

# SX25 Non-Pull Out Collets

## For Hi-Feed Milling Applications

Non Pull out collets are developed for hi-feed titanium and aluminum applications with a cutter helix of 45° 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.

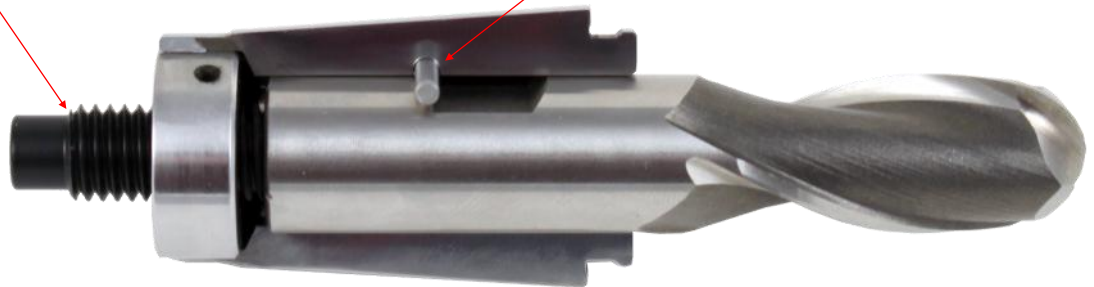


The modification is performed at our location in Chicago, the pin location can be adjusted to fit any flat or groove position within the collet bore behind the nut. Special configurations available upon request.

Preset screw finger tightened to hold assembly while locking into chuck

3mm Hardened Dowel Pin locks against flat or in radial groove

PART NUMBER	BORE
SX25-0375NP	0.3750
SX25-0500NP	0.5000
SX25-0625NP	0.6250
SX25-0750NP	0.7500
SX25-0875NP	0.8750
SX25-M120NP	12MM
SX25-M160NP	16MM
SX25-M200NP	20MM



## 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

Use safety gloves if required



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

Use safety gloves if required



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!**

