



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.



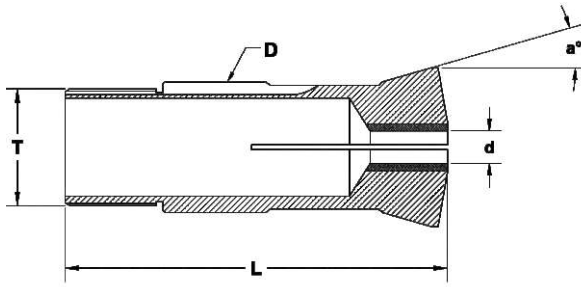
Standard Guide Bush

Max Land Guide Bushing

Guide Bush with Extended Carbide Insert (Max Land Guide Bushing)

- Guiding surface length up to 70mm
- Bore Diameter from 4mm to 42mm
- Guiding surface length will vary depending on bore diameter and guide bush model
- Suitable for components which require long drawing back like chasing a long thread
- High concentricity
- Extended carbide insert ensures improved guidance of component
- Prevents slippage of component from the carbide guide

Carbide Lined Guide Bushing - Drawn Type



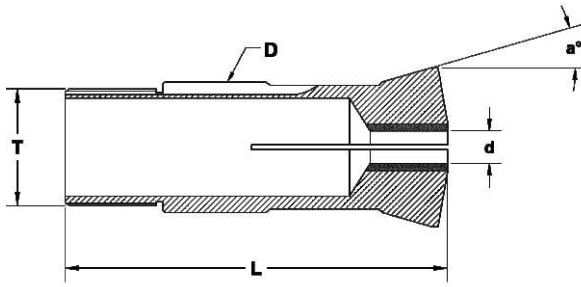
CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

| Part Nr. | Guiding Dia | Total Length | Thread | Angle | Capacity | | |
|----------|-------------|--------------|----------|--------|----------|---------|--------|
| | | | | | Round | Hexagon | Square |
| | | | | | ● | ⬡ | ■ |
| ØD | L | T | a° | | | | |
| R7/02 | 7 | 30 | M6x0.5 | 16° | 3.5 | - | - |
| R9/01 | 9 | 44 | M8X0.5 | 16° | 5 | 4 | 3 |
| R9/03 | 9 | 38.5 | M8x0.75 | 16° | 5 | 4 | 3 |
| R9/06 | 9 | 51 | M8x0.8 | 30° | 5 | 4 | 3 |
| R9/09 | 9 | 44 | M8x0.75 | 16° | 5 | 4 | 3 |
| R10/03 | 10 | 58 | M10x0.75 | 12° | 5.5 | 4 | 3 |
| R11/02 | 11 | 53 | M10x0.75 | 16° | 7 | 5 | 4 |
| R11/09 | 11 | 53 | M10x1 | 16° | 7 | 5 | 4 |
| R11/10 | 11 | 57 | M10x0.75 | 16° | 7 | 5 | 4 |
| R11/11 | 11 | 52.4 | M10x0.75 | 16° | 7 | 5 | 4 |
| R11/12 | 11 | 53 | M10x0.80 | 16° | 7 | 5 | 4 |
| R12/01 | 12 | 52 | M12x1 | 30° | 7 | 6 | 5 |
| R12/02 | 12 | 50 | M10x0.75 | 16° | 7 | 6 | 5 |
| R12/05 | 12 | 50 | M10x0.75 | 16° | 7 | 6 | 5 |
| R12/07 | 12 | 50 | M12x1 | 30° | 7.5 | 6 | 5 |
| R12/08 | 12 | 50 | M10x0.5 | 30° | 7 | 5 | 4 |
| R12/09 | 12 | 50 | M12x1 | 30° | 7.5 | 6 | 5 |
| R13/01 | 13 | 41.5 | M12x0.75 | 15° | 8 | 6 | 5 |
| R14/02 | 14 | 64 | M13x0.75 | 16° | 8.5 | 7 | 6 |
| R14/03 | 14 | 62 | M14x1 | 15°30' | 8.5 | 7 | 6 |

