



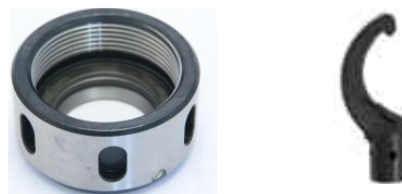
Recommended Collet Torque Values

Perske Motor KVAL Part Number	Horse Power	Type Collet	Type Nut	Torque Value	Columbo KVAL Motor PartNumber	Horse Power	Type Collet	Type Nut	Torque Value
PERKNS21-05-2400	0.37	ER16	Mini	18 ft/lbs	COLS55E389-1.5	1.5	ER 20	Slotted	59 ft/lbs
PERKRS35.1-2D	1.00	ER20	Mini	20 ft/lbs	COLS73E478-3D	3.0	ER 25	Mini	25 ft/lbs
PERKRS35.5-2D	2.00	ER 20	Mini	20 ft/lbs	COLS90E810-7.5,D	7.5	ER-25	Slotted	77 ft/lbs
PERVS503 – 3 HP	3.00	SOYUS 20	Hook	36 ft/lbs	GC90E1683-7.5D	7.5	ER 32	Slotted	100 ft/lbs
PERKRSV51.14-2D	7.00	SOYUS 25	Hook	90 ft/lbs	COLS116150-10,D	10.0	ER 40	Slotted	130 ft/lbs
HSD Motor KVAL Part Number	Horse Power	Type Collet	Type Nut	Torque Value	COLS63F0020-11D	11.0	ER 40	Slotted	130 ft/lbs
A6161H0824 – HSD Spindle Motor	10.0	ER 32	Slotted	100 ft/lbs	COLS135501-12D	12.0	ER 40	Slotted	130 ft/lbs

Mini Nut and Torque Head Used



Hook Nut and Torque Head Used



Slotted Nut and Torque Head Used



FACT

Exceeding the torque does not provide more clamping force; it just leads to runout. In fact, the more force is applied, the more the top of the collet wants to twist with the nut. Too much force can actually twist the collet's top, deforming the collet, which will increase runout and reduce clamping force.



Tips

- **Never use a torque wrench to loosen bolts or nuts**
- **Always set the torque wrench to zero after using it.**
- **Ensure a minimum of 1/8" clearance from the end of the bit to the bottom of the tool holder.**
- **Periodically use compressed air to clean both the nut and collet**
- **Check the collet for bluing (Overheating) or damage. If it is damaged or over heated , replace it.**
- **When inserting the collet into the nut , it should "SNAP" in to place.**

