



HPI Tooling Solution



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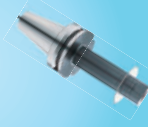
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Note

1. Specifications are subject to change without notice.
2. Photos may be different from actual products.

HMC



Powerful and Rigid

Smooth and powerful milling capability



- Roller Bearing System

Retainer sleeve system filled with symmetrically placed needle roller bearings provides smooth operation. 4 needle roller bearings per cell provide maximum contact area and heavy duty gripping capability.

- Powerful Gripping Torque

4-row retainer sleeve is used for the HMC CAT50/BT50 taper models (except HMC1.1/4-90). This system allows the HMC to achieve 5000Nm of clamping torque (using the HMC42 milling chuck).

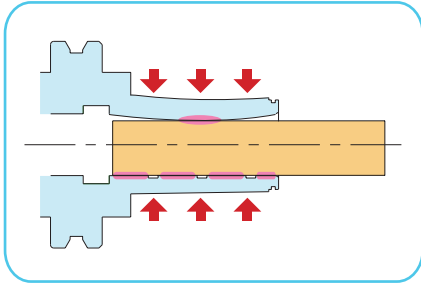


-Ultra-low temperature treatment

Removes the residual austenite from the holder and provides long lasting performance.

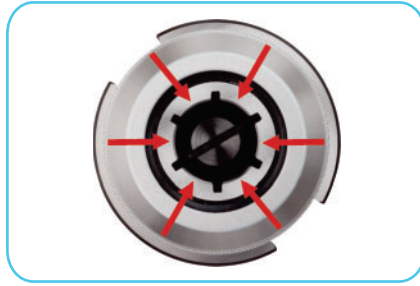
X-GROOVE System (PAT)

Combination of the Radical and Axial grooves



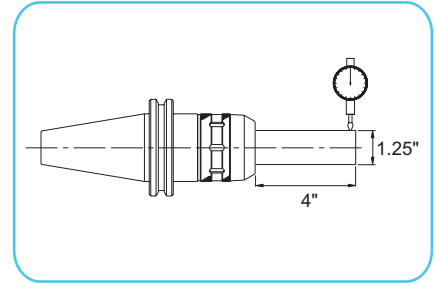
- Radial Grooves

The radial grooves provide more uniform collapse capability and allows the chuck to collapse evenly all the way to the nose. It provides reliable gripping and run-out capability, and also minimizes cutter vibration and chatter.



- Axial Grooves

The axial grooves provide more even collapse capability. It distributes gripping power more evenly all the way around the shank or collet and as a result provides better concentricity.

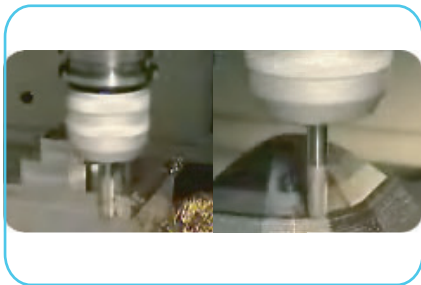


- Fine Run-out

The HMC is capable of .0002" (5μ) run-out up to 4" away from nose (HMC1/1/4). The X-GROOVE system also allows for drainage of oil and dirt to minimize loss of gripping torque.

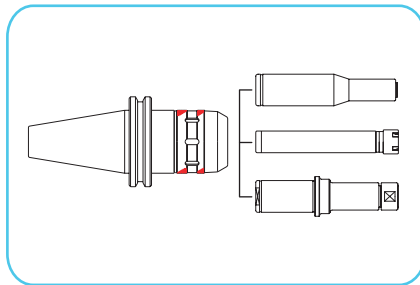
Flexible

Multi purpose use capability provides maximum flexibility



- Roughing To Finishing

With its unsurpassed gripping torque and fine run-out capability, the HMC provides the maximum performance not only for tough roughing applications but also for fine-finishing applications. It also provides longer cutter life.

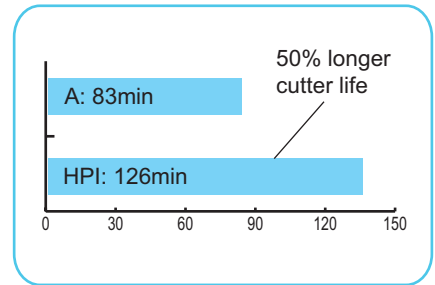


- Use as a master holder

With fine run-out and strong gripping power, the HMC allows the use of straight shank collets and other straight shank accessories. The HMC provides maximum flexibility for almost any application.

