

Oversize Collet and Bush Information



Increase your bar capacity

- Ø16mm machines up to Ø18mm
- Ø20mm machines up to Ø24mm
- Ø32mm machines up to Ø36mm

Ø16mm Bar Capacity Machines using Collet Type F20-87 (Din 138E) & Guide Bushes Type B238

Collet	Max Ø	Max □	Max □	Modified Sleeve & Spring Required	Modified Nose Cap Required
F22	18	n/a	n/a	yes(**)	no

Guide Bush B238 Is Available Up Ø18mm

Ø20mm Bar Capacity Machines using Collet Type F25-64 (Din 145E) & Guide Bushes Type B261

Collet Options	Max Ø	Max □ Hex	Max □ Sq	Requirements
F25-64 >Ø20mm	22.22	n/a	n/a	A modified spring with increased bore will be required. Some applications will need the bore in the back of the collet sleeve increasing. Prices for these adaptations on demand.
F27-22 >Ø20mm	24mm	21.0	20.0	F27-22 Oversize Kit Comprising of Collet Sleeve & Collet Nose Cap.

Bush Options	Max Ø	Keyway Modified for Oversize Bushes	Modified Thread Size	** New or Modified Guide Bush Nut Required?
B261- Standard (B.2882.251.16)	21.0	Yes*	Standard M25x1	No
B261R (B.2882.271.16)	23.0	Yes*	Oversize M27x1	Yes
B261RR (B.2882.281.16)	24.0	Yes*	Oversize M28x1	Yes

Ø32mm Bar Capacity Machines using Collet Type F37-740 (Din 1536E) & Guide Bushes Type N229 (J9)

Collet	Max Ø	Max □ Hex	Max □ Sq	Modified Sleeve & Spring Required	Price for Modified Sleeve & Spring	Modified Nose Cap Required
F40	36.0	31.0	25.40	Yes		No

Bush Options	Max Ø	Keyway Modified for Oversize Bushes	Modified Thread Size	** New or Modified Guide Bush Nut Required?
N229 B.4282.401.16	33.0	Yes*	Standard M40x1	No
N229R B.4282.421.16	36.0	Yes*	Oversize M42x1	Yes

* For oversize bushes we cannot manufacture the keyway to the standard depth it is only possible to have a depth of 1mm.
 **Guide bush nuts are available for most machines to accommodate the larger threads indicated. Price on demand. We can also modify an existing guide bush nut provided by the client.