Rotary Coolant Collars are designed in three styles - Standard RPM (CGS), High RPM (CGH) and 2 Piece High RPM (CGH2) for manual and transfer type machines. Specifically designed for applications where space is at a minimum. Rotary Coolant Collars are used in many special applications. If you have a special requirement, please call your local Representative or our factory.

**Rotary Coolant Collars • Standard RPM**

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>A I.D. (IN.)</th>
<th>B O.D. (IN.)</th>
<th>C WIDTH (IN.)</th>
<th>D OAL (IN.)</th>
<th>E SHIELD I.D. (IN.)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM) (3)</th>
<th>O-RING PART NUMBER (2 PCS INCLUDED)</th>
<th>THRUST WASHER (2 PCS INCLUDED)</th>
<th>SNAP RING (2 PCS INCLUDED)</th>
<th>REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED)</th>
</tr>
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<tbody>
<tr>
<td>CGS-0937</td>
<td>0.937</td>
<td>1.375</td>
<td>1.250</td>
<td>2.250</td>
<td>1.375</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>1300</td>
<td>001-001</td>
<td>403-001</td>
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<td>SK-0937</td>
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<td>1.750</td>
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<td>750 PSI</td>
<td>1100</td>
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<td>001-202</td>
<td>SK-1250</td>
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<td>2.187</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>1000</td>
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<td>403-003</td>
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</tr>
</tbody>
</table>

1, 2 - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to O-Rings.

3 - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures. These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:

- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds. Oil Mist may be utilized with these units at very low RPM.

**Rotary Coolant Collars • High RPM**

General Operating Recommendations For All Rotary Coolant Collars See Page 114.

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>A I.D. (IN.)</th>
<th>B O.D. (IN.)</th>
<th>C WIDTH (IN.)</th>
<th>D OAL (IN.)</th>
<th>E SHIELD I.D. (IN.)</th>
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<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM) (3)</th>
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<th>SNAP RING (2 PCS INCLUDED)</th>
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<tr>
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<td>750 PSI</td>
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<td>-</td>
<td>100 PSI</td>
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<td>1000 PSI</td>
<td>1400</td>
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</table>

1, 2 - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.

3 - Recommended Maximum RPM at Maximum 750/1000 PSI. Higher speeds may be achieved at pressures below 1000 PSI. These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:

- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.
ROTARY COOLANT COLLARS • 2 PIECE HIGH RPM

Dimensions

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>OLD PART NUMBER</th>
<th>A L.D. (IN.)</th>
<th>B O.D. (IN.)</th>
<th>C WIDTH (IN.)</th>
<th>D OAL (IN.)</th>
<th>E SHIELD L.D. (IN.)</th>
<th>F CTR (IN.)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM) (3)</th>
<th>THRUST WASHER (2 PCS INCLUDED)</th>
<th>SNAP RING (2 PCS INCLUDED)</th>
<th>MATING SHANK O-RING (2 PCS INCLUDED)</th>
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<tr>
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<td>0.8750</td>
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<td>750 PSI</td>
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<td>403-007</td>
<td>001-204</td>
<td>001-006</td>
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<td>103-006</td>
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<td>103-009</td>
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<td>100 PSI</td>
<td>750 PSI</td>
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<td>-</td>
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<td>001-210</td>
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<td>869-875</td>
<td>001-216</td>
<td>001-027</td>
<td>SK2-4250</td>
</tr>
</tbody>
</table>

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals. (3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:

Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.

PLASTIC SPLASH SHIELD ASSEMBLIES

<table>
<thead>
<tr>
<th>STANDARD RPM COOLANT GLAND</th>
<th>HIGH RPM COOLANT GLAND</th>
<th>(6) PLASTIC SHIELD 9-5/6 OD X 1-1/2 LG</th>
<th>SHIELD INSIDE DIAMETER</th>
<th>(7) COOLANT TORQUE BAR 3/8-18 NPT X 11&quot;</th>
<th>(8) U-BOLT ASSEMBLY</th>
</tr>
</thead>
<tbody>
<tr>
<td>CGS-0937</td>
<td>CGH-0937</td>
<td>846-001</td>
<td>1-3/8</td>
<td>869-001TB</td>
<td>874-001UB</td>
</tr>
<tr>
<td>CGS-1250</td>
<td>CGH-1250</td>
<td>846-002</td>
<td>1-5/8</td>
<td>869-001TB</td>
<td>874-001UB</td>
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<tr>
<td>CGS-1625</td>
<td>CGH-1500</td>
<td>846-003</td>
<td>2-3/16</td>
<td>869-001TB</td>
<td>874-001UB</td>
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<td>CGS-2250</td>
<td>CGH-2250</td>
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<td>869-001TB</td>
<td>874-001UB</td>
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<td>CGS-2750</td>
<td>CGH-2750</td>
<td>846-005</td>
<td>3-15/16</td>
<td>869-001TB</td>
<td>874-001UB</td>
</tr>
</tbody>
</table>