* table to be continued

Carbide Lined Guide Bushing - Drawn Type



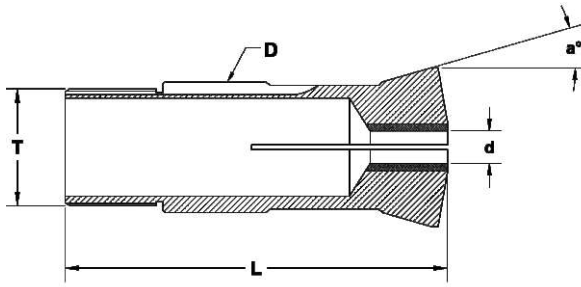
CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

| Part Nr. | Guiding Dia | Total Length | Thread | Angle | Capacity | | |
|----------|-------------|--------------|----------|--------|----------|---------|--------|
| | | | | | Round | Hexagon | Square |
| | | | | | ● | ⬡ | ■ |
| ØD | L | T | a° | | | | |
| R15/02 | 15 | 54 | M14x1 | 16° | 10 | 8 | 7 |
| R15/03 | 15 | 54 | M14x0.75 | 15° | 8.5 | 7 | 6 |
| R16/01 | 16 | 50 | M14x1 | 16° | 10 | 8 | 7 |
| R16/03 | 16 | 60 | M14x1 | 30° | 10 | 8 | 7 |
| R16/06 | 16 | 55 | M16x1 | 30° | 10 | 8 | 7 |
| R16/07 | 16 | 63 | M14x1 | 15°30' | 10 | 8 | 7 |
| R16/10 | 16 | 58 | M14x1 | 16° | 10 | 8 | 7 |
| R16/12 | 16 | 59 | M14x1 | 16° | 10 | 8 | 7 |
| R16/15 | 16 | 59 | M15x1 | 16° | 11 | 9 | 8 |
| R16/16 | 16 | 58.5 | M14x1 | 20° | 10 | 8 | 7 |
| R16/18 | 16 | 63 | M14x1 | 16°30' | 10 | 8 | 7 |
| R18/01 | 18 | 59 | M16x1 | 30° | 12 | 10 | 8 |
| R18/02 | 18 | 60 | M18x1 | 30° | 13 | 10 | 9 |
| R18/03 | 18 | 60 | M18x1 | 30° | 13 | 10 | 9 |
| R18/06 | 18 | 76 | M18X1 | 22° | 13 | 10 | 9 |
| R18/08 | 18 | 60 | M18X1 | 30° | 12.5 | 10 | 8 |
| R20/01 | 20 | 55 | M20x1 | 30° | 14 | 11 | 9 |
| R20/06 | 20 | 55 | M20x1 | 30° | 13 | 11 | 9 |
| R20/07 | 20 | 58 | M18x1 | 15° | 13 | 11 | 9 |
| R21/03 | 21 | 57.5 | M18x1 | 12° | 14 | 11 | 9 |

* table to be continued

Carbide Lined Guide Bushing - Drawn Type



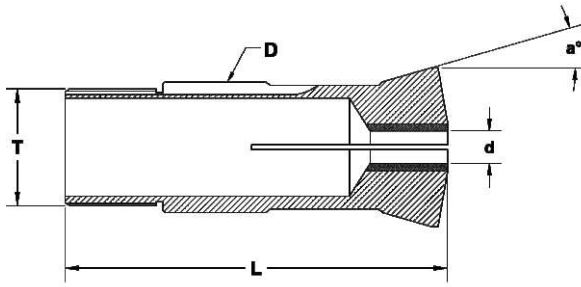
CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

| Part Nr. | Guiding Dia | Total Length | Thread | Angle | Capacity | | |
|----------|-------------|--------------|---------|-------|----------|---------|--------|
| | | | | | Round | Hexagon | Square |
| | | | | | ● | ⬡ | ■ |
| ØD | L | T | a° | | | | |
| R22/01 | 22 | 68 | M19x1 | 16° | 14 | 12 | 10 |
| R22/03 | 22 | 70 | M20x1 | 15° | 15.5 | 13 | 11 |
| R22/04 | 22 | 68 | M19X1 | 16° | 15 | 12 | 10 |
| R22/08 | 22 | 68 | M22x1 | 16° | 16 | 13 | 11 |
| R23/01 | 23 | 72 | M22x1 | 16° | 16.5 | 14 | 11 |
| R24/03 | 24 | 61 | M24x1 | 30° | 16 | 13 | 11 |
| R26/02 | 26 | 77 | M25x1 | 16° | 20 | 17 | 14 |
| R26/04 | 26 | 71 | M24X1.5 | 15° | 18 | 15 | 13 |
| R27/03 | 27 | 57.5 | M24x1 | 12° | 18 | 15 | 12 |
| R28/02 | 28 | 81 | M25x1 | 30° | 20.5 | 17 | 14 |
| R28/04 | 28 | 82 | M25x1 | 16° | 20.5 | 17 | 14 |
| R28/05 | 28 | 82 | M27x1 | 16° | 22 | 18 | 15 |
| R30/01 | 30 | 70 | M28x1 | 16° | 20.5 | 17 | 14 |
| R30/02 | 30 | 85 | M28x1 | 16° | 20.5 | 17 | 14 |
| R30/04 | 30 | 59 | M30x1 | 15° | 22 | 19 | 16 |
| R30/05 | 30 | 59 | M30x1 | 16° | 22 | 19 | 16 |
| R30/06 | 30 | 68 | M30x1 | 16° | 22 | 19 | 16 |
| R30/07 | 30 | 70 | M30x1 | 16° | 22 | 19 | 16 |
| R30/08 | 30 | 57.5 | M30X1 | 16° | 22 | 19 | 16 |
| R32/02 | 32 | 71 | M32x1 | 30° | 23 | 19 | 16 |

