



An ISO 9001:2015  
Certified Company

# tecnicrafts®

Precisely Crafted. To Inspire Trust

- Guide Bushings
- Main Spindle Collets
- Sub - Spindle Collets
- Carbide Lined Collets
- Special Collets
- Bar Feed Collets



## High Precision Collets & Guide Bushes

For Swiss Type CNC Automatic Lathes

Version 19.0.1

# Machines - Maschinen - Machine

**CITIZEN**  
Micro HumanTech

**Cincom**

**Miyano**

**star**

**TORNOS**

**NEXTURN**  
SWISS TURN LEADER

**TSUGAMI**

**Hanwha**

**DOOSAN**

**NOMURA**

**MAIER**

**INDEX**  
**TRAUB**

**GILDEMEISTER**



**POLY GIM**

**MANURHIN KMX**

**HARDINGE**

**JF CNC**  
Machine  
**JINN FA**

THE ULTIMATE MACHINING POWER  
**WOODWAY**

**Strohm**

*Petermann*

*André Bechler SA*  
*Moutier*

**EWAG**

**ANCA**

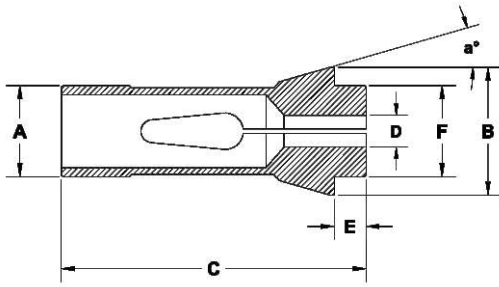
**ROLLOMATIC**

# Tecnicrafts Industries

Manufacturers of  
Hi-Precision Collets, Carbide Lined Guide Bushes  
for Swiss type Automatic Lathes



CITIZEN-CINCOM, TSUGAMI, STAR, TORNOS, TORNOS-DECO, TORNOS-DELTA,  
GILDEMEISTER, HARDINGE, HANWHA, INDEX, NEXTURN, MAIER,  
MANURHIN-KMX, MIYANO, NOMURA, POLYGIM, TRAUB, BECHET, BECHLER,  
PETERMAN, STROHM, GAUTHIER, GOODWAY, JIN-FA.

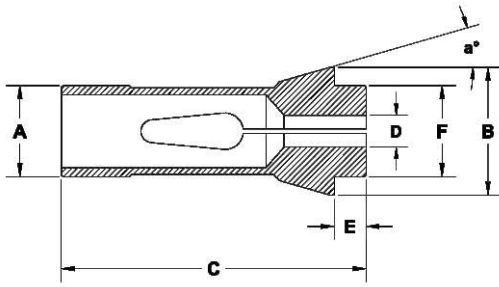


## F - TYPE WITH STRAIGHT SHOULDER

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity		
							Round	Hexagon	Square
							●	⬡	■
	ØA	ØB	C	E	ØF	a°			
SF7/66	7	10.7	26	2.9	7	15°	4.5	3	3
SF7/206	7	10.5	26	3	7	15°	4.5	3	3
SF8/577	8	12	42	4.5	8	16°	5.5	4	3
SF8/1079	8	12	41	3.5	8	16°	4.5	3	3
SF10/86	10	15.5	47.5	5.5	10	20°	7	5	4
SF10/1178	10	16	46	4	10	20°	7	5	4
SF10/9054	10	16	47	5	10	20°	7	6	5
SF10/9096	10	15	43	5	10	15°	6.5	5	4
SF12/78	12	18.1	44.5	4.3	12	15°	8	6	5
SF12/578	12	18	64	6	12	16°	8	6	5
SF13/357	13	19	64	6	13	16°	10	8	7
SF14/98	14	18	46	4	14	13°	10	8	7
SF15/358	15	22	47	5	15	20°	10.5	9	7
SF15/580	15	21	64	6	15	16°	11	9	8
SF15/9005	15	20	45.5	2.5	15	15°	10	8	7
SF15/9012	15	21	64	6	17.5	16°	11.5	9	8
SF16/104	16	22	55	5	16	15°	12	10	8
SF16/1076	16	21	64	6	16	16°	12	10	8
SF16/9070	16	21	62	4	16	16°	12	10	8
SF16/9098	16	21	62	4	16	16°	12	10	8

