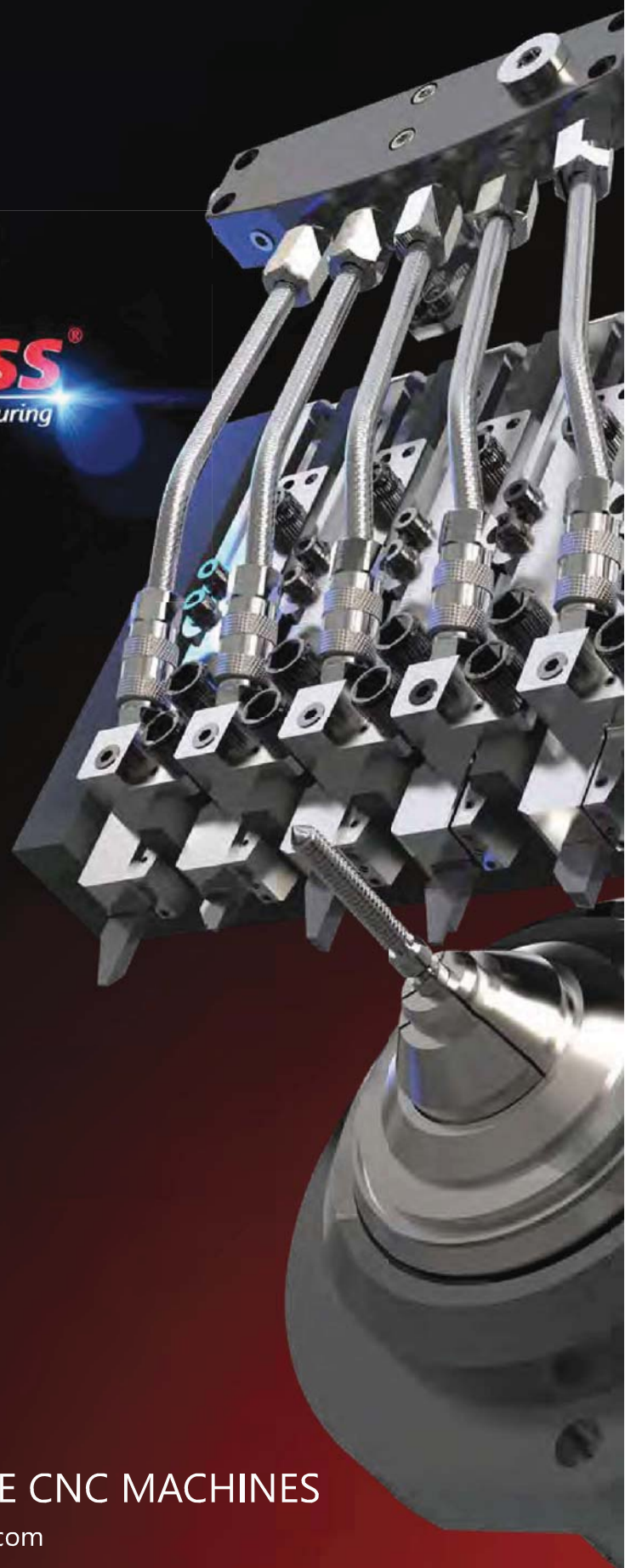




2019 Catalog

Version 10.19



TOOLING FOR SWISS-TYPE CNC MACHINES

www.genswiss.com



SIGNATURE SERIES COLLET SLEEVES

ER Style Collets are the tool holding system of choice for use in CNC machine applications. Swiss Precision collet sleeves provide rigid & accurate holding of ID tooling. These collet sleeves feature ground shanks and tapers. Mini nuts are used to reduce interference and to make setup and tool changing easier than collet sleeves with hexagonal clamping nuts.

