



Milling Chucks

Shrink Fit Holders

SK Collet Chucks

VC Collet Chucks



Current Promotion

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Featured Video

VC Collet Chuck Features

ULTRA PERFORMANCE

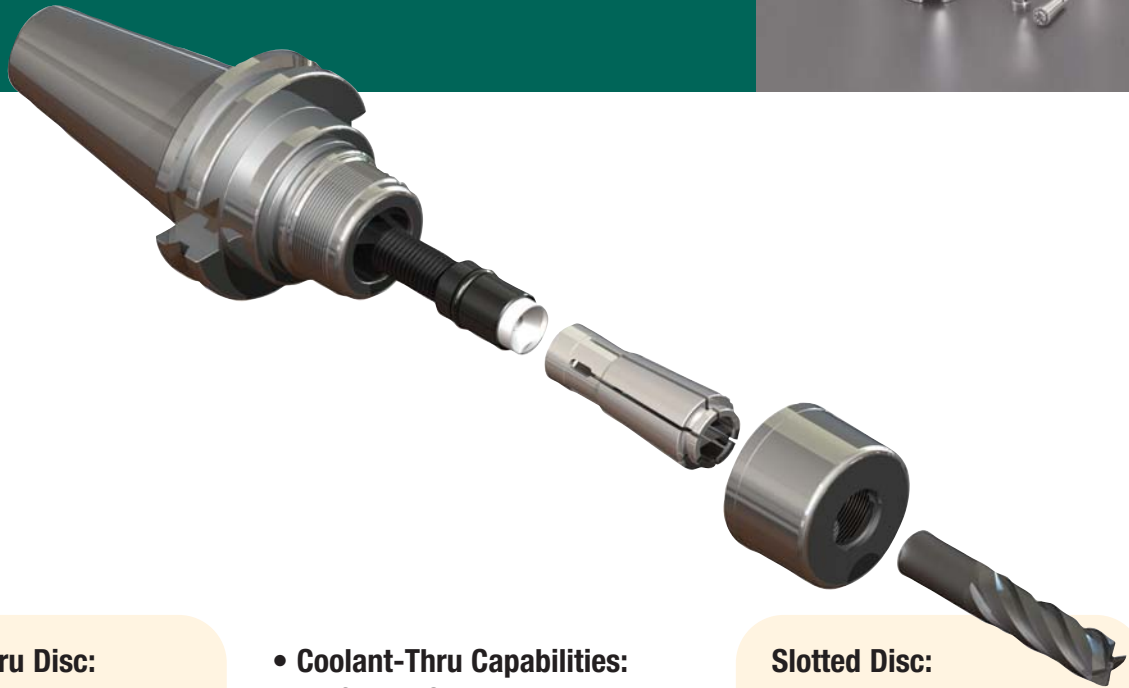
Extremely precise: 0.00012" or less concentricity guarantee with any collet

Extremely efficient: ideal for high-speed machining, thread milling, ultra precision reaming

Flexible: covers sizes from 0.079" to 0.5"

Extremely accurate: twice more accurate than a ER collet chuck, with 10 times better repeatability

8° versus 16° collet taper: twice more gripping power than ER Collet Chucks



Coolant-Thru Disc:

A perfect seal is formed between the nut and the coolant-thru disk. Ideal for coolant-thru tools.



• Coolant-Thru Capabilities:

Jet Coolant Splash with J-Type Nut



Discs and wrench for SK10 and SK16 type can be used for VC6 and VC13 type respectively.

Slotted Disc:

The jet coolant pressure creates a tornado effect, ensuring efficient swarf disposal.



VC Collet Chuck Features

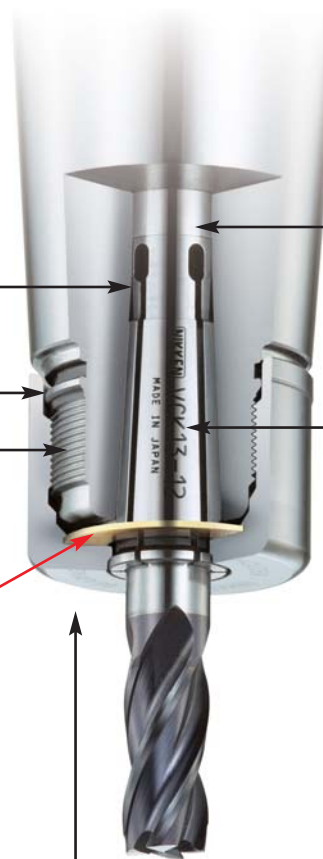
Symmetrical and simple external design without notch for ultra high speed rotation