\* table to be continued

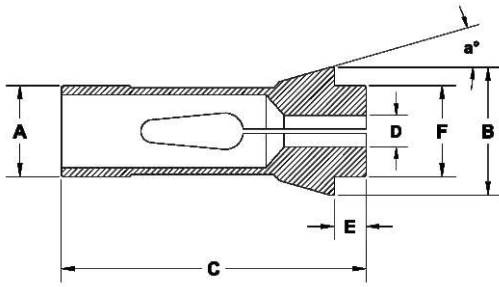


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All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity		
							Round	Hexagon	Square
							●	⬡	■
	ØA	ØB	C	E	ØF	a°			
SF18/85	18	25	67	7	19.5	15°	14	11	9
SF20/87	20	28	67	7	21	16°	16	13	11
SF 20/102	20	27.5	60	5	20	15°	16	13	11
SF 20/201	20	26	54	5	19	15°	16	13	11
SF 20/9026	20	26	67	3	19	16°	16	13	11
SF 22/727	22	32	66	7	25	16°	17	15	12
SF 23.8/9020	23.8	28	62	7	22	15°	18	15	12
SF24/9003	24	28	62	7	22	15°	17	15	12
SF25/64	25	35	77	10	27	16°	20	17	14
SF 25/91	25	34	65	6	25	15°	20	17	14
SF25/9015	25	35	85	18	27	16°	20	17	14
SF25/9091	25	35	72	5	27	16°	20	17	14
SF26/90	26	32	67	7	27.5	13°	20.5	17	14
SF26/9021	26	36	67	7	28	15°	20.5	17	14
SF27/22	27	38	72.7	8	30	15°	23	19	16
SF28/93	28	38	70	7	28	15°	23	19	16
SF28/9004	28	35	77	10	27.5	16°	22.5	19	16
SF30/63	30	42	80	10	34	16°	25	21	17
SF30/101	30	38	65	6	32	15°	25	21	17
SF30/9044	30	42	80	12	32	16°	25	22	18

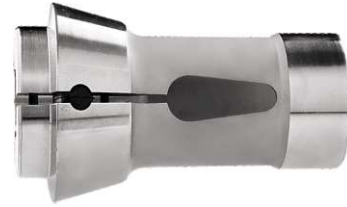
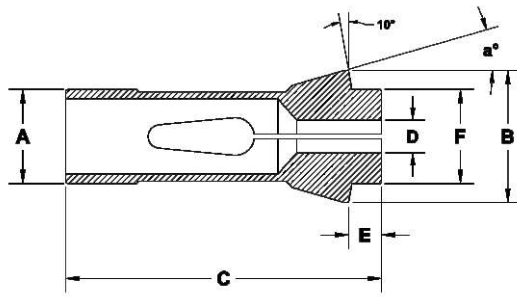
\* table to be continued



## F - TYPE WITH STRAIGHT SHOULDER

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity		
							Round	Hexagon	Square
							●	⬡	■
SF30/9066	30	42	78	10	32	16°	25	22	18
SF32/1023	32	40	65	6	34	15°	26	22	18
SF33/9043	33	40	80	12	32	16°	28	24	20
SF37/740	37	47	92	10	40	16°	32	27	22
SF40/9074	40	50	92	10	43	16°	35	30	24
SF44/9082	44	52	92	10	44	16°30'	38	32	27
SF44.4/9061	44.4	54.5	64	8.5	42	15°	37	31	26



## F - TYPE WITH TAPERED SHOULDER

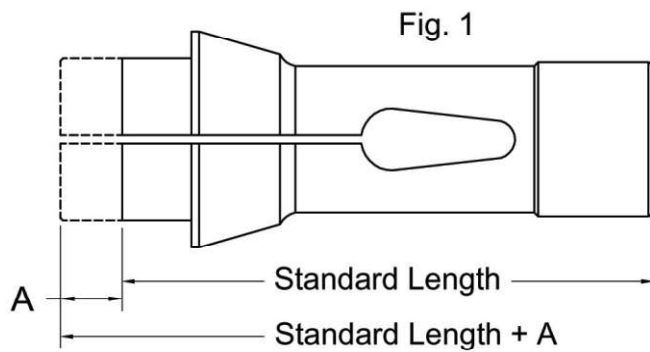
All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Nose Length	Nose Dia	Angle	Capacity		
							Round	Hexagon	Square
							●	⬡	■
	ØA	ØB	C	E	ØF	a°			
SF17.46/79	17.46	22	51	5	16	15°	13.5	11	9
SF22/71	22	30	55	6	21	15°	16.5	14	11
SF32/221	32	45	75	8	34	15°	26	22	18
SF35/94	35	48	80	8	38	15°	30	25	21
SF37/9087	37	44	91	5.7	38	16°	32	27	22
SF38/72	38.08	49	107.5	9	38	15°	32	27	22
SF42/99	42	55	94	9	42	15°	36	30	25
SF43/37	43	53	92	10	46	16°	38	33	27
SF43/9078	43	53	92	10	42	15°	35	30	25
SF48/38	48	54	100	10	44	15°	39	34	28
SF48/81	48	60	94	9	50	15°	42	36	29
SF48/9079	48	54	100	10	44	15°	41	35	29
SF58/355	58	70	94	9	60	15°	51	44	36
SF58/9046	58	70	94	9	60	15°	51	44	36
SF66/359	66	84	110	9	73	15°	59	48	39

