Recommended Maximum Collet Torque Values

	HSD Spindle Kval Part Number	Type Collet	Type Nut	Max Torque Value	Colombo Kval Spindle Part Number	Type Collet	Type Nut	Max Torque Value	
HSD	HSDH6161H0992 HSDH6161H2399 A6161H0328 AH6161H0669	HSK-F63 (Tool Holder)	Slotted	**130 ft-lbs**	COLS55E389-1.5	ER20	Slotted	**59 ft-lbs**	Colombo
	A6161H0824 GC90E1683-7.5D HSDY6162Y0019	ER32	Slotted	**100 ft-lbs**	COLS73E478-3D	ER25	Mini	**25 ft-lbs**	
	HSDY6162Y0071	ER25	Slotted	**77 ft-lbs**	COLS90E810-7.5D	ER25	Slotted	**77 ft-lbs**	
	HSDY6162Y0003	ER20	Slotted	**59 ft-lbs**	GC90E1683-7.5D	ER32	Slotted	**100 ft-lbs**	
	HSDH6162H0127	ER40	Slotted	**130 ft-lbs**	COLS116150-10D	ER40	Slotted	**130 ft-lbs**	
Perske	**Perske Spindle Kval Part Number**	**Type Collet**	**Type Nut**	**Max Torque Value**	COLS63F0020-11D	ER40	Slotted	**130 ft-lbs**	
	PERKNS21-05-2400	ER16	Mini	**18 ft-lbs**	COLS135501-12D	ER40	Slotted	**130 ft-lbs**	
	PERKRS35.1-2D	ER20	Mini	**20 ft-lbs**					
	PERKRS35.5-2D	ER20	Mini	**20 ft-lbs**					
	PERVS503 – 3 HP	SOYUS 20	Hook	**36 ft-lbs**					
	PERKRSV51.14-2D	SOYUS 25	Hook	**90 ft-lbs**					

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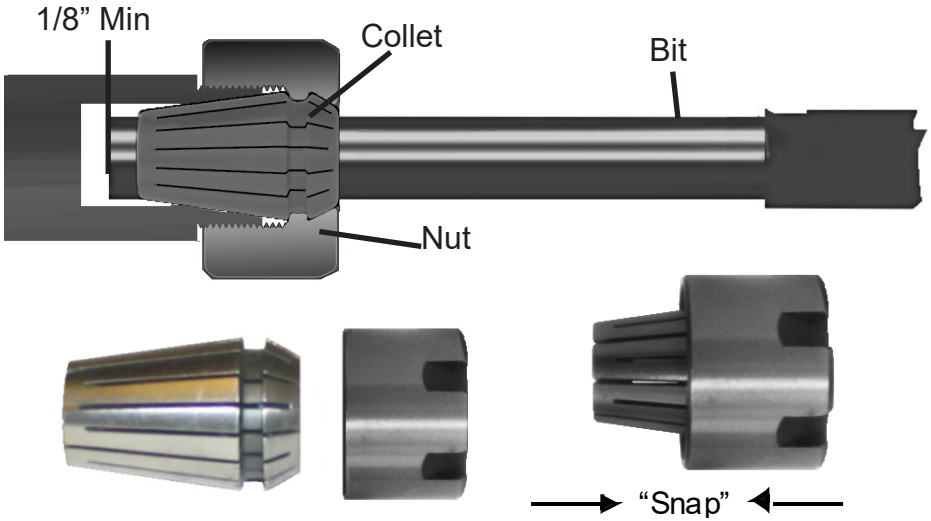
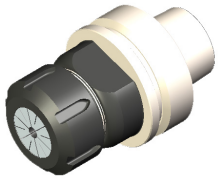
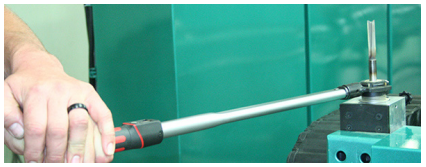
Note: Certain torque specifications might be customized for the specific machine and could differ from the recommended values. It is advisable to adhere to the engineered torque values in order to achieve optimal performance.

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.
* 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.



HSK Tool Holder and Torque Head

Hook Nut and Torque Head


Mini Nut and Torque Head


Slotted Nut and Torque Head


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.

EX-LRN-MD-0003 Collet Torque Values