8° internal taper collet for greater accuracy and clamping capability

The ground thread of collet chuck highly improves the torque and accuracy

TiN BEARING NUT
(Hardness: HV2,200)
US Patent 6923451

Collet compression force is perpendicular to the centerline of collet bore maximizing run out accuracy



The thick wall design of the VC holder body improves cutting rigidity

Ground pilot helps centralize the collet while giving additional length support on the cutting tool

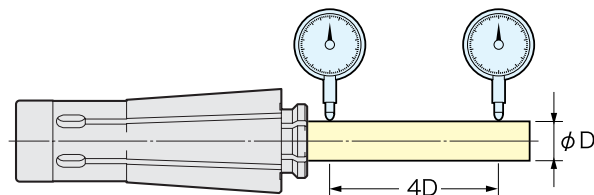
Extended Collet to minimize runout and to increase surface area contact of tooling

Easy, safe and reliable handling with GH wrench (see page 204)



High Runout Accuracy:

Within 0.00012 at 4 times the diameter of the cutting tool! This produces better stability and improves surface finish.



VC Collet Range:



VCK6: 2-6mm (1/8"-1/4")
VCK13: 3-12mm (1/8"-1/2")

VC Collet vs. Others:



VCK Collet

- Runout: 0.00012"
- 170N.m gripping power



ER Collet

- Runout: 0.0001"
- 80N.m gripping power










TG Collet

- Runout: 0.0003"
- 100N.m gripping power

CAT VC Collet Chucks

- Feature TiN Bearing Nut which considerably improves cutting rigidity and finish
- Extra thick body
- High concentricity and repeatability
- Ideal for high-speed applications

Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

	TIR: 0.00012 or better		Drilling ★★★★☆
	Speed: up to 40,000 rpm		Milling ★★★★☆
	Set-up: quick and easy to operate		Reaming ★★★★☆
	Coolant-thru: thru tool coolant		

CAT40

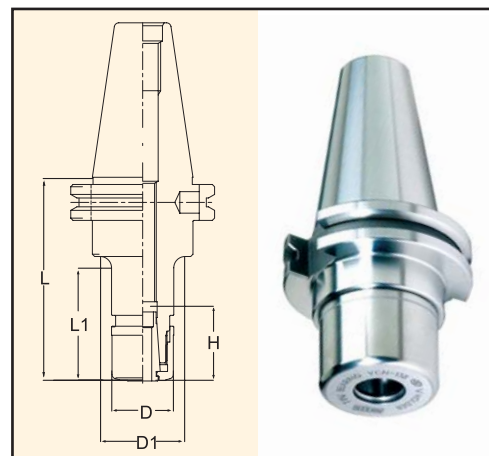
Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
CAT40-VC6-60U	VCK6	GH10	2.362"	0.906"	1.378"-1.772"	1.083"	1.083"	VCG6-8A
CAT40-VC6-90U	VCK6	GH10	3.543"	2.047"	1.378"-1.772"	1.083"	1.244"	VCG6-8A
CAT40-VC6-120U	VCK6	GH10	4.724"	3.228"	1.378"-1.772"	1.083"	1.409"	VCG6-8A
CAT40-VC13-60U	VCK13	GH16	2.362"	1.142"	1.969"-2.362"	1.575"	1.575"	VCG13-15A
CAT40-VC13-90U	VCK13	GH16	3.543"	2.756"	1.969"-2.362"	1.575"	1.083"	VCG13-15A
CAT40-VC13-120U	VCK13	GH16	4.724"	3.937"	1.969"-2.362"	1.575"	1.083"	VCG13-15A

Note:wrench sold separately.