Our Single Ended Swiss Precision Sleeves Feature:

- Locking flats to prevent damage to sleeve shank & provides orientation for tools
- Machined from medium carbon alloy steel
- Precision ground & through hardened for accuracy & precision
- Internal stop screw prevents tool pushback



Mini-Nut



Precision ER Collet Sleeves - Inch Shanks

Collet	Item No.	Description	Shank Dia. (D ₁)	Shank Length (L ₁)	OAL (L ₂)	With Locking Flat	Stop Screw	Nut Type
ER08	1025-000101	CS-08-095-070	0.375in	70mm	93mm	No	No	Mini-Nut
	1025-000201	CS-11-127-023	0.500in	23mm	30mm	Yes	No	No Mini-Nut
ER11	1025-000181	CS-11-158-022	0.625in	22mm	30mm	Yes	No	No Mini-Nut
	1025-000107	CS-11-158-050	0.625in	50mm	62mm	Yes	Yes	Mini-Nut
	1025-000108	CS-11-158-100	0.625in	100mm	112mm	Yes	Yes	Mini-Nut
	1025-000110	CS-11-190-070	0.750in	70mm	82mm	Yes	Yes	Mini-Nut
	1025-000177	CS-11-190-115	0.750in	115mm	135mm	Yes	Yes	Mini-Nut
	1025-000131	CS-16-158-075	0.625in	75mm	90mm	Yes	Yes	Mini-Nut
ER16	1025-000132A	CS-16-190-035	0.750in	35mm	50mm	Yes	Yes	Mini-Nut
	1025-000133	CS-16-190-050	0.750in	50mm	65mm	Yes	Yes	Mini-Nut
	1025-000134	CS-16-190-070	0.750in	70mm	85mm	Yes	Yes	Mini-Nut
	1025-000135	CS-16-190-100	0.750in	100mm	115mm	Yes	Yes	Mini-Nut
	1025-000224	CS-16-190-120	0.750in	120mm	148mm	Yes	Yes	Mini-Nut
	1025-000216	CS-16-254-022	1.00in	22mm	37mm	Yes	Yes	Mini-Nut
	1025-000272	CS-16-254-033	1.00in	33mm	49mm	Yes	Yes	Mini-Nut
	1025-000174	CS-16-254-038	1.00in	38mm	53mm	Yes	Yes	Mini-Nut
	1025-000130	CS-16-254-065	1.00in	65mm	80mm	Yes	No	Mini-Nut
	1025-000183	CS-16-254-075	1.00in	75mm	90mm	Yes	No	Mini-Nut
	1025-000138	CS-16-254-080	1.00in	80mm	95mm	Yes	Yes	Mini-Nut
	1025-000140	CS-16-254-100	1.00in	100mm	115mm	Yes	Yes	Mini-Nut
	1025-000142	CS-16-254-130	1.00in	130mm	145mm	Yes	Yes	Mini-Nut
	1025-000151	CS-20-254-100	1.00in	100mm	117mm	Yes	No	Mini-Nut
ER20	1025-000152	CS-20-254-140	1.00in	140mm	157mm	Yes	No	Mini-Nut



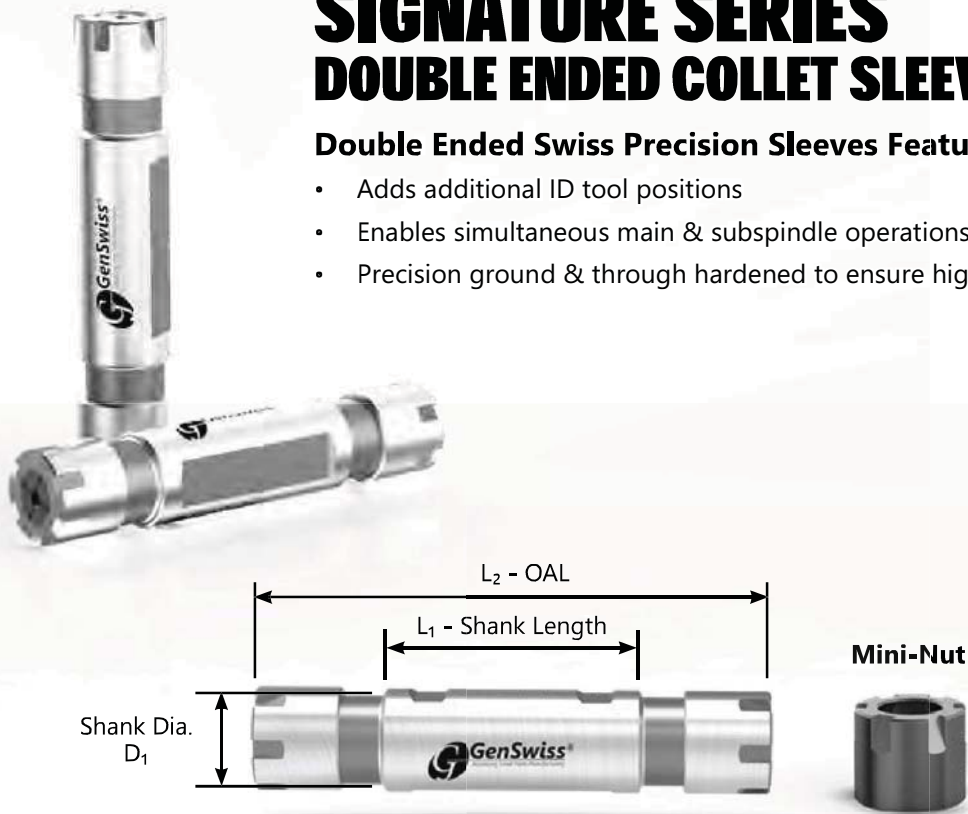
Precision ER Collet Sleeves - Metric Shanks