## Ordering Information for Extended Nose Collets / Guide Bush

<b>Machine Make &amp; Model</b>	
<b>Collet Part Number</b>	

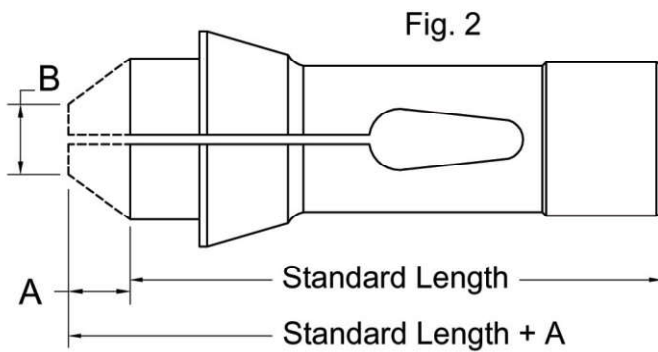
### Collets - Extended Nose



#### Straight Nose Extended Nose Collet

A : \_\_\_\_\_

Bore Dia : \_\_\_\_\_



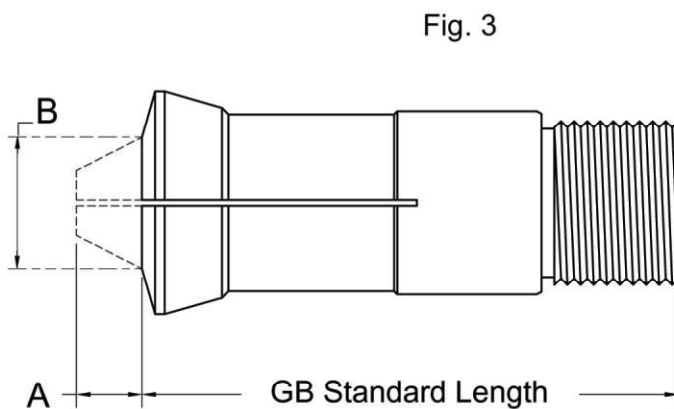
#### Tapered Nose Extended Nose Collet

A : \_\_\_\_\_

B : \_\_\_\_\_

Bore Dia : \_\_\_\_\_

### Guide Bush - Extended Nose

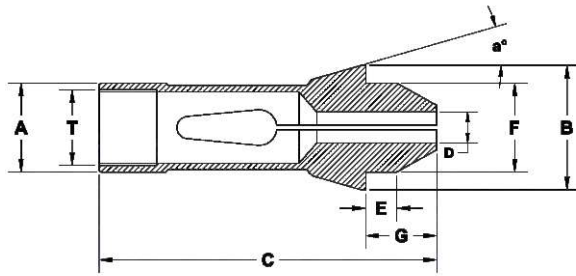


#### Extended Nose Guide Bush

A : \_\_\_\_\_

B : \_\_\_\_\_

Bore Dia : \_\_\_\_\_

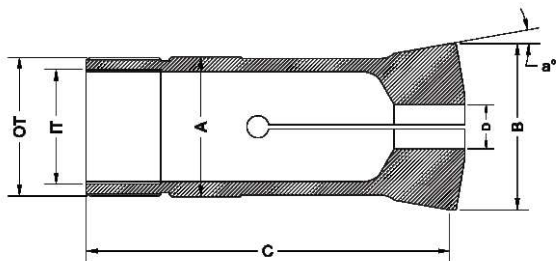


## LONG NOSE COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Total Nose Length	Std Nose Length	Nose Dia	Angle	Thread	Capacity		
									Round	Hexagon	Square
									●	⬡	■
ØA	ØB	C	G	E	ØF	a°	T	●	⬡	■	
SF13/2014	13	19	70	12	6	13	16°	M11x0.75	9.5	8	6
SF16/830	16	21	66	8	6	16	16°	M14x0.75	12.5	10	8
SF16/2015	16	21	71	13	6	16	16°	M14x0.75	12.5	10	8
SF20/2016	20	26	62	13	5	19	15°	M18x1	15.5	13	11
SF25/2018	25	35	85	18	9	27	16°	M22x1	20	17	14