CAT50

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
CAT50-VC6-105U	VCK6	GH10	4.134"	2.559"	1.378"-1.772"	1.083"	1.315"	VCG6-8A
CAT50-VC6-135U	VCK6	GH10	5.315"	3.740"	1.378"-1.772"	1.083"	1.480"	VCG6-8A
CAT50-VC6-165U	VCK6	GH10	6.496"	4.921"	1.378"-1.772"	1.083"	1.646"	VCG6-8A
CAT50-VC13-105U	VCK13	GH16	4.134"	2.559"	1.969"-2.362"	1.575"	1.772"	VCG13-15A
CAT50-VC13-135U	VCK13	GH16	5.315"	3.740"	1.969"-2.362"	1.575"	1.937"	VCG13-15A
CAT50-VC13-165U	VCK13	GH16	6.496"	4.921"	1.969"-2.362"	1.575"	2.102"	VCG13-15A

Note:wrench sold separately.



3-Lock VC Collet Chucks for Dual Contact Spindle

3-Lock VC Collet Chucks are available from stock and feature Nikken unique Triple Contact System. Please refer to page 239 in our technical section to learn more about Nikken's revolutionary 3-Lock System and tooling line.

For a complete list of part numbers and pricing, please contact our office at (800) 543-6237



Accessories:



VCK Collets
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Nut Wrench
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Back-up screw
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Coolant-thru nut
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BT VC Collet Chucks

- Feature TiN Bearing Nut which considerably improves cutting rigidity and finish
- Extra thick body
- High concentricity and repeatability
- Ideal for high-speed applications

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TIR: 0.00012 or better



Speed: up to 40,000 rpm



Set-up: quick and easy to operate



Coolant-thru: thru tool coolant



Drilling
★★★★☆



Milling
★★★★☆



Reaming
★★★★☆

BT30

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
BT30-VC6-45	VCK6	GH10	1.772"	0.906"	1.38"-1.77"	1.083"	1.083"	VCG6-8A
BT30-VC6-60	VCK6	GH10	2.362"	1.378"	1.38"-1.77"	1.083"	1.248"	VCG6-8A
BT30-VC6-90	VCK6	GH10	3.543"	2.559"	1.38"-1.77"	1.083"	1.315"	VCG6-8A
BT30-VC13-60	VCK13	GH16	2.362"	1.457"	1.97"-2.36"	1.575"	1.618"	VCG13-15A
BT30-VC13-90	VCK13	GH16	3.543"	2.638"	1.97"-2.36"	1.575"	1.626"	VCG13-15A
BT30-VC13-120	VCK13	GH16	4.724"	3.819"	1.97"-2.36"	1.575"	1.669"	VCG13-15A

Note: wrench sold separately.

BT40

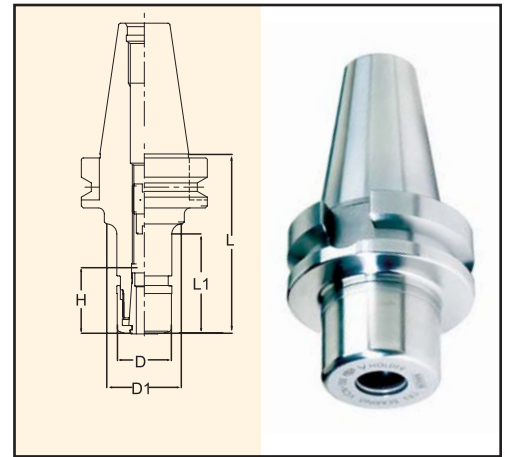
Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
BT40-VC6-60	VCK6	GH10	2.362"	1.181"	1.38"-1.77"	1.083"	1.181"	VCG6-8A
BT40-VC6-90	VCK6	GH10	3.543"	2.362"	1.38"-1.77"	1.083"	1.287"	VCG6-8A
BT40-VC6-120	VCK6	GH10	4.724"	3.543"	1.38"-1.77"	1.083"	1.452"	VCG6-8A
BT40-VC13-60	VCK13	GH16	2.362"	1.220"	1.97"-2.36"	1.575"	1.586"	VCG13-15A
BT40-VC13-90	VCK13	GH16	3.543"	2.362"	1.97"-2.36"	1.575"	1.744"	VCG13-15A
BT40-VC13-120	VCK13	GH16	4.724"	3.543"	1.97"-2.36"	1.575"	1.909"	VCG13-15A

Note: wrench sold separately.