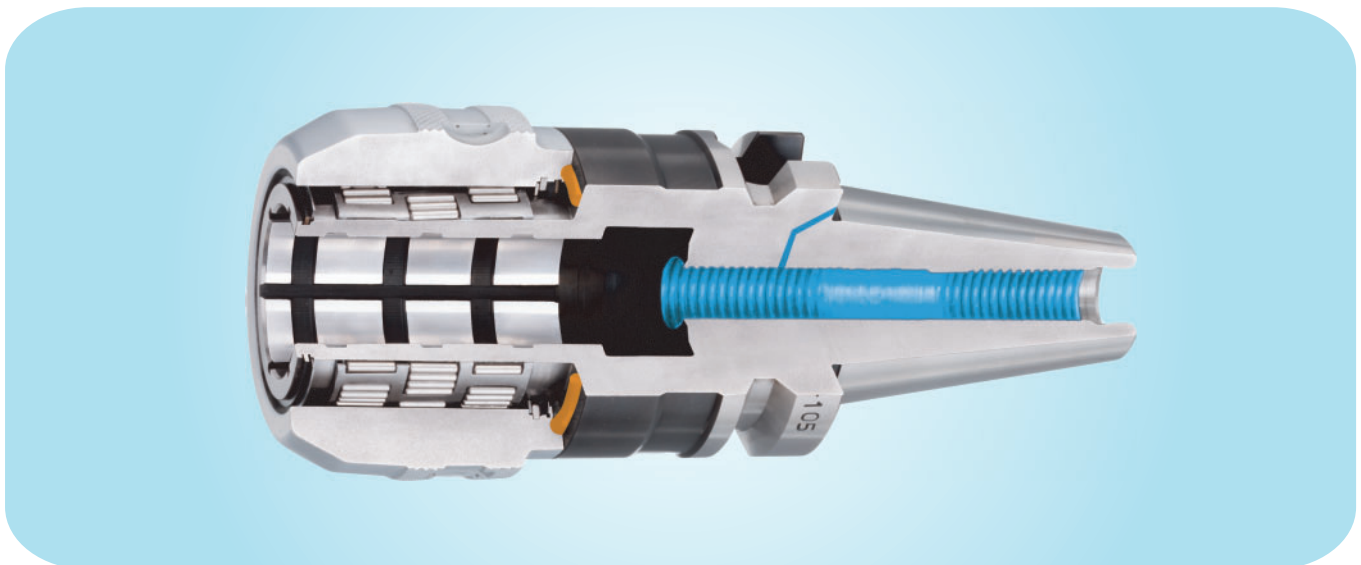
Long Cutter Life

Maximize the cutter performance



- V.S. competitor A

Holder	HPI : BT40-HMC3/4-75
	A : Competitor's equivalent
Endmill	10mm AlTiN coated carbide
Material	A2 60RC
Feed	45 IPM
Step-over	.020"
Step-down	.600"
Spindle RPM	3,800 RPM

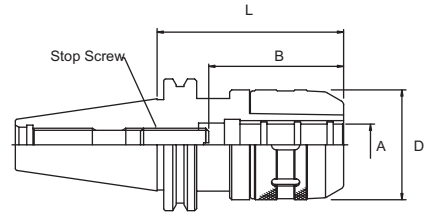


HMC

Milling Chuck

Feature

- Powerful clamp torque
- Fine run-out
- Through the center hole with built in stop screw
- Balanced type available upon request



Shank	Order No.	A	L	D	B	Collet	Wrench
CAT40	CAT40-HMC 3/4- 85	0.75	3.35	2.09	2.76	MC3/4	MCW20
	CAT40-HMC 3/4-120	0.75	4.72	2.09	2.76	MC3/4	MCW20
	CAT40-HMC1.1/4- 90	1.25	3.54	2.76	2.99	MC1.1/4	MCW32
	CAT40-HMC1.1/4-105	1.25	4.13	2.76	2.99	MC1.1/4	MCW32
	CAT40-HMC1.1/4-120	1.25	4.72	2.76	2.99	MC1.1/4	MCW32
CAT50	CAT50-HMC 3/4-105	0.75	4.13	2.09	2.76	MC3/4	MCW20
	CAT50-HMC 3/4-135	0.75	5.31	2.09	2.76	MC3/4	MCW20
	CAT50-HMC 3/4-165*	0.75	6.50	2.09	2.76	MC3/4	MCW20
	CAT50-HMC1.1/4- 90	1.25	3.54	2.76	3.74	MC1.1/4	MCW32
	CAT50-HMC1.1/4-105	1.25	4.13	2.76	3.74	MC1.1/4	MCW32
	CAT50-HMC1.1/4-135	1.25	5.31	2.76	3.74	MC1.1/4	MCW32
	CAT50-HMC1.1/4-165*	1.25	6.50	2.76	3.74	MC1.1/4	MCW32
BT30	BT30-HMC3/4- 80	0.75	3.15	2.09	2.76	MC3/4	MCW20
BT40	BT40-HMC 3/4- 75	0.75	2.95	2.09	2.76	MC3/4	MCW20
	BT40-HMC 3/4- 90*	0.75	3.54	2.09	2.76	MC3/4	MCW20
	BT40-HMC1.1/4- 85	1.25	3.35	2.76	2.99	MC1.1/4	MCW32
	BT40-HMC1.1/4-120*	1.25	4.72	2.76	2.99	MC1.1/4	MCW32
BT50	BT50-HMC 3/4-105	0.75	4.13	2.09	2.76	MC3/4	MCW20
	BT50-HMC1.1/4-105	1.25	4.13	2.76	2.76	MC1.1/4	MCW32

Note

1. Items with * mark are not regular stock items.
2. Wrench is not included. Please order separately.
3. Special length is available upon request.
4. DIN type flange coolant hole is available upon request.
5. See P.5 for MC collets.
6. See P.15 for how-to-use instruction.
7. See P.5 for important information on CAT40-HMC1.1/4-90 and CAT40-HMC1.1/4-120 about Non-ANSI specification.



Special long size

MC Collet

Precision Straight Collet for Milling Chuck



NC collet
(depth adjustable)

HMC3/4

Order number	I.D
MC 3/4-1/8	.125
MC 3/4-3/16	.188
MC 3/4-1/4	.250
MC 3/4-5/16	.313
MC 3/4-3/8	.375
MC 3/4-7/16	.438
MC 3/4-1/2	.500
MC 3/4-9/16	.563
MC 3/4-5/8	.625
MC 3/4-06	6mm
MC 3/4-08	8mm
MC 3/4-10	10mm
MC 3/4-12	12mm
MC 3/4-14	14mm
MC 3/4-16	16mm

