

*Quick Change Collets &
Adjustable RS Pushers for
Multi Spindle
Screw Machines*

Effective November 2011

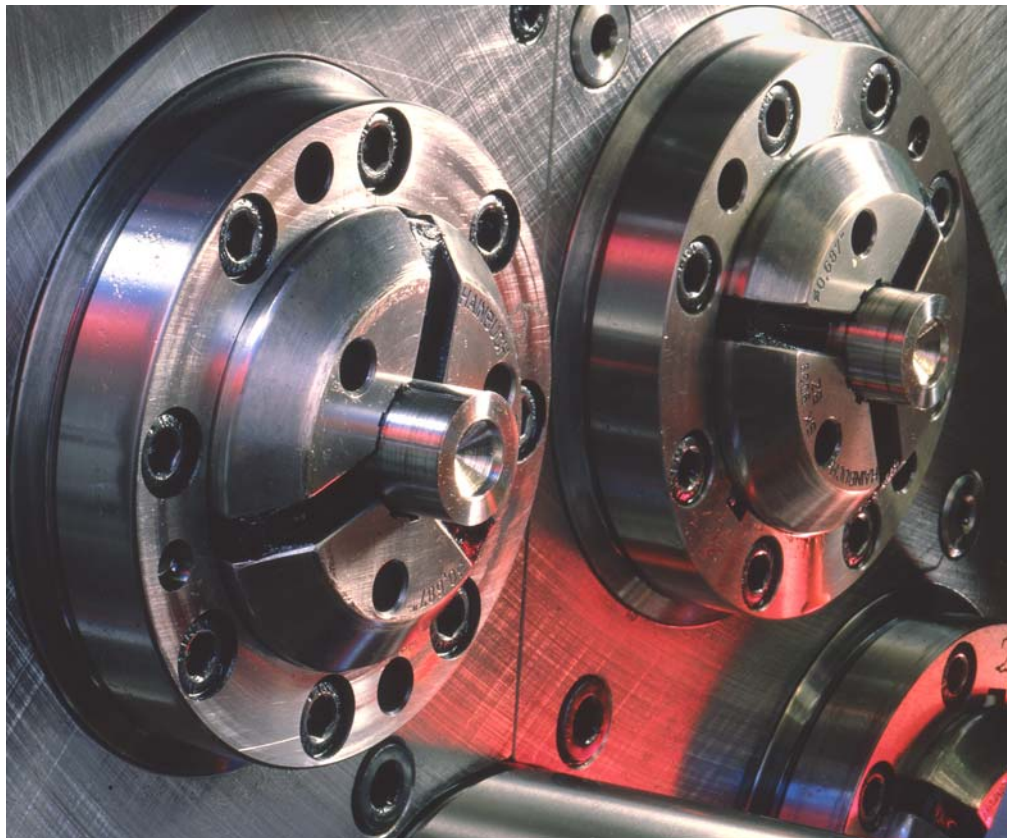


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Order Direct from the Factory

Same day shipping on orders from stock.



Reduce Setup Time, Maximize Run Time For Increased Output, And Lower Cost Per Part

MicroCentric's Quick Change Tooling for multi spindle screw machines lets you dramatically reduce your setup time, and increase the number of hours your machine is producing parts. MicroCentric quick change collets and RS pushers will not only lower your cost per part, but also increase your production capacity, and give you the flexibility to run small lots efficiently and profitably.

Performance Guarantee

The performance of all MicroCentric Multi Spindle Tooling Products is guaranteed. Install a set of Quick Change Collets or RS Adjustable Pushers, and if you are not satisfied with their performance, simply return the item(s) within 30 days for a full refund.

Product Highlights

Quick Change Collets

- Change collets in less than 15 seconds
- Tension adjustment not required after collet change
- Higher clamping force than solid and master collets
- Accuracy within .0005" TIR
- One piece vulcanized design for better handling and reduced chip and sludge buildup in the machine spindles



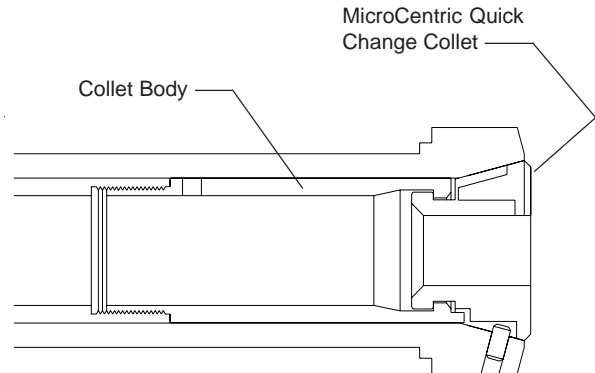
Adjustable RS Pushers

- Fine adjustment of feed tension
- Set uniform tension on all spindles
- Adjust tension as pusher wears
- Six segmented design for uniform contact
- Large range of adjustment
- Longer life than conventional pushers and feed fingers

MicroCentric Quick Change Collets

System Design

The MicroCentric system consists of a collet body, that threads onto the collet tube and remains in the spindle during change over, and a removable collet. The MicroCentric Collet is comprised of hardened and precision finished segments that are vulcanized into a single unit. MicroCentric Quick Change Collets replace conventional solid and master collets without modifications to the spindle or collet tube.

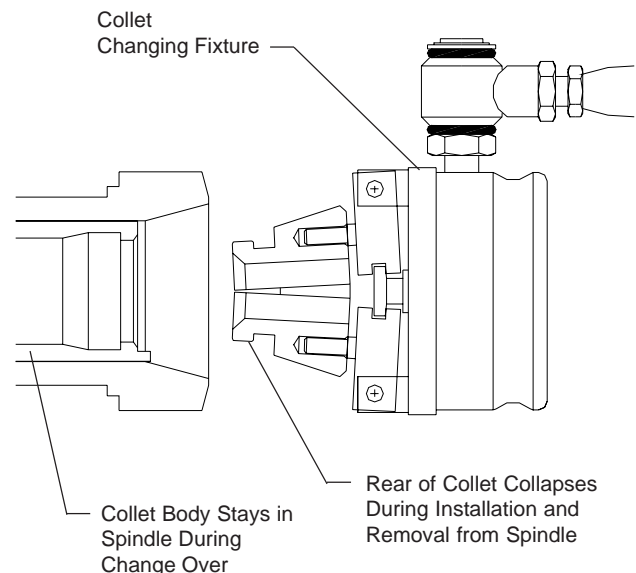


Collet Change In 15 Seconds Without Tension Adjustment

MicroCentric collets can be changed in 15 seconds. Changeover is accomplished by disengaging the collet from the collet body, removing it from the spindle, and replacing it with a different size MicroCentric collet.