Collet	Item No.	Description	Shank Dia. (D_1)	Shank Length (L_1)	OAL (L_2)	With Locking Flat	Stop Screw	Nut Type
ER08	1025-000100	CS-08-080-080	8mm	80mm	106mm	No	No	Mini-Nut
	1025-000200	CS-11-080-056	8mm	56mm	78mm	No	Yes	Mini-Nut
ER11	1025-000109	CS-11-160-038	16mm	38mm	51mm	Yes	Yes	Mini-Nut
	1025-000164	CS-11-200-070	20mm	70mm	82mm	Yes	Yes	Mini-Nut
	1025-000234	CS-16-200-035	20mm	35mm	50mm	Yes	Yes	Mini-Nut
ER16	1025-000199	CS-16-200-070	20mm	70mm	85mm	Yes	Yes	Mini-Nut
	1025-000184	CS-16-200-100	20mm	100mm	115mm	Yes	Yes	Mini-Nut
	1025-000286	CS-16-200-140	20mm	140mm	168mm	Yes	Yes	Mini-Nut
	1025-000169	CS-16-220-070	22mm	70mm	86mm	Yes	Yes	Mini-Nut
	1025-000209	CS-16-220-100	22mm	100mm	116mm	Yes	Yes	Mini-Nut
	1025-000176	CS-16-250-065	25mm	65mm	81mm	Yes	Yes	Mini-Nut
	1025-000197	CS-16-250-100	25mm	100mm	115mm	Yes	No	Hex-Nut
	1025-000232	CS-16-250-160	25mm	160mm	175mm	Yes	No	Hex-Nut
	1025-000150	CS-20-220-080	22mm	80mm	97mm	Yes	No	Mini-Nut
ER20	1025-000211	CS-20-250-154	25mm	154mm	170mm	Yes	Yes	Mini-Nut
	1025-000178	CS-25-220-070	22mm	70mm	117mm	Yes	Yes	Mini-Nut
ER25	1025-000220	CS-25-250-145	25mm	145mm	181mm	Yes	Yes	Mini-Nut
	1025-000293	CS-25-320-070	32mm	70mm	100mm	Yes	Yes	Mini-Nut

SIGNATURE SERIES DOUBLE ENDED COLLET SLEEVES

Double Ended Swiss Precision Sleeves Features:

- Adds additional ID tool positions
- Enables simultaneous main & subspindle operations
- Precision ground & through hardened to ensure high accuracy



Double Ended Precision ER Collet Sleeves - Inch Shanks

Collet Size	Item No.	Description	Shank Dia. (D ₁)	Shank Length (L ₁)	OAL (L ₂)	With Locking Flat	Stop Screw	Nut Type
ER08	1025-000233	CS-08-158-015D	0.625in	15mm	45mm	Yes	No	Mini-Nut
	1025-000114	CS-11-190-035D	0.750in	35mm	51mm	Yes	No	Mini-Nut
ER11	1025-000115	CS-11-190-057D	0.750in	57mm	73mm	Yes	No	Mini-Nut
	1025-000116	CS-11-190-069D	0.750in	69mm	85mm	Yes	No	Mini-Nut
	1025-000117	CS-11-190-096D	0.750in	96mm	112mm	Yes	No	Mini-Nut
	1025-000124	CS-16-190-056D	0.750in	56mm	87mm	Yes	No	Mini-Nut
ER16	1025-000139	CS-16-254-045D	1.00in	45mm	75mm	Yes	No	Mini-Nut
	1025-000141	CS-16-254-075D	1.00in	75mm	105mm	Yes	No	Mini-Nut

