



#### TYPE A\* for Permanent Fitting in the Tool-Head

Type A is pressed into the cutting tool and secured by screws. When pressurizing, only the inner sleeve expands towards the spindle.

#### *Type A, pour un ajustement permanent dans le porte-outils*

*Le type A est pressé dans la machine à couper et est sécurisé par des vis. Lors de la pression, seul le manchon interne gonfle en direction du mandrin.*



#### TYPE B\* Easily Inter Changed Between Tool-Heads

Type B is threaded and has a knurled ring nut so it can be easily interchanged between tools. When pressurizing, the outer sleeve expands towards the tool and the inner towards the spindle.

#### *Type B, facilement interchangeable entre les porte-outils*

*Le type B a été taraudé et possède un écrou moleté ainsi il peut être facilement interchangeable entre les outils. Lors de la pression, le manchon externe gonfle en direction de l'outil et le manchon interne en direction du mandrin.*

## PRESSURIZING

The hydraulic sleeve is activated in two different ways. The most common is by using a specially made, high pressure grease pump. The sleeve is equipped with a filler nipple and a release nipple (Fig. 1). The second, recently developed method is by tightening a pressure screw with a T-wrench. The screw pushes a piston in front of it, which builds up the required pressure (Fig. 2).

## PAR PRESSION

*Le manchon hydraulique est activé de deux manières différentes. La plus courante est celle consistant à utiliser une pompe de graisse spéciale à haute pression. Le manchon est équipé avec une valve d'entrée et une valve de sortie. La deuxième méthode récemment développée consiste en un serrage d'une vis à pression avec une clé en T. La vis pousse un piston en face de lui, ce qui déclenche la pression souhaitée.*

Fig. 1

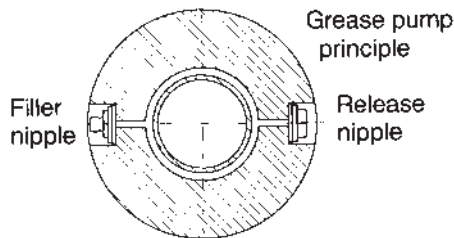
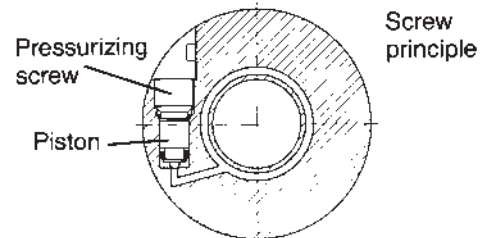


Fig. 2



G2



#### TYPE G2 + G3: Chuck for overhead routers equipped with precision tools.

- excellent repeat accuracy
- minimum runout
- presetting of tools facilitates rapid tool changes
- faster feed rates to increase productivity

#### Hydraulic Clamping of Tools Gives Almost Perfect Concentricity on the Spindle.

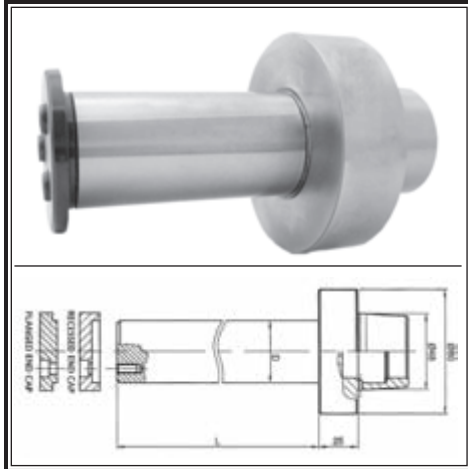
#### *TYPE G2 + G3, porte-outils pour le dessus de défonceuse équipée avec des outils de précision.*

- excellente précision de répétition
- une bonne stabilisation
- le pré-positionnement des outils facilite le changement des outils
- la vitesse d'avance rapide accroît la productivité

