



**EXSYS** **EPPINGER**

**Tooling Catalog**



**HAAS**

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# About Us

## HAAS Tooling for CNC Turning Centers

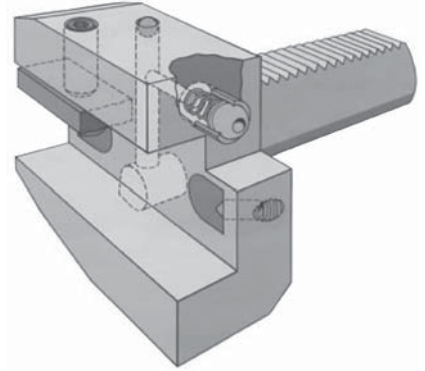
### WHO IS EPPINGER?

Eppinger CNC tool holders to DIN 69880 are manufactured to precision levels far in excess of the required standards using advanced, patented production systems and facilities.

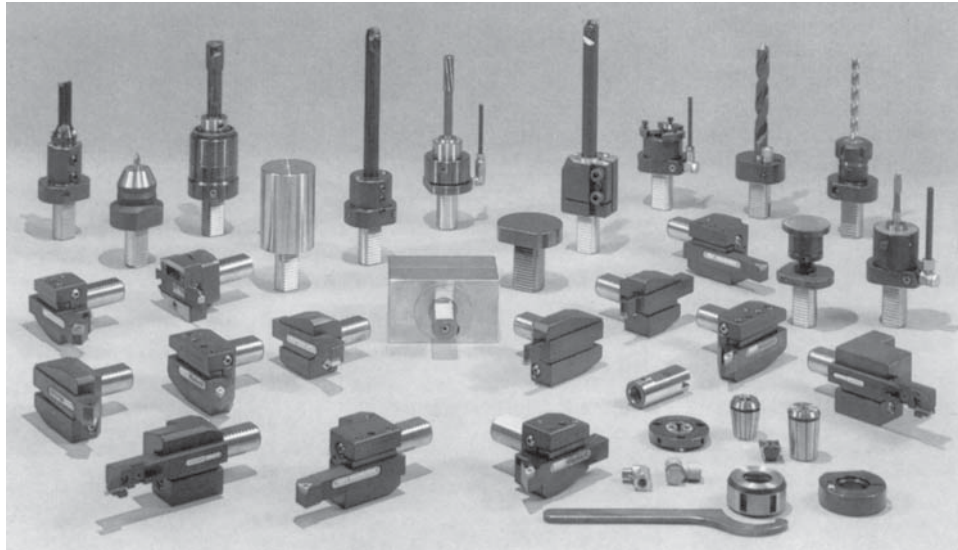
Their experience in tool manufacturing dates back to 1925, their team of skilled craftsmen, and the most advanced production methods available, are your guarantee of tools sophisticated in every detail.

We can process orders without delay thanks to our well stocked warehouse.

This ensures that our customers' important production processes run smoothly. The team at Eppinger can use their versatile production methods to satisfy one-of requirements or to produce custom designs quickly and efficiently.



***Eppinger Tooling is imported exclusively through EXSYS TOOL INC.***



### ***The special technical features of the Eppinger tools system are:***

- Shank identical or similar to DIN 69880/T1.
- Shank, seating face and serration are hardened and ground.
- Different ratios for ideal cutting conditions.
- Quick Change - **PRECI-FLEX**<sup>®</sup>
- All wear parts are case-hardened.
- Tools with internal coolant supply are available
- Grease packing for lifetime.
- Multiple sealings and optimum bearing configuration.
- Rigid and Compact Design

**EXSYS** TOOL, INC.  
The Smart Choice . . .

**EPPINGER**

Ph: (800) EXSYS-4-U (397-9748) | Fax: (800) 397-9739 | Email: quotes@exsysautomation.com | Web: www.exsysautomation.com.com

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### PRECI-FLEX® INFORMATION

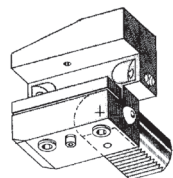
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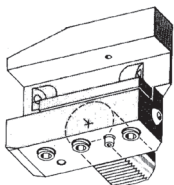
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# Fixed VDI Tool Holders

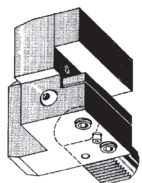
HAAS Tooling for CNC Turning Centers



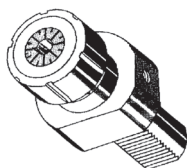
**Turning Tool Holder - Short**  
 213.115.250  
 213.115.150 (mm)



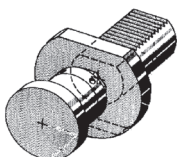
**Turning Tool Holder - Long**  
 223.115.250  
 223.115.150 (mm)



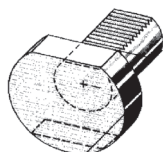
**Face Grooving Tool Holder**  
 223.125.250  
 223.125.150 (mm)



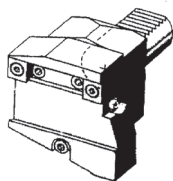
**Collet Chuck**  
 ER25 - 223.040.220  
 ER32 - 223.035.220  
 ER40 - 223.045.220



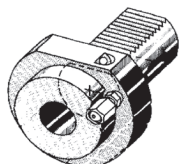
**Rotating Stock Stop**  
 203.040.220



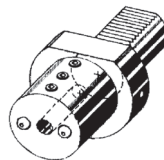
**Turret Plug**  
 Plastic - 213.500.001  
 Steel - 213.500.150



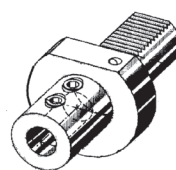
**Cut-Off Tool Holder**  
 Style B - 213.635.220  
 Style D - 213.645.220



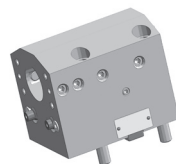
**Morse Taper Holder**  
 MT 2            203.130.150  
 MT 3            203.135.150  
 MT 4            203.140.150