HMC1.1/4

Order number	I.D
MC 1.1/4-1/8	.125
MC 1.1/4-3/16	.188
MC 1.1/4-1/4	.250
MC 1.1/4-5/16	.313
MC 1.1/4-3/8	.375
MC 1.1/4-7/16	.438
MC 1.1/4-1/2	.500
MC 1.1/4-9/16	.563
MC 1.1/4-5/8	.625
MC 1.1/4-3/4	.750
MC 1.1/4-7/8	.875
MC 1.1/4-1	1
MC 1.1/4-06	6mm
MC 1.1/4-08	8mm
MC 1.1/4-10	10mm
MC 1.1/4-12	12mm
MC 1.1/4-14	14mm
MC 1.1/4-16	16mm
MC 1.1/4-18	18mm
MC 1.1/4-20	20mm
MC 1.1/4-22	22mm
MC 1.1/4-25	25mm

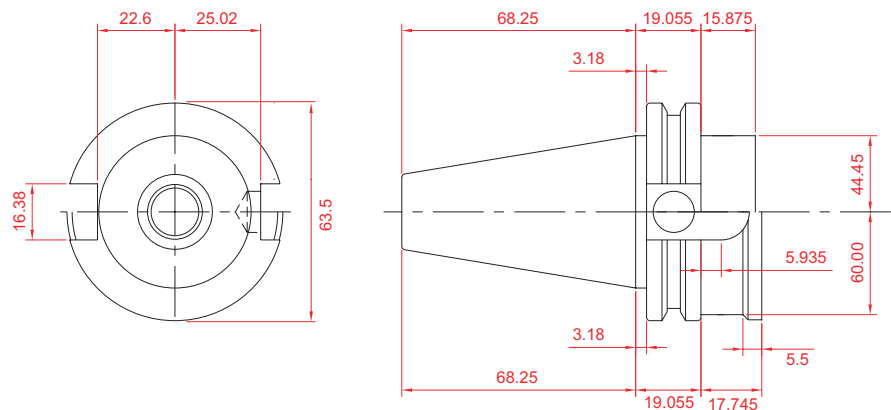
Note

1. Metric size is available upon request.
2. Other inch size is available upon request.
3. Depth adjustable type is available upon request.

*Important Information

The HPI CAT40-HMC1.1/4-90 and CAT40-HMC1.1/4-120 holders do not follow the 5/8" relief cut under the flange required by ANSI B5.50 specification. The added stock strengthens the holder for better performance and longer cutter life. This design works with most recent ATC (Automatic Tool Change) system, but some machines may still require the 5/8" relief cut for ATC finger grips or drive keys.

In most cases by having extended drive slots on the holder body, HPI has alleviated interference issues with most ATC Systems and drive keys. However, all CAT40-HMC1.1/4-90 and CAT40-HMC1.1/4-120 holders users are liable to check and confirm if interference exists with their ATC systems and drive keys before using the holders. Failing to do so may result in serious damage to the machine and the holder. If your ATC System require 5/8" relief cut, please specify CAT40-HMC1.1/4-105 or other HMC3/4 holders which follow ANSI B5.50 spec. Please ask your local distributor or HPI for more details.

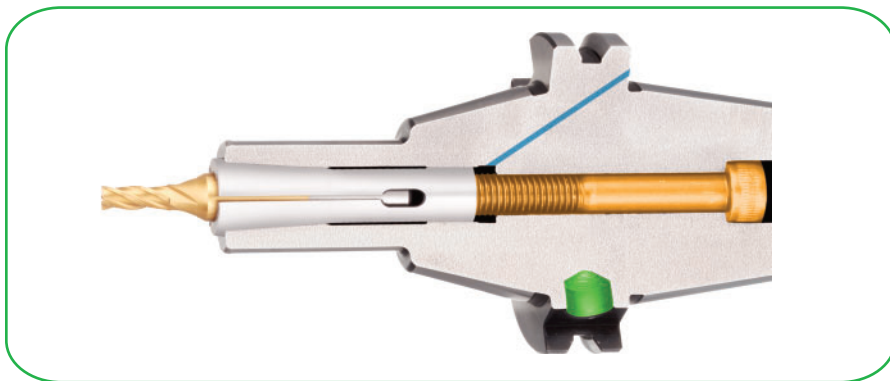


HMX



Super Fine Accuracy

Drawing the collet straight in from the back

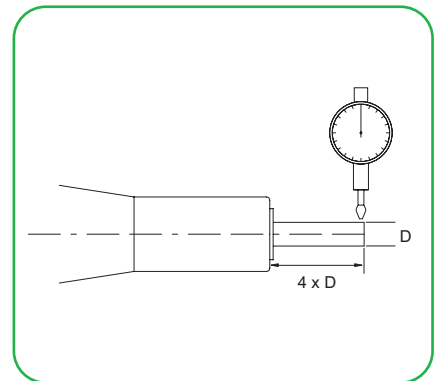


- Nut-Free Design

The HMX nut-free design eliminates collet twist and provides better run-out. It also provides less interference and better holder balance.

- Unique Collet System

Drawing the collets into the chuck from the back provides uniform clamping all the way to the chuck nose. This system also eliminates collet twist that happens with conventional collet systems, and ensures fine run-out.



- Super Fine Run-Out

With its unique design HMX is capable of providing .0001" (3 μ m) run-out at 4D away from the nose.

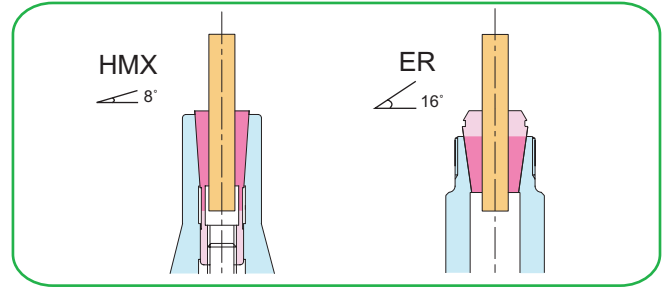
Strong Gripping Power

Smaller taper angle collet system



- Smaller Taper Angle

The HMX uses a smaller taper angle which is approximately half of the industry standard 16° collet systems. This collet system generates 100% more gripping torque when compared with the industry standard 16° collet systems.



