

Recommended tightening torque for ER and MR clamping nuts

Maximum torques for retention knobs (Nm)

		Hi-Q®/ER clamping nuts												
		ER/ERC		ERB/ERBC		ERM/ERMC		ERMX/ERMXC		ERAX/ERAXC		ER MS		
		Collets [Nm]										Collets [Nm]		
Collet size	Ø [mm]	Ø [decimal inch]	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	TORCO-FIX
ER 8 MB	0.2–0.9	0.0078–0.035	–	–	–	–	6	–	6	–	–	–	6	0
ER 8	1.0–5.0	0.039–0.196	–	–	–	–	6	–	6	–	–	–	6	0
ER 11 MB	0.2–0.9	0.0078–0.035	8	–	–	–	8	–	8	–	8	–	8	0, I
ER 11	1.0–2.9	0.039–0.098	8	8	–	–	8	8	8	8	8	8	10	0, I
	3.0–7.0	0.118–0.256	24	16	–	–	16	13	16	13	24	21	10	0, I
ER 16 MB	0.2–0.9	0.0078–0.035	8	–	–	–	8	–	8	–	8	–	12	0, I
ER 16	1.0	0.039	8	–	6.4	–	8	–	8	–	8	–	12	0, I
	1.5–3.5	0.059–0.138	20	–	16	–	20	–	20	–	20	–	20	0, I
	4.0–4.5	0.157–0.177	40	40	32	32	24	–	24	–	40	40	20	I, II
	5.0–10.0	0.197–0.394	56	44	56	44	24	–	24	–	40	40	20	II
ER 20	1.0	0.039	16	–	12	–	16	–	16	–	16	–	12	0, I
	1.5–6.5	0.059–0.256	32	32	24	24	28	28	28	28	52	35	20	I, II
	7.0–13.0	0.276–0.512	80	35	80	24	28	28	28	28	52	35	20	I, II
ER 25	1.0–3.5	0.059–0.138	24	–	20	–	24	–	24	–	24	–	–	I, II
	4.0–4.5	0.157–0.177	56	56	48	48	32	32	32	32	56	56	–	I, II
	5.0–7.5	0.196–0.295	80	80	72	72	32	32	32	32	80	80	–	II, III
	8.0–17.0	0.315–0.669	104	80	104	79	32	32	32	32	80	80	–	II, III
ER 32	2.0–2.5	0.078–0.098	24	24	20	–	–	–	–	–	24	–	–	I, II
	3.0–7.5	0.118–0.291	136	136	128	90	–	–	–	–	104	90	–	II, III
	8.0–22.0	0.315–0.787	136	136	136	90	–	–	–	–	104	90	–	II, III
ER 40	3.0–26.0	0.118–1.023	176	176	176	176	–	–	–	–	128	128	–	II, III
ER 50	6.0–36.0	0.236–1.417	240	300	240	300	–	–	–	–	–	–	–	III

*Includes ER standard and ER-UP

		micRun® clamping nuts					
		MR/MRC		MRM/MRMC			
		micRun® collets [Nm]					
Collet size	Ø [mm]	Ø [decimal inch]	MR	MRC	MRM	MRMC	
MR 11	1.0–2.9	0.039–0.098	8	8	–	–	
	3.0–7.0	0.118–0.256	16	16	–	–	
MR 16	1.0	0.039	8	8	8	8	
	1.5–3.5	0.059–0.138	20	20	20	20	
	4.0–4.5	0.157–0.177	40	40	24	24	
	5.0–10.0	0.197–0.394	56	56	24	24	
MR 25	1.0–3.5	0.059–0.138	24	24	–	–	
	4.0–4.5	0.157–0.177	56	56	–	–	
	5.0–7.5	0.196–0.295	80	80	–	–	
	8.0–17.0	0.315–0.669	104	80	–	–	
MR 32	2.0–2.5	0.078–0.098	24	24	–	–	
	3.0–22.0	0.118–0.2917	136	136	–	–	

Steep taper	maximum tightening torque
SK, BT, CAT 30	25 Nm
SK, BT, CAT 40	50 Nm
SK, BT, CAT 50	100 Nm

Higher tightening torques can lead to deformation of the steep taper!

Expert advice

We recommend tightening the clamping nuts with our TORCO-BLOCK or torque wrench.

Original REGO-FIX accessories can be found on page 237.