ASSEMBLY & PARTS DIAGRAM FOR STANDARD ROTARY COOLANT GLAND

1. Tool holder shank
2. Thrust washers (2)
3. Coolant inducer rings - apply grease or bearing lubricant
4. O-rings (2) - apply grease or bearing lubricant
5. Snap ring
6. Shield Assembly
7. 3/8 D.E. Pipe Nipple
8. U-bolt & washer assembly

CAUTION: (1) All holders with coolant glands (rotary coolant inducers) must have torque arm (pipe nipple) secured to prevent coolant hose interference with machine operation. (2) Rotary coolant assemblies are not designed to operate without coolant. (3) Torque arm centerline to be perpendicular to spindle centerline to maximize seal life.
**SHANK MOUNTING SPECIFICATIONS FOR THE GEORGE WHALLEY CO. STANDARD AND HIGH RPM ONE-PIECE ROTARY COOLANT GLANDS**

**SHANK O.D.** | **SNAP RING GROOVE O.D.** | **GLAND BEARING WIDTH** | **SNAP RING WIDTH** | **FOR USE WITH COOLANT GLAND NUMBER**
---|---|---|---|---
0.9360/0.9340 | 0.8790/0.8850 | 1.380/1.385 | 0.046/0.048 | CGH/CGS - 0937
1.249/1.247 | 1.172/1.180 | 1.380/1.385 | 0.056/0.060 | CGH/CGS - 1250
1.624/1.622 | 1.524/1.534 | 1.630/1.635 | 0.068/0.072 | CGH/CGS - 1625
2.249/2.247 | 2.114/2.126 | 1.815/1.820 | 0.086/0.091 | CGH/CGS - 2250
2.749/2.747 | 2.596/2.608 | 1.755/1.760 | 0.103/0.108 | CGH/CGS - 2750
3.499/3.497 | 3.310/3.322 | 1.815/1.820 | 0.103/0.108 | CGH - 3500
3.999/3.997 | 3.786/3.798 | 2.002/2.006 | 0.120/0.125 | CGH - 4000

**SHANK MOUNTING SPECIFICATIONS FOR THE GEORGE WHALLEY CO. HIGH RPM TWO-PIECE ROTARY COOLANT GLANDS**

**SHANK O.D.** | **O-RING GROOVE O.D.** | **GLAND BEARING WIDTH** | **O-RING WIDTH** | **SET SCREW POINT LOCATION** | **FOR USE WITH COOLANT GLAND NUMBER**
---|---|---|---|---|---
1.249/1.247 | 1.135 | 1.000 | 0.090/0.094 | 0.906 | CGH2 - 0937
1.499/1.497 | 1.380 | 1.000 | 0.090/0.094 | 1.000 | CGH2 - 1250
1.999/1.997 | 1.885 | 1.250 | 0.090/0.094 | 1.063 | CGH2 - 1625
2.561/2.559 | 2.375 | 1.500 | 0.138/0.142 | 1.188 | CGH2 - 2250
4.249/4.247 | 4.025 | 1.500 | 0.175/0.185 | 1.531 | CGH2 - 2750
4.999/4.997 | 4.885 | 1.250 | 0.090/0.094 | 0.906 | 801 - 083A
2.449/2.497 | 2.390 | 1.500 | 0.090/0.094 | 0.969 | 801 - 091

**BREAK IN AND OPERATING RECOMMENDATIONS FOR AUTOMATIC AND MANUAL TOOL CHANGE COOLANT GLANDS**

In order to assure proper lubrication, even wear, and proper seating, high RPM glands should be broken in at 100 RPM for 3 minutes with coolant introduced at a pressure and volume between 100 PSI and 500 PSI to prevent overloading seals. Repeat procedure at 500 RPM for 3 minutes, and again at 1000 RPM. After break in procedure is complete, units may be run at pressures between 100 PSI and 750/1000 PSI.