- More Contact Area

The HMX's smaller taper angle system provides more contact area on the cutter shank for better gripping power and more reliable concentricity compared to 16° collet system.

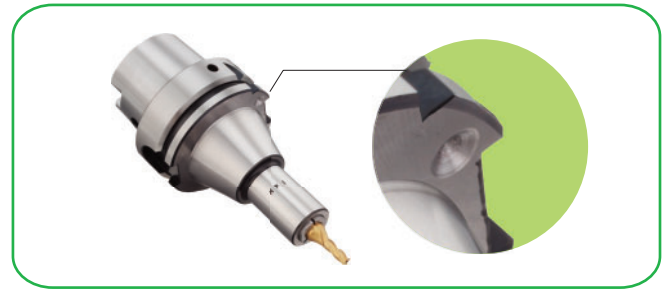
High Speed Capability

Symmetric and nut-free design



- Ideal design for high-speed

The HMX is designed for ultimate symmetry to minimize centrifugal force and vibration generated by high-speed spindle rotation. Its unique nut-free design provides better run-out and balance.

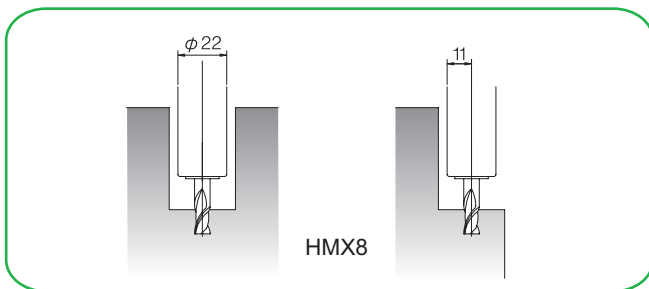


- High-Speed Type (option)

High speed balanced HMX is available for all sizes and lengths. The HMX can easily be balanced to G2.5 even up to 30,000 rpm upon request.

Slim & Compact

For hard-to-reach places



- Minimum Interference

The HMX's slim & compact design, along with its nut-free collet system minimizes interference issues and maximizes machining reach capability for those hard to reach places.

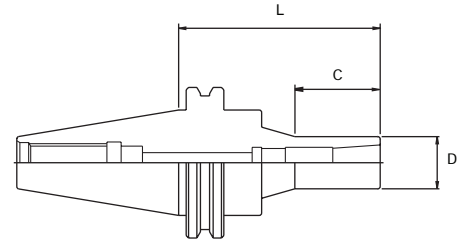


HMX

Super Precision Collet Chuck

Feature

- Super fine run-out
- Strong gripping torque
- Coolant through the center standard
- High speed type is available upon request



Taper	Order No.	Range	L	D	C	Collet	T-Wrench
BT30	BT30-HMX 8- 90	.118 - .394	3.54	.87	1.42	VX8	MXW05
BT40	BT40-HMX 8- 85	.118 - .394	3.35	.87	1.42	VX8	MXW05
	BT40-HMX 8- 120	.118 - .394	4.72	.87	1.42	VX8	MXW05
	BT40-HMX12- 90	.157 - .472	3.54	1.18	1.38	VX12	MXW05
CAT40	CAT40-HMX 8- 85	.118 - .394	3.35	.87	1.42	VX8	MXW05
	CAT40-HMX 8-120	.118 - .394	4.72	.87	1.42	VX8	MXW05
	CAT40-HMX 8-150	.118 - .394	5.91	.87	1.42	VX8	MXW05
	CAT40-HMX12- 90	.157 - .472	3.54	1.18	1.38	VX12	MXW05
	CAT40-HMX12- 120	.157 - .472	4.72	1.18	1.38	VX12	MXW05
CAT50	CAT50-HMX 8- 110	.118 - .394	4.33	.87	1.42	VX8	MXW05
	CAT50-HMX 8- 165*	.118 - .394	6.5	.87	1.42	VX8	MXW05
	CAT50-HMX12- 105	.157 - .472	4.13	1.18	1.38	VX12	MXW05
	CAT50-HMX12- 165*	.157 - .472	6.5	1.18	1.38	VX12	MXW05

Note

1. Items with * mark are not regular stock items.
2. Wrench is not included. Please order separately.
3. Special length is available upon request.
4. DIN type flange coolant hole is available upon request.
5. See P.9 for VX collets.
6. See P.15 for how-to-use instruction.



CAT50-HMX8-225
(special)

VX Collet

Precision Collet for HMX



VX8

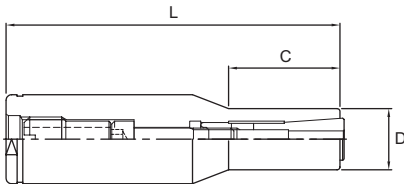
Order No.	I.D.
VX 8- 1/8	.125 (1/8)
VX 8- 3/16	.188 (3/16)
VX 8- 1/4	.250 (1/4)
VX 8- 5/16	.313 (5/16)
VX 8- 3/8	.375 (3/8)
VX 8- 3	3 mm
VX 8- 4	4 mm
VX 8- 6	6 mm
VX 8- 8	8 mm
VX 8-10	10 mm

VX12

Order No.	I.D.
VX12- 3/16	.188 (3/16)
VX12- 1/4	.25 (1/4)
VX12- 5/16	.313 (5/16)
VX12- 3/8	.375 (3/8)
VX12- 7/16	.438 (7/16)
VX12- 1/2	.500 (1/2)
VX12- 4	4 mm
VX12- 6	6 mm
VX12- 8	8 mm
VX12-10	10 mm
VX12-12	12 mm

Note
1. Coolant slot is available upon request.