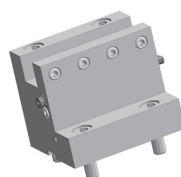
**Boring Bar Holder**  
 5/16"            213.015.240  
 3/8"             213.015.241  
 1/2"             213.015.242  
 5/8"             213.015.243  
 3/4"             213.015.244  
 1"                213.015.245  
 1-1/4"         213.015.246  
 1-1/2"         213.015.247  
 1-5/8"         213.015.248  
 1-3/4"         213.015.249  
 2"                213.015.250



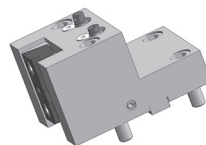
**Indexable Drill Holder**  
 5/8"            223.048.250  
 3/4"            223.050.250  
 1"               223.052.250  
 1-1/4"        223.055.250  
 1-1/2"        223.060.250



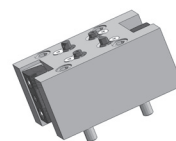
**Boring bar holder, angular, left hand - right hand cylindrical chuck Ø38,1 (1 1/2"), ext and int coolant supply**  
 Partno : 7.077.304



**Tool holder, angular, left hand-right hand rectangular transverse 25,4 (1"), external coolant supply**  
 Partno : 7.077.306



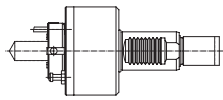
**Tool holder, straight, left hand offset rectangular transverse 25,4 (1"), external coolant supply**  
 Partno : 7.077.308



**Tool holder, straight, double sided rectangular transverse 25,4mm (1"), external coolant supply**  
 Partno : 7.078.117

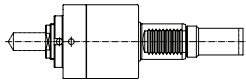
# Rotary Tool Holders

HAAS Tooling for CNC Turning Centers



## Axial Mill/Drill

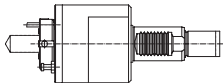
- 4.200.954 - Short Coupling
- 4.200.956 - Medium Coupling
- 4.200.958 - Long Coupling



## Heavy Duty Option

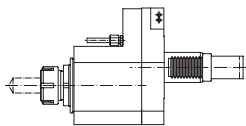
### Axial PRECI-FLEX®

- 4.201.HDOM - Medium Coupling
- 4.201.HDOL - Long Coupling



## Slim Fit - Axial Mill/Drill

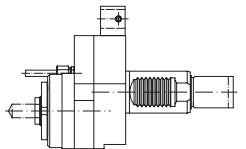
- 4.201.510 - Medium Coupling



## High Torque

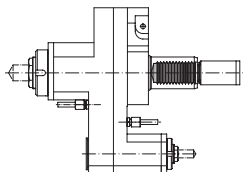
### Axial Offset Mill/Drill

- 8.629.204 - Short Coupling
- 8.629.209 - Medium Coupling
- 8.629.295 - Long Coupling



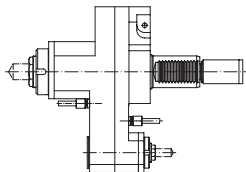
## High Speed Axial Offset Mill/Drill Head

- 4.200.569 - Short Coupling
- 4.201.525 - Medium Coupling
- 4.201.332 - Long Coupling



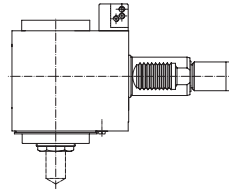
## Main/Sub Axial Offset Double Sided Mill/Drill

- 4.200.810 - Medium Coupling\*
- \*Available for machines with sub spindle only.



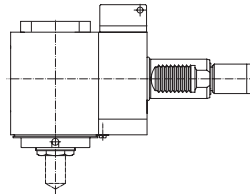
## Main/Sub Axial Offset Double Sided Mill/Drill

- 4.200.815 - Medium Coupling\*
- \*Available for machines with sub spindle only.



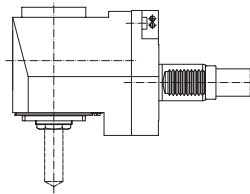
## Radial Mill/Drill

- 4.200.955 - Short Coupling
- 4.200.957 - Medium Coupling
- 4.200.959 - Long Coupling



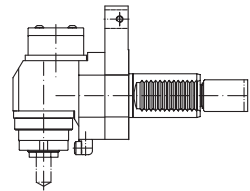
## Slim Fit - Radial Mill/Drill

- 4.201.513 - Medium Coupling



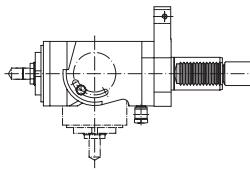
## High Torque Radial Mill/Drill

- 9.698.204 - Short Coupling
- 9.698.209 - Medium Coupling
- 9.698.295 - Long Coupling



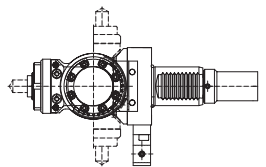
## High Speed Radial Mill/Drill

- 9.702.187 - Short Coupling
- 9.702.215 - Medium Coupling
- 9.702.303 - Long Coupling



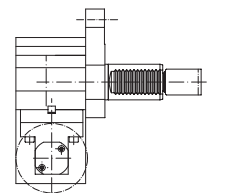
## Angular Adjustable 0-90°

- 8.760.187 - Short Coupling
- 8.760.215 - Medium Coupling
- 8.760.303 - Long Coupling



## Angular Adjustable 0-90°

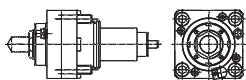
- 4.201.AAM - Medium Coupling
- 4.201.462 - Long Coupling



## Slotting Saw 5/8" Arbor

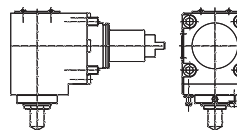
- 4.200.556 - Short Coupling
- 4.201.327 - Medium Coupling
- 4.201.328 - Long Coupling

## BMT65 Tool Holders



## Axial Mill/Drill

- 7.171.887 - External Coolant
- 7.073.364 - Internal Coolant



## Radial Mill/Drill

- 7.171.888 - External Coolant
- 7.073.365 - Internal Coolant

### Coupling Identification Chart

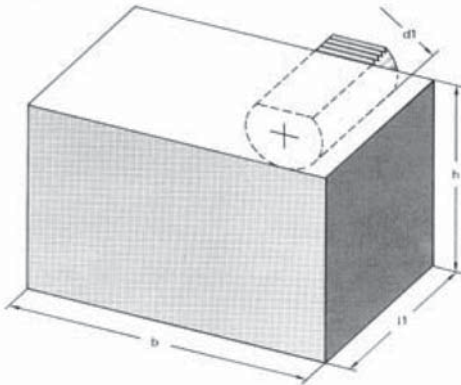
This chart will help you identify the correct coupling length for your Haas machine.