## 5C / 16C Collets

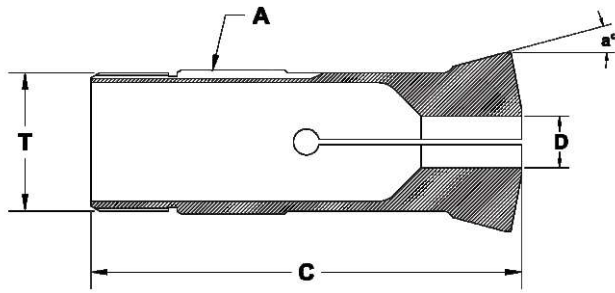


## SPECIAL COLLETS - 5C / 16C COLLETS

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	OD Thread	ID Thread	Angle	Capacity		
							Round	Hexagon	Square
							●	⬡	■
ØA	ØB	C	OT	IT	a°	●	⬡	■	
5C	1.25"(31.75)	1.484"(37.70)	3.268"(83.0)	1.238"x20TPI	1.041"x24TPI	10°	25	21	17
16C	1.889"(48.0)	2.260"(57.40)	4.291"(109.5)	1.870"x1.75	1.687"x20TPI	10°	41	35	29

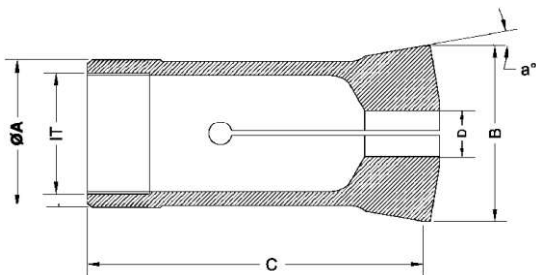
# Collet with External Thread



## COLLETS WITH EXTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Total Length	OD Thread	Angle	Capacity		
					Round	Hexagon	Square
	ØA	C	T	a°	●	⬡	■
SF19/9018	19.05	77	M18.3 x 1.2	15°	13.5	11	9
SF33/9017	33	100	M32 x 1.5	15°	27.0	23	19
359E	23	93.8	Tr 23 x 1.5	20°	18.0	15	12
363E	25	89	M23 x 1	16°	18.0	15	12
366E	28	106.5	Tr 27 x 20TPI	18°30'	21.0	17	14
367E	28	104.4	Tr 28 x 1.5	20°	22.0	19	15
386E	32	115	Tr 32 x 1.5	20°	27.0	23	19
390E	47	115	Tr 47 x 1.5	20°	38.0	32	26

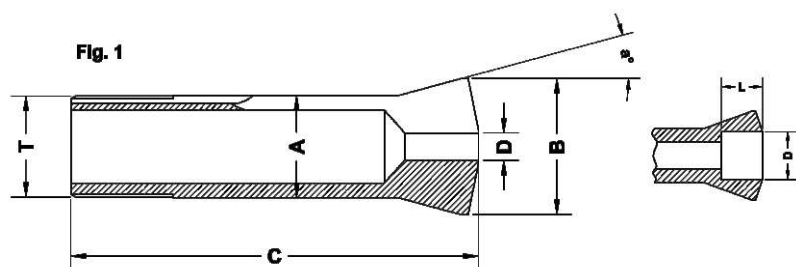


## COLLETS WITH INTERNAL THREAD

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	ID Thread	Angle	Capacity		
						Round	Hexagon	Square
	ØA	ØB	C	IT	a°	●	⬡	■
SF30/9019	30	38	75	M25X1.5	15°	22.5	19	16
TI-58/01	58	70	105	M50X1.5	15°	41	35	29