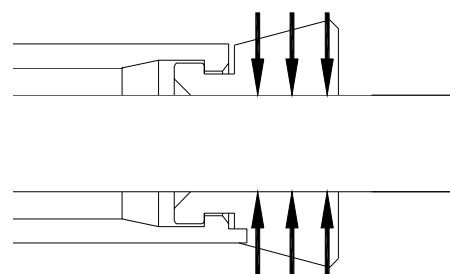
A changing fixture is engaged into the holes on the face of the collet to collapse the collet for installation and removal from the machine spindle. Changing fixtures are available in manual and hydraulic models.

Tension adjustment is not required after collet change. MicroCentric collets are manufactured to very close tolerances to insure uniform chucking tension from collet to collet.



Higher Clamping Force Than Solid and Master Collets

The segmented design of the MicroCentric collet produces parallel clamping that produces higher clamping forces than solid and master collets. In addition to producing increased chucking force for heavy cutting applications, most jobs can be run at lower tension settings than required with conventional collets, resulting in less wear on chucking shoes.

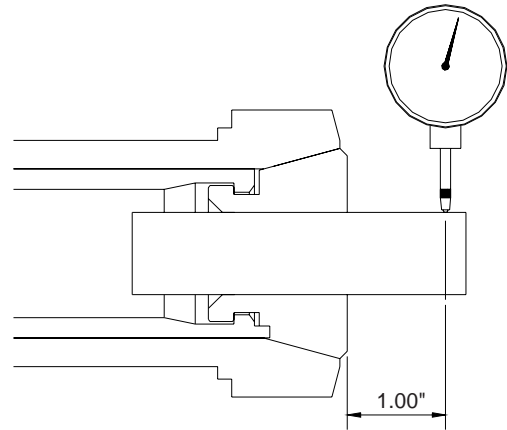


Parallel Clamping Over Entire Length of Collet

Maximum .0005" TIR Runout

MicroCentric collets are manufactured to very close size tolerances and concentricities. The parallel clamping design, together with MicroCentric's high quality standards produces a collet with unmatched accuracy.

Collet Type	Accuracy (TIR)
Round	.0005"
Hex & Square	.001"



One-Piece Vulcanized Design for Easy Handling, Reduced Chip & Sludge Buildup

The advanced vulcanized design of MicroCentric collets produces a seal which prevents chips and sludge from accumulating in the machine spindles. Customers have confirmed their spindles stay cleaner with MicroCentric collets than with solid and master collets.

MicroCentric's one piece design is far more accurate and easier to handle than quick change collets which are held together with replaceable rubber inserts. The MicroCentric collet always remain intact while in the machine and during change over and storage.



Vulcanized rubber is recessed below face of collet to prevent chip abrasion

Vulcanized Rubber is Guaranteed for Life

MicroCentric's vulcanizing technology produces a permanent bond between rubber and metal. In addition, the rubber compound is formulated to be resistant to oil and cutting fluid. If the bond ever separates during the life of the collet, the collet will be revulcanized free of charge.

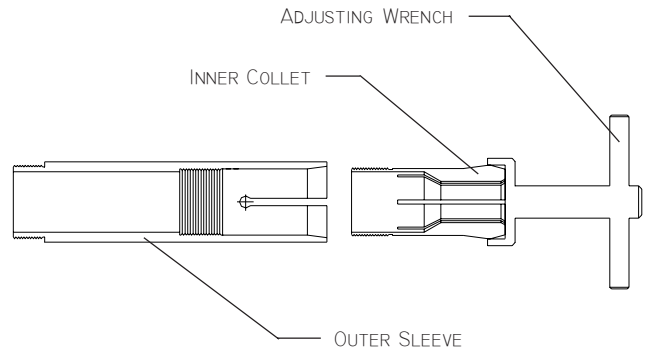


Hydraulic collet changing fixture with air driven hydraulic pump

Hainbuch Adjustable RS Pushers

System Design

Hainbuch RS Adjustable Pushers consist of an Outer Sleeve, that threads onto the feed tube, and an RS Collet. The RS Collet is changed and adjusted with a specially designed wrench. The Adjusting Wrench is engaged onto the collet to thread it into or out of the Outer Sleeve. Feed tension is determined by how far the RS Collet is threaded into the Outer Sleeve.



Accurate Uniform Tension Setting & Adjustment

Feed tension is very difficult to set and adjust with conventional pushers. Improper feed tension causes lost production time and results in scrapped parts and wasted bar stock. Feed tension is quickly and accurately set with the RS System, and can be easily adjusted as the RS Collet wears. Additionally, feed tension can be set uniformly on all spindles. Therefore RS pushers will eliminate misfeeds, and increase machine uptime since tension adjustment is made less frequently.



Six Segmented Design

RS Collets are six segmented to provide uniform contact with the bar which minimizes wear and reduces how often feed tension is adjusted.

Large Range & Increased Life Increases Run Time

RS Collets are made from through hardened steel and have an adjustment range of up to .125". This makes the RS System extremely cost effective, since the life of an RS Collet is typically 3 to 5 times that of conventional pushers and pads.

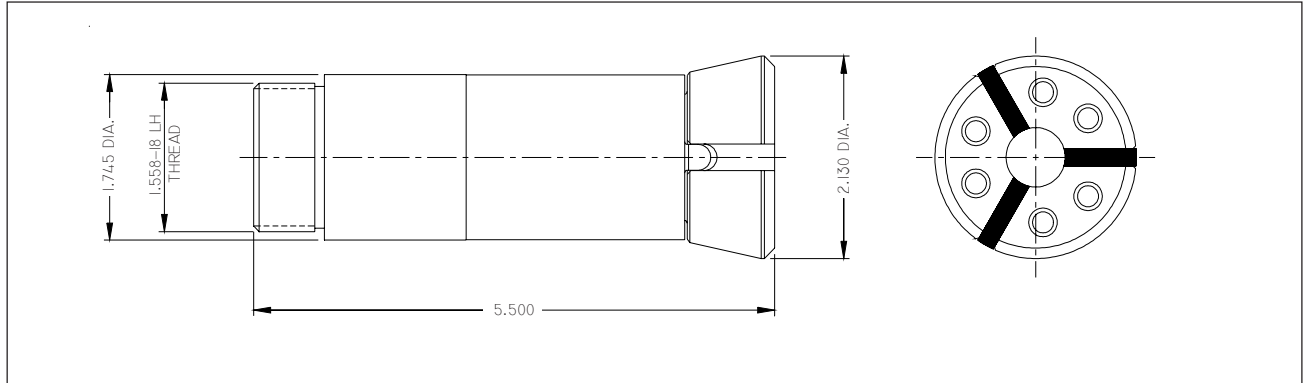
Ceramic, Plastic, and Bronze RS Collets Eliminate Scratching

RS collets are available with ceramic inserts, plastic coatings, and in bronze to eliminate scratches to the OD of finished bar stock.