TURRET	MACHINE	COUPLING LENGTH	DIMENSION FROM MOUNTING FACE
Haas Turret	SL20/30	Medium	117.55mm
	SL40	Long	130.25mm
VDI Turret	SL20/30	Short	104.85mm
	DS30 (Y)	Medium	117.55mm
	SL40		
	ST40		
Hybrid VB-24 Turret	ST20SS	Medium	117.55mm
	ST20SSY		
	ST30SS		
	ST30SSY		
	DS30SS		
	DS30SSY		
Hybrid VB-12 Turret	TL 15/25	Medium	117.55mm
	SL20/30		
	SL40		
	ST20/30 (Y)		
	DS20/30 (Y)		
	ST40	Long	130.25mm

# PRE-MACHINED BLANKS

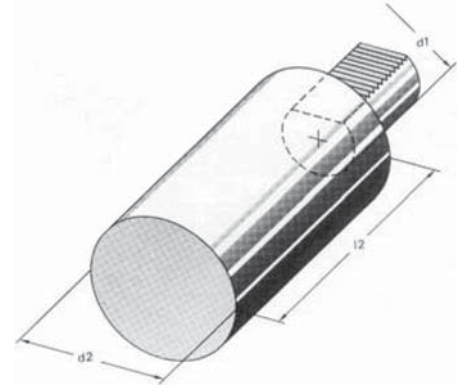
## Form A1

Ref. No.	d1	b	h	L1
203.075.150	40	151	96	100



## Form A2

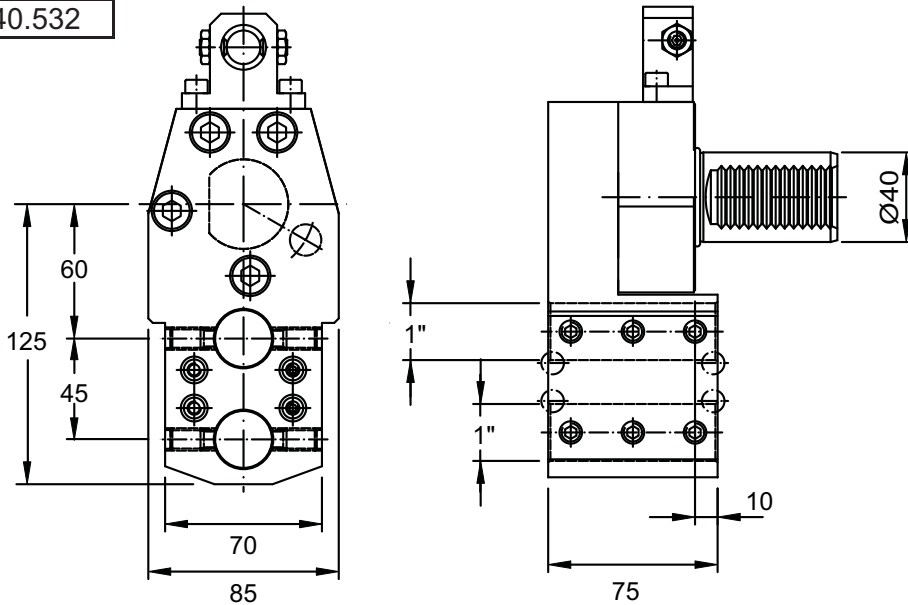
Ref. No.	d1	d2	L2
203.077.150	40	83	120
203.080.150	40	83	320



# DOUBLE TOOL HOLDER

For Boring Bars and Collet Extensions

Ref. No.
7.040.532



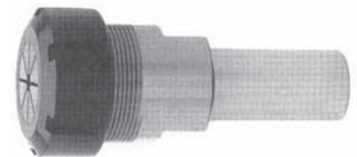
### STRAIGHT SHANK COLLET CHUCK

ER25 OD=1" L=100mm

**Optional:** ER25 Collet Extension, Part No. 2625.12561

**Description:**  
Collet Capacity: 0.5mm-16mm

(For collet part numbers see page #33)

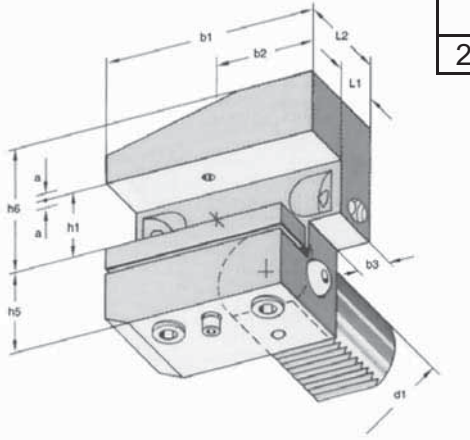


**Wrench ER25**  
(See page #25)

# TURNING TOOL HOLDER

Short, right hand tool, insert down

## Form B2

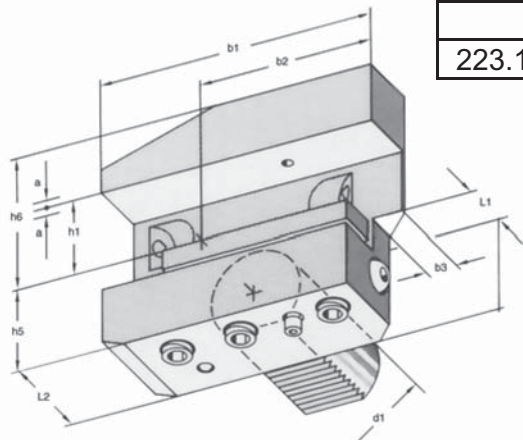


Ref. No.	d1	b1	b2	b3	hl 0-0.1	h5	h6	L1 + 0.50	L2
213.115.250	40	85	42.5	12.5	1"	32.5	48	22	44
METRIC									
213.115.150	40	85	42.5	12.5	25mm	32.5	48	22	44