BT50

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
BT50-VC6-105	VCK6	GH10	4.134"	2.441"	1.38"-1.77"	1.083"	1.299"	VCG6-8A
BT50-VC6-135	VCK6	GH10	5.315"	3.622"	1.38"-1.77"	1.083"	1.461"	VCG6-8A
BT50-VC6-165	VCK6	GH10	6.496"	4.803"	1.38"-1.77"	1.083"	1.626"	VCG6-8A
BT50-VC13-105	VCK13	GH16	4.134"	2.441"	1.97"-2.36"	1.575"	1.756"	VCG13-15A
BT50-VC13-135	VCK13	GH16	5.315"	3.622"	1.97"-2.36"	1.575"	1.921"	VCG13-15A
BT50-VC13-165	VCK13	GH16	6.496"	4.803"	1.97"-2.36"	1.575"	1.890"	VCG13-15A

Note: wrench sold separately.



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Accessories:



VCK Collets
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Nut Wrench
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Back-up screw
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Coolant-thru nut
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HSK VC Collet Chucks

- Feature TiN Bearing Nut which considerably improves cutting rigidity and finish
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Speed: up to 40,000 rpm



Set-up: quick and easy to operate



Coolant-thru: thru tool coolant



Drilling
★★★★☆



Milling
★★★★☆

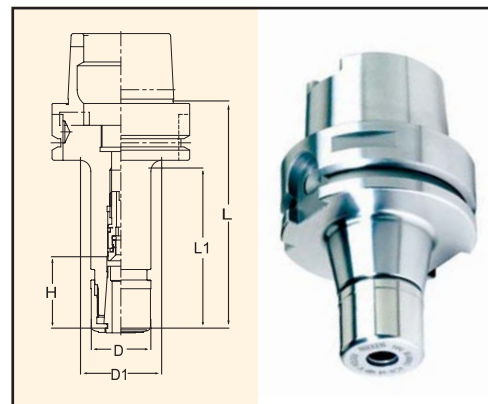


Reaming
★★★★☆

HSK40A

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
HSK40A-VC6-65	VCK6	GH10	2.559"	1.693"	1.38"-1.77"	1.083"	1.362"	VCG6-8A
HSK40A-VC6-90	VCK6	GH10	3.543"	2.677"	1.38"-1.77"	1.083"	1.330"	VCG6-8A
HSK40A-VC13-90	VCK13	GH16	3.543"	2.756"	1.97"-2.36"	1.575"	1.575"	VCG13-15A
HSK40A-VC13-120	VCK13	GH16	4.724"	3.937"	1.97"-2.36"	1.575"	1.575"	VCG13-15A

Note: wrench, coolant tubes and coolant tube wrenches are sold separately. See page 204 for more details.



HSK63A

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
HSK63A-VC6-70	VCK6	GH10	2.76"	1.614"	1.38"-1.77"	1.083"	1.330"	VCG6-8A
HSK63A-VC6-90	VCK6	GH10	2.54"	2.402"	1.38"-1.77"	1.083"	1.291"	VCG6-8A
HSK63A-VC6-120	VCK6	GH10	4.724"	3.583"	1.38"-1.77"	1.083"	1.457"	VCG6-8A
HSK63A-VC13-90	VCK13	GH16	3.543"	2.520"	1.97"-2.36"	1.575"	1.752"	VCG13-15A
HSK63A-VC13-120	VCK13	GH16	4.724"	3.622"	1.97"-2.36"	1.575"	1.921"	VCG13-15A

Note: wrench, coolant tubes and coolant tube wrenches are sold separately. See page 204 for more details.

HSK100A

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
HSK100A-VC6-105	VCK6	GH10	4.134"	2.795"	1.38"-1.77"	1.083"	1.346"	VCG6-8A
HSK100A-VC6-135	VCK6	GH10	5.315"	3.976"	1.38"-1.77"	1.083"	1.512"	VCG6-8A
HSK100A-VC6-165	VCK6	GH10	6.496"	5.157"	1.38"-1.77"	1.083"	1.677"	VCG6-8A
HSK100A-VC13-105	VCK13	GH16	4.134"	2.795"	1.97"-2.36"	1.575"	1.807"	VCG13-15A
HSK100A-VC13-135	VCK13	GH16	5.315"	3.976"	1.97"-2.36"	1.575"	1.972"	VCG13-15A
HSK100A-VC13-165	VCK13	GH16	6.496"	5.157"	1.97"-2.36"	1.575"	2.138"	VCG13-15A

Note: wrench, coolant tubes and coolant tube wrenches are sold separately. See page 204 for more details.