Double Ended Precision ER Collet Sleeves - Metric Shanks

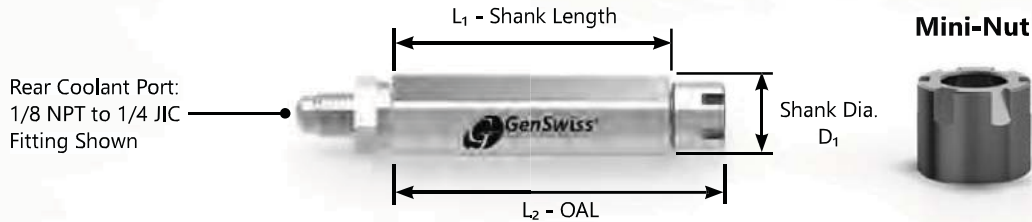
Collet Size	Item No.	Description	Shank Dia. (D ₁)	Shank Length (L ₁)	OAL (L ₂)	With Locking Flat	Stop Screw	Nut Type
ER11	1025-000103	CS-11-160-050D	16mm	50mm	77mm	Yes	No	Mini-Nut
	1025-000167	CS-11-200-030D	20mm	30mm	57mm	Yes	No	Mini-Nut
	1025-000203	CS-11-200-050D	20mm	50mm	90mm	Yes	No	Mini-Nut
ER16	1025-000213	CS-16-200-055D	20mm	55mm	107mm	Yes	No	Mini-Nut
	1025-000127	CS-16-220-055D	22mm	55mm	91mm	Yes	No	Mini-Nut
	1025-000128	CS-16-220-075D	22mm	75mm	111mm	Yes	No	Mini-Nut
	1025-000129	CS-16-250-062D	25mm	62mm	118mm	Yes	No	Mini-Nut
ER20	1025-000206	CS-20-320-075D	32mm	75mm	107mm	Yes	No	Mini-Nut
	1025-000180	CS-20-320-110D	32mm	110mm	142mm	Yes	No	Mini-Nut

SIGNATURE SERIES

COOLANT-FED COLLET SLEEVES

Coolant-Fed Collet Sleeves Features:

- Designed for high-pressure coolant delivery systems
- Single & dual coolant port versions available
- Use with sealed coolant-style ER collets or standard collets



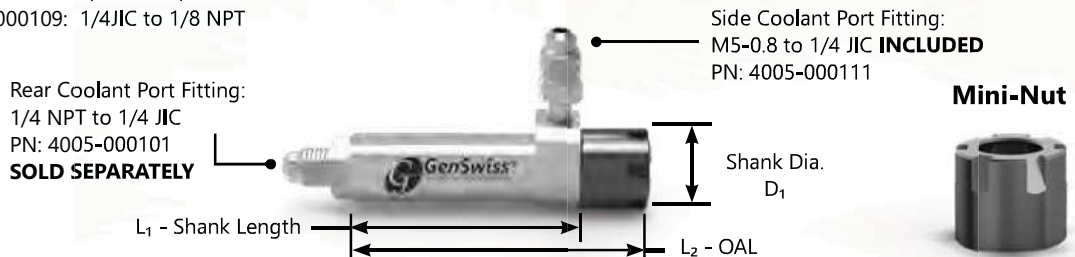
Coolant-Fed ER Collet Sleeves - Inch Shanks

Single Coolant Port

Collet Size	Item No.	Description	Shank Dia. (D ₁)	Shank Length (L ₁)	OAL (L ₂)	With Locking Flat	Stop Screw	Nut Type	Rear Coolant Port	Fitting PN
ER11	1025-000188	CS-11-190-035C	0.75in	35mm	44.5mm	Yes	Yes	Mini-Nut	1/8 NPT	4005-000109
	1025-000190	CS-11-190-062C	0.75in	62mm	71.5mm	Yes	Yes	Mini-Nut	1/8 NPT	4005-000109
ER16	1025-000119	CS-16-190-042C	0.75in	42mm	55mm	Yes	Yes	Mini-Nut	1/4 NPT	4005-000101
	1025-000121	CS-16-190-062C	0.75in	62mm	75mm	Yes	Yes	Mini-Nut	1/4 NPT	4005-000101
	1025-000123	CS-16-190-086C	0.75in	86mm	100mm	Yes	Yes	Mini-Nut	1/4 NPT	4005-000101
	1025-000228	CS-16-254-049C	1in	49mm	65mm	Yes	Yes	Mini-Nut	3/8 NPT	4005-000102
ER20	1025-000147	CS-20-254-050C	1in	50mm	67mm	Yes	Yes	Mini-Nut	3/8 NPT	4005-000102
	1025-000149	CS-20-254-085C	1in	83mm	100mm	Yes	Yes	Mini-Nut	3/8 NPT	4005-000102

