

# TOOLING SYSTEMS



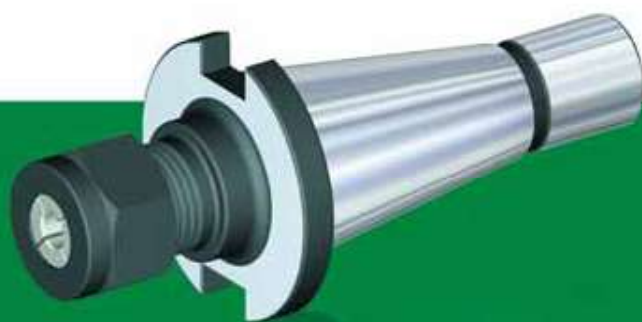
## QC and R8 Shank Tools

QC30 Shank Tools .....	G2–G9
QC40 Shank Tools .....	G10–G17
QC50 Shank Tools .....	G18–G22
R8 Shank Tools .....	G24–G27



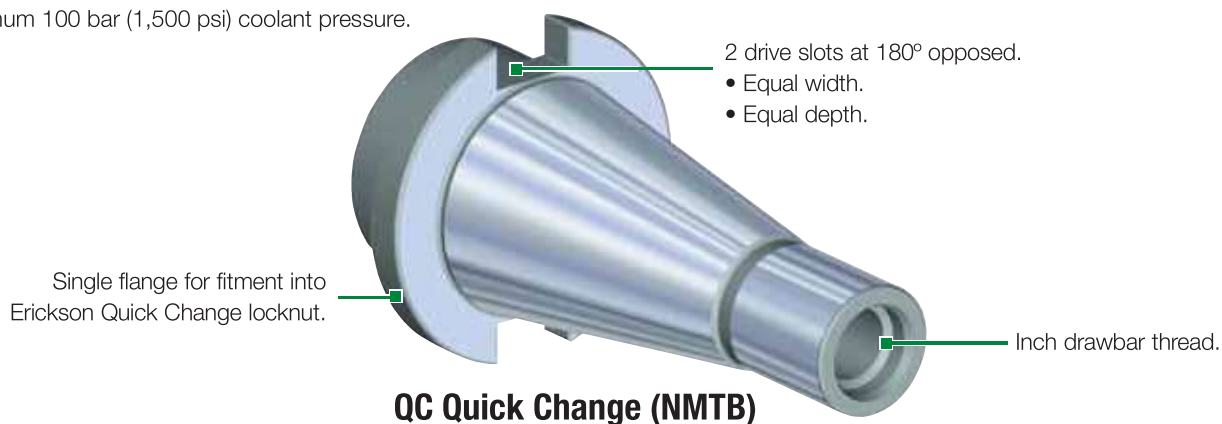
## Erickson™ Quick Change Flange Shank Tooling System • QC30 Series

With an Erickson QC locknut retrofitted to manual-loading milling machine spindles, the Erickson Quick Change Flange QC Taper Tooling can be used as a quick-change system. These tools are manufactured from premium materials and meet or exceed the latest ISO-1947 taper accuracy. The QC30 tools are balanced-by-design and will perform effectively up to 8,000 RPM. For any applications higher than 8,000 RPM, WIDIA™ recommends that the complete toolholder assembly (toolholder, collets, hardware, and cutting tools) be balanced as one identity.



# QC30

- 7/24 taper, interchangeable with NMTB and DIN2080 shank tooling.
- Hub at the tail end of taper cone houses the machine's drawbar bolt, standard 1/2" – 13 UNC – 2B thread.
- Flange faces are precision ground to accommodate Erickson QC locknuts.
- Taper accuracy of AT4 specification or better.
- Maximum 8,000 RPM.
- Maximum 100 bar (1,500 psi) coolant pressure.





### How Do Catalog Numbers Work?

Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



QC30TG50100M

**QC**

Shank  
Style

**30**

Shank  
Taper  
Size

30 = 30  
40 = 40  
50 = 50

**TG**

Toolholder  
Style

**DA** = Double-angle collet chuck  
**EM** = End mill adapter  
**MS** = Morse taper adapter  
**SA** = Slotting cutter adapter  
**SM** = Shell mill adapter  
**TA** = Tap chuck adapter  
**TG** = Tremendous Grip single-angle collet chuck

**50**

Toolholder  
Size

**100**

Tool  
Length

(Taper gage  
line to from  
of tool)  
**inch**  
xxx = x.xx

**M**

Tool  
Length

**TG** =  
Collet series xx (50), xxx (100)  
**EM** =  
I.D. size: metric — xx = xx, (20);  
inch — xxx = x.xx, (075)  
**SM** =  
O.D. size: metric — xx = xx, (20);  
inch — xxx = x.xx, (075)

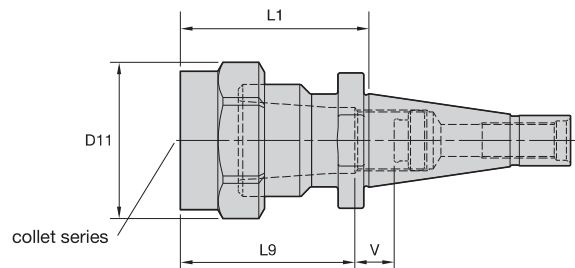
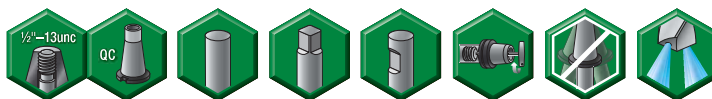
**M** = Tool built to metric  
values and has metric  
retention thread  
**(blank)** = Tool built to inch  
values and has inch  
retention thread

## QC30 Shank Tools

### TG Single-Angle Collet Chucks



- Tremendous Grip (3:1 advantage).



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#### ■ TG Hex-QC IN

TG collet series	Collet Capacity			
	mm		inch	
	min	max	min	max
TG75	2,6	20,0	3/64	3/4
TG100	2,6	25,5	5/64	1

order number	catalog number	collet series	D11	L1	L9	V	locknut	wrench	ft. lbs.	stop screw	wrench size stop screw	lbs
1025640	QC30TG075253	TG75	1.81	2.53	2.31	.37	NPA075	OEW188	100	SS081041G	4mm & 5/32	1.26
1025641	QC30TG100394	TG100	2.44	3.94	2.91	.83	NPA100	OEW225	150	SS081041G	4mm & 5/32	2.57

NOTE: Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque.

