Recommended Maximum Collet Torque Values

Perske Spindle Kval Part Number	Horse Power	Type Collet	Type Nut	Max Torque Value
PERKNS21-05-2400	0.37	ER16	Mini	18 ft/lbs
PERKRS35.1-2D	1.00	ER20	Mini	20 ft/lbs
PERKRS35.5-2D	2.00	ER20	Mini	20 ft/lbs
PERVS503 – 3 HP	3.00	SOYUS 20	Hook	36 ft/lbs
PERKRSV51.14-2D	7.00	SOYUS 25	Hook	90 ft/lbs
HSD Spindle Kval Part Number	**Horse Power**	**Type Collet**	**Type Nut**	**Max Torque Value**
HSDH6161H0992	13.4	HSK-F63	Slotted	130 ft/lbs
A6161H0824 GC90E1683-7.5D HSDY6162Y0019	10.0	ER32	Slotted	100 ft/lbs
HSDY6162Y0071	4.8	ER25	Slotted	77 ft/lbs
HSDY6162Y0003	1.7	ER20	Slotted	59 ft/lbs

Colombo Kval Spindle Part Number	Horse Power	Type Collet	Type Nut	Max Torque Value
COLS55E389-1.5	1.5	ER20	Slotted	59 ft/lbs
COLS73E478-3D	3.0	ER25	Mini	25 ft/lbs
COLS90E810-7.5,D	7.5	ER25	Slotted	77 ft/lbs
GC90E1683-7.5D	7.5	ER32	Slotted	100 ft/lbs
COLS116150-10,D	10.0	ER40	Slotted	130 ft/lbs
COLS63F0020-11D	11.0	ER40	Slotted	130 ft/lbs
COLS135501-12D	12.0	ER40	Slotted	130 ft/lbs

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Hook Nut and Torque Head

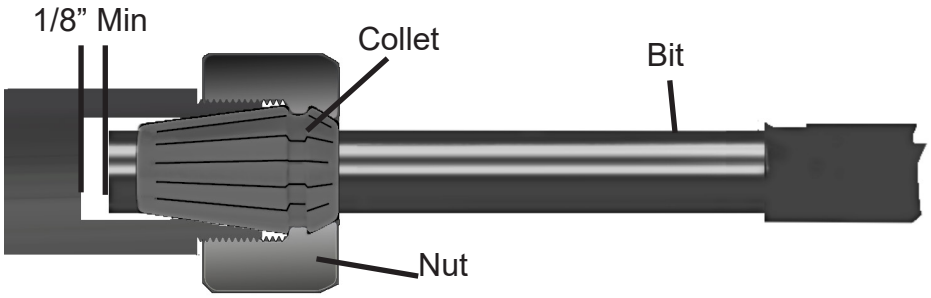
Mini Nut and Torque Head

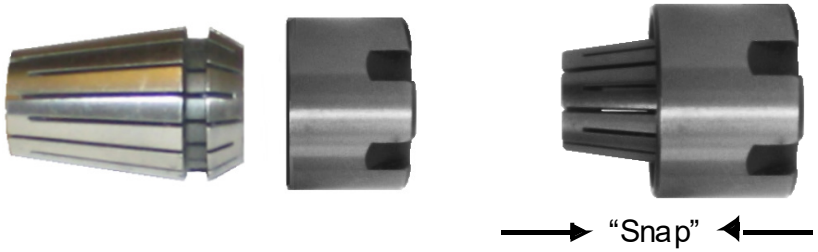
Slotted Nut and Torque Head

Note: Certain torque specifications might be customized for the specific machine and could differ from the recommended values. It is advisable to adhere to the engineered torque values in order to achieve optimal performance.

Tips

- Never use a torque wrench to loosen bolts or nuts
- Always set the torque wrench to zero after using it.
- Ensure a minimum of 1/8” clearance from the end of the bit to the bottom of the tool holder.
- Periodically use compressed air to clean both the nut and collet
- Check the collet for bluing (Overheating) or damage. If it is damaged or over heated , replace it.
- When inserting the collet into the nut , it should “SNAP” in to place.





FACT

Exceeding the torque does not provide more clamping force; it just leads to runout. In fact, the more force is applied, the more the top of the collet wants to twist with the nut. Too much force can actually twist the collet’s top, deforming the collet, which will increase runout and reduce clamping force.