NOTE: Fitting is included with **all** collet sleeves
 PN 4005-000101: 1/4JIC to 1/4 NPT
 PN 4005-000102: 1/4JIC to 3/8 NPT
 PN 4005-000109: 1/4JIC to 1/8 NPT

NOTE: Stop screws included with **all** shanks



Coolant-Fed ER Collet Sleeves - Inch Shanks

Double Coolant Ports

Collet Size	Item No.	Description	Shank Dia. (D ₁)	Shank Length (L ₁)	OAL (L ₂)	With Locking Flat	Stop Screw	Nut Type	Side Coolant Port	Rear Coolant Port
ER16	1025-000245A	CS-16-190-050GC	0.75in	50mm	77mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000251A	CS-16-190-060GC	0.75in	60mm	87mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000252A	CS-16-190-070GC	0.75in	70mm	97mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000258A	CS-16-254-050GC	1.0in	50mm	77mm	Yes	No	Mini-Nut	M5	1/4 NPT

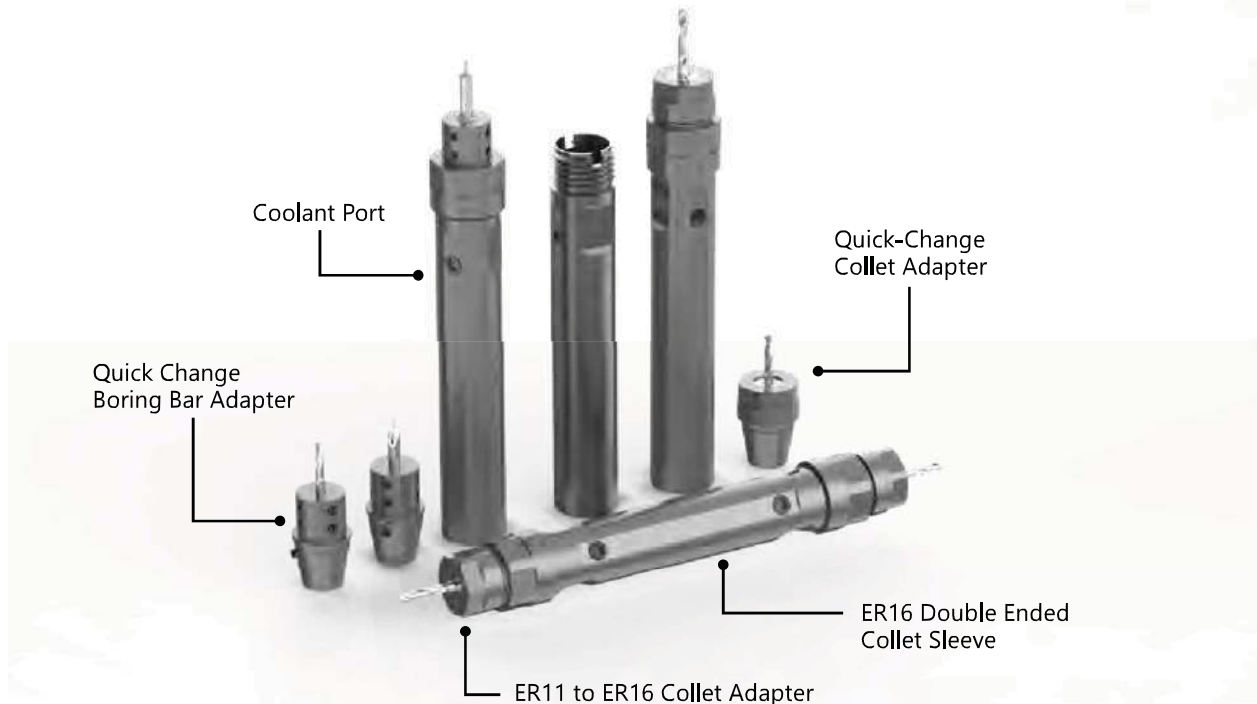
Coolant-Fed ER Collet Sleeves - Metric Shanks