Collet chuck technical section, see page K74.

Supplied with locknut and stop screw.

Locknut wrench must be ordered separately.

Interchangeable locknuts, coolant-style locknuts, and coolant disks are available and must be ordered separately; see page J6.

Stop screw coolant caps are available and must be ordered separately; see page J22.

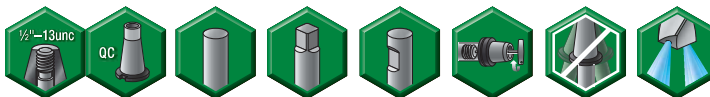
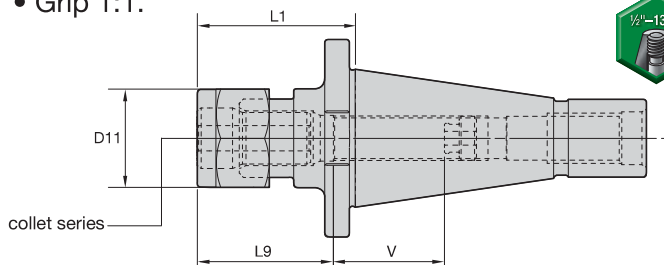
Balanceable/interchangeable locknuts are available and must be ordered separately; see page J3.

TG standard straight-bore collets, see page I10.

TG tap collets, see page I10.

For retention knobs, see page J33.

- Grip 1:1.


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**■ DA Hex-QC IN**

DA collet series	Collet Capacity			
	mm		inch	
	min	max	min	max
DA300	0,2	6	1/64	1/4
DA200	0,2	10	1/64	25/64
DA100	1,8	14	1/64	9/16
DA180	2,2	20	1/64	3/4

order number	catalog number	collet series	D11	L1	L9	V	lbs
1015552	QC30DA308162	DA300	.77	1.62	1.34	1.38	.73
1015546	QC30DA208181	DA200	1.15	1.81	1.42	1.49	.82
1015595	QC30DA188206	DA180	1.73	2.06	1.93	.47	.90
1015544	QC30DA108200	DA100	1.44	2.00	1.65	1.10	.90

**■ Spare Parts**

catalog number	locknut	locknut wrench	ft. lbs.	stop screw	wrench size stop screw
QC30DA308162	LNA308M	—	20	SS031031G	2mm & 5/64
QC30DA208181	NPA208	OEW100	40	SS044038G	2mm & 5/64
QC30DA188206	NPA188	OEW150	75	SS081041G	4mm & 5/32
QC30DA108200	LNA108M	OEW32M	55	SS056041G	4mm & 5/32

NOTE: Tighten locknut to the recommended tightening torque.

Collet chuck technical section, see page K74.

Supplied with locknut and stop screw.

Locknut wrench must be ordered separately.

Stop screw coolant caps are available and must be ordered separately; see page J22.

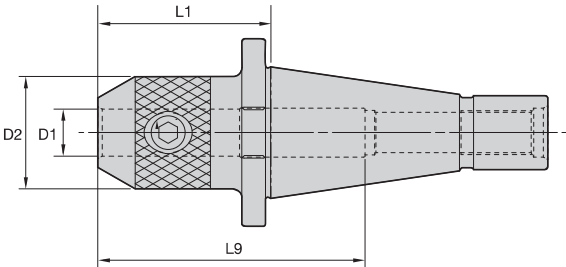
DA standard straight-bore collets, see page I62.

DA non-pullout collets, see page I65.

For retention knobs, see page J33.

# QC30 Shank Tools

## End Mill Adapters



### ERICKSON

#### ■ EM IN-QC IN

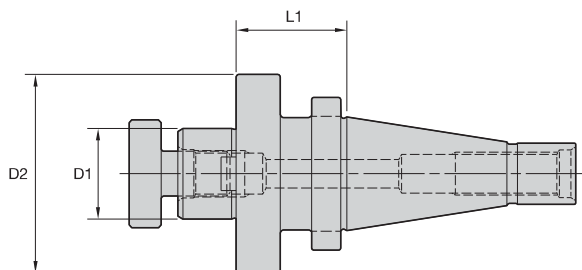
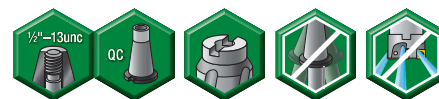


order number	catalog number	D1	D2	L1	L9	lock screw	wrench size lock screw	ft. lbs.	lbs
1018668	QC30EM018175	3/16	.69	1.75	3.40	S1045PKG	3/32	3	.73
1018669	QC30EM038175	3/8	1.00	1.75	3.40	ELS038031PKG	3/16	15	.84
1018671	QC30EM062175	5/8	1.44	1.75	2.14	DWG ELS056038	1/4	40	.96
1018242	QC30EM025175	1/4	1.00	1.75	3.40	ELS025025PKG	1/8	5	.86
1018670	QC30EM050175	1/2	1.25	1.75	3.07	ELS044038PKG	7/32	20	.90
1018672	QC30EM075213	3/4	1.75	2.13	2.27	ELS062050PKG	5/16	70	1.28
1018714	QC30EM100269	1	2.00	2.69	2.51	ELS075056PKG	3/8	110	1.73
1018715	QC30EM125363	1 1/4	2.50	3.63	2.51	ELS075062PKG	3/8	110	3.65

NOTE: Do not overtighten lock screw; use torque recommendations above.  
 Supplied with lock screw.  
 Lock screw wrench not included.  
 For retention knobs, see page J33.

QC30 Shank Tools





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■ SM IN-QC IN



order number	catalog number	D1	D2	L1	lock screw	drive key	wrench size retention screw	lbs
1018716	QC30SM050125	1/2	1.44	1.25	KLS05	KDK04	3/16	1
1018717	QC30SM075131	3/4	1.75	1.31	KLS07	KDK05	1/4	1
1018718	QC30SM100131	1	2.19	1.31	KLS10	KDK06	5/16	2
1018719	QC30SM125144	1 1/4	2.88	1.44	KLS12	KDK08	5/16	2
1018720	QC30SM150156	1 1/2	3.81	1.56	KLS15	KDK10	3/8	4

NOTE: Do not overtighten lock screw.