#### Montage hydraulique d'outils qui donne une parfaite concentration sur le mandrin.

G3





**TOOL HOLDERS FOR CNC MOULDERS**

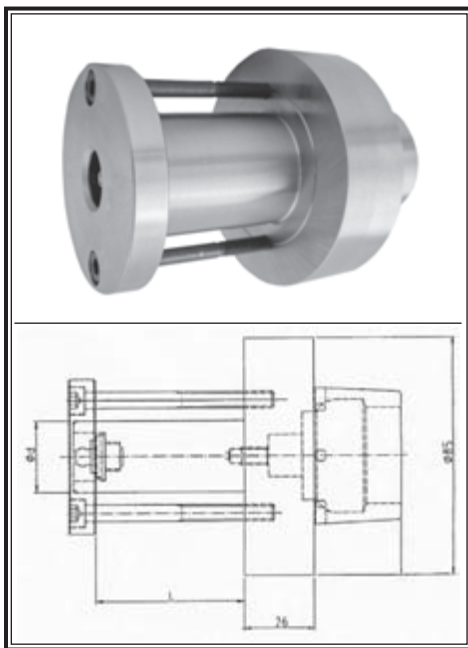
Part #	D	L
PRC-HSK80W-30060	30mm	60mm
PRC-HSK80W-40040	40mm	40mm
PRC-HSK80W-40060	40mm	60mm
PRC-HSK80W-40080	40mm	80mm
PRC-HSK80W-40130	40mm	130mm
PRC-HSK80W-40240	40mm	240mm

**Technical Details:**

Standard HSK80W Tool holders for "WEINIG PowerLock-System".

**Applications:**

Used to run a variety of tooling on CNC moulders.



**HYDRAULIC TOOL HOLDERS FOR CNC MOULDERS**

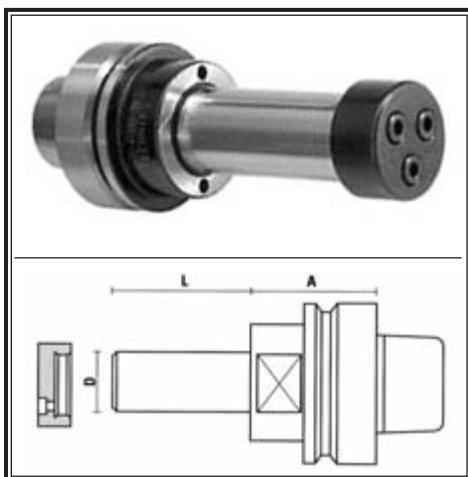
Part #	D	L
PRC-ETP.GEW-4055	40mm	55mm
PRC-ETP.GEW-40100	40mm	100mm
PRC-ETP.GEW-40170	40mm	170mm
PRC-ETP.GEW-50210	50mm	210mm

**Technical Details:**

ETP® Hydro-Grip Tool holders for "WEINIG PowerLock-System".

**Applications:**

Used to run a variety of tooling on CNC moulders with Hydro-Lock for additional precision.



**TOOL HOLDER ARBOR FOR CNC ROUTERS ETC. - HSK 63F**

Part #	D	L	A
PRC-HSK63F-10055	1	55mm	33mm
PRC-HSK63F-10080	1	80mm	33mm
PRC-HSK63F-100100	1	100mm	33mm
PRC-HSK63F-12555	1-1/4	55mm	33mm
PRC-HSK63F-12580	1-1/4	80mm	33mm
PRC-HSK63F-125100	1-1/4	100mm	33mm
PRC-HSK63F-12555-42	1-1/4	55mm	42mm
PRC-HSK63F-12580-42	1-1/4	80mm	42mm
PRC-HSK63F-125100-42	1-1/4	100mm	42mm

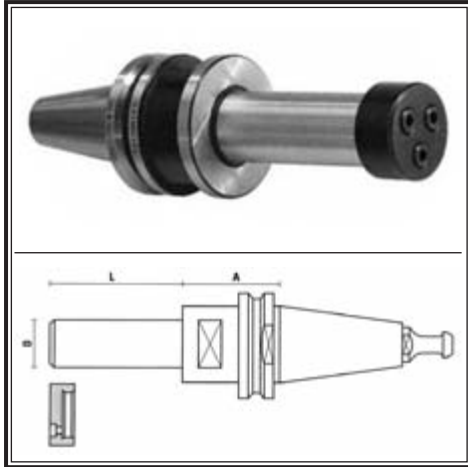
**Technical Details:**

High precision tool holders balanced as a unit or in combination with mounted tooling.