# TURNING TOOL HOLDER

Long, right hand tool, insert down

## Form B6



Ref. No.	d1	b1	b2	b3	hl 0-0.1	h5	h6	L1 + 0.50	L2
223.115.250	40	118	75.5	12.5	1"	32.5	48	22	44
METRIC									
223.115.150	40	118	75.5	12.5	25mm	32.5	48	22	44

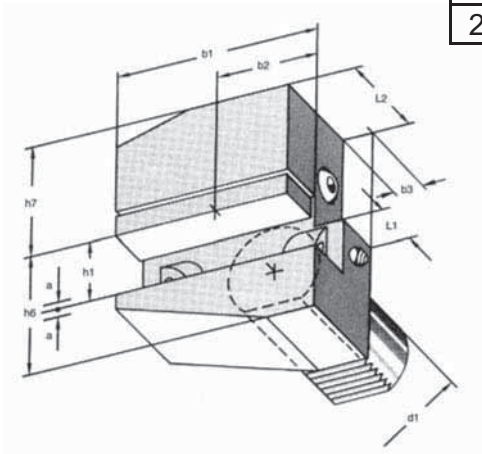


# TURNING TOOL HOLDER

Short, left hand tool, insert up

## Form B4

Ref. No.	d1	b1	b2	b3	hl 0-0.1	h6	h7	L1 + 0.50	L2
213.110.250	40	85	42.5	12.5	1"	48	42.5	22	44
METRIC									
213.110.150	40	85	42.5	12.5	25mm	48	42.5	22	44

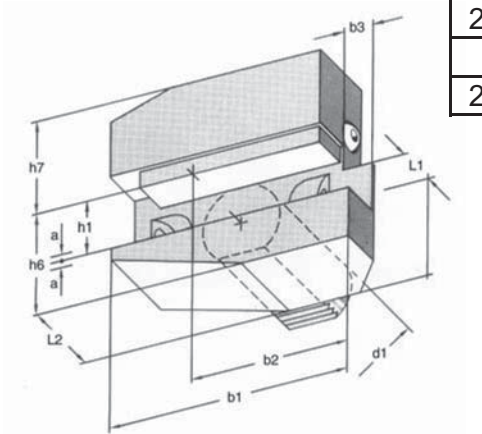


# TURNING TOOL HOLDER

Long, left hand tool, insert up

## Form B8

Ref. No.	d1	b1	b2	b3	hl 0-0.1	h6	h7	L1 + 0.50	L2
223.110.250	40	118	75.5	12.5	1"	48	42.5	22	44
METRIC									
223.110.150	40	118	75.5	12.5	25mm	48	42.5	22	44

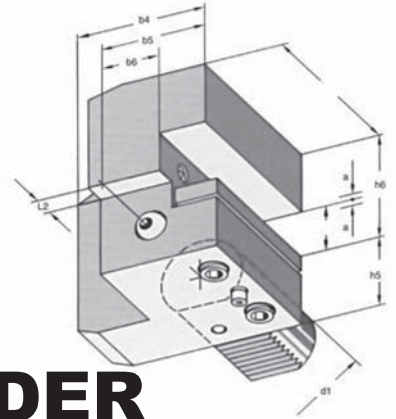


# FACE GROOVING TOOL HOLDER

Insert down

## Form C2

Ref. No.	d1	b4	b5	b6 0.50	h1 0-0.1	h5	h6	L1	L2
223.125.250	40	90	47.5	25.5	1"	32.5	48	85	12.5
METRIC									
223.125.150	40	90	47.5	25.5	25mm	32.5	48	85	12.5

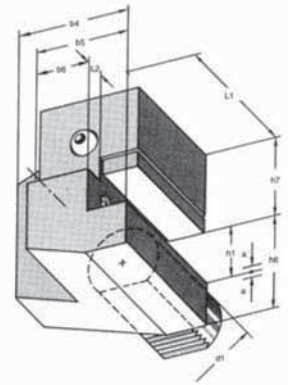


# FACE GROOVING TOOL HOLDER

Insert up

## Form C4

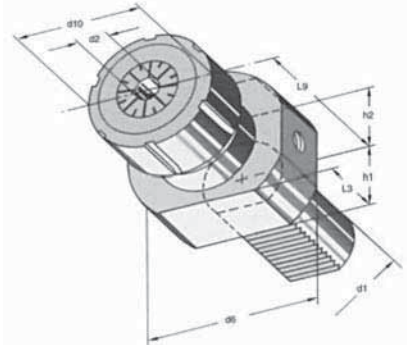
Ref. No.	d1	b1	b2	b6 0.50	h1 0-0.1	h6	h7	L1 + 0.50	L2
223.120.250	40	90	47.5	12.5	1"	48	42.5	85	12.5
METRIC									
223.120.150	40	90	47.5	25.5	25mm	48	42.5	85	12.5



# COLLET CHUCK

## Form E4 - ER

Ref. No.	d1	ER	d6	d10 max.	L9 h1	h2	L3	max.
223.040.220	40	ER25	83	42	32.5	-	22	75
223.035.220	40	ER32	83	50	32.5	-	22	75
223.045.220	40	ER40	83	63	32.5	-	22	75