Supplied with lock screw and drive keys.

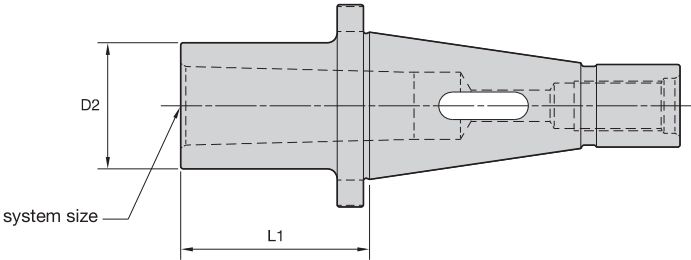
Interchangeable coolant-style lock screws are available and must be ordered separately; see page J26.

Lock screw wrench not included.

For retention knobs, see page J33.

# QC30 Shank Tools

## Morse Taper Adapters



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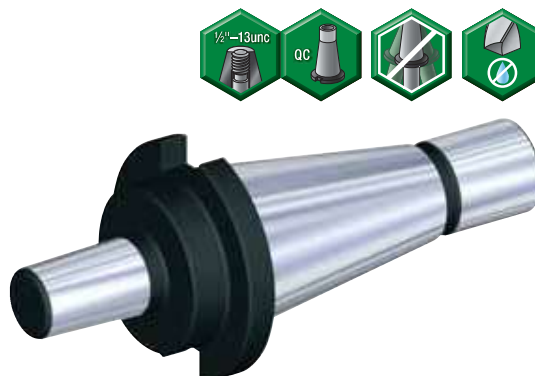
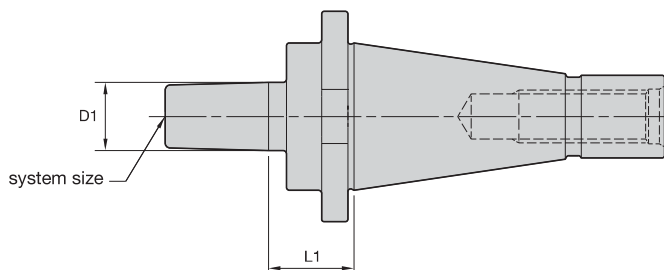
■ MT-QC IN

order number	catalog number	system size	D2	L1	kg
1018721	QC30MT1100	1	25	25,40	0,31
1018722	QC30MT2212	2	32	53,85	0,44
1018723	QC30MT3281	3	40	71,37	0,54

NOTE: For retention knobs, see page J33.

QC30 Shank Tools





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■ JT-QC IN

order number	catalog number	system size	D1	L1	lbs
1018774	QC30JT1159	1	.38	.93	.80
1018775	QC30JT2181	2	.56	.94	.84
1018776	QC30JT3219	3	.81	.97	.95
1018779	QC30JT33197	33	.62	.97	.86
1018777	QC30JT4262	4	1.12	.96	1.25
1018778	QC30JT6197	6	.68	.97	.89

NOTE: For retention knobs, see page J33.



## Erickson™ Quick Change Flange Shank Tooling System •

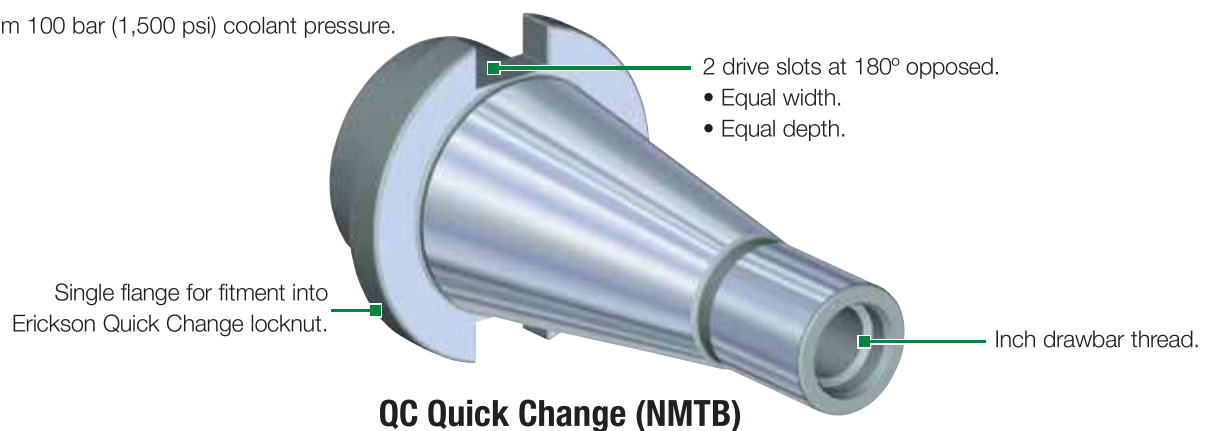
### QC40 Series

With an Erickson QC locknut retrofitted to manual-loading milling machine spindles, the Erickson Quick Change Flange QC Taper Tooling can be used as a quick-change system. These tools are manufactured from premium materials and meet or exceed the latest ISO-1947 taper accuracy. The QC40 tools are balanced-by-design and will perform effectively up to 8,000 RPM. For any applications higher than 8,000 RPM, WIDIA™ recommends that the complete toolholder assembly (toolholder, collets, hardware, and cutting tools) be balanced as one identity.

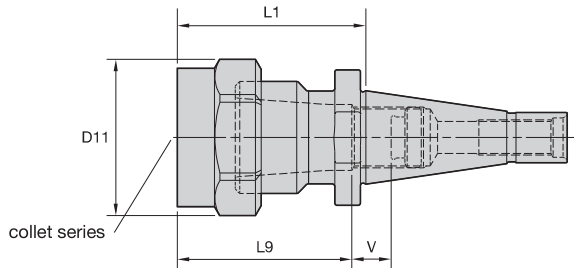
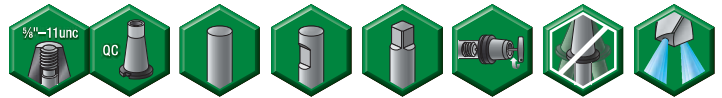


# QC40

- 7/24 taper, interchangeable with NMTB and DIN2080 shank tooling.
- Hub at the tail end of taper cone houses the machine's drawbar bolt, standard 5/8" – 11 UNC – 2B thread.
- Flange faces are precision ground to accommodate Erickson QC locknuts.
- Taper accuracy of AT4 specification or better.
- Maximum 8,000 RPM.
- Maximum 100 bar (1,500 psi) coolant pressure.