For maximum life and performance of these coolant glands and seals the following conditions are recommended:

1. Coolant filtration: 30 to 50 micron minimum; 5 micron optimum

2. Proper type & viscosity of coolant: preferably a good water soluble synthetic with good lubrication and heat dissipation under pressure.

3. Coolant pressure: minimum of 100 lbs. coolant pressure at high R.P.M’s (1800 SFM or more based on I.D. dimension of coolant gland or O.D. bearing diameter of tool holder). Maximum pressure of 750/1000 PSI.

4. Coolant volume must be sufficient to properly lubricate cutting tool as recommended by its manufacturer. The combination of volume and pressure can not exceed the coolant orifice delivery capability of your tool or premature gland failure may result due to excessive heat build up.
V-FLANGE SINGLE ANGLE COLLET CHUCKS WITH POSITIVE SEAL ADJUSTING STOP SCREW AND ROTARY COOLANT COLLARS

### Assembly Part Number

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>A RANGE (IN.)</th>
<th>COLLET SERIES</th>
<th>B CLEARANCE (IN.)</th>
<th>C PROJ. (IN.)</th>
<th>COOLANT GLAND (INCLUDED)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM) (3)</th>
<th>REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED)</th>
<th>OPTIONAL EXTENSION STYLE STOP SCREW (NOT INCLUDED)</th>
<th>SPANNER WRENCH (NOT INCLUDED)</th>
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<tbody>
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<td></td>
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<td>CGH-2250</td>
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- See pages 112-114 for Rotary Coolant Collars information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals. (3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures. These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:

- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.

### V-FLANGE END MILL HOLDERS WITH HIGH RPM ROTARY COOLANT GLANDS

<table>
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<th>A I.D. (IN.)</th>
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<th>C PROJECTION (IN.)</th>
<th>COOLANT GLAND (INCLUDED)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM) (3)</th>
<th>REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED)</th>
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(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals. (3) - Recommended Maximum RPM at Maximum 750/1000 PSI. Higher speeds may be achieved at lower pressures. These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:

- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.

- See pages 112-114 for Rotary Coolant Gland information
- For CAT 40 End Mill Holders please see bottom of page 105.

Retention Knobs
Sold Separately,
See Pages 163-167.
V-FLANGE MORSE TAPER HOLDERS WITH HIGH RPM ROTARY COOLANT GLAND

With High RPM Rotary Coolant Glands

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>A) MORSE TAPER</th>
<th>B) CLEARANCE (INCHES)</th>
<th>C) PROJECTION (INCHES)</th>
<th>COOLANT GLAND (INCLUDED)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM) (3)</th>
<th>REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED)</th>
</tr>
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<tbody>
<tr>
<td>45 V-FLANGE *C45-MT4-CGH-4</td>
<td>MT 4</td>
<td>1.62</td>
<td>3.18</td>
<td>CGH-1625</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>3300</td>
<td>SK-1625</td>
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<tr>
<td>50 V-FLANGE *C50-MT4-CGH-4</td>
<td>MT 4</td>
<td>1.62</td>
<td>3.38</td>
<td>CGH-1625</td>
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<td>750 PSI</td>
<td>3300</td>
<td>SK-1625</td>
</tr>
<tr>
<td>*C50-MT5-CGH-5</td>
<td>MT 5</td>
<td>2.75</td>
<td>4.25</td>
<td>CGH-2750</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>2200</td>
<td>SK-2750</td>
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</table>

* Outgoing Items
- See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
All units require coolant at all speeds.