Straight Shank Extension



Order No.	Range	L	D	C	Collet	wrench
S3/4-HMX 8-100	.118-.394	3.94	.79	1.57	VX8	MXW05

Note
1. Wrench is not included.

HSX

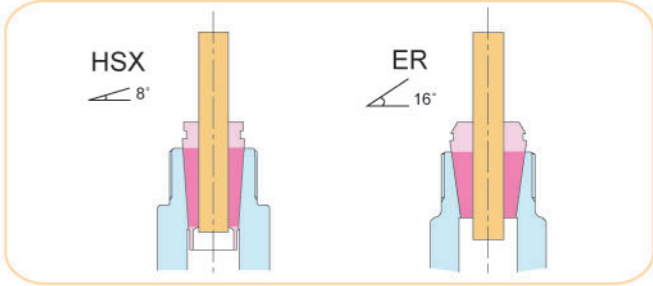


Strong Gripping Power

Smaller taper angle collet system



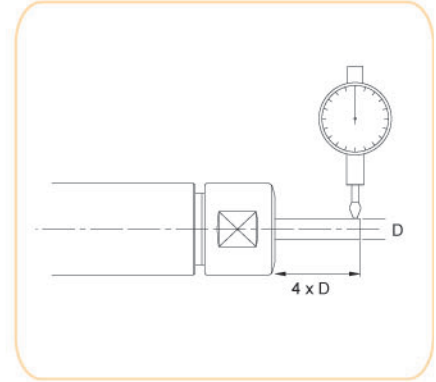
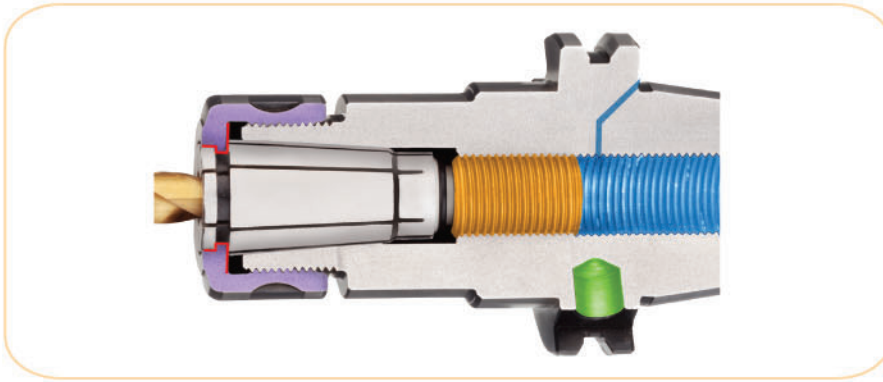
- Smaller Taper Angle
The HSX uses a smaller taper angle, which is approximately half of the industry standard 16° collet systems. This collet system provides 100% more gripping torque and better concentricity when compared with the industry standard 16° collet system.



- More Contact Area
The HSX's smaller taper angle system provides more contact area on the cutter shank for better gripping power and more reliable concentricity compared to 16° collet system.

Fine Accuracy

Flat ground shoulder collet system



- Flat Ground Shoulder

By having a flat ground shoulder in the collet nut, the collet can be clipped into the nut ensuring to hold the cutter on the tool holder centerline.

- Bearing-Free Design

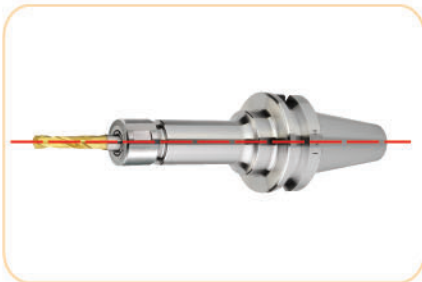
The flat ground shoulder eliminates the need for a bearing nut system and permits collet rotation during clamping without collet twist.

-Fine Run-Out

With its unique collet system the HSX is capable of providing .0002" (5 μ m) run-out at 4D away from the nose.

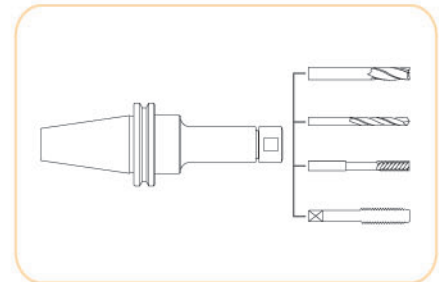
High Speed Capability

Symmetric design



Flexible

For various kinds of applications



- Symmetrically Designed Body

With a symmetric designed body and fine run-out capability provided by flat ground shoulder collet system, the HSX is easily balanced to G2.5 at 20,000 RPM upon request.

- High-Speed Type (option)

