

Recommended tightening torque

for ER clamping nuts

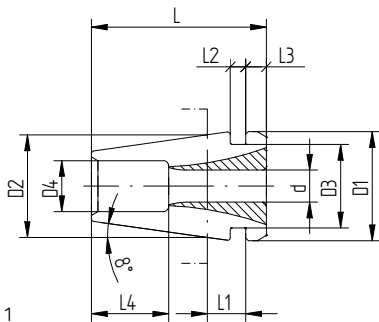
			Hi-Q®/ER clamping nuts											
			ER/ERC		ERB/ERBC		ERM/ERMC		ERMx/ERMxC		ERAX/ERAXC		ER MS	
			Collets [Nm]										Collets [Nm]	
Collet size	Ø [mm]	Ø [inch]	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	
ER 8 MB	0.2–0.9	0.0078–0.035	–	–	–	–	6	–	6	–	–	–	6	0
ER 8	1.0–5.0	0.039–0.196	–	–	–	–	6	–	6	–	–	–	6	0
ER 11 MB	0.2–0.9	0.0078–0.035	8	–	–	–	8	–	8	–	8	–	8	0, I
ER 11	1.0–2.9	0.039–0.098	8	8	–	–	8	8	8	8	8	8	10	0, I
	3.0–7.0	0.118–0.256	24	16	–	–	16	13	16	13	24	21	10	0, I
ER 16 MB	0.2–0.9	0.0078–0.035	8	–	–	–	8	–	8	–	8	–	12	0, I
ER 16	1.0	0.039	8	–	6.4	–	8	–	8	–	8	–	12	0, I
	1.5–3.5	0.059–0.138	20	–	16	–	20	–	20	–	20	–	20	0, I
	4.0–4.5	0.157–0.177	40	40	32	32	24	–	24	–	40	40	20	I, II
	5.0–10.0	0.197–0.394	56	44	56	44	24	–	24	–	40	40	–	II
ER 20	1.0	0.039	16	–	12	–	16	–	16	–	16	–	12	0, I
	1.5–6.5	0.059–0.256	32	32	24	24	28	28	28	28	52	35	18.4	I, II
	7.0–13.0	0.276–0.512	80	35	80	24	28	28	28	28	52	35	18.4	I, II
ER 25	1.0–3.5	0.059–0.138	24	–	20	–	24	–	24	–	24	–	–	I, II
	4.0–4.5	0.157–0.177	56	56	48	48	32	32	32	32	56	56	–	I, II
	5.0–7.5	0.196–0.295	80	80	72	72	32	32	32	32	80	80	–	II, III
	8.0–17.0	0.315–0.669	104	80	104	79	32	32	32	32	80	80	–	II, III
ER 32	2.0–2.5	0.078–0.098	24	24	20	–	–	–	–	–	24	–	–	I, II
	3.0–7.5	0.118–0.291	136	136	128	90	–	–	–	–	104	90	–	II, III
	8.0–22.0	0.315–0.787	136	136	136	90	–	–	–	–	104	90	–	II, III
ER 40	3.0–26.0	0.118–1.023	176	176	176	176	–	–	–	–	128	128	–	II, III
ER 50	6.0–36.0	0.236–1.417	240	300	240	300	–	–	–	–	–	–	–	III

* Includes ER standard and ER-UP.

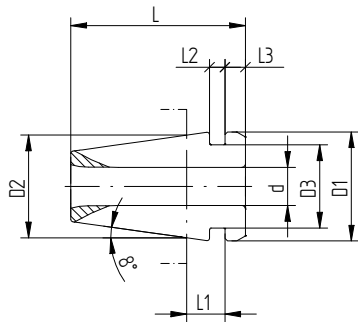
for socoje clamping nuts

			socoje® clamping nuts				
			MR / MRC		MRM / MRMC		
			socoje® collets [Nm]				
Collet size	Ø [mm]	Ø [inch]	MR	MRC	MRM	MRMC	TORCO-FIX
MR 11	1.0–2.9	0.039–0.098	8	8	–	–	0, I
	3.0–7.0	0.118–0.256	16	16	–	–	0, I
MR 16	1.0	0.039	8	8	8	8	0, I
	1.5–3.5	0.059–0.138	20	20	20	20	0, I
	4.0–4.5	0.157–0.177	40	40	24	24	I, II
	5.0–10.0	0.197–0.394	56	56	24	24	I, II
MR 25	1.0–3.5	0.059–0.138	24	24	–	–	I
	4.0–4.5	0.157–0.177	56	56	–	–	I, II
	5.0–7.5	0.196–0.295	80	80	–	–	II, III
	8.0–17.0	0.315–0.669	104	80	–	–	II, III
MR 32	2.0–2.5	0.078–0.098	24	24	–	–	0, I
	3.0–22.0	0.118–0.2917	136	136	–	–	II, III

Size [mm]			Measurements [mm]								Drawing
D2	d	D1	D2	D3	D4	L	L1	L2	L3	L4	
MR 11	1.0 – 2.0	11.5	11	9.5	5	18	3.8	2	2.5	9	1
MR 11	3.0 – 6.35	11.5	11	9.5	–	18	3.8	2	2.5	–	2
MR 16	1.0	17	16	13.8	7.5	27.5	6.26	2.7	4	13	1
MR 16	2.0 – 4.0	17	16	13.8	7.5	27.5	6.26	2.7	4	10	1
MR 16	5.0 – 10.0	17	16	13.8	–	27.5	6.25	2.7	4	–	2
MR 25	1.0	26	25	22	12	34	6.66	3.1	5	18	1
MR 25	2.0 – 6.35	26	25	22	12	34	6.66	3.1	5	15	1
MR 25	8.0 – 16.0	26	25	22	–	34	6.66	3.1	5	–	2
MR 32	2.0 – 4.0	33	32	29.2	15	40	7.2	3.6	5.5	20	1
MR 32	5.0 – 6.35	33	32	29.2	15	40	7.2	3.6	5.5	15	1
MR 32	8.0 – 20.0	33	32	29.2	–	40	7.2	3.6	5.5	–	2



Drawing No 1



Drawing No 2

Increase collet and tool life

Optimize your surface finishes and extend tool life by minimizing occurring vibrations during machining.

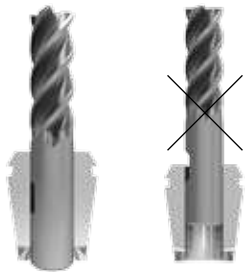
Always assemble correctly

First, clip the collet in the nut. Second, insert the tool shank more than $\frac{2}{3}$ into the collet.

1.



2.



Listen to the click

Do not tighten the torque wrench further after the first click is heard.



Get your TORCO-FIX.

Only use REGO-FIX wrenches

To mount the collet in the toolholder please use one of these special wrenches. Preferably the torque wrench, as they display the amount of applied force.



Regular wrenches can also be used. Be aware that only the torque wrench will display the exact amount of applied force, making it the most exact tool to mount collets professionally.

Never use any extensions nor hammers