NMTB TAPER SHANK • SINGLE ANGLE COLLET CHUCKS WITH POSITIVE SEAL ADJUSTING STOP SCREW AND ROTARY COOLANT GLAND

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>A) RANGE (IN.)</th>
<th>COLLET SERIES</th>
<th>B) CLEARANCE (IN.)</th>
<th>C) PROJ. (IN.)</th>
<th>COOLANT GLAND (INCLUDED)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM) (3)</th>
<th>REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED)</th>
<th>OPTIONAL EXTENSION STYLE STOP SCREW (NOT INCLUDED)</th>
<th>SPANNER WRENCH (NOT INCLUDED)</th>
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</thead>
<tbody>
<tr>
<td>40 NMTB</td>
<td>0.094 - 1.000</td>
<td>TG 100</td>
<td>2.50</td>
<td>6.25</td>
<td>CGH-2250</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>2800</td>
<td>SK-2250</td>
<td>-</td>
<td>116-002</td>
</tr>
<tr>
<td></td>
<td>0.500 - 1.500</td>
<td>TG 150</td>
<td>3.50</td>
<td>6.25</td>
<td>CGH-2750</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>2200</td>
<td>SK-2750</td>
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<td>112-002</td>
</tr>
<tr>
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<td>6.25</td>
<td>CGH-2250</td>
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<td>750 PSI</td>
<td>2800</td>
<td>SK-2250</td>
<td>-</td>
<td>116-002</td>
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<tr>
<td></td>
<td>0.500 - 1.500</td>
<td>TG 150</td>
<td>3.50</td>
<td>6.25</td>
<td>CGH-2750</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>2200</td>
<td>SK-2750</td>
<td>-</td>
<td>112-002</td>
</tr>
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</table>

* See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
All units require coolant at all speeds.
NMTB TAPER SHANK • END MILL HOLDERS WITH ROTARY COOLANT GLAND

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>A (I.D.) (IN.)</th>
<th>B CLEARANCE (IN.)</th>
<th>C PROJECTION (IN.)</th>
<th>COOLANT GLAND (INCLUDED)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM)</th>
<th>REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED)</th>
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<td>SK-1625</td>
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<tr>
<td>*N30-EM75-4</td>
<td>0.750</td>
<td>2.25</td>
<td>3.88</td>
<td>CGH-1625</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>3300</td>
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</tr>
<tr>
<td>40 NMTB</td>
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<td>SK-2250</td>
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<tr>
<td>N40-EM10-4</td>
<td>1.000</td>
<td>2.25</td>
<td>3.88</td>
<td>CGH-2250</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>2800</td>
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</tr>
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<td>N50-EM75-5</td>
<td>0.750</td>
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<td>N50-EM12-7</td>
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<td>7.00</td>
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<td>N50-EM15-7</td>
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<td>1000 PSI</td>
<td>1500</td>
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<tr>
<td>N50-EM20-7</td>
<td>2.000</td>
<td>3.50</td>
<td>7.00</td>
<td>CGH-3500</td>
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<td>N50-EM22-7</td>
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<td>7.00</td>
<td>CGH-4000</td>
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<td>1400</td>
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<tr>
<td>N50-EM25-7</td>
<td>2.500</td>
<td>4.75</td>
<td>7.00</td>
<td>CGH-4000</td>
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<td>1000 PSI</td>
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<tr>
<td>N50-EM30-10</td>
<td>3.000</td>
<td>4.75</td>
<td>9.00</td>
<td>CGH-4000</td>
<td>100 PSI</td>
<td>1000 PSI</td>
<td>1400</td>
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</tbody>
</table>

* Outgoing Items
- NMTB End Mill Holders are supplied with set screws. • See pages 112-114 for Rotary Coolant Gland information.
(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750/1000 PSI. Higher speeds may be achieved at lower pressures.
These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
- All units require coolant at all speeds.