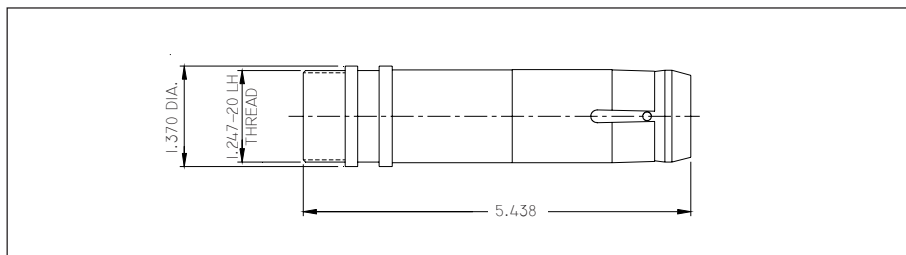
Acme-Gridley 1" RA6, RAN6

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB25A Collet Body			\$225.00	\$198.00	\$180.00
MA25A/RSR Collet - Serrated Bore	.312"	1.000"	\$162.00	\$142.56	\$129.60
MA25A/RSM Collet - Smooth Bore	.187"	1.000"	\$162.00	\$142.56	\$129.60
MA25A/HEX Collet - Hexagonal	.187"	.875"	\$195.00	\$171.60	\$156.00
WM25 Manual Changing Fixture			\$548.00		
WH25 Hydraulic Changing Fixture			\$650.00		
EN162 Hydraulic Pump			\$935.00		

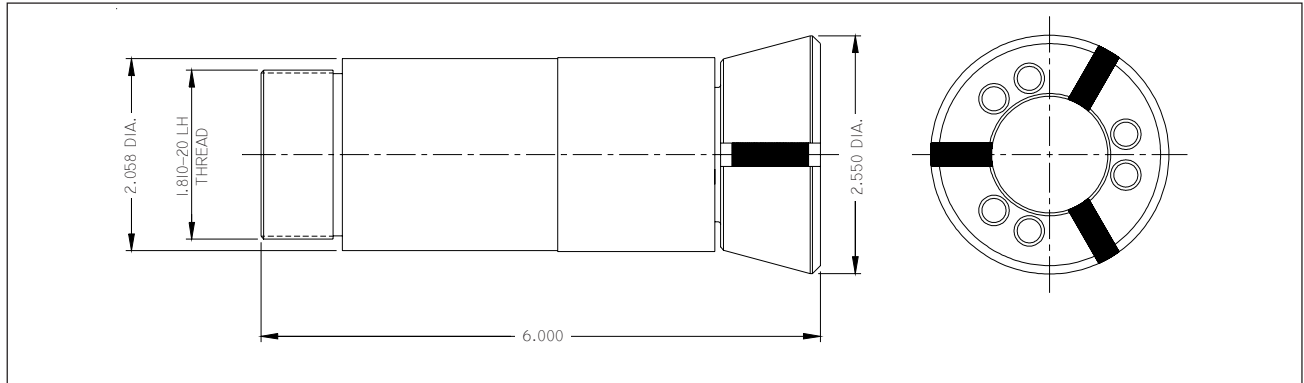
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9278E/RS25 Outer Sleeve			CALL
RS25/RD Inner Collet - Round	.187"	1.000"	CALL
RS25/HEX Inner Collet - Hexagonal	.187"	.875"	CALL
S25 Adjusting Wrench			CALL

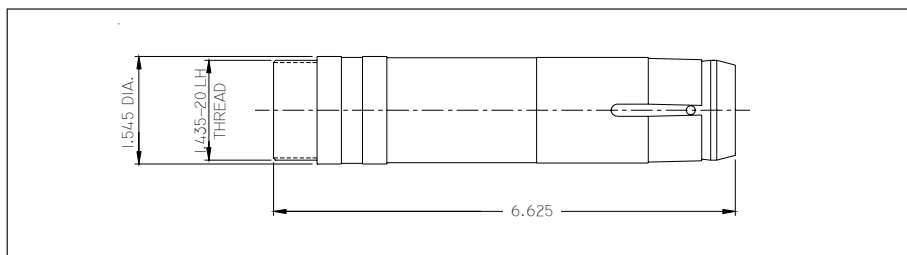
Acme-Gridley 1-1/4" RA6, RB6, RB8

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB32A Collet Body			\$258.00	\$227.04	\$206.40
MA32A/RSR Collet - Serrated Bore	.375"	1.250"	\$165.00	\$145.20	\$132.00
MA32A/RSM Collet - Smooth Bore	.187"	1.250"	\$165.00	\$145.20	\$132.00
MA32A/HEX Collet - Hexagonal	.250"	1.125"	\$198.00	\$174.24	\$158.40
WM32 Manual Changing Fixture			\$548.00		
WH32 Hydraulic Changing Fixture			\$650.00		
EN162 Hydraulic Pump			\$935.00		

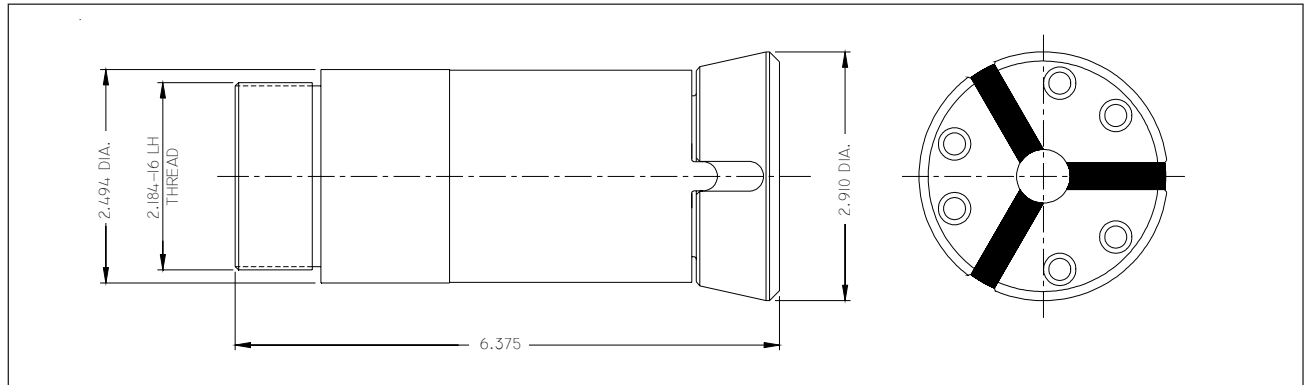
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9285E/RS30 Outer Sleeve			CALL
RS30/RD Inner Collet - Round	.250"	1.187"	CALL
RS30/HEX Inner Collet - Hexagonal	.250"	1.000"	CALL
S30 Adjusting Wrench			CALL