Double Coolant Ports

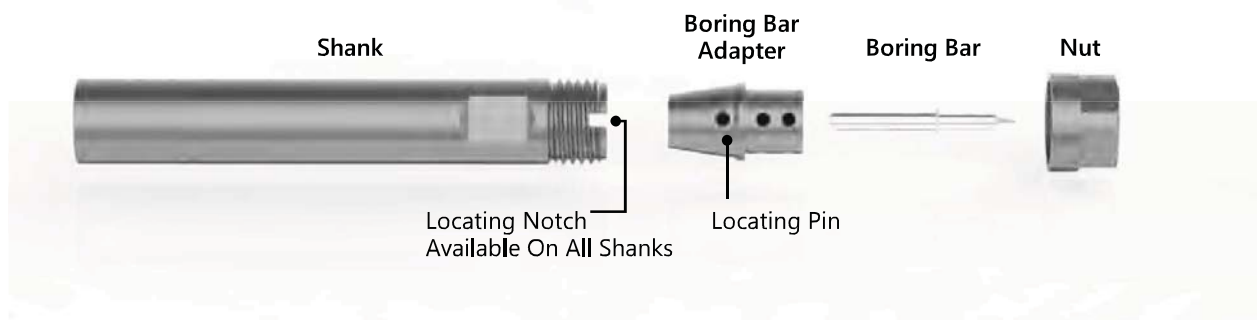
Collet Size	Item No.	Description	Shank Dia. (D ₁)	Shank Length (L ₁)	OAL (L ₂)	With Locking Flat	Stop Screw	Nut Type	Side Coolant Port	Rear Coolant Port
ER16	1025-000253A	CS-16-200-050GC	20mm	50mm	77mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000254A	CS-16-200-070GC	20mm	70mm	97mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000250A	CS-16-220-050GC	22mm	50mm	77mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000255A	CS-16-220-070GC	22mm	70mm	97mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000256A	CS-16-250-050GC	25mm	50mm	77mm	Yes	No	Mini-Nut	M5	1/4 NPT
	1025-000257A	CS-16-250-070GC	25mm	70mm	97mm	Yes	No	Mini-Nut	M5	1/4 NPT

QUICK CHANGE TOOL HOLDING SOLUTIONS

These collet sleeves are cost effective solutions to tool holding and are available in a variety of both Inch and Metric sized shank diameters. Also featuring a solid shank for rigidity and a side coolant port for connection to a high-pressure coolant delivery system. Every unit has a notched collet taper for easy tool orientation when combined with Quick-Change boring bar adapters.



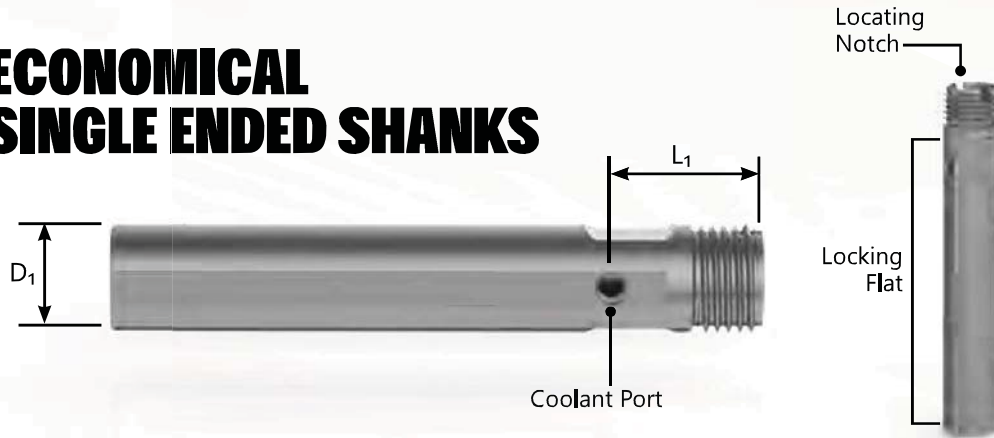
Single Ended Shank Used With The Quick Change Boring Bar Adapter