# W - Type Collet

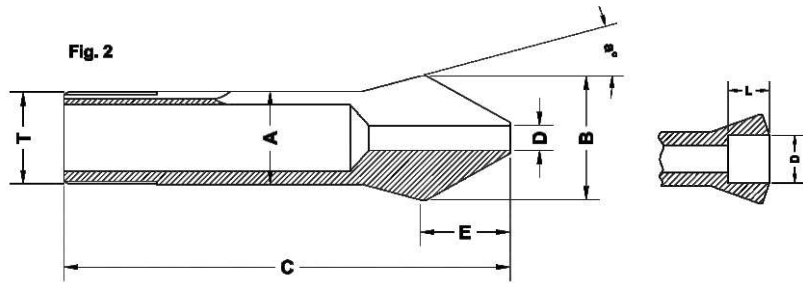


## W - TYPE COLLETS

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Thread	Nose Length	Angle	Figure	Length	Capacity
									D
									Min - Max
ØA	ØB	C	T	E	a°	L			
SW10/001	10	14	43.6	Ø9.83x0.833 <) 45°/5°	-	15°	1	-	1.00...6.70
								15	6.71...8.00
								6	8.01...8.50
								5	8.51...9.00
								4	9.01...9.50
3	9.51...10.00								
SW12/002	12	16	46	Ø11.75x1.25 <) 45°/5°	-	15°	1	-	1.00...8.00
								17	8.01...10.00
								6	10.01...10.50
								5	10.51...11.00
								4	11.01...11.50
								3	11.51...12.00
SW12/93108	12	16	52	Ø11.75x1.25 <) 45°/5°	8.8	15°	2	-	1.00...8.00
								24	8.01...10.00
SW15/003	15	20.2	58.3	Ø14.75x1.25 <) 45°/5°	-	15°	1	-	1.00...10.70
								22	10.71...12.70
								9.5	12.71...13.00
								8.5	13.01...13.50
								7.5	13.51...14.00
								6.5	14.01...14.50
								5.5	14.51...15.00
								4.5	15.01...15.50
3.5	15.51...16.00								
SW15/93285	15	20.2	67	Ø14.75x1.25 <) 45°/5°	12	15°	2	-	1.00...10.20
								22	10.21...12.70
SW20/004	20	26.3	73	Ø19.7x1.666 <) 45°/5°	-	15°	1	-	1.00...14.50
								28	14.51...16.00
								13.5	16.01...16.50
								13	16.51...17.00
								12.2	17.01...17.50
								11.5	17.51...18.00
								10.7	18.01...18.50
								10	18.51...19.00
								8.7	19.01...19.50

# W - Type Collet

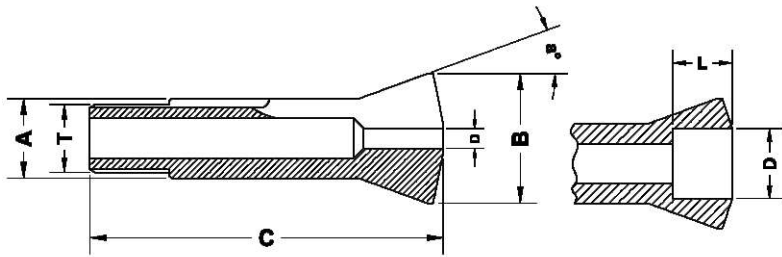


## W - TYPE COLLETS

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total Length	Thread	Nose Length	Angle	Figure	Length	Capacity
									D
									Min - Max
$\varnothing A$	$\varnothing B$	C	T	E	$\alpha^\circ$	L			
SW20/004	20	26.3	73	$\varnothing 19.7 \times 1.666 (<) 45^\circ/5^\circ$	-	$15^\circ$	1	7.5	19.51...20.00
								6.5	20.01...20.50
								5.5	20.51...21.00
								4.7	21.01...21.50
								4	21.51...22.00
								3	22.01...22.50
								2	22.51...23.00
SW20/92744	20	26.3	84.5	$\varnothing 19.7 \times 1.666 (<) 45^\circ/5^\circ$	15.5	$15^\circ$	2	-	1.00...13.00
								41	13.01...16.00
SW25/005	25	33.7	97.6	$\varnothing 24.7 \times 15f" (<) 45^\circ/5^\circ$	-	$15^\circ$	1	-	1.00...19.05
								35	19.06...21.00
								16.5	21.01...21.50
								16	21.51...22.00
								15.7	22.01...22.50
								15.5	22.51...23.00
								15	23.01...23.50
								14.5	23.51...24.00
								13.5	24.01...24.50
								12.5	24.51...25.00
								11.5	25.01...25.50
								10.5	25.51...26.00
								9.5	26.01...26.50
								8.5	26.51...27.00
7.5	27.01...27.50								
6.5	27.51...28.00								
5.5	28.01...28.50								
4.5	28.51...29.00								
SW25/92872	25	33.7	112.2	$\varnothing 24.7 \times 15f" (<) 45^\circ/5^\circ$	19.7	$15^\circ$	2	-	1.00...19.05
								50	19.06...21.00
SW31.75/842	31.75	37.4	87	$\varnothing 31.4 \times 20f" (<) 60^\circ$	-	$10^\circ 3'$	1	-	1.00...25.19
								40	25.20...27.99
								10	28.00...28.99
								7	29.00...29.99
								4	30.00...31.00