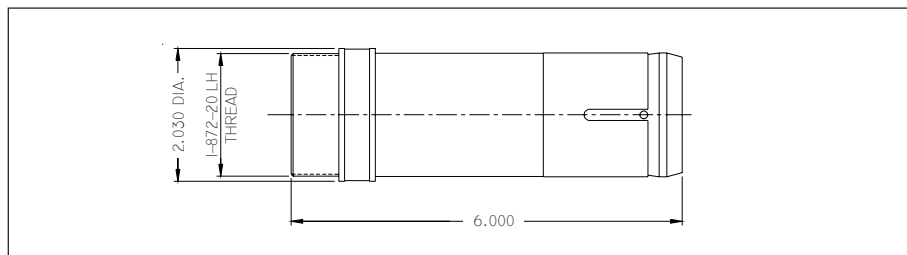
Acme-Gridley 1-5/8" RA6, RA8, RB6, RB8

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB42A Collet Body			\$285.00	\$250.80	\$228.00
MA42A/RSR Collet - Serrated Bore	.375"	1.625"	\$187.00	\$164.56	\$149.60
MA42A/RSM Collet - Smooth Bore	.187"	1.625"	\$187.00	\$164.56	\$149.60
MA42A/HEX Collet - Hexagonal	.250"	1.500"	\$282.00	\$248.16	\$225.60
WM42 Manual Changing Fixture			\$560.00		
WH42 Hydraulic Changing Fixture			\$670.00		
EN162 Hydraulic Pump			\$935.00		

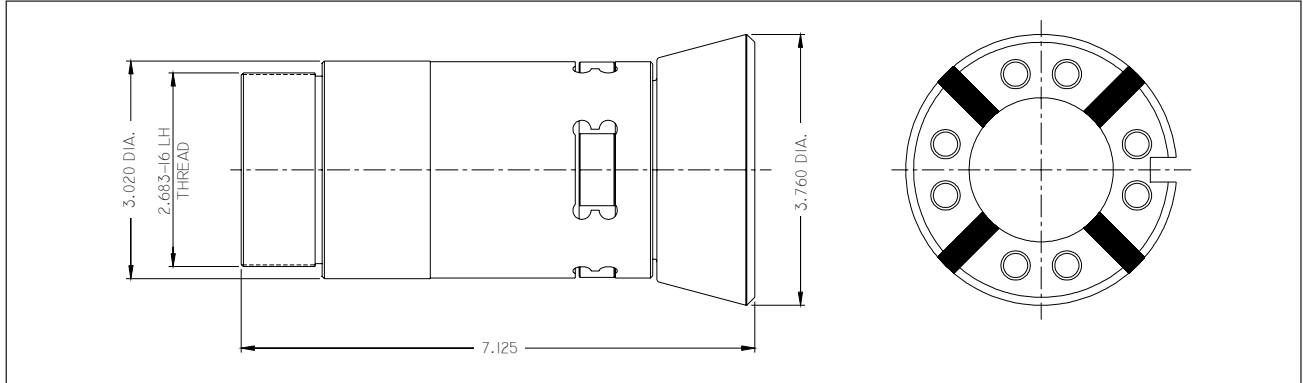
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9361E/RS40 Outer Sleeve			CALL
RS40/RD Inner Collet - Round	.250"	1.562"	CALL
RS40/HEX Inner Collet - Hexagonal	.250"	1.375"	CALL
S40 Adjusting Wrench			CALL

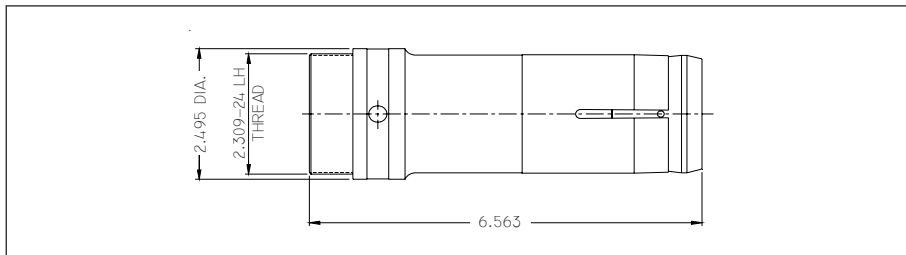
Acme-Gridley 2" RA6, RB6

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB50A Collet Body			\$465.00	\$409.20	\$372.00
MA50A/RSR Collet - Serrated Bore	.500"	2.000"	\$356.00	\$313.28	\$284.80
MA50A/RSM Collet - Smooth Bore	.500"	2.000"	\$356.00	\$313.28	\$284.80
MA50A/HEX Collet - Hexagonal	.500"	1.687"	\$398.00	\$350.24	\$318.40
WH50 Hydraulic Changing Fixture			\$792.00		
EN162 Hydraulic Pump			\$935.00		

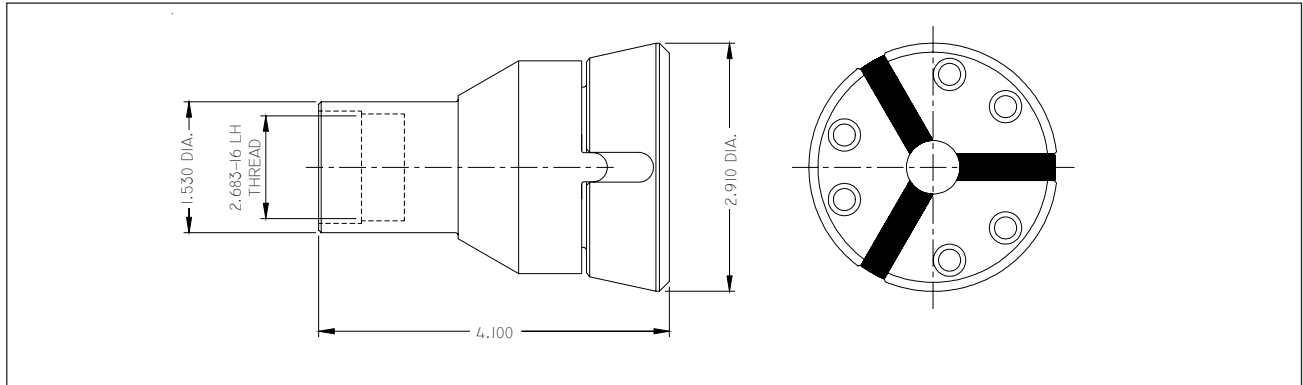
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
940E/RS50 Outer Sleeve			CALL
RS50/RD Inner Collet - Round	.500"	1.937"	CALL
RS50/HEX Inner Collet - Hexagonal	.500"	1.687"	CALL
S50 Adjusting Wrench			CALL