**Applications:**

For mounting a variety of tooling on CNC Routers and other CNC Equipment where tool holders are required.

Other sizes available on request



**TOOL HOLDER ARBOR FOR CNC ROUTERS ETC. - ISO 30**

Part #	D	L	A
PRC-IS030-10040	1	40mm	35mm
PRC-IS030-10055	1	55mm	35mm
PRC-IS030-10080	1	80mm	35mm
PRC-IS030-100100	1	100mm	35mm
PRC-IS030-12540	1-1/4	40mm	35mm
PRC-IS030-12555	1-1/4	55mm	35mm
PRC-IS030-12580	1-1/4	80mm	35mm
PRC-IS030-125100	1-1/4	100mm	35mm

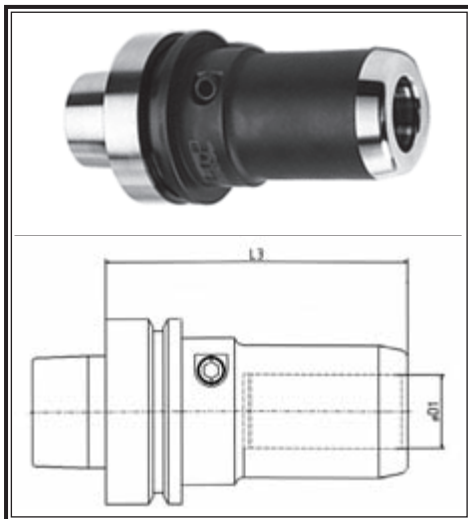
**Technical Details:**

High precision tool holders balanced as a unit or in combination with mounted tooling.

**Applications:**

For mounting a variety of tooling on CNC Routers and other CNC Equipment where tool holders are required.

**NOTE:** Complete with nut. Pull stud and collet not included.



**HYDRO-GRIP G2**

**Extremely user friendly.  
Quick and easy tool changes.  
No grease pump needed.  
Perfectly centered and balanced tools.**

**HYDRAULIC TOOL HOLDERS (for shank tools)**

Part #	D1	L3
PRC-ETP.G2-1/2-HSK63F	1/2	87mm
PRC-ETP.G2-5/8-HSK63F	5/8	87mm
PRC-ETP.G2-3/4-HSK63F	3/4	87mm

**HYDRAULIC TOOL HOLDERS (for tools with bore)**

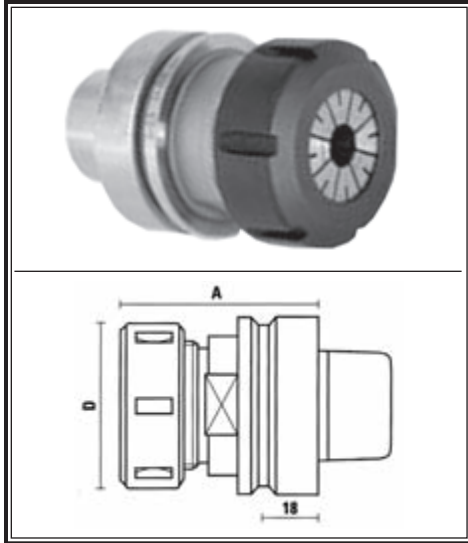
Part #	D	L
PRC-ETP.HSK63F-07540	3/4	40mm
PRC-ETP.HSK63F-07555	3/4	55mm
PRC-ETP.HSK63F-10040	1	40mm
PRC-ETP.HSK63F-10055	1	55mm
PRC-ETP.HSK63F-10080	1	80mm
PRC-ETP.HSK63F-12540	1-1/4	40mm
PRC-ETP.HSK63F-12555	1-1/4	55mm
PRC-ETP.HSK63F-12580	1-1/4	80mm

**Technical Details:**

High precision tool holders balanced as a unit or in combination with mounted tooling. Hydraulic precision arbors provide perfect balance and centricity for the tool. Arbor is equipped with standard safety ring but can also be used without, by using the safety screws supplied.

