



Non Pull Out SX25 Collets

SX25 Non-Pull Out Collets

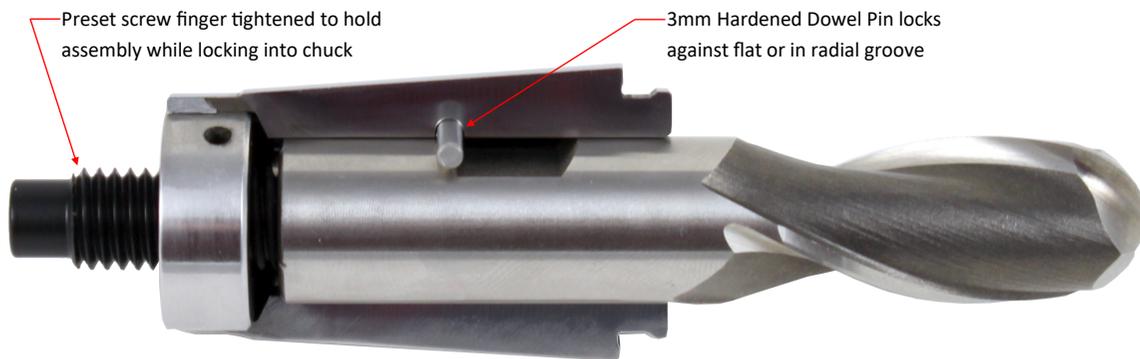
For Hi-Feed Milling Applications

Non Pull out collets are developed for hi feed titanium and aluminum applications with cutter helix of 37° or greater to prevent cutter pull out.

The Pioneer design utilizes a standard hardened 62Rc 3mm dowel pin to provide contact across the flat and superior shear strength. The preset screw is used to hold the cutter in position, preventing any movement while being locked into the tool holder.

The modification is performed at our location in Chicago, the pin location can be adjusted to fit any flat or groove position within the collet bore behind the nut. Special configurations available upon request.

Available in 1/8-7/8, 3mm-20mm and will fit any SX25 chuck using a SX25M Nut.



SX25 Non-Pull Out Assembly - How does it work?



Insert SX25-NP Collet into the SXN25M Nut



Insert cutting tool into the collet, cutter flat orientation to the pin hole as shown



Fully insert cutter into the collet



Insert Pin into the Pin Hole
Note: if cutting tool flat is not in the correct orientation the pin will not insert, rotate cutter if needed to align the pin to the flat



Once the pin is fully inserted pull out on the cutting tool so the back of the flat is tight against the pin



Insert the preset screw finger tight against the back of the cutting tool to hold the cutter in place and eliminate gap and movement

Assemble into the collet chuck, torque to 85 ft/lbs, you are ready to go!

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