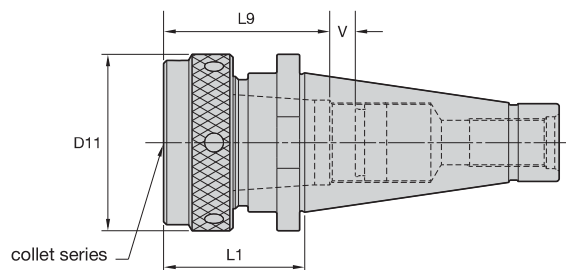
- Tremendous Grip (3:1 advantage).



TG collet series	mm		inch	
	min	max	min	max
TG75	2,6	20,0	3/64	3/4
TG100	2,6	25,5	5/64	1
TG150	11,6	40,0	23/64	1-1/2

**ERICKSON**
**■ TG Hex-QC IN**


order number	catalog number	collet series	D11	L1	L9	V	locknut	wrench	stop screw	wrench size stop screw	lbs
1025642	QC40TG075211	TG75	2.09	2.11	2.31	1.04	NPA075	OEW188	SS081041G	4mm & 5/32	2.07
1025643	QC40TG100255	TG100	2.50	2.55	2.72	.41	NPA100	OEW225	SS112041G	4mm & 5/32	2.56



TG collet series	mm		inch	
	min	max	min	max
TG150	11,6	40,0	23/64	1-1/2

**■ TG Round-QC IN**


order number	catalog number	collet series	D11	L1	L9	V	locknut	wrench	stop screw	wrench size stop screw	lbs
1013525	QC40TG150450	TG150	3.48	4.50	3.22	1.24	NPA150	PSW350	SS125050G	4mm & 5/32	5.75

**NOTE:** Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque.

Collet chuck technical section, see page K74.

Supplied with locknut and stop screw.

Locknut wrench must be ordered separately.

Interchangeable locknuts, coolant-style locknuts, and coolant disks are available and must be ordered separately; see page J6.

Stop screw coolant caps are available and must be ordered separately; see page J22.

Balanceable/interchangeable locknuts are available and must be ordered separately; see page J3.

TG standard straight-bore collets, see page I10.

TG tap collets, see page I10.

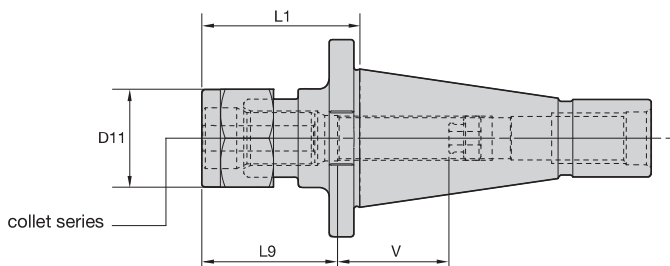
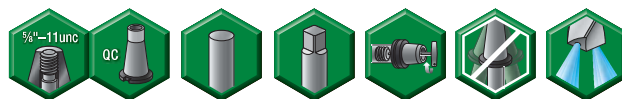
For retention knobs, see page J33.

## QC40 Shank Tools

### DA 08 Series Double-Angle Collet Chucks



- Grip 1:1.



**ERICKSON**

#### ■ DA Hex-QC IN

DA collet series	Collet Capacity			
	mm		inch	
	min	max	min	max
DA300	0,2	6	1/64	1/4
DA200	0,2	10	1/64	25/64
DA100	1,8	14	1/64	9/16
DA180	2,2	20	1/64	3/4

order number	catalog number	collet series	D11	L1	L9	V	lbs
1015413	QC40DA308163	DA300	.77	1.63	1.30	1.30	1.69
1015412	QC40DA208181	DA200	1.15	1.81	1.46	2.04	1.79
1015410	QC40DA108200	DA100	1.44	2.00	1.65	2.05	1.87
1015411	QC40DA188206	DA180	1.73	2.06	1.93	1.73	1.82

#### ■ Spare Parts



catalog number	locknut	locknut wrench	ft. lbs.	stop screw	wrench size stop screw
QC40DA308163	LNA308M	—	20.00	SS031031G	2mm & 5/64
QC40DA208181	NPA208	OEW100	40.00	SS044038G	4mm & 5/32
QC40DA108200	LNA108M	OEW32M	55.00	SS056041G	4mm & 5/32
QC40DA188206	NPA188	OEW150	75.00	SS081041G	4mm & 5/32

NOTE: For retention, tighten locknut to the recommended tightening torque.

Collet chuck technical section, see page K74.

Supplied with locknut and stop screw.

Locknut wrench must be ordered separately.

Stop screw coolant caps are available and must be ordered separately; see page J22.

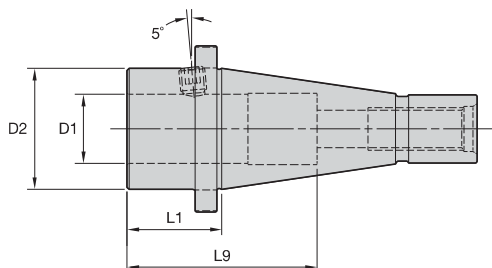
DA standard straight-bore collets, see page I62.

DA non-pullout collets, see page I65.

For retention knobs, see page J33.



- Through-the-toolholder coolant capability — form AD.
- 1" — 8 UNC drawbar thread.
- Suitable for Whistle Notch straight-shank-style tap chucks.