**Applications:**

For mounting a variety of tooling on CNC Routers and other CNC Equipment where tool holders are required.



**TOOL HOLDERS FOR CNC Routers - HSK 63F**

Part #	D	A
PRC-HSK63F-16 (ER32)	50mm	70mm
PRC-HSK63F-16L (ER32)	50mm	70mm
PRC-HSK63F-20 (ER40)	63mm	76mm
PRC-HSK63F-20L (ER40)	63mm	76mm
PRC-HSK63F-38 (ORT25)	60mm	80mm

**Technical Details:**

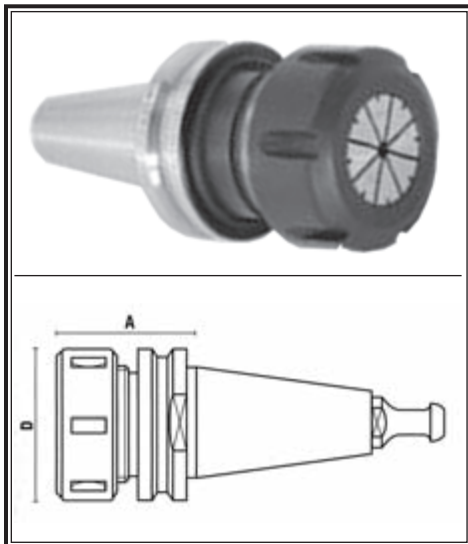
Standard HSK63F Tool holders for CNC Routers and shapers.

**Applications:**

To hold a variety of routing tools with mechanical collets.

**NOTE:** Complete with nut. Pull stud and collet not included.

See page 50 for listing of collets.



**TOOL HOLDERS FOR CNC Routers - ISO 30**

**For Biesse (after 09/09/92) & Masterwood with H.S.D. spindle**

Part #	D	A
PRC-225-50.R (Biesse) ER32	50mm	50mm
PRC-225-50.L (Biesse) ER32	50mm	50mm
PRC-225-63.R (Biesse) ER40	63mm	50mm
PRC-225-63.L (Biesse) ER40	63mm	50mm

**Technical Details:**

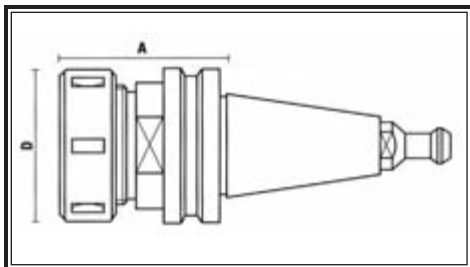
Standard ISO 30 Tool holders for CNC Routers and Point to Point machines.

**Applications:**

To hold a variety of routing tools with mechanical collets.

**NOTE:** Complete with nut. Pull stud and collet not included.

See page 50 for listing of collets.