Single Ended Shank Used With The Quick Change Collet Adapter



ECONOMICAL SINGLE ENDED SHANKS



Shank Only - Inch

Item No.	Description	Collet	D ₁	L ₁	OAL
1045-000258	CQS-SS-160500	ER16	.500"	1.1"	4.5"
1045-000168	CQS-SS-160625	ER16	.625"	1.1"	4.5"
1045-000160	CQS-SS-160750	ER16	.750"	1.1"	4.5"
1045-000173	CQS-SS-161000	ER16	1.00"	1.1"	4.5"
1045-000189	CQS-SS-200750	ER20	.750"	1.2"	4.5"
1045-000164	CQS-SS-201000	ER20	1.00"	1.2"	4.5"
1045-000254	CQS-SS-201250	ER20	1.25"	1.2"	4.5"

Shank w/ Nut - Inch

Item No.	Description
1045-000257	CQS-S16-0500-CSE
1045-000195	CQS-S16-0625-CSE
1045-000129	CQS-S16-0750-CSE
1045-000133	CQS-S16-1000-CSE
1045-000134	CQS-S20-0750-CSE
1045-000136	CQS-S20-1000-CSE
1045-000291	CQS-S20-1250-CSE

Shank Only - Metric

Item No.	Description	Collet	D ₁	L ₁	OAL
1045-000219	CQS-SS-160787	ER16	20mm	28mm	114mm
1045-000161	CQS-SS-160866	ER16	22mm	28mm	118mm
1045-000241	CQS-SS-160984	ER16	25mm	28mm	95mm
1045-000163	CQS-SS-200866	ER20	22mm	30mm	114mm
1045-000171	CQS-SS-201260	ER20	32mm	30mm	118mm

Shank w/ Nut - Metric

Item No.	Description
1045-000225	CQS-S16-0787-CSE
1045-000206	CQS-S16-0866-CSE
1045-000220	CQS-S16-0984-CSE
1045-000135	CQS-S20-0866-CSE
1045-000243	CQS-S20-1260-CSE

ECONOMICAL DOUBLE ENDED SHANKS



Inch

Item No.	Description	Collet	D ₁	OAL
1045-000127	CQS-S16-0750-CDE	ER16	.750"	4.5"
1045-000131	CQS-S16-1000-CDE	ER16	1.00"	4.5"
1045-000170	CQS-S20-1000-CDE	ER20	1.00"	4.5"

Metric

Item No.	Description	Collet	D ₁	OAL
1045-000130	CQS-S16-0866-CDE	ER16	22mm	114mm
1045-000200	CQS-S16-0984-CDE	ER16	25mm	95mm
1045-000275A	CQS-S20-1260-CDE	ER20	32mm	118mm

NOTE: Each double ended shank is sold with two nuts

SPARE ER COLLET NUTS



Item No.	Description	ER Size	Nut Thread
1045-000199	CQS-NT160001	ER16	M19 x 1.0
1045-000216	CQS-NT200001	ER20	M24 x 1.0
1045-000289	CQS-NT250001	ER25	M32 x 1.5

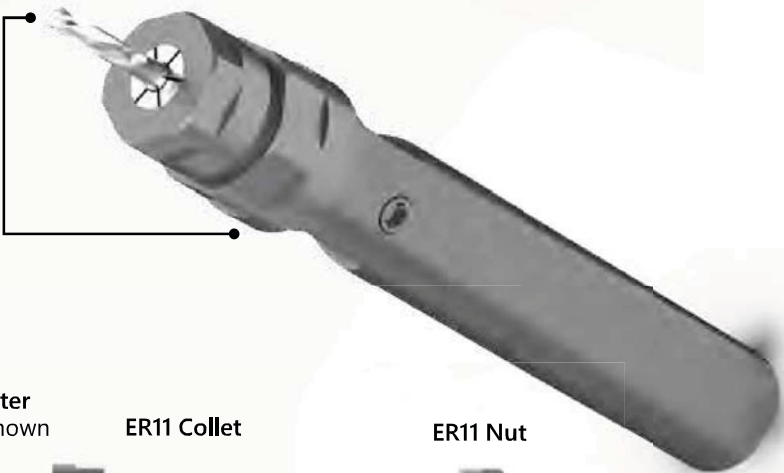
QUICK CHANGE COLLET ADAPTERS

Quick Change collet adapters make it easier to control quality in your shop. These adapters make it simple to have preset tooling available, eliminating the need to touch off the tool after a routine change. This also enables less experienced machine operators to be more productive.