**ERICKSON**

■ SWN IN-QC IN

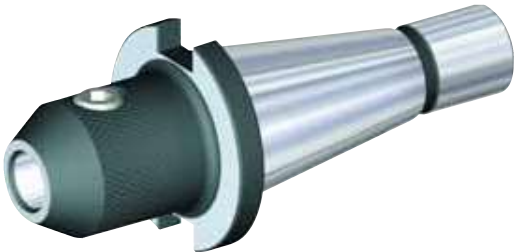
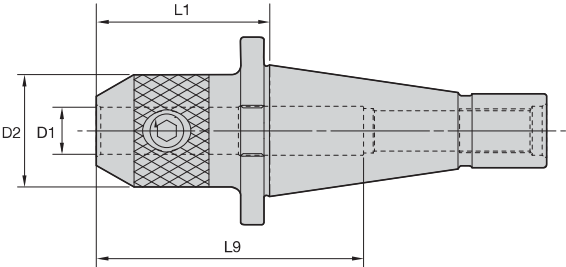


order number	catalog number	D1	D2	L1	L9	lock screw	wrench size lock screw	ft. lbs.	lbs
1017943	QC40TA1137	1.00	1.75	1.38	2.75	—	3/16	15	1.68

NOTE: Do not overtighten clamp screw; use torque recommendations above.  
Supplied with clamp screw.  
Clamp screw wrench not included.  
For retention knobs, see page J33.

# QC40 Shank Tools

## End Mill Adapters



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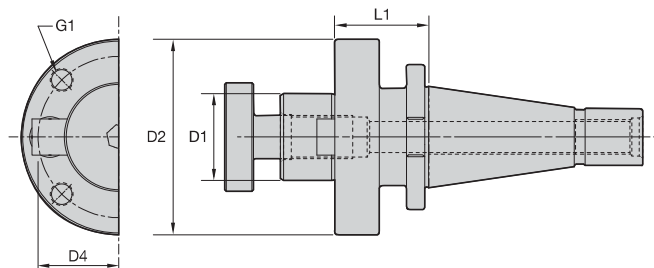
■ EM IN-QC IN



order number	catalog number	D1	D2	L1	L9	lock screw	wrench size lock screw	ft. lbs.	lbs
1018781	QC40EM018231	.19	.69	2.31	4.84	S1045PKG	3/32	3	1.74
1018667	QC40EM025138	.25	1.00	1.38	3.91	ELS025025PKG	1/8	5	1.73
1018782	QC40EM038231	.38	1.00	2.31	4.84	ELS038031PKG	3/16	15	1.86
1018783	QC40EM050231	.50	1.25	2.31	4.84	ELS044038PKG	7/32	20	2.02
1018844	QC40EM062231	.63	1.50	2.31	3.56	ELS056050PKG	1/4	40	2.18
1018845	QC40EM075231	.75	1.75	2.31	3.94	ELS062050PKG	5/16	70	2.46
1018846	QC40EM088294	.88	2.00	2.94	4.19	ELS062050PKG	5/16	70	2.80
1018847	QC40EM100338	1.00	2.00	3.38	4.49	ELS075056PKG	3/8	110	3.00
1018848	QC40EM125369	1.25	2.50	3.69	2.39	ELS075062PKG	3/8	110	4.63
1019099	QC40EM150395	1.50	2.75	3.95	2.82	ELS075062PKG	3/8	110	5.29

NOTE: Do not overtighten lock screw; use torque recommendations above.  
 Supplied with lock screw.  
 Lock screw wrench not included.  
 For retention knobs, see page J33.

QC40 Shank Tools



**ERICKSON**

### ■ SM IN-QC IN

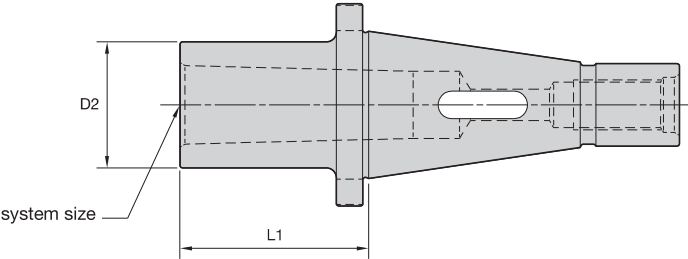


order number	catalog number	D1	D2	D4	G1	L1	lock screw	drive key	wrench size lock screw	lbs
1018849	QC40SM050088	1/2	1.44	—	—	.88	KLS05	KDK04	3/16	1.90
1018850	QC40SM075088	3/4	1.75	—	—	.88	KLS07	KDK05	1/4	2.02
1018851	QC40SM100131	1	2.19	—	—	1.31	KLS10	KDK06	5/16	2.57
1018852	QC40SM125150	1 1/4	2.88	—	—	1.50	KLS12	KDK08	5/16	3.47
1018853	QC40SM150163	1 1/2	3.38	—	—	1.63	KLS15	KDK10	3/8	4.58
1018904	QC40SM200163	2	4.88	4.00	5/8-11 UNC	1.63	KLS20	KDK12	9/16	6.85

**NOTE:** Do not overtighten lock screw.  
 Supplied with lock screw and drive keys.  
 Interchangeable coolant-style lock screws are available and must be ordered separately; see page J26.  
 Lock screw wrench not included.  
 For retention knob, see page J33.

# QC40 Shank Tools

## Morse Taper Adapters



### ERICKSON

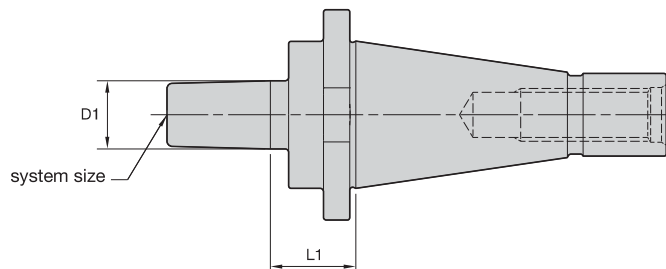
#### ■ MT-QC IN

order number	catalog number	system size	D2	L1	lbs
1018905	QC40MT1094	1	1.00	.94	1.64
1018906	QC40MT2206	2	1.25	2.06	1.93
1018907	QC40MT3225	3	1.50	2.25	1.95
1018908	QC40MT4306	4	1.88	3.06	2.33
1019097	QC40MT5700	5	2.38	7.00	5.57

NOTE: For retention knobs, see page J33.