NMTB TAPER SHANK • MORSE TAPER HOLDERS WITH HIGH RPM ROTARY COOLANT GLAND

<table>
<thead>
<tr>
<th>ASSEMBLY PART NUMBER</th>
<th>A MORSE TAPER</th>
<th>C PROJECTION (IN.)</th>
<th>COOLANT GLAND (INCLUDED)</th>
<th>MINIMUM COOLANT PRESSURE (1)</th>
<th>MAXIMUM COOLANT PRESSURE (2)</th>
<th>MAXIMUM SPEED (RPM)</th>
<th>REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED)</th>
</tr>
</thead>
<tbody>
<tr>
<td>40 NMTB</td>
<td></td>
<td></td>
<td></td>
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<td>SK-0937</td>
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<tr>
<td>*N40-MT2-CGH-4</td>
<td>MT 2</td>
<td>4.00</td>
<td>CGH-0937</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>5000</td>
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<tr>
<td>*N40-MT3-CGH-4</td>
<td>MT 3</td>
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<td>CGH-1250</td>
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<td>750 PSI</td>
<td>4000</td>
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<tr>
<td>50 NMTB</td>
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<td>SK-1250</td>
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<td>*N50-MT3-CGH-5</td>
<td>MT 3</td>
<td>5.38</td>
<td>CGH-1250</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>4000</td>
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<tr>
<td>*N50-MT4-CGH-3</td>
<td>MT 4</td>
<td>3.12</td>
<td>CGH-1625</td>
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<td>750 PSI</td>
<td>3300</td>
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<tr>
<td>*N50-MT5-CGH-3</td>
<td>MT 5</td>
<td>3.50</td>
<td>CGH-2250</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>2800</td>
<td></td>
</tr>
<tr>
<td>*N50-MT5-CGH-7</td>
<td>MT 5</td>
<td>7.25</td>
<td>CGH-2250</td>
<td>100 PSI</td>
<td>750 PSI</td>
<td>2800</td>
<td></td>
</tr>
</tbody>
</table>

* Outgoing Items
- See pages 112-114 for Rotary Coolant Gland information.
(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.
These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
- All units require coolant at all speeds.
STRAIGHT SHANK • MORSE TAPER HOLDERS WITH ROTARY COOLANT GLAND

Rotary Coolant Gland

Coolant Entry

**ASSEMBLY PART NUMBER** | **A MORSE TAPER** | **B SHANK DIA. (IN.)** | **C OAL. (IN.)** | **COOLANT GLAND (INCLUDED)** | **MINIMUM COOLANT PRESSURE (1)** | **MAXIMUM COOLANT PRESSURE (2)** | **MAXIMUM SPEED (RPM) (3)** | **REPLACEMENT SEAL KIT PART NUMBER** (NOT INCLUDED)
--- | --- | --- | --- | --- | --- | --- | --- | ---
SS12-MT2-CGH-4 | MT 2 | 1.250 | 4.00 | CGH-1250 | 100 PSI | 750 PSI | 4000 | SK-1250
SS12-MT3-CGH-6 | MT 3 | 1.250 | 5.75 | CGH-1250 | 100 PSI | 750 PSI | 4000 | SK-1250
SS12-MT4-CGH-6 | MT 4 | 1.250 | 5.75 | CGH-1625 | 100 PSI | 750 PSI | 4000 | SK-1250
SS15-MT2-CGH-4 | MT 3 | 1.500 | 4.00 | CGH-1250 | 100 PSI | 750 PSI | 4000 | SK-1250
SS15-MT3-CGH-6 | MT 4 | 1.500 | 5.75 | CGH-1250 | 100 PSI | 750 PSI | 4000 | SK-1250

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals.

(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

**FACE MOUNTED DOUBLE ANGLE COLLET CHUCK WITH HIGH RPM ROTARY COOLANT GLAND FOR USE WITH DRILL SPEEDER**

---

**ASSEMBLY PART NUMBER** | **A OAL (IN.)** | **B PROJ. (IN.)** | **C DIA. (IN.)** | **D DIA. (IN.)** | **MAX. SCREW ADJUST (IN.)** | **COOLANT GLAND (INCLUDED)** | **MINIMUM COOLANT PRESSURE (1)** | **MAXIMUM COOLANT PRESSURE (2)** | **MAXIMUM SPEED (RPM) (3)** | **REPLACEMENT SEAL KIT PART NUMBER** (NOT INCLUDED)
--- | --- | --- | --- | --- | --- | --- | --- | --- | --- | ---
*FM-DA10-4* | 3.937 | 3.625 | 2.625 | 1.250 | 1.25 | CGH-1250 | 100 PSI | 750 PSI | 4000 | SK-1250

---

**Outgoing Items**

* Holders use DA10 collets • See pages 112-114 for Rotary Coolant Gland information.

* Furnished with High RPM Coolant Gland and Nylon Seal Stop Screw

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals.

(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:

- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.
JACOBS TAPER MOUNT • DOUBLE ANGLE COLLET CHUCKS WITH ROTARY COOLANT GLAND

- For applications where additional reach and maximum tool adjustments are needed • For replacement nylon seals, see page 158 • See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.
These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.