### TOOL HOLDERS FOR CNC Routers - ISO 30

For Alberti, Vitap & Masterwood with Colombo spindle

Part #	D	A
PRC-225-50.R (Alberti) ER32	50mm	60mm
PRC-225-50.L (Alberti) ER32	50mm	60mm
PRC-225-63.R (Alberti) ER40	63mm	60mm
PRC-225-63.L (Alberti) ER40	63mm	60mm

For Biesse, Masterwood

Part #	D	A
PRC-225-50.R (Biesse) ER32	50mm	50mm
PRC-225-50.L (Biesse) ER32	50mm	50mm
PRC-225-63.R (Biesse) ER40	63mm	50mm
PRC-225-63.L (Biesse) ER40	63mm	50mm

For Busellato, Weeke, Ima, Bulleri, Maka, & Cosmec

Part #	D	A
PRC-225-50.R (Busellato) ER32	50mm	60mm
PRC-225-50.L (Busellato) ER32	50mm	60mm
PRC-225-63.R (Busellato) ER40	63mm	60mm
PRC-225-63.L (Busellato) ER40	63mm	60mm

For CMS

Part #	D	A
PRC-CMS.ER32	50mm	50mm
PRC-CMS.ER40	63mm	57mm

**Technical Details:**

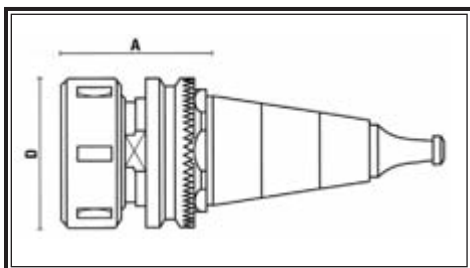
Standard ISO 30 Tool holders for CNC Routers.

**Applications:**

To hold a variety of routing tools with mechanical collets.

**NOTE:** Complete with nut. Pull stud and collet not included.

See page 50 for listing of collets.



### TOOL HOLDERS FOR CNC Routers - ISO 30

For Morbidelli & SCM

Part #	D	A
PRC-250.R (ER32)	50mm	55mm
PRC-250.L (ER32)	50mm	55mm
PRC-250.R (ER40)	60mm	72mm
PRC-250.L (ER40)	60mm	72mm

**Technical Details:**

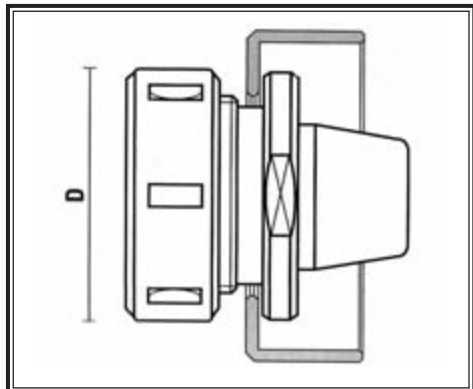
Standard ISO 30 Tool holders for CNC Routers.

**Applications:**

To hold a variety of routing tools with mechanical collets.

**NOTE:** Complete with nut. Pull stud and collet not included.

See page 50 for listing of collets.

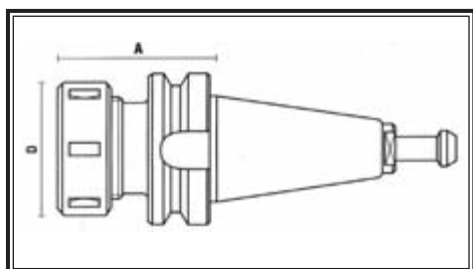


### Special CMS Holders

Part #	D
PRC-CMS-SPEC.ER32	50mm
PRC-CMS-SPEC.ER40	63mm

\* For "ball bearing nuts" add BB to the end of part number.

**NOTE:** Pull stud not included.



### BT Holders

Part #	D	A
PRC-200-BT30.ER32.BB	50mm	60mm
PRC-200-BT30.ER40.BB	63mm	70mm
PRC-200-BT35.ER32.BB	50mm	65mm
PRC-200-BT35.ER40.BB	50mm	65mm
PRC-200-BT40.ER32.BB	50mm	65mm
PRC-200-BT40.ER40.BB	63mm	70mm

\*All BT holders are shipped complete with "ball bearing nuts".