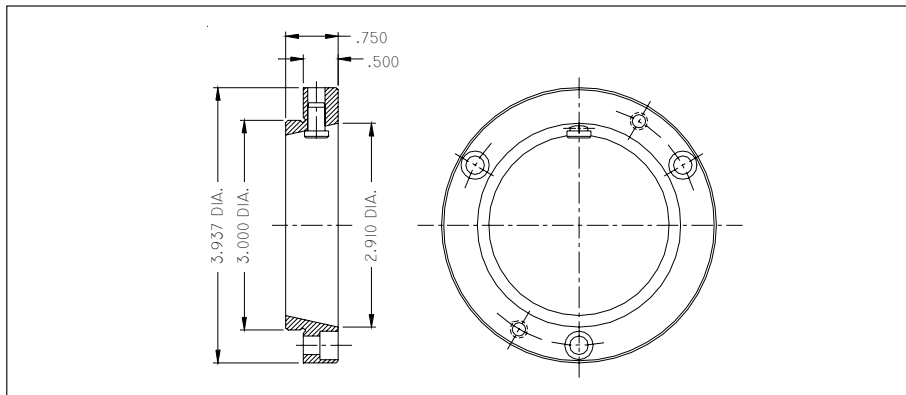
Acme-Gridley 2-3/8" HSC

Quick Change Collets



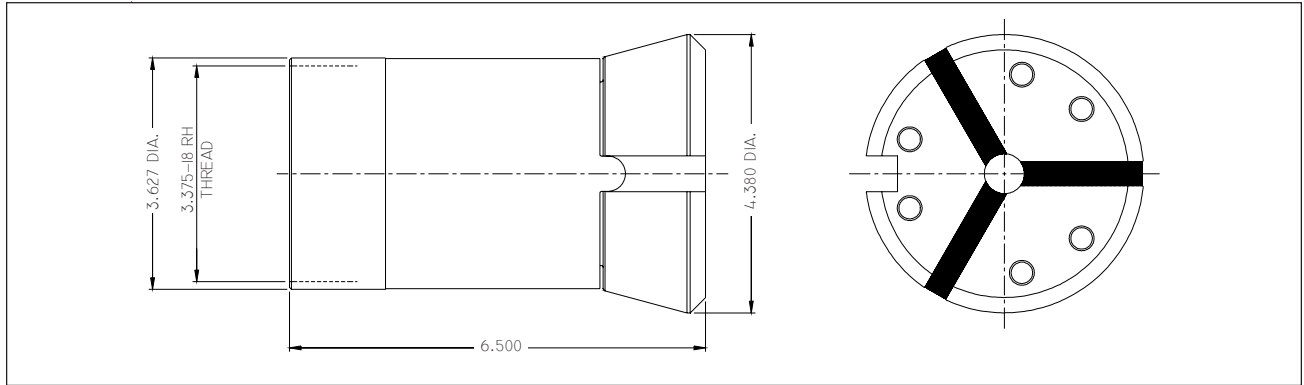
Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB42A Collet Body			\$450.00	\$396.00	\$360.00
MA42A/RSR Collet - Serrated Bore	.375"	1.625"	\$187.00	\$164.56	\$149.60
MA42A/RSM Collet - Smooth Bore	.187"	1.625"	\$187.00	\$164.56	\$149.60
MA42A/HEX Collet - Hexagonal	.250"	1.500"	\$282.00	\$248.16	\$225.60
WM42 Manual Changing Fixture			\$560.00		
WH42 Hydraulic Changing Fixture			\$670.00		
EN162 Hydraulic Pump			\$935.00		

Collet Seat



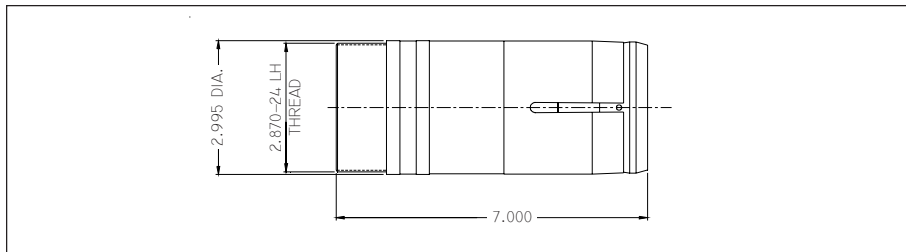
Model / Description	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MS42A/HSC Collet Seat (with collet pin)	\$655.00	\$576.00	\$524.00

Acme-Gridley 2-5/8" RA6, RA8, RB6, RB8 Quick Change Collets



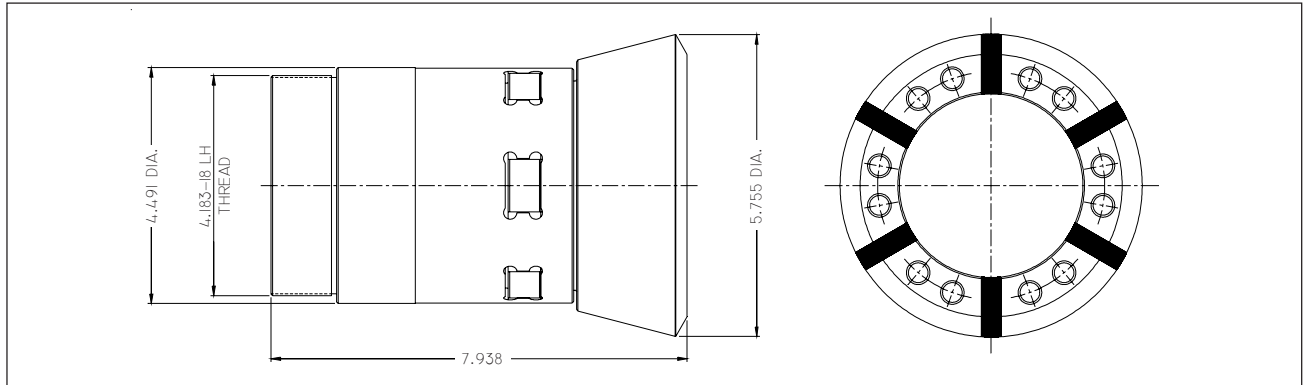
Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB67A Collet Body			\$386.00	\$339.68	\$308.80
MA67A/RSR Collet - Serrated Bore	.500"	2.625"	\$310.00	\$272.80	\$248.00
MA67A/RSM Collet - Smooth Bore	.500"	2.625"	\$310.00	\$272.80	\$248.00
MA67A/HEX Collet - Hexagonal	.500"	2.250"	\$356.00	\$313.78	\$284.80
WH67 Hydraulic Changing Fixture			\$698.00		
EN162 Hydraulic Pump			\$935.00		

Adjustable Pushers



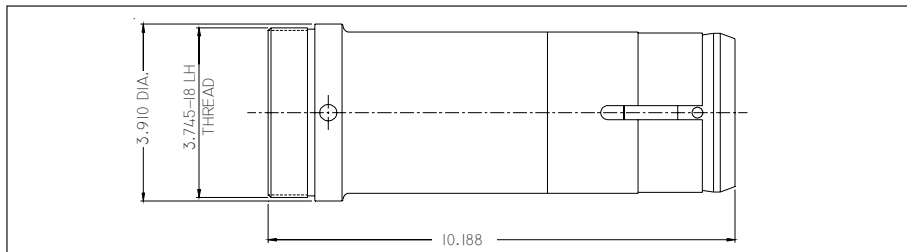
Model / Description	Min. Dia.	Max. Dia.	Price
9446E/RS67 Outer Sleeve			CALL
RS67/RD Inner Collet - Round	.500"	2.500"	CALL
RS67/HEX Inner Collet - Hexagonal	.500"	2.125"	CALL
S67 Adjusting Wrench			CALL

