

## The optimum holder choices for a variety of applications!!



**CTA**



**CTH**  
For high-speed

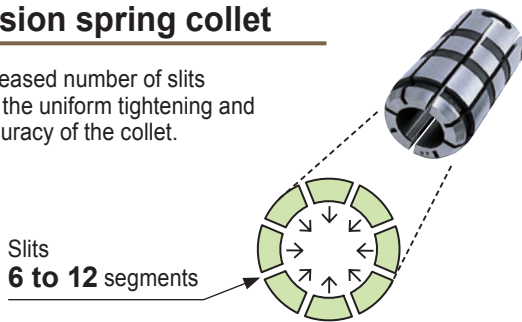
Coolant-through



Coolant-Through Cutter  
"SUKIMA" Coolant Around Tool  
Coolant-Through Collet

### Precision spring collet

The increased number of slits ensures the uniform tightening and high accuracy of the collet.



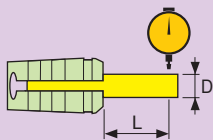
Slits  
6 to 12 segments

Using a high-precision collet will increase the life of your tools. P. 117

**Highest guaranteed accuracies throughout entire chucking range (100% inspection)**

Collet	Run-out accuracy(μm)
Precision Collet	5
Standard Collet	10

※Accuracy of collet alone

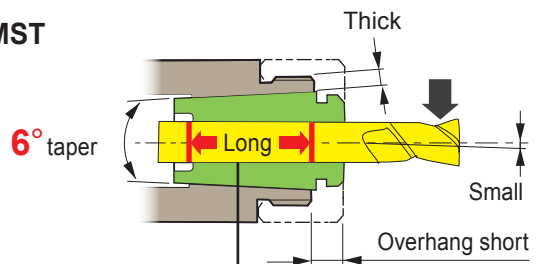


D	L
~10	4×D
10 ~20	40
20.5~42	60

### Ideal taper angle

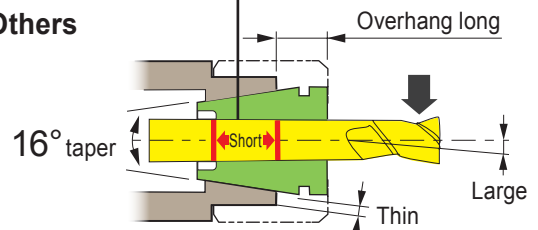
Since the collet angle is smaller than that of typical collets, the collapsibility is also small. However, because the collet can be inserted deeper into the main body, the gripping area increases, it provides stable run-out accuracy and high gripping force and rigidity for end milling. This collet as a taper angle of 6°, the ideal angle for run-out accuracy, gripping force and rigidity.

**MST**



**True clamping length**  
When the taper angle decreases, the collapsibility decreases; however, the true clamping length increases.

**Others**



JIG

Measuring Equipment

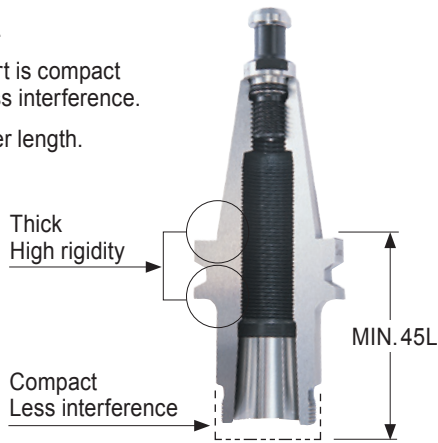
Maintenance Tool

Wire EDM fixture

Technical Information

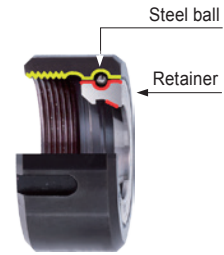
## Thick and highly rigid body

- Thick body.
- The nut part is compact and has less interference.
- Short holder length.