QC40 Shank Tools





**ERICKSON**

■ JT-QC IN

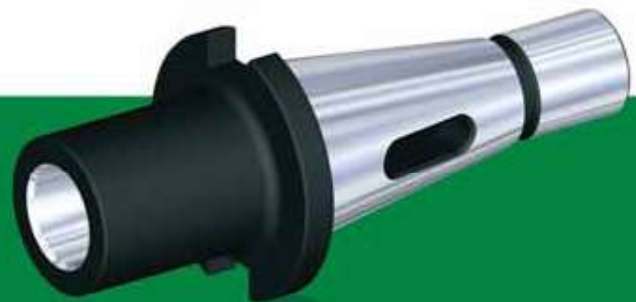
order number	catalog number	system size	D1	L1	lbs
1018909	QC40JT2188	2	.56	1.01	2.02
1018910	QC40JT3225	3	.81	1.03	2.11
1018913	QC40JT33194	33	.62	.94	2.00
1018911	QC40JT4269	4	1.12	1.03	2.44
1018912	QC40JT6194	6	.68	.94	2.02

NOTE: For retention knobs, see page J33.

## Erickson™ Quick Change Flange Shank Tooling System •

### QC50 Series

With an Erickson QC locknut retrofitted to manual-loading milling machine spindles, the Erickson Quick Change Flange QC Taper Tooling can be used as a quick-change system. These tools are manufactured from premium materials and meet or exceed the latest ISO-1947 taper accuracy. The QC50 tools are balanced-by-design that will perform effectively up to 8,000 RPM. For any applications higher than 8,000 RPM, WIDIA™ recommends that the complete toolholder assembly (toolholder, collets, hardware, and cutting tools) be balanced as one identity.

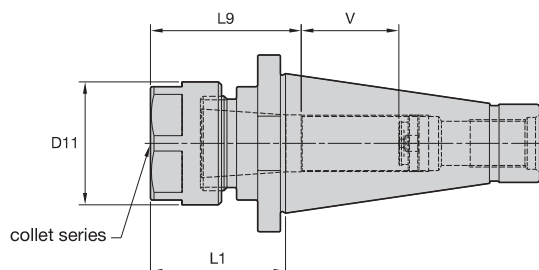
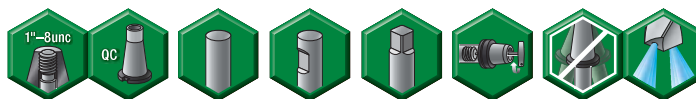


# QC50

- 7/24 taper, interchangeable with NMTB and DIN2080 shank tooling.
- Hub at the tail end of taper cone houses the machine's drawbar bolt, standard 1" – 8 UNC – 2B thread.
- Flange faces are precision ground to accommodate Erickson QC locknuts.
- Taper accuracy of AT4 specification or better.
- Maximum 8,000 RPM.
- Maximum 100 bar (1,500 psi) coolant pressure.



- Tremendous Grip (3:1 advantage).



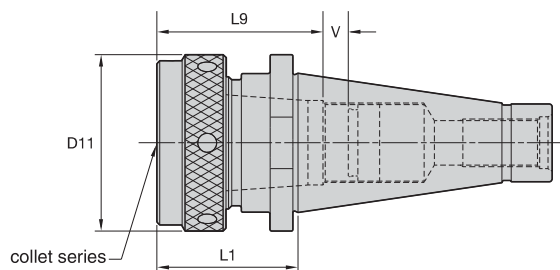
TG collet series	Collet Capacity			
	mm	inch	min	max
TG100	2,6	25,5	5/64	1
TG150	11,6	40,0	23/64	1-1/2

## ERICKSON

### ■ TG Hex-QC IN



order number	catalog number	collet series	D11	L1	L9	V	locknut	wrench	stop screw	wrench size stop screw	ft. lbs.	lbs
1025798	QC50TG100272	TG100	2.44	2.72	2.76	2.28	NPA100	OE225	SS112041G	4mm & 5/32	150	6.45



### ■ TG Round-QC IN



order number	catalog number	collet series	D11	L1	L9	V	locknut	wrench	stop screw	wrench size stop screw	ft. lbs.	lbs
1013526	QC50TG150284	TG150	3.50	2.84	3.15	1.26	NPA150	PSW350	SS162062G	4 mm & 5/32	200	7.14

**NOTE:** Collet must be loaded into locknut first. Before loading into the chuck body, insert the cutting tool, then tighten to the recommended tightening torque.

Collet chuck technical section, see page K74.

Supplied with locknut and stop screw.

Locknut wrench must be ordered separately.

Interchangeable locknuts, coolant-style locknuts, and coolant disks are available and must be ordered separately; see page J6.

Stop screw coolant caps are available and must be ordered separately; see page J22.

Balanceable/interchangeable locknuts are available and must be ordered separately; see page J3.

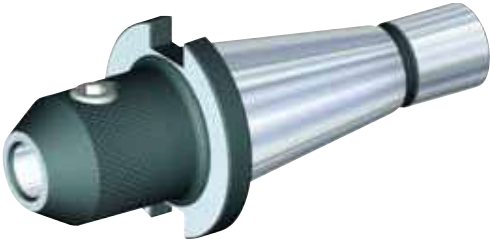
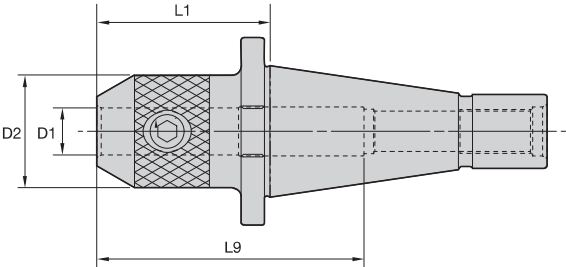
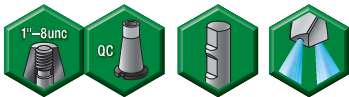
TG standard straight-bore collets, see page I10.

TG tap collets, see page I10.

For retention knobs, see page J33.

