

CREATECH MACHINE AND DESIGN

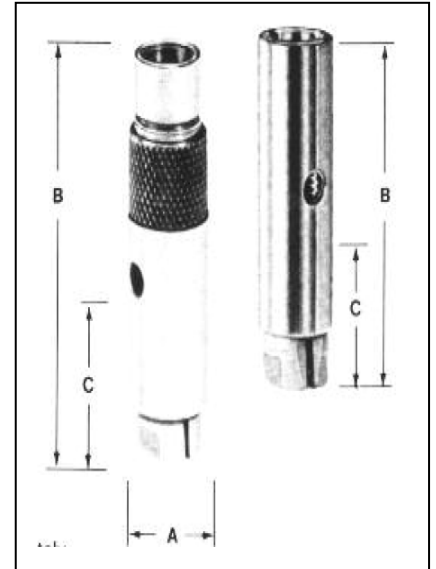
Single Purpose Threaded Collet Tool Holders

Single purpose threaded collet tool holders are available with rigid grip or floating collets and may be used for accurate close center drilling or tapping operations. Style 1 tool holders utilize serrated spindles and have vertical adjustment. Vertical adjustment is accomplished by lifting the top collar on the body, repositioning the mating lock insert to another set of spindle serrations and returning the collar to its original position. Style 2 tool holders are used with Jacobs taper spindles on either multiple spindle heads or drill press spindles; but they do not have vertical adjustment feature.

Standard tooling is used with the rigid grip threaded collets. Drill drive is accomplished by using the shank of the readily available straight shank automotive series drills. Taps are driven by the shank square. On both drills and taps the round portion of the shank is clamped rigidly when the angular areas are tightened and resulting forces collapse the split collet.

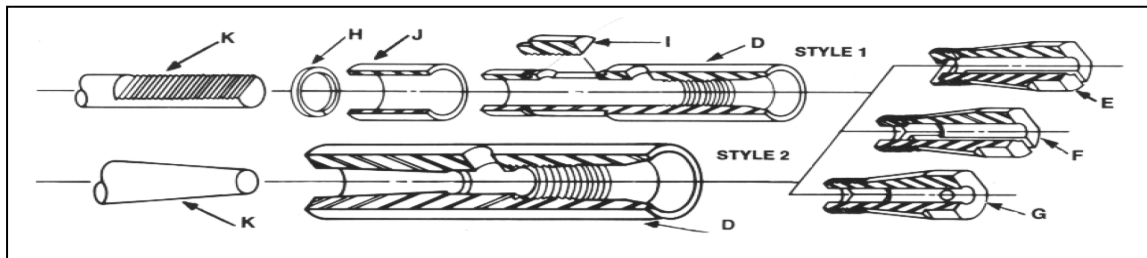
Ordering Information:

1. Order by part number as shown in tabulations; assembly includes all components except collets; collets and replacement parts are ordered separately
2. Collets are single purpose, order one collet for each tool size; specify type of tool and size
3. Tool holders on existing equipment are identified by the collet thread diameter, pitch and type of spindle.



SPECIFICATIONS									
Series	Style	Assembly Part No	Capacity		Dimensions				Spindle Dia/Taper
			Drill	Tap	A	B	C Drill	C Tap	
3800	1	3800.000-00	#60 to 1/4	#0 to 1/4	0.63	2.31	0.87	0.75	.375 Serrated
4200	1	4200.000-00	#60 to 5/16	#0 to 5/16	0.88	2.31	1.06	0.81	.4375 Serrated
4300	2	4301.1A0-00	#60 to 5/16	#0 to 5/16	0.88	2.06	1.06	0.81	1 Jacobs
4300	2	4301.2A0-00	#60 to 5/16	#0 to 5/16	0.88	2.06	1.06	0.81	2 Jacobs
4400	2	4401.1A0-00	#60 to 1/4	#0 to 1/4	0.56	1.88	0.88	0.75	1 Jacobs
5400	2	5401.0T0-00	#60 to 5/32	#0 to #10	0.47	1.88	0.84	0.75	0 Jacobs XX

* Assembly includes all components except collets. Collet part numbers are shown in tabulations at bottom of page.
 XX 1 Jacobs available C = depth that tool enters holder. Style 1 holders have .25 vertical adjustment.



COLLETS AND REPLACEMENT PARTS										
Series	Style	Body	Collet				Retaining Ring	Spindle Lock	Collar	Spindle Dia/Taper
		D	E Drill	F Tap-Rigid	G Tap- Floating	Thread	H	I	J	K
3800	1	380100000	4402XXXXX	44030XXXX	4403FXXXX	3/8-24	380600000	660500000	660300000	.375 Serrated
4200	1	420100000	4202XXXXX	43020XXXX	NA	1/2-20	410510000	410200000	410400000	.4375 Serrated
4300	2	43011A000	4202XXXXX	43020XXXX	NA	1/2-20	NR	NR	NR	1 Jacobs
4300	2	43012A000	4202XXXXX	43020XXXX	NA	1/2-20	NR	NR	NR	2 Jacobs
4400	2	44011A000	4402XXXXX	44030XXXX	4403FXXXX	3/8-24	NR	NR	NR	1 Jacobs
5400	2	54010T000	5402XXXXX	54030XXXX	5403FXXXX	5/16-24	NR	NR	NR	0 Jacobs

Part numbers with X to be completed by Createch. Order one collet for each tool size, identify tool and specify shank dia.
 NA = Not Available NR = Not Required