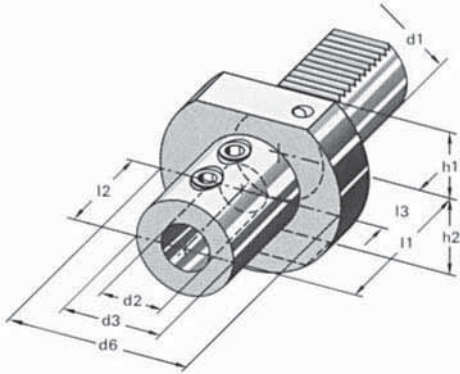


# VDI Fixed

HAAS Tooling for CNC Turning Centers

## TOOL HOLDER FOR CARBIDE INDEXABLE DRILL WITH INTERNAL COOLANT SUPPLY

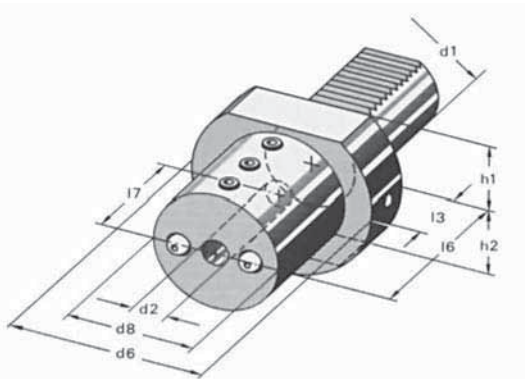
### Form E1



Ref. No.	d1	d2 H6	d3	d6	h1	L1 0-0.2	L2	L3
223.048.250	40	5/8"	36	83	32.5	64	51	22
223.050.250	40	3/4"	40	83	32.5	67	54	22
223.052.250	40	1"	45	83	32.5	75	59	22
223.055.250	40	1-1/4"	52	83	32.5	75	63	22
223.060.250	40	1-1/2"	60	83	32.5	90	73	22
METRIC								
223.048.150	40	8mm	36	83	32.5	64	51	22
223.050.150	40	20mm	40	83	32.5	67	54	22
223.052.150	40	25mm	45	83	32.5	75	59	22
223.055.150	40	32mm	52	83	32.5	75	63	22
223.060.150	40	40mm	60	83	32.5	90	73	22

## BORING BAR HOLDER

### Form E2



Ref. No.	d1	d2 H6	d6	d8	h1	L3	L6	L7
213.015.240	40	5/16"	83	55	32.5	22	75	61
213.015.241	40	3/8"	83	55	32.5	22	75	61
213.015.242	40	1/2"	83	55	32.5	22	75	61
213.015.243	40	5/8"	83	55	32.5	22	75	61
213.015.244	40	3/4"	83	55	32.5	22	75	61
213.015.245	40	1"	83	55	32.5	22	75	61
213.015.246	40	1-1/4"	83	83	32.5	22	75	61
213.015.247	40	1-1/2"	83	83	32.5	22	90	76
213.015.248	40	1-5/8"	83	83	32.5	22	90	76
213.015.250	40	2"	83	75	32.5	22	75	76
METRIC								
213.015.150	40	8mm	83	55	32.5	22	75	61
213.015.151	40	10mm	83	55	32.5	22	75	61
213.015.152	40	12mm	83	55	32.5	22	75	61
213.015.153	40	16mm	83	55	32.5	22	75	61
213.015.154	40	20mm	83	55	32.5	22	75	61
213.015.155	40	25mm	83	55	32.5	22	75	61
213.015.156	40	30mm	83	83	32.5	22	75	61
213.015.157	40	32mm	83	83	32.5	22	90	76
213.015.158	40	40mm	83	83	32.5	22	90	76

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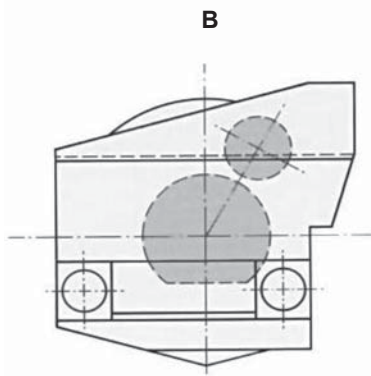
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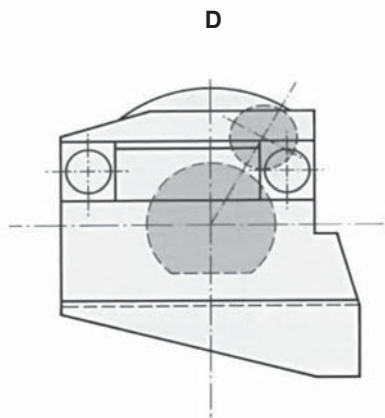
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# CUT-OFF TOOL HOLDER

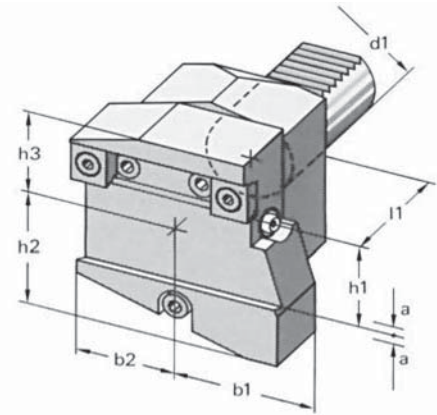
Ref. No.	d1	Form	b1	b2	h1	h2	h3	L1	a
213.635.220	40	B	42.5	42.5	32	48	32	44	2
213.645.220	40	D	42.5	42.5	32	48	32	44	2