# QC50 Shank Tools

## End Mill Adapters



**ERICKSON**

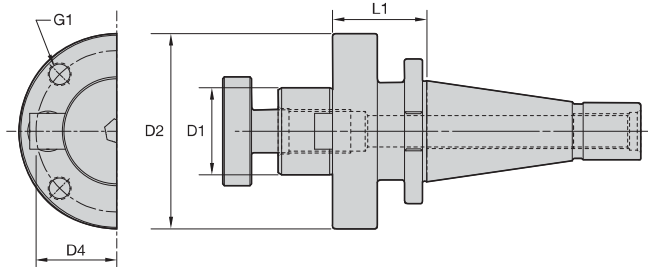
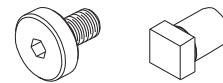
■ EM IN-QC IN



order number	catalog number	D1	D2	L1	L9	lock screw	wrench size lock screw	ft. lbs.	lbs
1019096	QC50EM038275	3/8	1.00	2.75	5.96	ELS038031PKG	3/16	15	5.81
1018979	QC50EM050275	1/2	1.38	2.75	5.96	ELS044038PKG	7/32	20	6.07
1019101	QC50EM062275	5/8	1.63	2.75	5.96	ELS056050PKG	1/4	40	6.18
1019100	QC50EM075275	3/4	1.75	2.75	5.96	ELS062050PKG	5/16	70	6.30
1018980	QC50EM088200	7/8	2.00	2.00	4.19	ELS062050PKG	5/16	70	6.05
1018981	QC50EM100306	1	2.00	3.06	4.49	ELS075056PKG	3/8	110	6.58
1019102	QC50EM125306	1-1/4	2.50	3.06	2.39	ELS075062PKG	3/8	110	7.57
1019145	QC50EM150350	1-1/2	2.75	3.50	2.82	ELS075069PKG	3/8	110	8.42
1018982	QC50EM200475	2	3.75	4.75	3.38	ELS100088PKG	1/2	150	13.67

NOTE: Do not overtighten lock screw; use torque recommendations above.  
 Supplied with lock screw.  
 Lock screw wrench not included.  
 For retention knobs, see page J33.

QC50 Shank Tools


**ERICKSON**
**■ SM IN-QC IN**


order number	catalog number	D1	D2	D4	G1	L1	lock screw	drive key	wrench size retention screw	lbs
1925520	QC50SM050125	1/2	1.44	—	—	1.25	KLS05	KDK04	3/16	5.71
1018983	QC50SM075125	3/4	1.75	—	—	1.25	KLS07	KDK05	1/4	5.78
1019273	QC50SM075600	3/4	1.75	—	—	6.00	KLS07	KDK05	1/4	9.40
1019024	QC50SM100188	1	2.19	—	—	1.88	KLS10	KDK06	5/16	7.28
1019334	QC50SM100600	1	2.19	—	—	6.00	KLS10	KDK06	5/16	11.57
1019335	QC50SM100800	1	2.19	—	—	8.00	KLS10	KDK06	5/16	14.36
1019336	QC50SM125600	1-1/4	2.75	—	—	6.00	KLS12	KDK08	5/16	14.45
1019337	QC50SM1251000	1-1/4	2.75	—	—	10.00	KLS12	KDK08	5/16	20.66
1019025	QC50SM125188	1-1/4	2.88	—	—	1.88	KLS12	KDK08	5/16	14.78
1019146	QC50SM150188	1-1/2	3.38	—	—	1.88	KLS15	KDK10	3/8	8.99
1019095	QC50SM200188	2	4.88	4.00	5/8-11 UNC	1.88	KLS20	KDK12	9/16	11.04
1019026	QC50SM250200	2-1/2	4.88	4.00	5/8-11 UNC	2.00	—	KDK16	1/2	11.94

NOTE: Do not overtighten lock screw; use torque recommendations above.

Supplied with lock screw and drive keys.

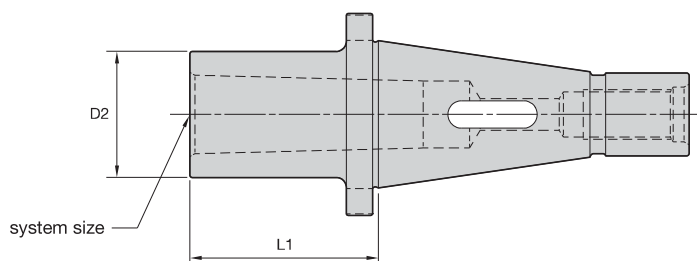
Interchangeable coolant-style lock screws are available and must be ordered separately; see page J26.

Lock screw wrench not included.

For retention knob, see page J33.

## QC50 Shank Tools

Morse Taper Adapters • Slotting Cutter Adapters



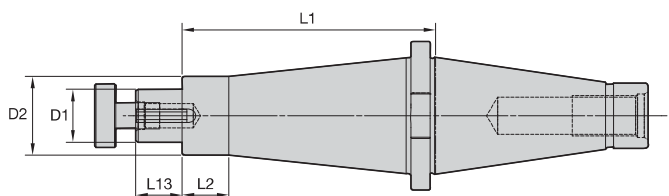
**ERICKSON**

■ MT-QC IN

order number	catalog number	system size	D2	L1	lbs
1019027	QC50MT2188	2	1.25	1.88	5.61
1019028	QC50MT3238	3	1.62	2.38	5.67
1019029	QC50MT4325	4	2.00	3.25	6.44
1019030	QC50MT5462	5	2.75	4.62	8.74

NOTE: For retention knobs, see page J33.

QC50 Shank Tools



**ERICKSON**

■ SA IN-QC IN

order number	catalog number	D1	D2	L1	L2	L13	lock screw	wrench size lock screw	drive key	lbs
1026342	QC50SA125600	1-1/4	1.86	6.00	1.10	1.09	KLS12	5/16	DWG SDK125119	12.27
1026343	QC50SA150600	1-1/2	2.11	6.00	1.25	1.70	KLS15	3/8	DWG SDK150175	13.49
1026222	QC50SA200600	2	2.75	6.00	5.41	1.70	KLS20	9/16	SDK200169	16.72

NOTE: Do not overtighten lock screw.  
Supplied with lock screw and drive key.  
Lock screw wrench not included.  
For retention knobs, see page J33.