Recommended tightening torque for ER and MR clamping nuts

Maximum torques for retention knobs (ft-lbs)

		Hi-Q®/ER clamping nuts												
		ER/ERC		ERB/ERBC		ERM/ERMC		ERMx/ERMxC		ERAx/ERAxC		ER MS		
		Collets [ft-lbs]										Collets [ft-lbs]		
Collet size	Ø [mm]	Ø [decimal inch]	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	ER-GB	ER*	TORCO-FIX*
ER 8 MB	0.2–0.9	0.0078–0.035	–	–	–	–	4	–	4	–	–	–	4	Micro
ER 8	1.0–5.0	0.039–0.196	–	–	–	–	4	–	4	–	–	–	4	Micro
ER 11 MB	0.2–0.9	0.0078–0.035	6	–	–	–	6	–	6	–	6	–	6	Micro, S
ER 11	1.0–2.9	0.039–0.098	6	6	–	–	6	6	6	6	6	6	7	Micro, S
	3.0–7.0	0.118–0.256	24	16	–	–	16	13	16	13	24	21	7	Micro, S
ER 16 MB	0.2–0.9	0.0078–0.035	6	–	–	–	6	–	6	–	6	–	9	Micro, S
ER 16	1.0	0.039	6	–	5	–	6	–	6	–	6	–	9	Micro, S
	1.5–3.5	0.059–0.138	15	–	12	–	15	–	15	–	15	–	15	Micro, S
	4.0–4.5	0.157–0.177	30	30	25	25	18	–	18	–	30	30	15	S, M
	5.0–10.0	0.197–0.394	46	32	40	21	18	–	18	–	30	30	–	M
ER 20	1.0	0.039	12	–	10	–	12	–	12	–	12	–	9	Micro, S
	1.5–6.5	0.059–0.256	25	25	20	20	21	21	21	21	40	25	14	S, M
	7.0–13.0	0.276–0.512	60	60	60	60	21	21	21	21	40	25	14	S, M
ER 25	1.0–3.5	0.059–0.138	18	–	15	–	18	–	18	–	18	–	–	S, M
	4.0–4.5	0.157–0.177	40	40	35	35	24	24	24	24	40	40	–	S, M
	5.0–7.5	0.196–0.295	60	60	55	55	24	24	24	24	60	60	–	M, L
	8.0–17.0	0.315–0.669	80	60	80	60	24	24	24	24	60	60	–	M, L
ER 32	2.0–2.5	0.078–0.098	18	18	15	–	–	–	–	–	20	–	–	S, M
	3.0–7.5	0.118–0.291	100	100	95	65	–	–	–	–	80	65	–	M, L
	8.0–22.0	0.315–0.787	100	100	100	65	–	–	–	–	80	65	–	M, L
ER 40	3.0–26.0	0.118–1.023	130	130	130	130	–	–	–	–	95	95	–	M, L
ER 50	6.0–36.0	0.236–1.417	180	220	180	220	–	–	–	–	–	–	–	L

*Includes ER standard and ER-UP

Collet size	Ø [mm]	Ø [decimal inch]	micRun® clamping nuts				Steep taper	maximum tightening torque
			MR/MRC		MRM/MRMC			
			MR	MRC	MRM	MRMC		
MR 11	1.0–2.9	0.039–0.098	6	6	–	–	SK, BT, CAT 30	18 ft-lbs
	3.0–7.0	0.118–0.256	12	12	–	–	SK, BT, CAT 40	36-ft-lbs
MR 16	1.0	0.039	6	6	6	6	SK, BT, CAT 50	72 ft-lbs
	1.5–3.5	0.059–0.138	15	15	15	15		
	4.0–4.5	0.157–0.177	30	30	18	18		
	5.0–10.0	0.197–0.394	41	41	18	18		
MR 20	1.0	0.039	12	12	–	–		
	1.5–6.5	0.059–0.256	24	24	–	–		
	7.0–13.0	0.276–0.512	60	60	–	–		
MR 25	1.0–3.5	0.059–0.138	18	18	–	–		
	4.0–4.5	0.157–0.177	42	42	–	–		
	5.0–7.5	0.196–0.295	60	60	–	–		
	8.0–17.0	0.315–0.669	78	78	–	–		
MR 32	2.0–2.5	0.078–0.098	18	18	–	–		
	3.0–22.0	0.118–0.2917	100	100	–	–		

Higher tightening torques can lead to deformation of the steep taper and therefore to bad runout!

Expert advice

We recommend tightening the clamping nuts with our TORCO-BLOCK or torque wrench.

Original REGO-FIX accessories can be found on page 237.