Acme-Gridley 3-1/2" RA4, RA6, RB4, RB6, RB8 Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB90A Collet Body			\$687.00	\$604.56	\$549.60
MA90A/RSR Collet - Serrated Bore	1.000"	3.500"	\$772.00	\$679.36	\$617.60
MA90A/RSM Collet - Smooth Bore	1.000"	3.500"	\$772.00	\$679.36	\$617.60
MA90A/HEX Collet - Hexagonal	1.000"	3.000"	\$850.00	\$748.00	\$680.00
WH90 Hydraulic Changing Fixture			\$1,210.00		
EN162 Hydraulic Pump			\$935.00		

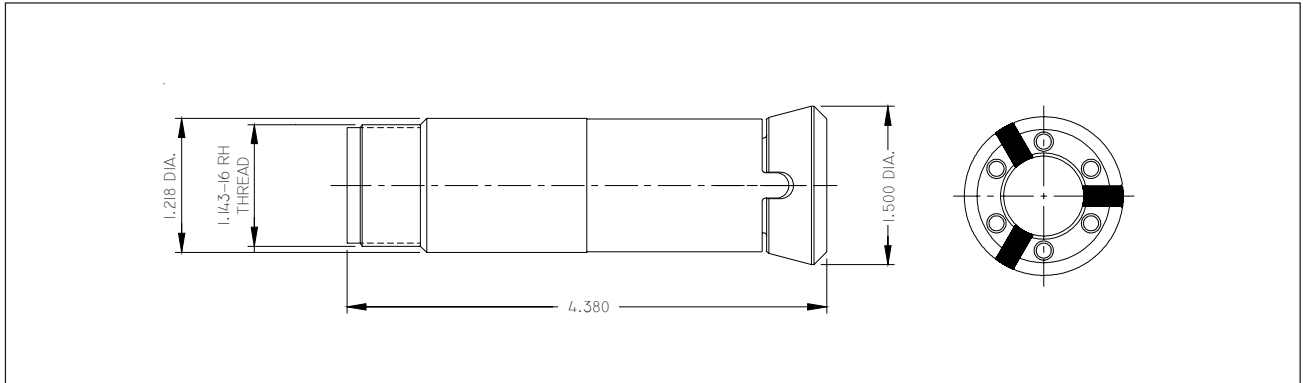
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9479E/RS80 Outer Sleeve			CALL
RS80/RD Inner Collet - Round	.500"	3.125"	CALL
RS80/HEX Inner Collet - Hexagonal	.500"	2.687"	CALL
S80 Adjusting Wrench			CALL

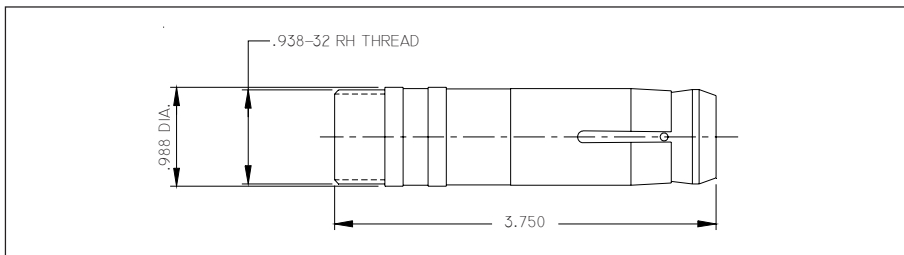
Davenport 3/4" Model B - Oversize

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB19D Collet Body			\$184.00	\$161.92	\$147.20
MA19D/RSM Collet - Smooth Bore	.187"	.750"	\$146.00	\$128.48	\$116.80
MA19D/HEX Collet - Hexagonal	.187"	.656"	\$164.00	\$144.32	\$131.20
WH19 Hydraulic Changing Fixture			\$678.00		
EN162 Hydraulic Pump			\$935.00		

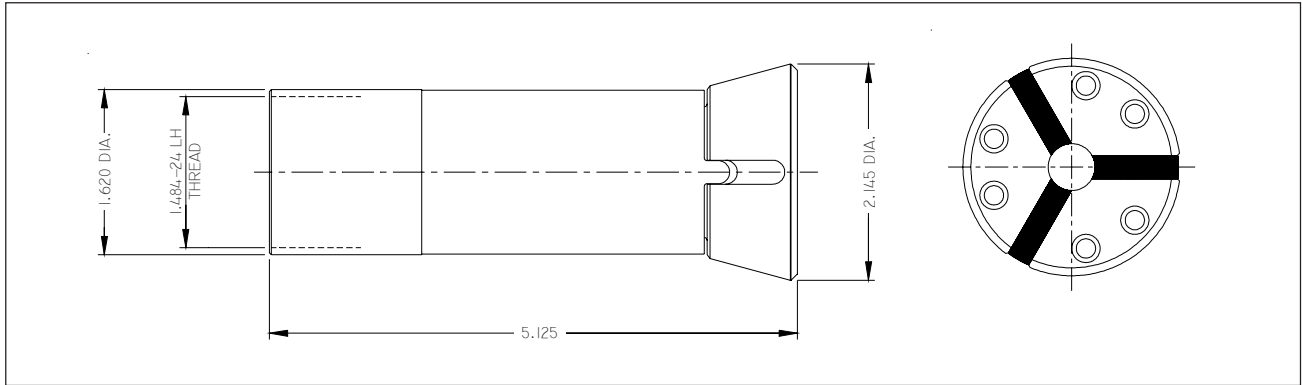
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
92534H/RS20 Outer Sleeve			CALL
RS20/RD Inner Collet - Round	.187"	.687"	CALL
RS20/HEX Inner Collet - Hexagonal	.187"	.593"	CALL
S20 Adjusting Wrench			CALL

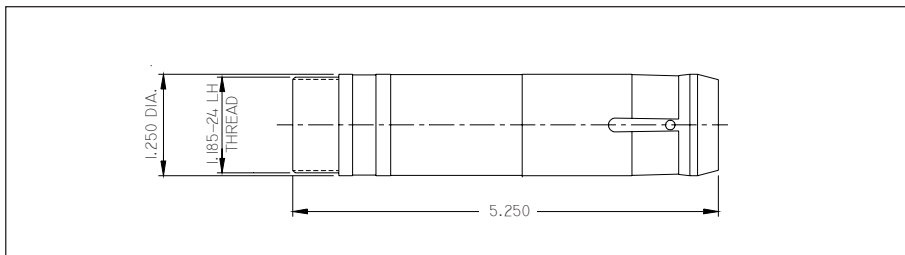
New Britain 1" Model 51 & 60

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB25N Collet Body			\$225.00	\$198.00	\$180.00
MA25N/RSR Collet - Serrated Bore	.312"	1.000"	\$162.00	\$142.50	\$129.60
MA25N/RSM Collet - Smooth Bore	.187"	1.000"	\$162.00	\$142.50	\$129.60
MA25N/HEX Collet - Hexagonal	.187"	.875"	\$195.00	\$171.60	\$156.00
WM25 Manual Changing Fixture			\$548.00		
WH25 Hydraulic Changing Fixture			\$650.00		
EN162 Hydraulic Pump			\$935.00		