STRAIGHT SHANK • END MILL HOLDERS WITH HIGH RPM ROTARY COOLANT GLAND

- To be used in most Straight Shank tooling applications - Gun Drills, Carbide Indexable Drills, Spade Drills, etc. • Triple entry design -(1) with coolant gland, (2) without coolant gland, (3) coolant-thru-the-spindle and stationary tool applications, thru entry on side of gland bearing surface • See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.
These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
All units require coolant at all speeds.
STRAIGHT SHANK • SINGLE ANGLE COLLET CHUCKS WITH ROTARY COOLANT GLAND AND POSITIVE STOP SCREW

- Triple entry design -(1) with coolant gland, (2) without coolant gland, (3) coolant-thru-the-spindle and stationary tool applications, thru entry on side of gland bearing surface.
- See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
- All units require coolant at all speeds.

STRAIGHT SHANK / JACOBS TAPER MOUNT • DOUBLE ANGLE COLLET CHUCK WITH POSITIVE SEAL STOP SCREW AND HIGH RPM ROTARY COOLANT GLAND

- Designed to provide additional reach and maximum tool adjustment with use of our positive seal stop screw • Single entry design requires that this chuck be used with coolant gland for coolant-thru-the-tool operations • Maximum adjustment of stop screw is 5/8" • See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
- All units require coolant at all speeds.
AUTOMOTIVE ADJUSTABLE SHANK • SINGLE ANGLE COLLET CHUCK HOLDERS WITH ROTARY COOLANT GLAND

- Dual Entry design allows use without gland for coolant-thru-the-spindle applications • See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions: Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.

- Dual Entry design allows use without gland for coolant-thru-the-spindle applications • See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions: Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.

All units require coolant at all speeds.
### AUTOMOTIVE ADJUSTABLE SHANK • MORSE TAPER HOLDERS WITH ROTARY COOLANT GLAND

#### ASSEMBLY PART NUMBER | A MORSE TAPER | B CLEARANCE (IN.) | C PROJECTION (IN.) | D OAL (IN.) | E SHANK | COOLANT GLAND (INCLUDED) | MINIMUM COOLANT PRESSURE (1) | MAXIMUM COOLANT PRESSURE (2) | MAXIMUM SPEED (RPM) (3) | REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED) |
--- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
AA75-MT2-CGH-3 | 2 | 0.937 | 3.50 | 6.00 | 3/4 - 12 | CGH-0937 | 100 PSI | 750 PSI | 5000 | SK-0937 |
AA88-MT2-CGH-2 | 2 | 0.937 | 2.00 | 5.62 | 7/8 - 12 | CGH-0937 | 100 PSI | 750 PSI | 4000 | SK-1250 |
AA10-MT3-CGH-4 | 3 | 1.250 | 3.62 | 7.25 | 1" - 12 | CGH-1250 | 100 PSI | 750 PSI | 5000 | SK-0937 |
AA10-MT2-CGH-3 | 2 | 0.937 | 3.00 | 6.62 | CGH-0937 | 100 PSI | 750 PSI | 5000 | SK-0937 |
AA106-MT3-CGH-4 | 3 | 1.250 | 4.00 | 7.62 | 1-1/16 - 12 | CGH-1250 | 100 PSI | 750 PSI | 4000 | SK-1250 |
AA137-MT3-CGH-2 | 3 | 1.250 | 2.00 | 6.62 | 1-3/8 - 12 | CGH-1250 | 100 PSI | 750 PSI | 4000 | SK-1250 |
AA137-MT4-CGH-2 | 4 | 1.625 | 2.00 | 7.62 | 1-3/8 - 12 | CGH-1625 | 100 PSI | 750 PSI | 3300 | SK-1250 |
AA188-MT3-CGH-2 | 3 | 1.250 | 2.00 | 7.62 | 1-7/8 - 12 | CGH-1625 | 100 PSI | 750 PSI | 3300 | SK-1250 |
AA188-MT4-CGH-2 | 4 | 1.625 | 2.00 | 7.62 | 1-7/8 - 12 | CGH-1625 | 100 PSI | 750 PSI | 3300 | SK-1250 |

- See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
- All units require coolant at all speeds.