Insert Down



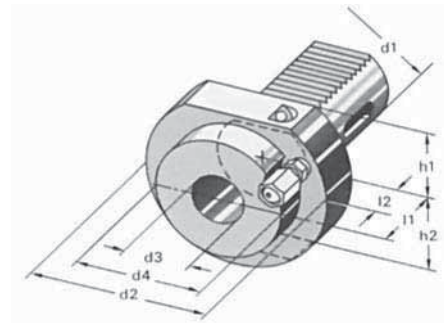
Insert Up



# MORSE TAPER HOLDER

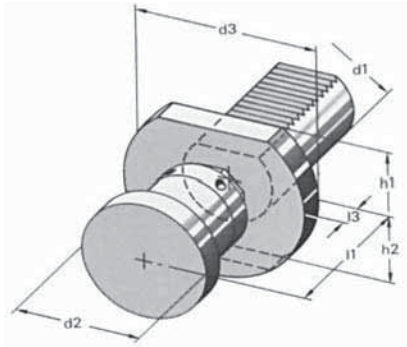
## Form F1

Ref. No.	d1	d2	d3 MT	d4	h1	L1	L2
203.130.150	40	83	2	55	32.5	36	22
203.135.150	40	83	3	58	32.5	36	22
203.140.150	40	83	4	68	32.5	80	22



# REVOLVING STOCK STOP

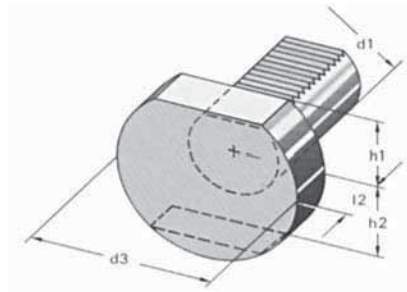
Ref. No.	d1	d2	d3	h1	L1	L3
203.040.220	40	58	83	32.5	62-95	12



# BLANKING PLUG

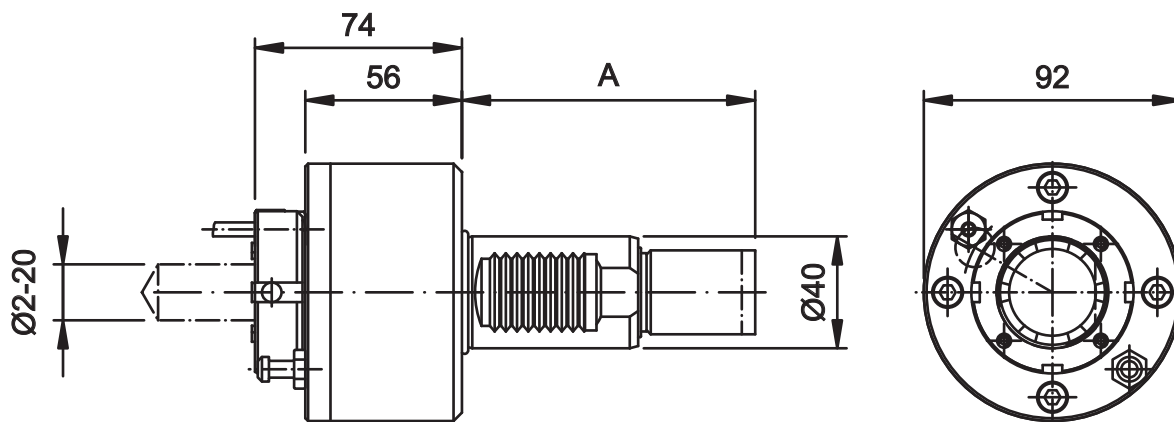
## Form Z2

Ref. No.	d1	d3	h1	L2	Mat.
213.500.001	40	83	32.5	20	P
213.500.150	40	83	32.5	20	ST



P= Plastic

ST= Steel



### PRECI-FLEX® External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.200.954	1:1	4,000	40	ER32	Short	104.85
4.200.956	1:1	4,000	40	ER32	Medium	117.55
4.200.958	1:1	4,000	40	ER32	Long	130.25

### PRECI-FLEX® Internal Coolant

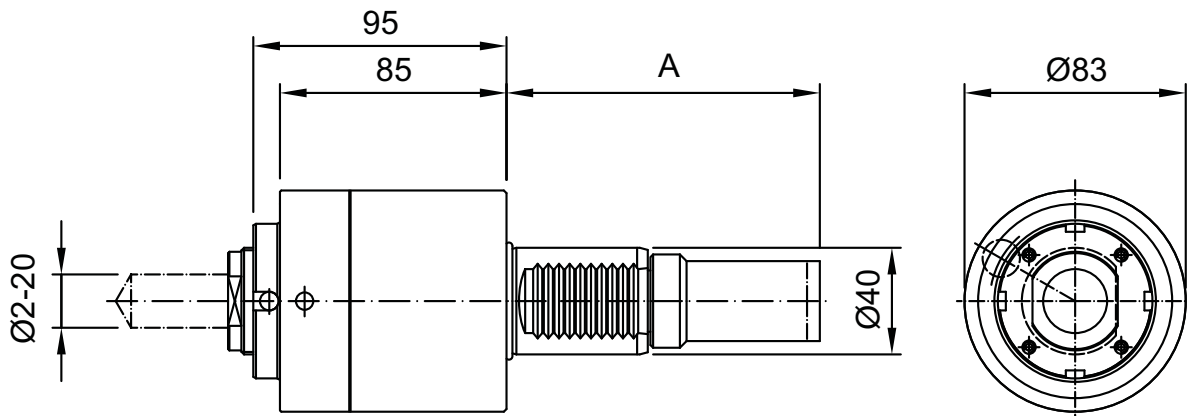
Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.333	1:1	4,000	40	ER32	Short	104.85
4.201.334	1:1	4,000	40	ER32	Medium	117.55
4.201.335	1:1	4,000	40	ER32	Long	130.25

\*Refer to page 5 for machine and turret specifications.

For adapters, see back cover and ask for special catalog.

# PRECI-FLEX® Axial Heavy Duty Option ER32 with collet chuck

HAAS Tooling for CNC Turning Centers



## PRECI-FLEX® External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.HDOM	1:1	4,000	50	ER32	Medium	117.55
4.201.HDOL	1:1	4,000	50	ER32	Long	130.25

## PRECI-FLEX® Internal Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.274	1:1	4,000	50	ER32	Medium	117.55
4.201.HDOLIK	1:1	4,000	50	ER32	Long	130.25

\*Refer to page 5 for machine and turret specifications.