**NOTE:** Pull stud not included.



### COLLETS - ER Collets

Part # ER32	Part# ER40	Size
PRC-350.03	PRC-375.03	1/8
PRC-350.04	PRC-375.04	3/16
PRC-350.05	PRC-375.05	7/32
PRC-350.6.35	PRC-375.6.35	1/4
PRC-350.08	PRC-375.08	5/16
PRC-350.12	PRC-375.12	7/16
PRC-350.12.7	PRC-375.12.7	1/2
PRC-350.14	PRC-375.14	17/32
PRC-350.15	PRC-375.15	9/16
PRC-350.16	PRC-375.16	5/8
PRC-350.19.05	PRC-375.19.05	3/4
PRC-350.19/20	PRC-375.19/20	25/32
PRC-350.22/23	PRC-375.22/23	7/8
	PRC-375.25.4	1

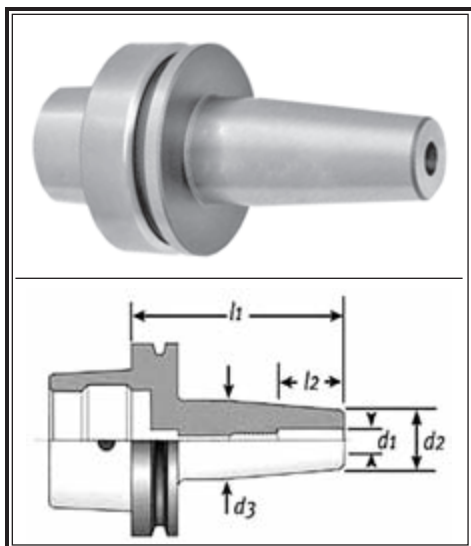


### COLLETS - PERSKE SYOZ

Part # SYOZ 25	Size
PRC-400.03	1/8
PRC-400.04	3/16
PRC-400.06	1/4
PRC-400.10	3/8
PRC-400.12	7/16
PRC-400.13	1/2
PRC-400.15	9/16
PRC-400.16	5/8
PRC-400.19	3/4
PRC-400.22/23	7/8
PRC-400.25	1

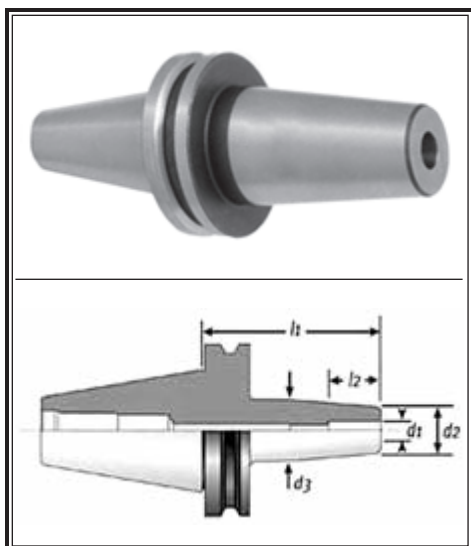
For complete selection of collets, pull studs and router accessories visit

[www.royceayr.com](http://www.royceayr.com)



**SHRINK FIT TOOL HOLDER - HSK 63F**

Part #	D1	L1
PRC-SHRINK-HSK.1/4	1/4	80mm
PRC-SHRINK-HSK.3/8	3/8	95mm
PRC-SHRINK-HSK.1/2	1/2	95mm
PRC-SHRINK-HSK.3/4	3/4	100mm
PRC-SHRINK-HSK.1	1	115mm



**SHRINK FIT TOOL HOLDER - ISO 30**

Part #	D1	L1
PRC-SHRINK-ISO.1/4	1/4	80mm
PRC-SHRINK-ISO.3/8	3/8	80mm
PRC-SHRINK-ISO.1/2	1/2	80mm
PRC-SHRINK-ISO.5/8	5/8	80mm
PRC-SHRINK-ISO.3/4	3/4	80mm

**Technical Details:**

High precision tool holders balanced 24,000 RPM at G2.5.  
Maximum T.I.R. only .0001".

**Applications:**

For mounting a variety of tooling on CNC Routers and other CNC Equipment where extra precision tool holders are required.