- Simplifies setup
- Decreases downtime

Preset Spare Tooling
Quick Change
Can Be Used As An Extension



Assembly With Collet

Item No.	Description	Adapter	Collet	Middle Nut Thread
Call For Details	CQS-AS11-0801-xxx	ER11 to ER8	ER8	M13 x .75
Call For Details	CQS-AS11-0802-xxx	ER11 to ER8	ER8	M14 x .75
Call For Details	CQS-AS16-1101-xxx	ER16 to ER11	ER11	M19 x 1
Call For Details	CQS-AS16-1102-xxx	ER16 to ER11	ER11	M22 x 1.5
Call For Details	CQS-AS20-1601-xxx	ER20 to ER16	ER16	M24 x 1

*replace xxx with desired collet size in nominal inch or mm sizes

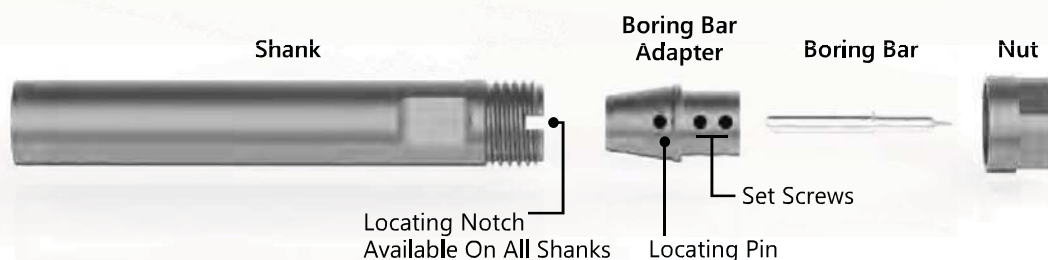
Assembly Only

Item No.	Description	Adapter	Collet	Middle Nut Thread
1045-000242	CQS-AS11-0803	ER11 to ER8	ER8	M13 x .75
1045-000226	CQS-AS11-0804	ER11 to ER8	ER8	M14 x .75
1045-000111	CQS-AS16-1103	ER16 to ER11	ER11	M19 x 1
1045-000112	CQS-AS16-1104	ER16 to ER11	ER11	M22 x 1.5
1045-000114	CQS-AS20-1603	ER20 to ER16	ER16	M24 x 1

QUICK CHANGE BORING ADAPTERS

Quick Change Boring adaptors make it fast and simple to locate center position for boring bars when combined with notched ER holders. A simple locating pin rests within the notched holder ensuring accurate centering. These solid bushings utilize the ER collet system to securely hold a boring bar in a rigid fashion. Axial length can be easily set using any form of presetting device.

- Easily locates boring bar axial & radial position



Inch

Item No.	Description	ER Size	Bore	Nut Thread
1045-000137	CQS-SH16-12501	ER16	.1250in	M19 x 1
1045-000140	CQS-SH16-18701		.1875in	M19 x 1
1045-000142	CQS-SH16-25001		.2500in	M19 x 1
1045-000145	CQS-SH16-31201		.3125in	M19 x 1
1045-000147	CQS-SH16-37501		.3750in	M19 x 1
1045-000149	CQS-SH20-12501	ER20	.1250in	M24 x 1
1045-000193	CQS-SH20-18701		.1875in	M24 x 1
1045-000153	CQS-SH20-25001		.2500in	M24 x 1
1045-000155	CQS-SH20-3125		.3125in	M24 x 1
1045-000156	CQS-SH20-37501		.3750in	M24 x 1

Metric

Item No.	Description	ER Size	Bore	Nut Thread
1045-000260	CQS-SH16-15701	ER16	4mm	M19 x 1
1045-000201	CQS-SH16-19701		5mm	M19 x 1
1045-000202	CQS-SH16-23601		6mm	M19 x 1
1045-000146	CQS-SH16-31501		8mm	M19 x 1

Additional Size Options Available, please call.