Accessories:



VCK Collets
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Back-up screw
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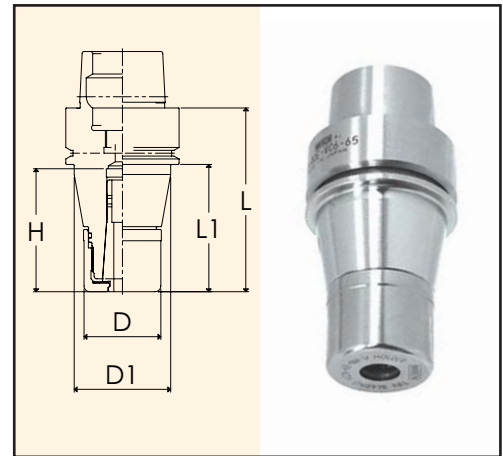
Coolant-thru nut
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HSK VC Collet Chucks

HSK40E

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
HSK40E-VC6-65	VCK6	GH10	2.559"	1.693"	-	1.083"	1.362"	VCG6-8A
HSK40E-VC6-90	VCK6	GH10	3.543"	2.677"	1.38"-1.77"	1.083"	1.330"	VCG6-8A
HSK40E-VC13-90	VCK13	GH16	3.543"	2.756"	1.97"-2.36"	1.575"	1.575"	VCG13-15A
HSK40E-VC13-120	VCK13	GH16	4.724"	3.937"	1.97"-2.36"	1.575"	1.575"	VCG13-15A

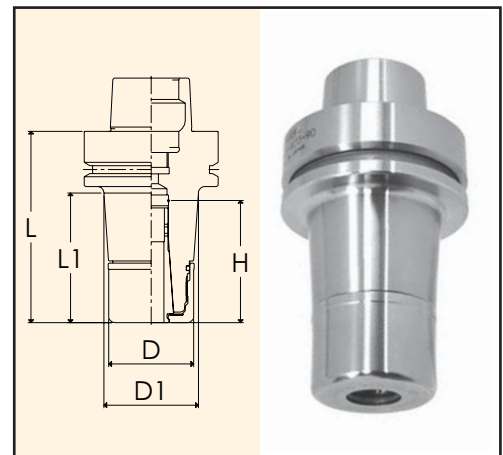
Note: wrench, coolant tubes and coolant tube wrenches are sold separately.
See page 204 for more details.



HSK63F

Part Number	Collet Size	Wrench	L	L1	H	D	D1	Back-up Screw
HSK63F-VC6-65	VCK6	GH10	2.559"	1.457"	1.38"-1.77"	1.083"	1.083"	VCG6-8A
HSK63F-VC6-90	VCK6	GH10	3.543"	2.402"	1.38"-1.77"	1.083"	1.205"	VCG6-8A
HSK63F-VC6-120	VCK6	GH10	4.724"	3.583"	1.38"-1.77"	1.083"	1.370"	VCG6-8A
HSK63F-VC13-90	VCK13	GH16	3.543"	2.520"	1.97"-2.36"	1.575"	1.670"	VCG13-15A
HSK63F-VC13-120	VCK13	GH16	4.724"	3.622"	1.97"-2.36"	1.575"	1.835"	VCG13-15A

Note: wrench, coolant tubes and coolant tube wrenches are sold separately.
See page 204 for more details.



Accessories:



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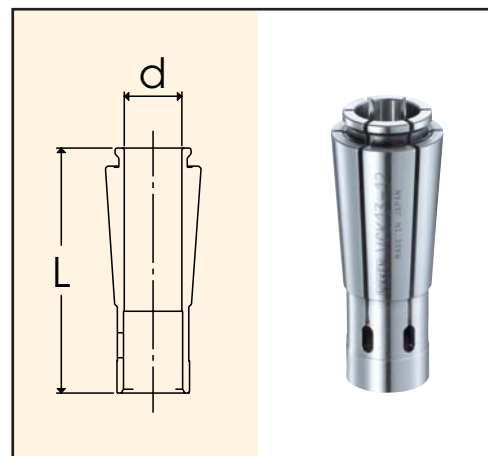


Coolant-thru nut
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VCK Collets

Dimensional Data

Collet Series	D	L	Collet Range
VCK6	0.55" (14mm)	1.56" (39.8mm)	1/8" - 1/4" (2mm-6mm)
VCK13	0.82" (21mm)	2.12" (54mm)	1/8" - 1/2" (3mm-12mm)



These collets do not collapse.