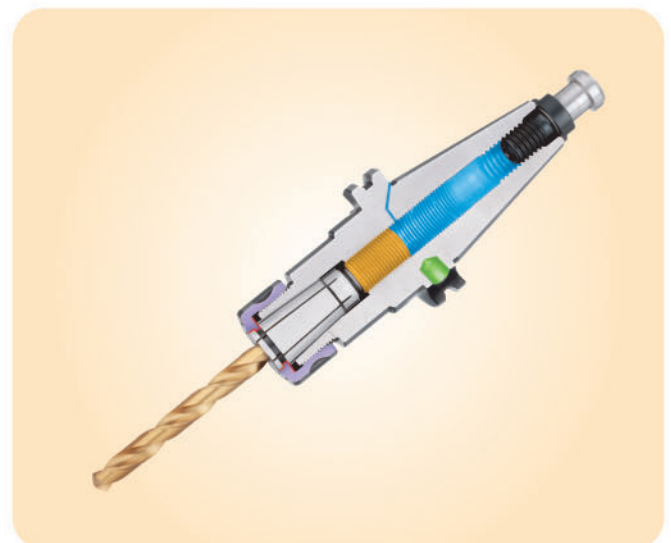
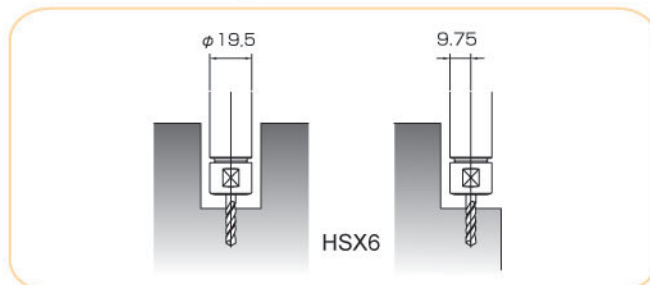
High speed balanced HSX is available for all sizes and lengths. Higher than 20,000 rpm balanced HSX is also available upon request.

- Multipurpose use capability

With strong gripping power and fine run-out, the HSX is the best collet chuck for various kinds of applications, such as light rough milling, semi finishing, finishing, high-speed machining, drilling, reaming and rigid tapping.

Slim & Compact

For hard-to-reach places



- Minimum Interference

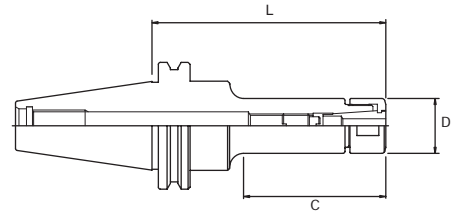
The HSX slim & compact design minimize interference with work pieces and maximize machining reach capability for those hard to reach places.

HSX

Hi Precision Collet Chuck

Feature

- Fine run-out
- Strong gripping torque
- Coolant through the center standard
- High speed type is available upon request



Shank	Order No.	Range	L	D	C	Collet	Nut	Wrench	Stop Screw
CAT40	CAT40-HSX 6 - 90	.030 - .236	3.54	0.77	1.75	SX6	SXN-06	SXW-06	AS-SX06
	CAT40-HSX 6 -120	.030 - .236	4.72	0.77	2.17	SX6	SXN-06	SXW-06	AS-SX06
	CAT40-HSX10 - 90	.069 - .394	3.54	1.08	2.16	SX10	SXN-10	SXW-10	AS-SX10
	CAT40-HSX10 -120	.069 - .394	4.72	1.08	2.75	SX10	SXN-10	SXW-10	AS-SX10
	CAT40-HSX10 -150*	.069 - .394	5.91	1.08	2.75	SX10	SXN-10	SXW-10	AS-SX10
	CAT40-HSX16 - 90	.108 - .630	3.54	1.58	2.16	SX16	SXN-16	SXW-16	AS-SX16
	CAT40-HSX16 -120	.108 - .630	4.72	1.58	3.13	SX16	SXN-16	SXW-16	AS-SX16
	CAT40-HSX16 -150*	.108 - .630	5.91	1.58	4.31	SX16	SXN-16	SXW-16	AS-SX16
	CAT40-HSX25 - 90	.630 - 1.000	3.54	2.17	2.56	SX25	SXN-25	SXW-25	AS-SX25
	CAT40-HSX25 -120*	.630 - 1.000	4.72	2.17	3.74	SX25	SXN-25	SXW-25	AS-SX25
CAT50	CAT50-HSX 6 -105*	.030 - .236	4.13	0.77	2.16	SX6	SXN-06	SXW-06	AS-SX06
	CAT50-HSX 6 -165*	.030 - .236	6.50	0.77	2.16	SX6	SXN-06	SXW-06	AS-SX06
	CAT50-HSX10 -105	.069 - .394	4.13	1.08	2.75	SX10	SXN-10	SXW-10	AS-SX10
	CAT50-HSX10 -135	.069 - .394	5.31	1.08	2.75	SX10	SXN-10	SXW-10	AS-SX10
	CAT50-HSX10 -165	.069 - .394	6.50	1.08	2.75	SX10	SXN-10	SXW-10	AS-SX10
	CAT50-HSX16 -105	.108 - .630	4.13	1.58	2.75	SX16	SXN-16	SXW-16	AS-SX16
	CAT50-HSX16 -135	.108 - .630	5.31	1.58	2.75	SX16	SXN-16	SXW-16	AS-SX16
	CAT50-HSX16 -165	.108 - .630	6.50	1.58	3.54	SX16	SXN-16	SXW-16	AS-SX16
	CAT50-HSX25 -105	.630 - 1.000	4.13	2.17	2.75	SX25	SXN-25	SXW-25	AS-SX25
	CAT50-HSX25 -135*	.630 - 1.000	5.31	2.17	3.54	SX25	SXN-25	SXW-25	AS-SX25
CAT50-HSX25 -165*	.630 - 1.000	6.50	2.17	5.12	SX25	SXN-25	SXW-25	AS-SX25	

HSX coolant through adjust screw

Size	Order No.
SX6	ASC-SX06
SX10	ASC-SX10
SX16	ASC-SX16
SX25	ASC-SX25

Note

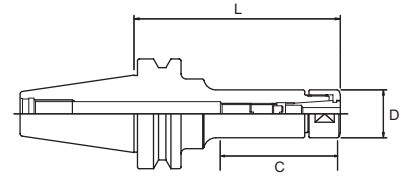
1. Items with * mark are not regular stock items.
2. Wrench is not included. Please order separately.
3. Special length is available upon request.
4. DIN type flange coolant hole is available upon request.
5. See P.14 for SX collets.
6. See P.15 for how-to-use instruction.