For adapters, see back cover and ask for special catalog.

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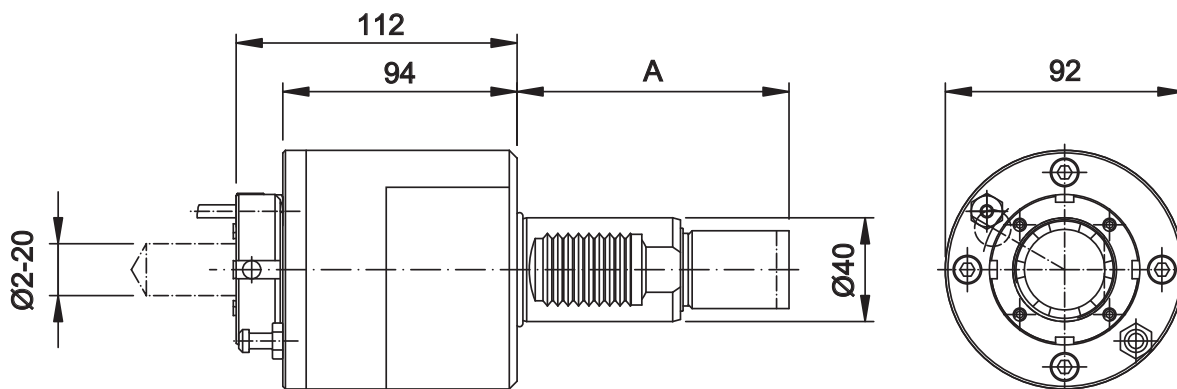
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# PRECI-FLEX® Axial Slim-Fit Mill/Drill ER32 with collet chuck

HAAS Tooling for CNC Turning Centers



## PRECI-FLEX® External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.510	1:1	4,000	40	ER32	Medium	117.55

\*Exclusivly for Hybrid VB-24 Turret.

\*Refer to page 5 for machine and turret specifications.

For adapters, see back cover and ask for special catalog.

**EXSYS** TOOL, INC.  
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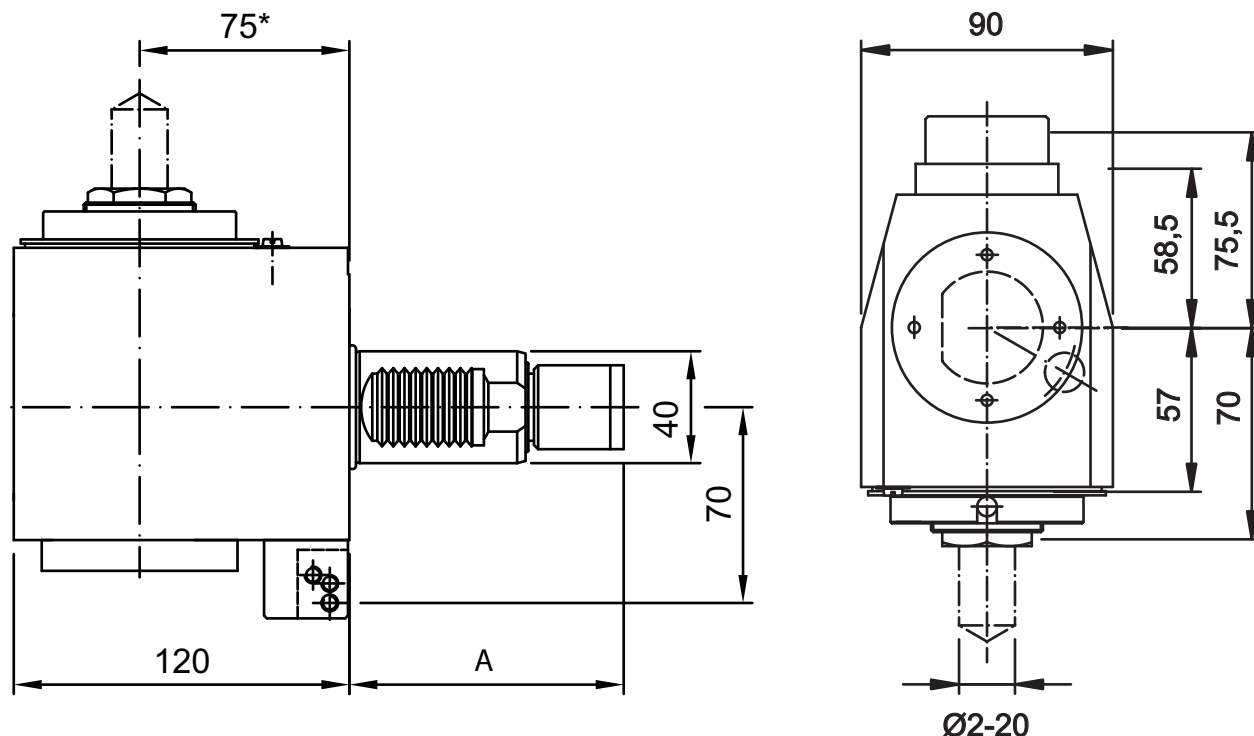
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# PRECI-FLEX® Radial Mill/Drill ER32 with collet chuck

HAAS Tooling for CNC Turning Centers



## PRECI-FLEX® External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.200.955	1:1	4,000	40	ER32	Short	104.85
4.200.957	1:1	4,000	40	ER32	Medium	117.55
4.200.959	1:1	4,000	40	ER32	Long	130.25

## PRECI-FLEX® Internal Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.329	1:1	4,000	40	ER32	Short	104.85
4.201.275	1:1	4,000	40	ER32	Medium	117.55
4.201.330	1:1	4,000	40	ER32	Long	130.25

\*Refer to page 5 for machine and turret specifications.

For adapters, see back cover and ask for special catalog.