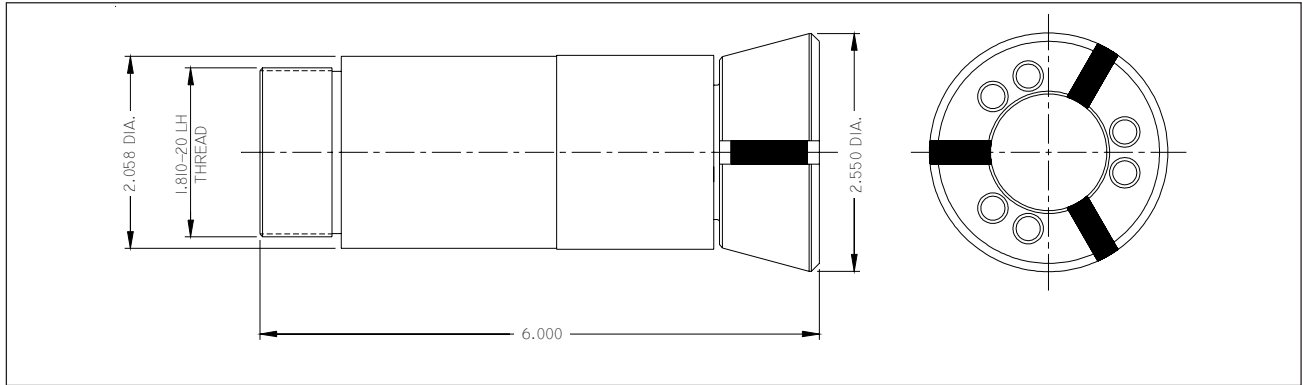
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9276E/RS25 Outer Sleeve			CALL
RS25/RD Inner Collet - Round	.187"	1.000"	CALL
RS25/HEX Inner Collet - Hexagonal	.187"	.875"	CALL
S25 Adjusting Wrench			CALL

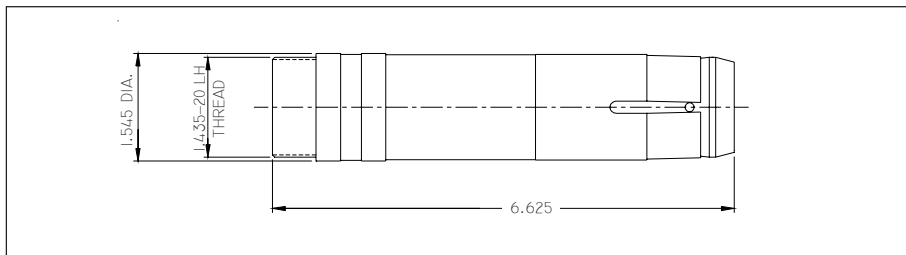
New Britain 1-1/4" Model 52 & 601

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB32A Collet Body			\$258.00	\$227.04	\$206.40
MA32A/RSR Collet - Serrated Bore	.375"	1.250"	\$165.00	\$145.20	\$132.00
MA32A/RSM Collet - Smooth Bore	.187"	1.250"	\$165.00	\$145.20	\$132.00
MA32A/HEX Collet - Hexagonal	.250"	1.125"	\$198.00	\$174.24	\$158.40
WM32 Manual Changing Fixture			\$548.00		
WH32 Hydraulic Changing Fixture			\$650.00		
EN162 Hydraulic Pump			\$935.00		

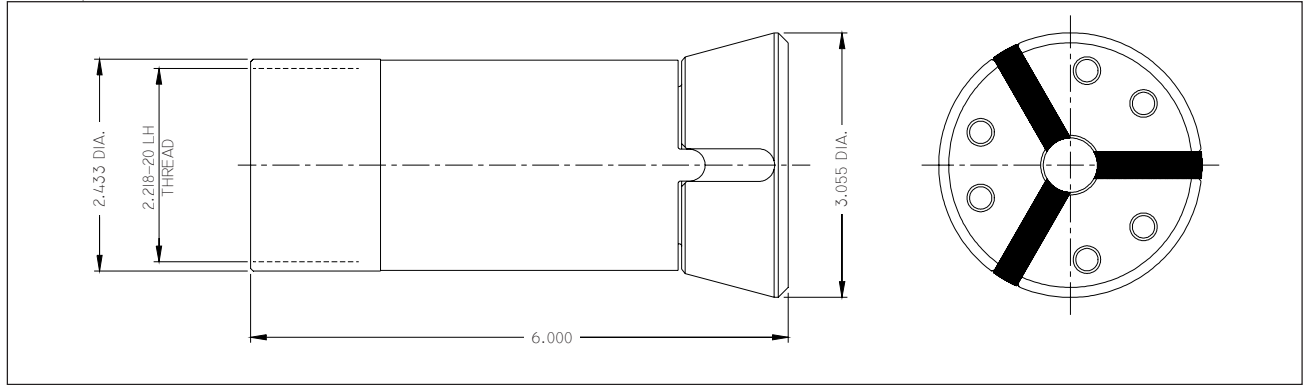
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9285E/RS30 Outer Sleeve			CALL
RS30/RD Inner Collet - Round	.250"	1.187"	CALL
RS30/HEX Inner Collet - Hexagonal	.250"	1.000"	CALL
S30 Adjusting Wrench			CALL

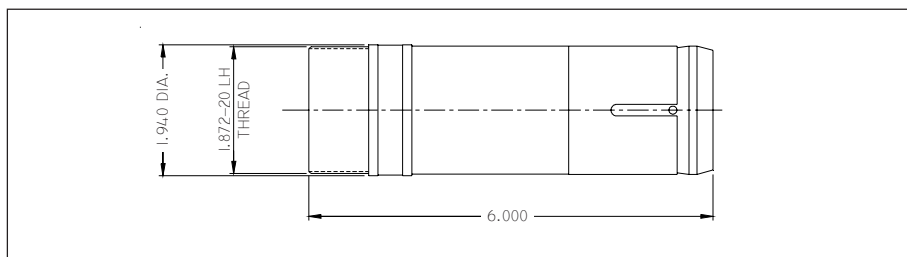
New Britain 1-5/8" Model 61 & 62

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB42C Collet Body			\$372.00	\$327.36	\$297.60
MA42C/RSR Collet - Serrated Bore	.500"	1.625"	\$231.00	\$203.28	\$184.80
MA42C/RSM Collet - Smooth Bore	.500"	1.625"	\$231.00	\$203.28	\$184.80
MA42C/HEX Collet - Hexagonal	.500"	1.375"	\$264.00	\$232.32	\$211.20
WM42 Hydraulic Changing Fixture			\$560.00		
WH42 Hydraulic Changing Fixture			\$670.00		
EN162 Hydraulic Pump			\$935.00		