HSX

Hi Precision Collet Chuck

Feature

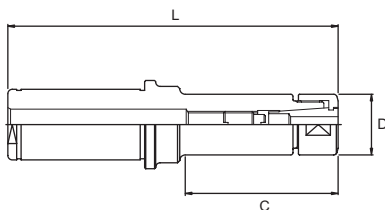
- Fine run-out
- Strong gripping torque
- Coolant through the center standard
- High speed type is available upon request



Shank	Order No.	Range	L	D	C	Collet	Nut	Wrench	Screw
BT30	BT30-HSX 6 - 60	.030 - .236	2.36	0.77	1.3	SX6	SXN-06	SXW-06	AS-SX06
	BT30-HSX 6 - 90	.030 - .236	3.54	0.77	2.2	SX6	SXN-06	SXW-06	AS-SX06
	BT30-HSX10 - 45*	.069 - .394	1.77	1.08	0.87	SX10	SXN-10	SXW-10	AS-SX10
	BT30-HSX10 - 60	.069 - .394	2.36	1.08	1.38	SX10	SXN-10	SXW-10	AS-SX10
	BT30-HSX10 - 90	.069 - .394	3.54	1.08	2.56	SX10	SXN-10	SXW-10	AS-SX16
	BT30-HSX16 - 60	.108 - .630	2.36	1.58	1.46	SX16	SXN-16	SXW-16	AS-SX16
	BT30-HSX16 - 90	.108 - .630	3.54	1.58	2.64	SX16	SXN-16	SXW-16	AS-SX16
	BT30-HSX25 - 90	.630 - 1.000	3.54	2.17	2.68	SX25	SXN-25	SXW-25	AS-SX25
BT40	BT40-HSX 6 - 90	.030 - .236	3.54	0.77	2.36	SX6	SXN-06	SXW-06	AS-SX06
	BT40-HSX 6 - 120	.030 - .236	4.72	0.77	2.36	SX6	SXN-06	SXW-06	AS-SX06
	BT40-HSX10 - 90	.069 - .394	3.54	1.08	2.36	SX10	SXN-10	SXW-10	AS-SX10
	BT40-HSX10 - 120	.069 - .394	4.72	1.08	2.76	SX10	SXN-10	SXW-10	AS-SX10
	BT40-HSX10 - 150*	.069 - .394	5.91	1.08	2.87	SX10	SXN-10	SXW-10	AS-SX10
	BT40-HSX16 - 90	.108 - .630	3.54	1.58	2.28	SX16	SXN-16	SXW-16	AS-SX16
	BT40-HSX16 - 120	.108 - .630	4.72	1.58	3.46	SX16	SXN-16	SXW-16	AS-SX16
	BT40-HSX16 - 150*	.108 - .630	5.91	1.58	4.65	SX16	SXN-16	SXW-16	AS-SX16
	BT40-HSX25 - 90*	.630 - 1.000	3.54	2.17	2.4	SX25	SXN-25	SXW-25	AS-SX25

Note

1. Items with * mark are not regular stock items.
2. Wrench is not included. Please order separately.
3. Special length is available upon request.
4. DIN type flange coolant hole is available upon request.
5. See P.14 for SX collets.
6. See P.15 for how-to-use instruction.



HSX Straight shank

Order No.	Range	Shank	L	D	C	Collet
S1.1/4-HSX 6-150	.030 - .236	1.25	5.91	0.77	1.69	SX6
S1.1/4-HSX10-150	.069 - .394	1.25	5.91	1.08	2.95	SX10
S1.1/4-HSX10-210*	.069 - .394	1.25	8.27	1.08	2.95	SX10

Note

1. Wrench is not included.
2. Extended length is available upon request.

SX Collet

Precision Collet for HSX

SX6

Order No.	Range
SX 6- 1/8 A	1/8
SX 6- 3/16A	3/16
SX 6- 1.0	.030 - .039
SX 6- 1.25	.039 - .049 (3/64)
SX 6- 1.5	.049 - .059
SX 6- 1.75	.059 - .069 (1/16)
SX 6- 2.0	.069 - .079 (5/64)
SX 6- 2.25	.079 - .089
SX 6- 2.5	.089 - .098 (3/32)
SX 6- 2.75	.098 - .108
SX 6- 3.0	.108 - .118 (7/64)
SX 6- 3.5	.118 - .138 (1/8)
SX 6- 4.0	.138 - .157 (5/32)
SX 6- 4.5	.157 - .177 (11/64)
SX 6- 5.0	.177 - .197 (3/16)
SX 6- 5.5	.197 - .217 (13/64)
SX 6- 6.0	.217 - .236 (15/64)

SX10

Order No.	Range
SX10- 1/8 A	1/8
SX10- 3/16A	3/16
SX10- 1/4 A	1/4
SX10- 5/16A	5/16
SX10- 3/8 A	3/8
SX10- 2.0	.069 - .079
SX10- 2.25	.079-.089
SX10- 2.5	.089 - .098
SX10- 2.75	.098 - .108
SX10- 3.0	.108 - .118
SX10- 3.5	.118 - .138 (1/8)
SX10- 4.0	.138 - .157
SX10- 4.5	.157 - .177
SX10- 5.0	.177 - .197 (3/16)
SX10- 5.5	.197 - .217
SX10- 6.0	.217 - .236
SX10- 6.5	.236 - .256 (1/4)
SX10- 7.0	.256 - .276
SX10- 7.5	.276 - .295
SX10- 8.0	.295 - .315 (5/16)
SX10- 8.5	.315 - .335
SX10- 9.0	.335 - .354
SX10- 9.5	.354 - .374 (3/8)
SX10- 10.0	.374 - .394

