



Swiss
Precision
Tools

Clamping Nuts Tightening Torque

Recommended Tightening Torque

Collet Size	Ø mm	Ø inch	Nut Torque (ft-lbs)						Recommended Torque Wrench
			Hi-Q & Hi-QC		Hi-QB & Hi-QBC		AX & AXC		
			ER	ER-GB	ER	ER-GB	ER	ER-GB	
ER 11 MB	0.2 – 0.9	0.0078 – 0.035	6				6		Small
ER 11	1.0 – 2.5	0.0390 – 0.098	6	6			6	6	
	3.0 – 7.0	0.1180 – 0.256	20	12			20	15	
ER 16 MB	0.2 – 0.9	0.0078 – 0.035	6				6		Small
ER 16	1	0.039	6		5		6		
	1.5 – 3.5	0.059 – 0.138	15		12		15		
	4.0 – 4.5	0.157 – 0.177	30	30	25	25	30	30	
	5.0 – 10.0	0.197 – 0.394	40	32	40	32	30	30	
ER 20	1	0.039	12		10		12		Small
	1.5 – 6.5	0.059 – 0.256	25	25	20	20	25	25	Medium
	7.0 – 13.0	0.276 – 0.512	60	26	60	60	40	26	
ER 25	1.0 – 3.5	0.039 – 0.138	20		15		20		Medium
	4.0 – 4.5	0.157 – 0.177	40	40	35	35	40	40	
	5.0 – 7.5	0.196 – 0.295	60	60	55	55	60	60	
	8.0 – 16.0	0.315 – 0.630	80	80	80	60	60	60	
ER 32	2.0 – 2.5	0.078 – 0.098	20		15		20		Small
	3.0 – 7.5	0.118 – 0.291	100	100	95	80	80	80	Large
	8.0 – 20.0	0.315 – 0.787	100	110	100	85	80	80	
ER 40	3.0 – 8.5	0.118 – 0.335	130	130	130	130	95	95	Large
	9.0 – 26.0	0.354 – 1.023	130	130	130	140	95	95	
ER 50	6.0 – 34.0	0.236 – 1.338	180	220	180	220			Large



The maximum torque must not be more than 25% above the recommended tightening torque. Higher tightening torque may result in the damage of the toolholder.



Higher clamping force of the clamping nut means higher stress on the toolholder. We recommend the use of REGO-FIX® torque wrench. REGO-FIX® will not be responsible for damage to toolholders or spindles of other manufacturers.



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ER

Technical Information

Clamping Nuts Tightening Torque

Recommended Tightening Torque

Nut Torque (ft-lbs)							
Collet Size	Ø mm	Ø inch	Hi-QM & Hi-QMC		MS		Recommended Torque Wrench
			ER	ER-GB	ER	ER-GB	
ER 8 MB	0.2 – 0.9	0.0078 – 0.035	4		4		Micro
ER 8	1.0 – 1.5	0.039 – 0.060	4		4		
	2.0 – 2.5	0.079 – 0.197	4		4		
	3.0 – 5.0	0.118 – 0.197	4		4		
ER 11 MB	0.2 – 0.9	0.0078 – 0.035	6		6		Small
ER 11	1.0 – 2.5	0.039 – 0.098	6	6	7		
	3.0 – 7.0	0.118 – 0.256	12	10	7		
ER 16 MB	0.2 – 0.9	0.0078 – 0.035	9		9		Small
ER 16	1	0.039	9		9		
	1.5 – 3.5	0.059 – 0.138	18		15		
	4.0 – 4.5	0.157 – 0.177	18	18	15		
	5.0 – 10.0	0.197 – 0.394	18	18	15		
ER 20	1	0.039	12		9		
	1.5 – 6.5	0.059 – 0.256	21	21	14		
	7.0 – 13.0	0.276 – 0.512	21	21	14		
ER 25	1.0 – 3.5	0.039 – 0.138	18				Small
	4.0 – 7.5	0.157 – 0.295	24	24			
	5.0 – 16.0	0.196 – 0.630	24	24			



The maximum torque must not be more than 25% above the recommended tightening torque. Higher clamping force of the clamping nut at the same time means higher stress on the toolholder.