* table to be continued

Carbide Lined Guide Bushing - Drawn Type



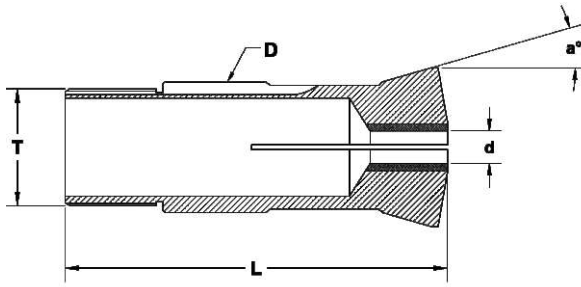
CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

| Part Nr. | Guiding Dia | Total Length | Thread | Angle | Capacity | | |
|----------|-------------|--------------|----------|--------|----------|---------|--------|
| | | | | | Round | Hexagon | Square |
| | | | | | ØD | L | T |
| R32/03 | 32 | 74 | M32x1 | 30° | 24 | 21 | 17 |
| R33/01 | 33 | 70 | M30x1 | 16° | 26 | 22 | 18 |
| R34/02 | 34 | 87.5 | M34x1 | 10° | 27.5 | 23 | 19 |
| R34/03 | 34 | 87.5 | M34X1 | 10° | 27.5 | 23 | 19 |
| R36/02 | 36 | 89.5 | M36x1 | 13° | 25 | 21 | 18 |
| R40/03 | 40 | 72 | M36x1 | 30° | 29 | 25 | 21 |
| R40/05 | 40 | 72 | M40x1 | 30° | 30 | 25 | 21 |
| R41/01 | 41 | 54 | M38x1 | 10° | 32 | 27 | 22 |
| R41/02 | 41 | 82 | M38x1 | 10° | 32 | 27 | 22 |
| R41/03 | 41 | 82 | M38X1 | 10° | 32 | 27 | 22 |
| R41/04 | 41 | 54 | M38X1 | 10° | 30 | 26 | 21 |
| R42/01 | 42 | 82 | M40x1 | 16° | 33 | 28 | 23 |
| R42/02 | 42 | 82 | M40x1 | 20°30' | 33 | 28 | 23 |
| R42/04 | 42 | 82 | M40x1 | 20° | 33 | 28 | 23 |
| R44/01 | 44 | 87 | M40x1 | 20° | 33 | 28 | 23 |
| R45/01 | 45 | 82 | M42x1 | 16° | 36 | 30 | 25 |
| R46/01 | 46 | 92 | M45x1 | 16° | 38 | 32 | 26 |
| R46/02 | 46 | 82 | M45x1 | 16° | 38 | 32 | 26 |
| R48/02 | 48 | 81 | M48x1.25 | 30° | 38 | 33 | 27 |
| R48/04 | 48 | 82 | M46x1 | 16° | 38 | 33 | 27 |

* table to be continued

Carbide Lined Guide Bushing - Drawn Type

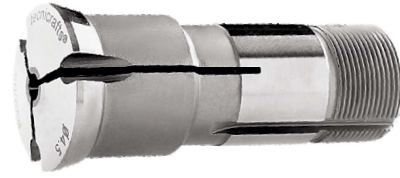
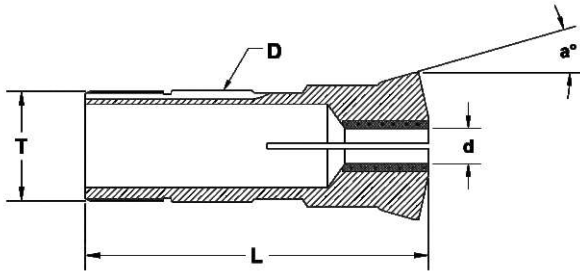