SX16

Order No.	Range
SX16- 1/8 A	1/8
SX16- 3/16A	3/16
SX16- 1/4 A	1/4
SX16- 5/16A	5/16
SX16- 3/8 A	3/8
SX16- 7/16A	7/16
SX16- 1/2 A	1/2
SX16- 9/16A	9/16
SX16- 5/8 A	5/8
SX16- 3.0	.108 - .118
SX16- 3.5	.118 - .138 (1/8)
SX16- 4.0	.138 - .157
SX16- 4.5	.157 - .177
SX16- 5.0	.177 - .197 (3/16)
SX16- 5.5	.197 - .217
SX16- 6.0	.217 - .236
SX16- 6.5	.236 - .256 (1/4)
SX16- 7.0	.256 - .276
SX16- 7.5	.276 - .295
SX16- 8.0	.295 - .315 (5/16)
SX16- 8.5	.315 - .335
SX16- 9.0	.335 - .354
SX16- 9.5	.354 - .374
SX16- 10.0	.374 - .394
SX16- 10.5	.394 - .413
SX16- 11.0	.413 - .433
SX16- 11.5	.433 - .453
SX16- 12.0	.453 - .472
SX16- 12.5	.472 - .492
SX16- 13.0	.492 - .512 (1/2)
SX16- 13.5	.512 - .531
SX16- 14.0	.531 - .551
SX16- 14.5	.551 - .571 (9/16)
SX16- 15.0	.571 - .591
SX16- 15.5	.591 - .610
SX16- 16.0	.610 - .630 (5/8)

SX25

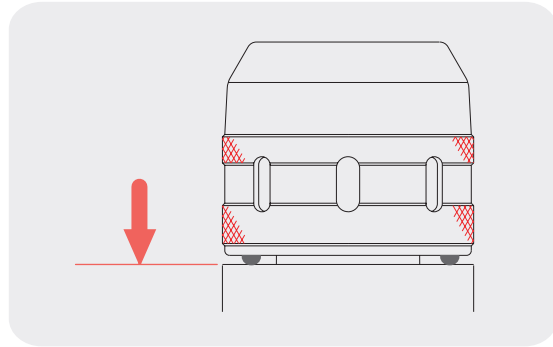
Order No.	Range
SX25- 3/16A	3/16
SX25- 1/4 A	1/4
SX25- 5/16A	5/16
SX25- 3/8 A	3/8
SX25- 7/16A	7/16
SX25- 1/2 A	1/2
SX25- 9/16A	9/16
SX25- 5/8 A	5/8
SX25- 3/4 A	3/4
SX25- 7/8 A	7/8
SX25- 16.0	.610 - .630
SX25- 16.5	.630 - .650
SX25- 17.0	.650 - .669
SX25- 17.5	.669 - .689 (11/16)
SX25- 18.0	.689 - .709
SX25- 18.5	.709 - .728
SX25- 19.0	.728 - .748
SX25- 19.5	.748 - .768 (3/4)
SX25- 20.0	.768 - .787
SX25- 20.5	.787 - .807
SX25- 21.0	.807 - .827 (13/16)
SX25- 21.5	.827 - .846
SX25- 22.0	.846 - .866
SX25- 22.5	.866 - .886 (7/8)
SX25- 23.0	.886 - .906
SX25- 23.5	.906 - .925
SX25- 24.0	.925 - .945 (15/16)
SX25- 24.5	.945 - .965
SX25- 25.0	.965 - .984
SX25- 25.4	.984 - 1.000 (1)



Information

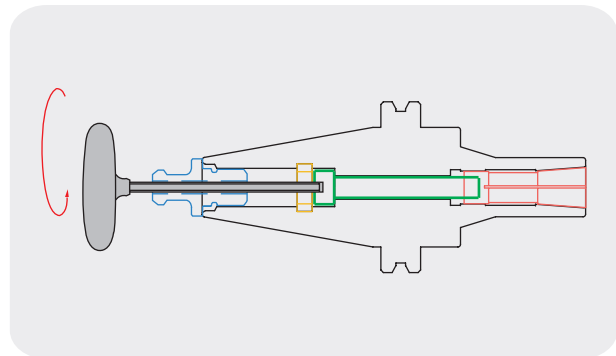
How to use HMC

1. Clean up the I.D. of the HMC, I.D. and O.D. of the collet and the cutter shank.
2. Insert the collet or the cutter shank in the I.D. of the HMC.
3. Tighten the nut using MCW wrench. Tighten the nut all the way down until the o-ring located at the bottom of the nut kisses the flange of the body.
4. Do not tighten the nut after o-ring kisses the flange.



How to use HMX

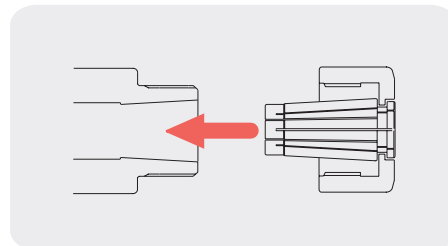
1. Clean up the taper bore of the chuck, O.D and I.D. of VX collet and cutter shank by using air blow.
2. Insert wrench from the back of the holder or through coolant hole of the pull stud. Pull the collet into the chuck by rotating the wrench clockwise. Tightening torque is 29-43 lb-ft.



How to use HSX

1. Clean up the taper bore of the chuck, O.D. and I.D. of SX collet and cutter shank by using air blow.
2. Insert collet into nut using collet squeezer first.
3. Put nut and collet into the bore of the chuck.
4. Insert cutter into the collet.
5. Tighten the nut. Refer to the tightening torques shown right.

*Insert collet into nut using collet squeezer first.



size	ft - lbs (Nm)
HSX 6	22 - 28 (29 - 39)
HSX10	33 - 43 (44 - 58)
HSX16	54 - 61 (73 - 83)
HSX25	65 - 71 (88 - 97)