INCH		
Collet series	Size	Part Number
VCK6	1/8"	VCK6-1/8
	3/16"	VCK6-3/16
	1/4"	VCK6-1/4

METRIC	
Size	Part Number
2.0mm	VCK6-2
3.0mm	VCK6-3
4.0mm	VCK6-4
5.0mm	VCK6-5
6.0mm	VCK6-6

VCK13	1/8"	VCK13-1/8
	3/16"	VCK13-3/16
	1/4"	VCK13-1/4
	5/16"	VCK13-5/16
	3/8"	VCK13-3/8
	7/16"	VCK13-7/16
	1/2"	VCK13-1/2

3.0mm	VCK13-3
4.0mm	VCK13-4
5.0mm	VCK13-5
6.0mm	VCK13-6
7.0mm	VCK13-7
8.0mm	VCK13-8
9.0mm	VCK13-9
10.0mm	VCK13-10
11.0mm	VCK13-11
12.0mm	VCK13-12

Accessories:



VCK Collets
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Nut Wrench
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Back-up screw
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Coolant-thru nut
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VC Coolant System



Collet Chuck	Collet	Coolant Nut Part Number	Cutting Tool Size	Coolant-Thru Disk Part Number	Slotted Disk Part Number	Disk Wrench Part Number	Blank Disk (machinable) Part Number
VC6	VCK6- range: 2 -6mm [1/8" - 1/4"]	VCN-6BJ	2mm	-	-	SKJL-10	SKJ10-BLANK
			3mm	SKJ10-3C	SKJ10-3		
			4mm	SKJ10-4C	SKJ10-4		
			5mm	SKJ10-5C	SKJ10-5		
			6mm	SKJ10-6C	SKJ10-6		
			1/8"	SKJ10-1/8C	SKJ10-1/8		
			3/16"	SKJ10-3/16C	SKJ10-3/16		
VC13	VCK13- range: 3 -12mm [1/8" - 1/2"]	VCN-13BJ	3mm	-	-	SKJL-16	SKJ16-BLANK
			4mm	-	-		
			5mm	-	-		
			6mm	SKJ16-6C	SKJ16-6		
			7mm	-	-		
			8mm	SKJ16-8C-	SKJ16-8		
			10mm	SKJ16-10C	SKJ16-10		
		12mm	SKJ16-12C	SKJ16-12			
		1/8"	-	-			
		3/16"	-	-			
		1/4"	SKJ16-1/4C	SKJ16-1/4			
		5/16"	SKJ16-5/16C	SKJ16-5/16			
		3/8"	SKJ16-3/8C	SKJ16-3/8			
		7/16"	SKJ16-7/16C	SKJ16-7/16			
1/2"	SKJ16-1/2C	SKJ16-1/2					

Note: Coolant-Thru Disk and Slotted Disk must be ordered on size for the cutting tool.
When using the Coolant Nut, add 6mm (0.236") to the toolholder gage length.
Assembly of the Coolant Nut and Disk is easily accomplished with the Disk Wrench (sold separately).

VC Collet Chucks Accessories

VC Back-up Screw (coolant-thru)

Part Number	Description
VCG6-8A	use with VC6 chucks
VCG13-15A	use with VC13 chucks



VC Nut

Part Number	Description
VCN-6B	standard nut for VC6 chucks
VCN-6BJ	J type coolant nut for VC6 chucks
VCN-13B	standard nut for VC13 chucks
VCN-13BJ	J type coolant nut for VC13 chucks



VC Nut Wrench

Part Number	Description
GH10	VC6 chuck wrench
GH16	VC13 chuck wrench



Coolant Tube Wrench

Part Number	Description
HSK63-WRENCH	Wrench for HSK63 Coolant Tube
HSK40-WRENCH	Wrench for HSK40 Coolant Tube
HSK100-WRENCH	Wrench for HSK100 Coolant Tube

Coolant tube wrenches are needed to remove or install coolant tubes in HSK toolholders



Coolant Tube

Part Number	Description
HSK63-TUBE	Coolant tube for HSK63 holders
HSK40-TUBE	Coolant tube for HSK40 holders
HSK100-TUBE	Coolant tube for HSK100 holders