CARBIDE LINED GUIDE BUSH - DRAWN TYPE

All Dimension are in mm - Unless Otherwise Specified

| Part Nr. | Guiding Dia | Total Length | Thread | Angle | Capacity | | |
|----------|-------------|--------------|------------|-------|----------|---------|--------|
| | | | | | Round | Hexagon | Square |
| | ØD | L | T | a° | ● | ⬡ | ■ |
| R48/06 | 48 | 81 | M46x1 | 10° | 38 | 33 | 27 |
| R48/08 | 48 | 82 | M46X1 | 16° | 38 | 33 | 27 |
| R50/02 | 50 | 82 | M49x1 | 19° | 42 | 36 | 29 |
| R52/01 | 52 | 99 | M48x1.5 LH | 10° | 40 | 34 | 28 |
| R52/02 | 52 | 95 | M50x1 | 16° | 43 | 37 | 30 |

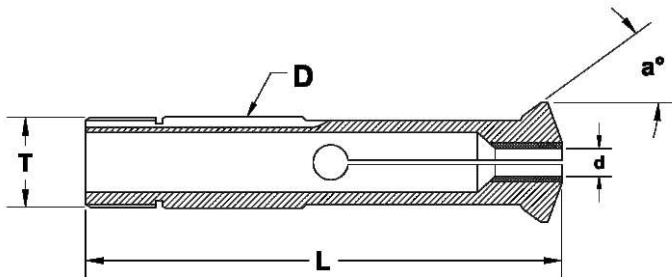
Carbide Lined Guide Bush - With Reinforced Shank



CARBIDE LINED GUIDE BUSH - WITH REINFORCED SHANK

All Dimension are in mm - Unless Otherwise Specified

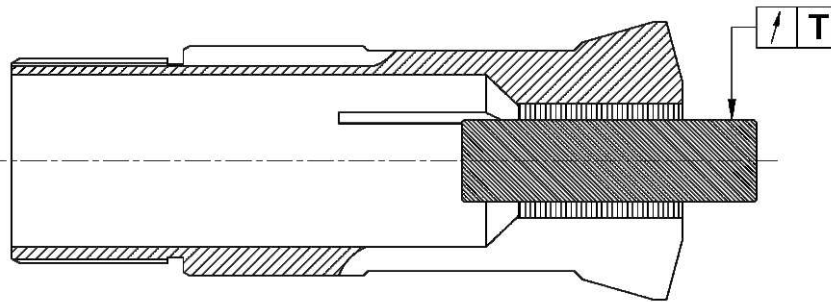
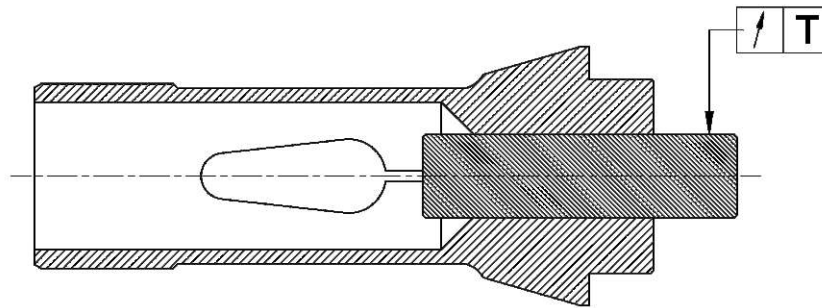
| Part Nr. | Guiding Dia | Total Length | Thread | Angle | Capacity | | |
|----------|-------------|--------------|----------|-------|----------|---------|--------|
| | | | | | Round | Hexagon | Square |
| | ØD | L | T | a° | ● | ⬡ | ■ |
| R22/05 | 22 | 68 | M22x1 | 16° | 16 | 13 | 11 |
| R34/06 | 34 | 150 | M32x1.50 | 20° | 27 | 22 | 19 |



CARBIDE LINED GUIDE BUSH - MAGIC TYPE

All Dimension are in mm - Unless Otherwise Specified

| Part Nr. | Guiding Dia | Total Length | Thread | Angle | Capacity | | |
|----------|-------------|--------------|--------|-------|----------|---------|--------|
| | | | | | Round | Hexagon | Square |
| | ØD | L | T | a° | ● | ⬡ | ■ |
| R10/02 | 10 | 58 | M10x1 | 36° | 5.5 | 4 | 3 |
| R13/02 | 13 | 68 | M13x1 | 36° | 8 | 6 | 5 |
| R18/05 | 18 | 68 | M18x1 | 36° | 13 | 10 | 9 |



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.