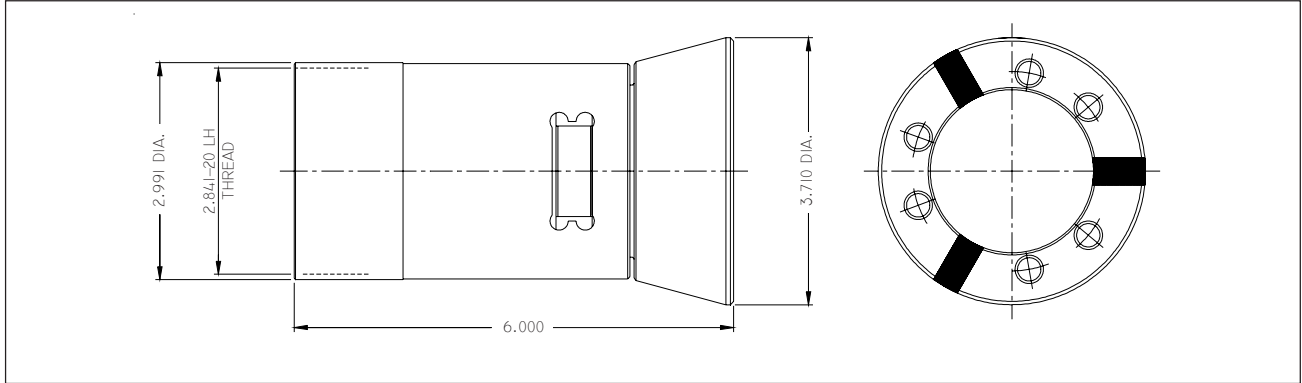
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9360E/RS40 Outer Sleeve			CALL
RS40/RD Inner Collet - Round	.250"	1.562"	CALL
RS40/HEX Inner Collet - Hexagonal	.250"	1.375"	CALL
S40 Adjusting Wrench			CALL

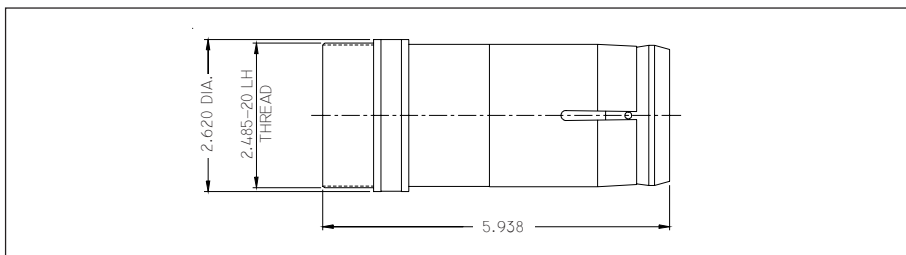
New Britain 2-1/4" Model 61 & 62

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB57N Collet Body			\$424.00	\$373.12	\$339.20
MA57N/RSR Collet - Serrated Bore	.500"	2.250"	\$358.00	\$315.04	\$286.40
MA57N/RSM Collet - Smooth Bore	.500"	2.250"	\$358.00	\$315.04	\$286.40
MA57N/HEX Collet - Hexagonal	.500"	1.937"	\$402.00	\$353.76	\$321.60
WH57 Hydraulic Changing Fixture			\$792.00		
EN162 Hydraulic Pump			\$935.00		

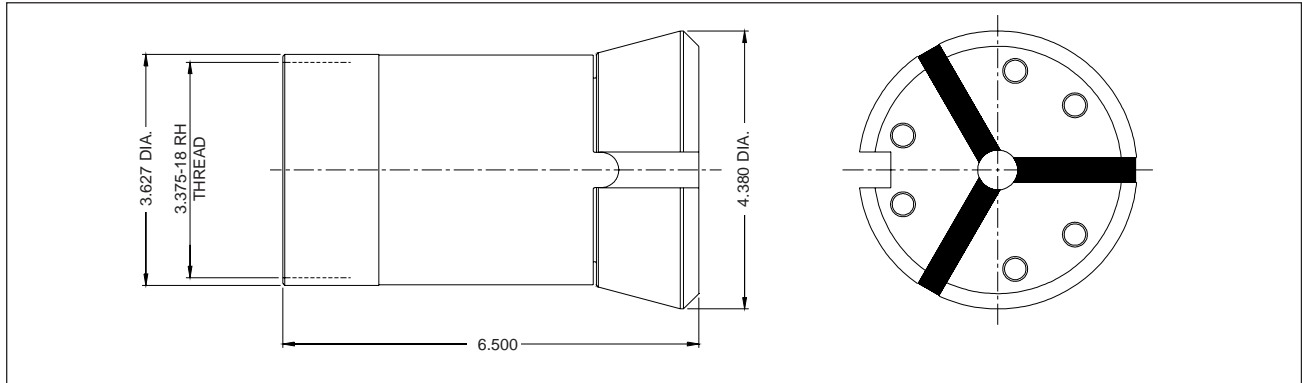
Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9411E/RS55 Outer Sleeve			CALL
RS55/RD Inner Collet - Round	.500"	2.125"	CALL
RS55/HEX Inner Collet - Hexagonal	.500"	1.875"	CALL
S55 Adjusting Wrench			CALL

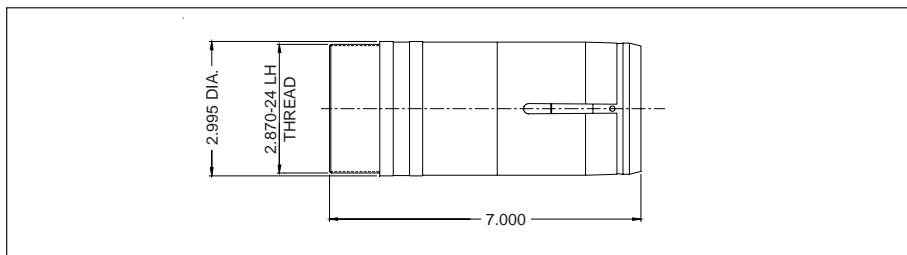
New Britain 2-5/8" Model 126 & 626

Quick Change Collets



Model / Description	Min. Dia.	Max. Dia.	Price (1pcs)	Price (2-5 pcs)	Price (6+ pcs)
MB67A Collet Body			\$386.00	\$339.68	\$308.80
MA67A/RSR Collet - Serrated Bore	.500"	2.625"	\$310.00	\$272.80	\$248.00
MA67A/RSM Collet - Smooth Bore	.500"	2.625"	\$310.00	\$272.80	\$248.00
MA67A/HEX Collet - Hexagonal	.500"	2.250"	\$356.00	\$313.78	\$284.80
WH67 Hydraulic Changing Fixture			\$698.00		
EN162 Hydraulic Pump			\$935.00		

Adjustable Pushers



Model / Description	Min. Dia.	Max. Dia.	Price
9446E/RS67 Outer Sleeve			CALL
RS67/RD Inner Collet - Round	.500"	2.500"	CALL
RS67/HEX Inner Collet - Hexagonal	.500"	2.125"	CALL
S67 Adjusting Wrench			CALL



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