10mm | SKJ16-10C | SKJ16-10 | | |
| | | | 12mm | SKJ16-12C | SKJ16-12 | | |
| | | | 1/8" | SKJ16-1/8C | SKJ16-1/8 | | |
| | | | 3/16" | SKJ16-3/16C | SKJ16-3/16 | | |
| | | | 1/4" | SKJ16-1/4C | SKJ16-1/4 | | |
| | | | 5/16" | SKJ16-5/16C | SKJ16-5/16 | | |
| | | | 3/8" | SKJ16-3/8C | SKJ16-3/8 | | |
| | | | 7/16" | SKJ16-7/16C | SKJ16-7/16 | | |
| | | | 1/2" | SKJ16-1/2C | SKJ16-1/2 | | |

VC COLLET CHUCKS



VCK Collets
Page 86



Nut Wrench
Page 88



Back-up Screw
Page 88



Coolant-thru Nut
Page 87

VC COLLET CHUCK ACCESSORIES

VC BACK-UP SCREW

| Part Number | Description |
|------------------|----------------------|
| VC66-8A | Use with VC6 chucks |
| VC613-15A | Use with VC13 chucks |



VC NUTS

| Part Number | Description |
|-----------------|-------------------------------|
| VCN-6B | Standard Nut for VC6 chucks |
| VCN-6BJ | J Coolant Nut for VC6 chucks |
| VCN-13B | Standard Nut for VC13 chucks |
| VCN-13BJ | J Coolant Nut for VC13 chucks |



VC NUT WRENCHES

| Part Number | Description |
|-------------|-------------------|
| GH10 | VC6 Chuck Wrench |
| GH16 | VC13 Chuck Wrench |



TORQUE WRENCH AND ATTACHMENT FOR VC COLLET CHUCK

| Part Number | Description |
|------------------------|------------------------------------------|
| TQW-025 | Torque Wrench for VC6 Collet Chuck Nut |
| TQW-200 | Torque Wrench for VC13 Collet Chuck Nut |
| TQW-GH10(14X18) | VC6 Attachment for TQW-025 Chuck Wrench |
| TQW-GH16 | VC13 Attachment for TQW-200 Chuck Wrench |



COOLANT TUBE WRENCH

| Part Number | Description |
|----------------------|--------------------------------|
| HSK32-WRENCH | Wrench for HSK32 Coolant Tube |
| HSK40-WRENCH | Wrench for HSK40 Coolant Tube |
| HSK50-WRENCH | Wrench for HSK50 Coolant Tube |
| HSK63-WRENCH | Wrench for HSK63 Coolant Tube |
| HSK100-WRENCH | Wrench for HSK100 Coolant Tube |



COOLANT TUBE

| Part Number | Description |
|--------------------|---------------------------------|
| HSK40-TUBE | Coolant Tube for HSK40 holders |
| HSK63-TUBE | Coolant Tube for HSK63 holders |
| HSK100-TUBE | Coolant Tube for HSK100 holders |