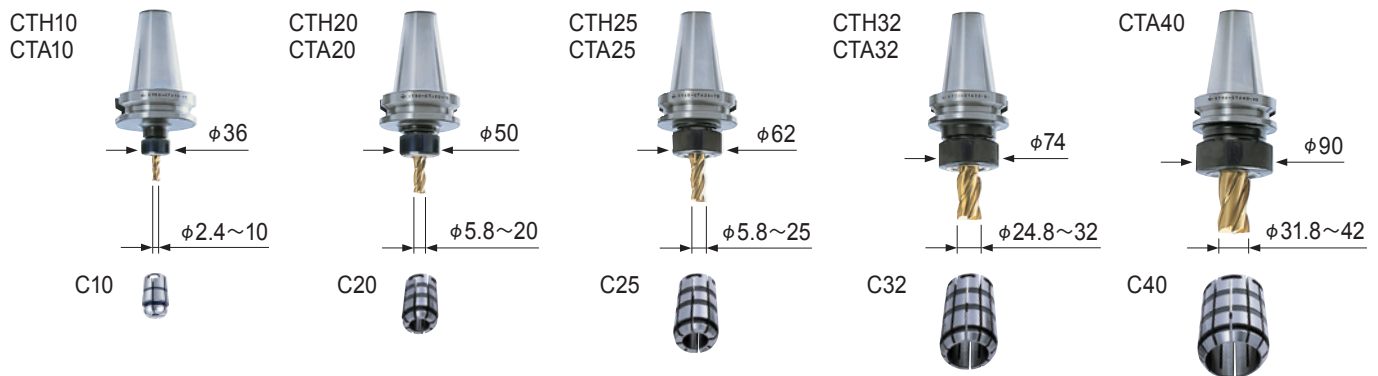


## Nut for high accuracy

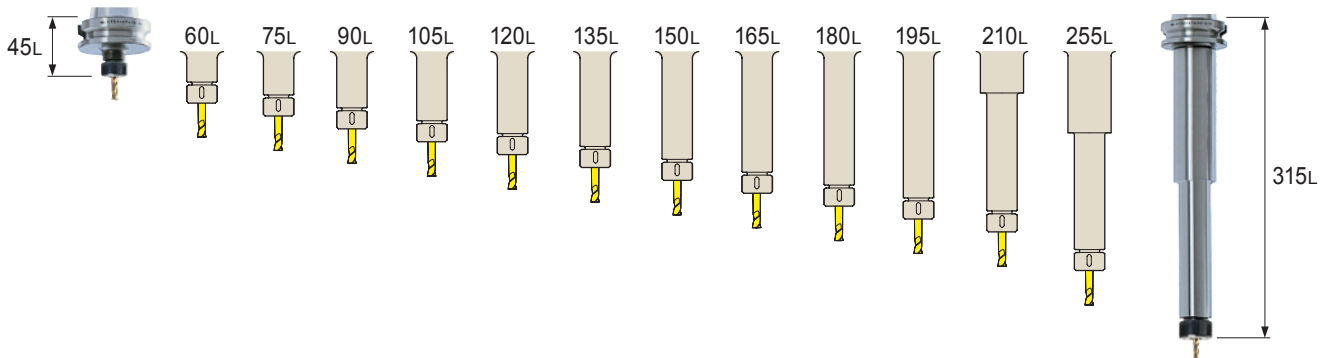
- Because steel ball bearings are built into the nut, the collet does not get twisted when tightened.
- The threaded area and the ball bearing grooves for steel bearings are finished using the same process after heat treatment, thus providing high accuracy with no distortion.
- Stable tightening force and smoothly rotation achieve high accuracy.



## Five main body types based on cutting tool size

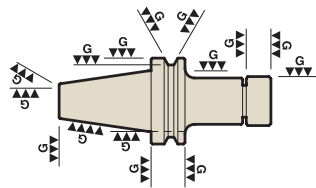


## A variety of holder lengths 45L~315L



## Pre-balanced by previously designing (CTH<sub>type</sub>)

The collet holder (CTH type) is pre-balanced by previously designing the holder to be as axisymmetrical as possible. When used with the precision collet, it enables stable machining during high-speed machining.



## Comparison in imbalance value

Holder code	Spring collet used	Cutter used		Imbalance value (g·mm)
		Diameter	Overhang	
BT30-CTH10-75	Precision collet C10-10-P	φ10	40	3.3
-CTA10-75	Standard collet C10-10			13.1

Longer cutter life using through-spindle capability  
➔ P. 117

## Coolant-through system

The spindle-through feature can be used whether the cutting tool has oil holes or not. ➔ P. 39

Pressure  
**7 Mpa**

Coolant-Through Cutter



“SUKIMA” Coolant Around Tool



Coolant-Through Collet