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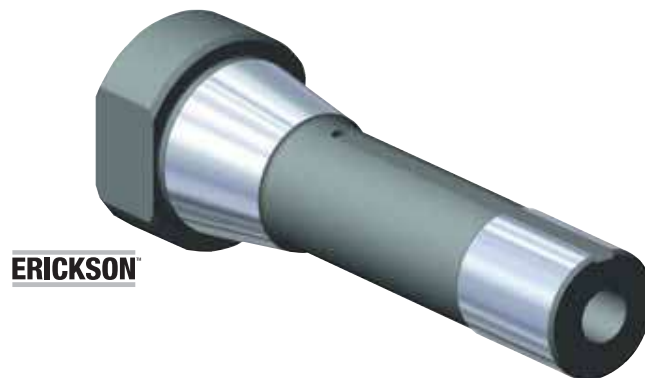
## Shank Tooling System • R8 Shank Tooling

R8 Shank Toolholders are designed with a locking groove that aligns into a locking mechanism when inserted into the spindle. A milling machine drawbar bolt pulls the tool into the spindle for a secure connection. If the toolholder assembly is properly balanced and application conditions are appropriate, R8 shanks can operate effectively up to 8,000 RPM.



# R8

- All non-critical surfaces are black oxide.
- Design enables coolant as a standard feature.
- Clean components prior to assembly.
- To avoid destroying the toolholder, never overtighten toolholders or neglect surface damage.



### How Do Catalog Numbers Work?

Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



## R8

Shank  
Style

## DA

Toolholder  
Style

**DA** = Double-angle collet chuck  
**EM** = End mill adapter  
**SM** = Shell mill adapter

## 188

Toolholder  
Size

## 181

Tool  
Length

(Tool gage line  
to front of tool)

**inch**  
xxx = x.xx

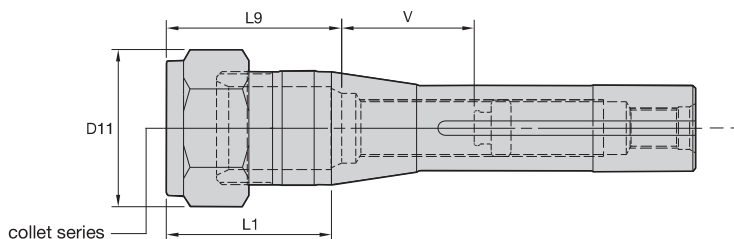
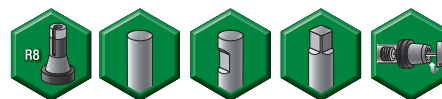
**DA** =  
Collet series xxx (188)  
**EM** =  
I.D. size: metric — xx = xx, (20);  
inch — xxx = x.xx, (075)  
**SM** =  
O.D. size: metric — xx = xx, (20);  
inch — xxx = x.xx, (075)

## R8 Shank Tools

DA 08 Series Double-Angle Collet Chucks



- Grip 1:1.



**ERICKSON**

### ■ DA 08 Hex-R8

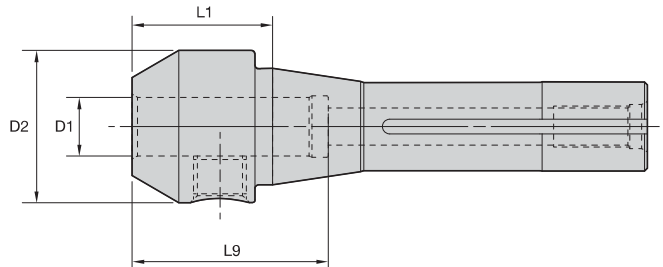
DA collet series	Collet Capacity			
	mm		inch	
	min	max	min	max
DA180	2,2	20	1/64	3/4

order number	catalog number	collet series	D11	L1	L9	V	lbs
1015548	R8DA188181	DA180	1.73	1.81	2.29	2.36	1.01

### ■ Spare Parts

catalog number	locknut	locknut wrench	ft. lbs.	stop screw	wrench size stop screw
R8DA188181	NPA188	OEW150	75	SS062041G	4mm & 5/32

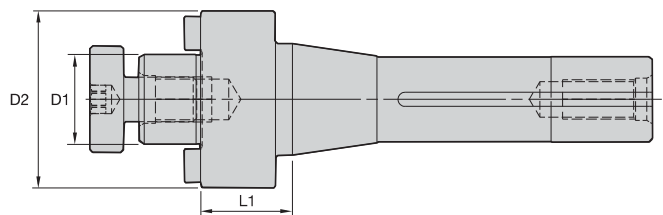
NOTE: For retention, tighten locknut to the recommended tightening torque.  
 Collet chuck technical section, see page K74.  
 Supplied with locknut and stop screw.  
 Locknut wrench must be ordered separately.  
 Stop screw coolant caps are available and must be ordered separately; see page J22.  
 DA standard straight-bore collets, see page I62.  
 DA non-pullout collets, see page I65.


**ERICKSON**
**EM IN-R8**


order number	catalog number	D1	D2	L1	L9	lock screw	wrench size lock screw	ft. lbs.	lbs
1286048	R8EM018112	3/16	.69	1.13	1.01	S1045PKG	3/32	5	.86
1286049	R8EM038100	3/8	1.00	1.00	1.73	ELS038031PKG	3/16	15	.90
1286050	R8EM050112	1/2	1.24	1.13	1.73	ELS044038PKG	7/32	20	.95
1286051	R8EM062150	5/8	1.63	1.50	2.09	ELS056050PKG	1/4	40	1.29
1229174	R8EM075262	3/4	1.75	2.63	2.22	ELS062050PKG	5/16	70	2.04
1286052	R8EM088306	7/8	2.00	3.06	2.22	ELS062050PKG	5/16	70	2.80
1286053	R8EM100306	1	2.00	3.06	2.46	ELS075056PKG	3/8	110	2.64
1286054	R8EM125306	1-1/4	2.50	3.06	2.51	ELS075056PKG	3/8	110	3.72

NOTE: Do not overtighten lock screw; use torque recommendations above.  
Supplied with lock screw.  
Lock screw wrench not included.

R8 Shank Tools


**ERICKSON**
**SM Lock IN-R8**


order number	catalog number	D1	D2	L1	lock screw	drive key	wrench size lock screw	lbs
1286058	R8SM050102	1/2	1.28	1.02	KLS05	KDK04	3/16	1.23
1286059	R8SM075102	3/4	1.63	1.02	KLS07	KDK05	1/4	1.50
1286060	R8SM100102	1	1.97	1.02	KLS10	KDK06	5/16	1.85
1286061	R8SM125102	1-1/4	2.50	1.02	KLS12	KDK08	5/16	2.51

NOTE: Do not overtighten lock screw.  
Supplied with lock screw and drive keys.  
Lock screw wrench not included.