### MORSE TAPER SHANK • SINGLE ANGLE STYLE COLLET CHUCKS WITH NYLON CAP POSITIVE SEAL STOP SCREW AND ROTARY COOLANT GLAND

#### ASSEMBLY PART NUMBER | A RANGE (IN.) | COLLET SERIES | B CLEARANCE (IN.) | C PROJ. (IN.) | D OAL (IN.) | E MORSE TAPER | COOLANT GLAND (INCLUDED) | MINIMUM COOLANT PRESSURE (1) | MAXIMUM COOLANT PRESSURE (2) | MAXIMUM SPEED (RPM) (3) | REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED) | OPTIONAL EXTENSION STYLE STOP SCREW (NOT INCLUDED) | SPANNER WRENCH (NOT INCLUDED) |
--- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
MT3-TG10-CGH-8P | 0.094 - 1.000 | TG 100 | 2.50 | 5.50 | 9.37 | MT 3 | CGH-1625 | 100 PSI | 750 PSI | 3300 | SK-1625 | 116-001 | 112-001 |
MT4-TG10-CGH-8P | 0.094 - 1.000 | TG 100 | 2.50 | 5.50 | 13.70 | MT 4 | CGH-1625 | 100 PSI | 750 PSI | 3300 | SK-1625 | 116-001 | 112-001 |
MT5-TG15-CGH-7P | 0.500 - 1.500 | TG 150 | 3.50 | 6.25 | 12.37 | MT 5 | CGH-2750 | 100 PSI | 750 PSI | 2200 | SK-2750 | - | 112-002 |
MT6-TG15-CGH-7P | 0.500 - 1.500 | TG 150 | 3.50 | 6.25 | 14.81 | MT 6 | CGH-2750 | 100 PSI | 750 PSI | 2200 | SK-2750 | - | 112-002 |

- See page 111 for positive seal stop screw.

- See pages 112-114 for Rotary Coolant Gland information.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM's. Pressures above recommended PSI may cause internal damage to seals.
(3) - Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:
- Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
- All units require coolant at all speeds.
COOLANT-FED TOOLING & SYSTEMS® DIVISION

MORSE TAPER SHANK • DOUBLE ANGLE COLLET CHUCKS WITH NYLON CAP POSITIVE SEAL STOP SCREW AND ROTARY COOLANT GLAND

The life and performance of the units depends on the following conditions:

1. Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
2. These RPM and Pressure ranges are not a guarantee of performance.
3. Recommended Maximum RPM at Maximum 750 PSI. Higher speeds may be achieved at lower pressures.

* Outgoing Items

- See pages 112-114 for Rotary Coolant Gland information.

| ASSEMBLY PART NUMBER | A RANGE (IN.) | COLLET SERIES | B CLEARANCE (IN.) | C PROJ. (IN.) | D OAL (IN.) | E MORSE TAPER | COOLANT GLAND (INCLUDED) | MINIMUM COOLANT PRESSURE (1) | MAXIMUM COOLANT PRESSURE (2) | MAXIMUM SPEED (RPM) (3) | REPLACEMENT SEAL KIT PART NUMBER (NOT INCLUDED) | POSITIVE SEAL STOP SCREW (NOT INCLUDED) | SPANNER WRENCH (NOT INCLUDED) |
|----------------------|--------------|---------------|-------------------|--------------|-------------|---------------|------------------------|--------------------------|--------------------------|-----------------|-----------------------------------------------|-----------------------------------------------|
| MT2-DA18-CGH-6P      | 0.047 - 0.750| DA 180        | 1.62              | 5.31         | 8.44        | 2             | CGH-1250               | 100 PSI                  | 750 PSI                  | 4000            | SK-1250                                       | SK-1250                                       |
| MT3-DA18-CGH-6P      | 0.047 - 0.750| DA 180        | 1.62              | 5.31         | 10.18       | 4             | CGH-1250               | 100 PSI                  | 750 PSI                  | 4000            | SK-1250                                       | SK-1250                                       |

* - Standard RPM Coolant Glands also available. Substitute “CGS” for “CGH” in Assembly Part Numbers listed above.

(1), (2) - These are recommended pressures. Lower coolant pressures may be utilized at very slow RPM’s. Pressures above recommended PSI may cause internal damage to seals.

These RPM and Pressure ranges are not a guarantee of performance. The life and performance of the units depends on the following conditions:

1. Proper Filtration - Proper Type & Viscosity of Coolant - Coolant Pressure and Volume.
2. All units require coolant at all speeds.

MORSE TAPER SHANK TO MORSE TAPER HOLDERS WITH ROTARY COOLANT GLAND

Splash Shield Assembly Included With Holder.

See page 113, for assembly instructions.