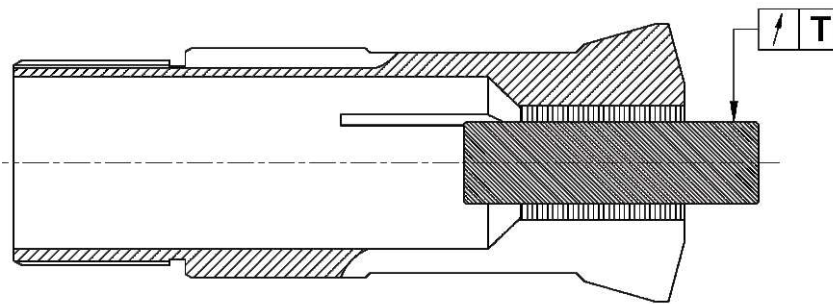
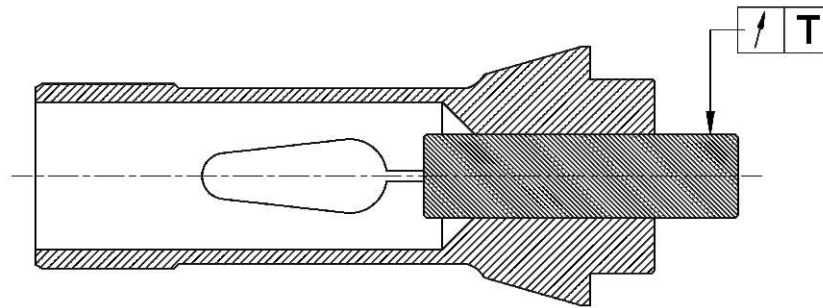
# B - Type Collet



## B - TYPE COLLETS

All Dimension are in mm - Unless Otherwise Specified

Part Nr.	Guiding Dia	Major Dia	Total length	Thread	Angle	Length	Capacity
							D
							Min - Max
ØA	ØB	C	T	a°	L	ØD	
SB6/128	6	10.5	31.3	Ø5x36f" <) 55°	20°	-	1.00...3.00
						12	3.01...4.50
						4.5	4.51...5.00
						4	5.01...5.50
						3.5	5.51...6.00
SB8/137	8	13	35.5	Ø6.82x0.625 <) 55°	20°	-	1.00...4.00
						12.5	4.01...6.50
						6	6.51...7.00
						5	7.01...7.50
						4	7.51...8.00
						3.2	8.01...8.50
						2.5	8.51...9.00
						1.7	9.01...9.50
1	9.51...10.00						
SB15/139	15	21	55	M13 x 1	20°	-	1.00...9.50
						20	9.51...12.50
						8.5	12.51...13.00
						7.7	13.01...13.50
						7	13.51...14.00
						6.5	14.01...14.50
6	14.51...15.00						
SB32/55	32	40	102	M30 x 1.5	15°	-	1.00...24.00
						44	24.01...28.00
						12	28.01...30.00
						8	30.01...32.00
SB32/65	32	40	106	Ø29.7x15f" <) 45°/5°	15°	-	1.00...24.00
						44	24.01...28.00
						12	28.01...30.00
						8	30.01...32.00
SB45/199	45	53	115	M42 x 1.5	15°	-	1.00...36.00
						53	36.01...40.99
						14	41.00...41.99
						12	42.00...42.99
						10	43.00...43.99
8	44.00...45.00						



## Run Out Tolerance

All Dimension are in mm - Unless Otherwise Specified

Bore Size	Round Bores ( T Maximum )		Hex. / Sq. Bores ( T Maximum )	
	Standard Precision	Ultra Precision	Standard Precision	Ultra Precision
1.00 - 10.00	0.010	0.005	0.060	0.030
10.01 - 20.00	0.015	0.008	0.060	0.040
20.01 - 30.00	0.020	0.010	0.060	0.040
30.01 - 40.00	0.025	0.012	0.060	0.040

The Specification / Dimension Contained in this catalogue are subject to change without notice.