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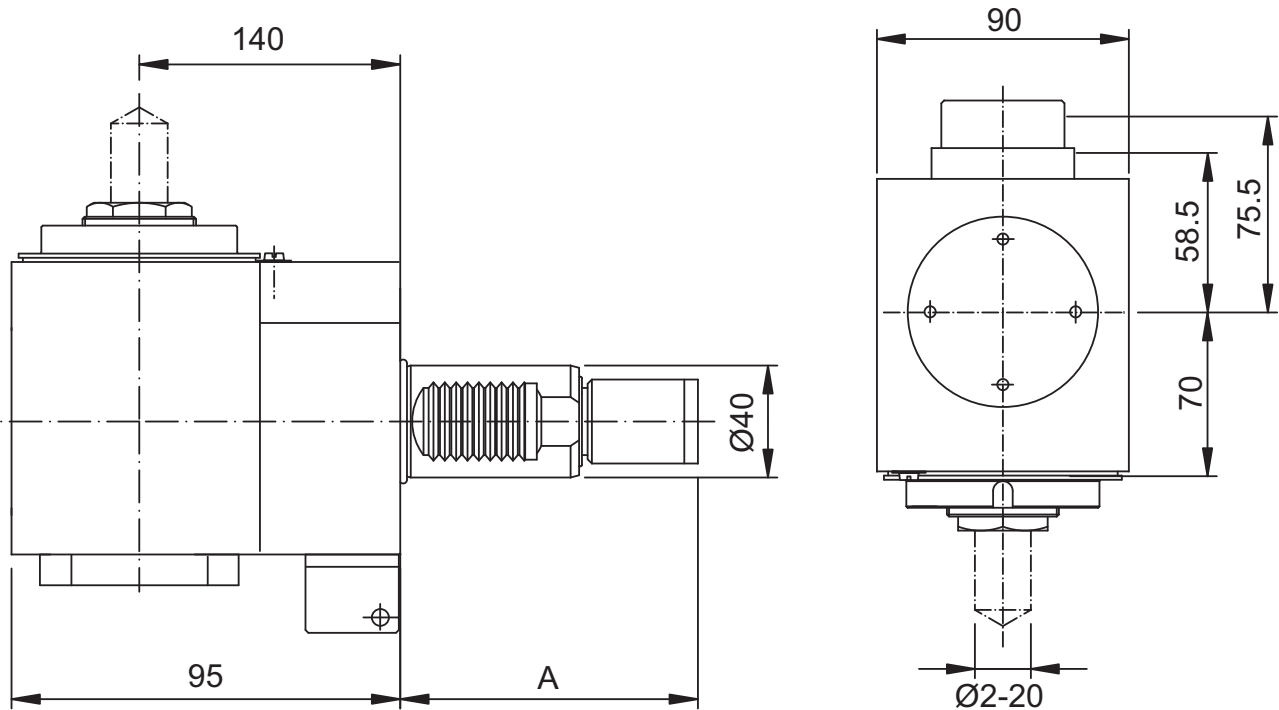
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# PRECI-FLEX® Radial Slim-Fit Mill/Drill ER32 with collet chuck

HAAS Tooling for CNC Turning Centers



## PRECI-FLEX® External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.513	1:1	4,000	40	ER32	Medium	117.55

\*Exclusivly for Hybrid VB-24 Turret.

\*Refer to page 5 for machine and turret specifications.

For adapters, see back cover and ask for special catalog.

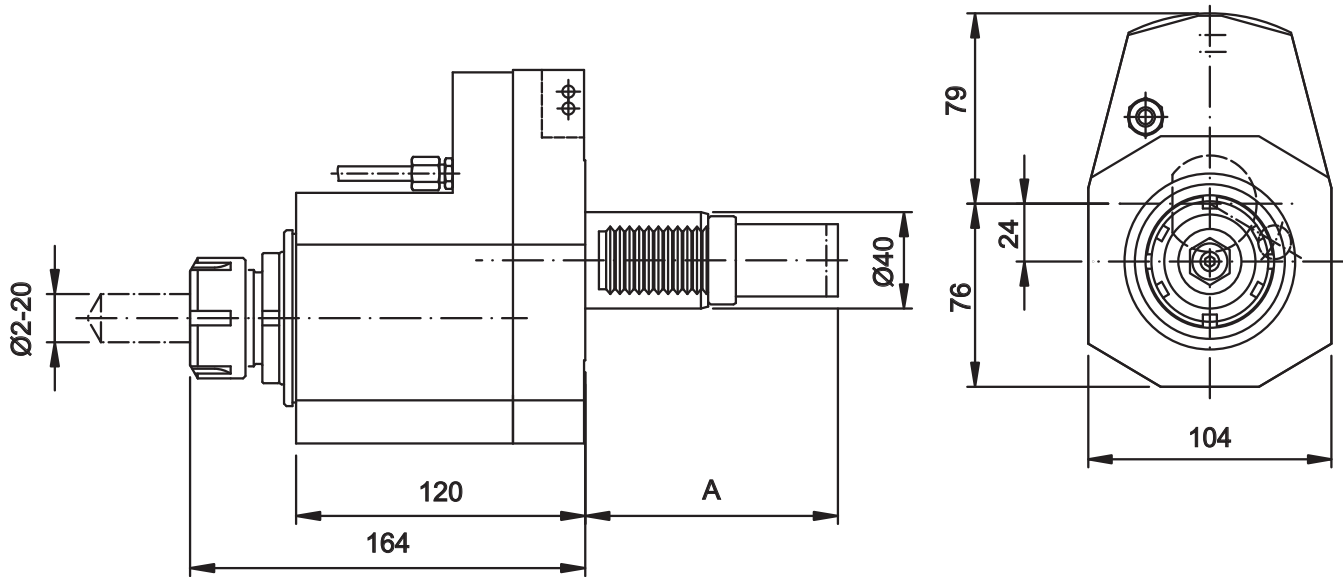
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# High Torque Axial Offset Mill/Drill Ratio 3:1

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
8.629.204	3:1	1,500	100	ER32	Short	104.85
8.629.209	3:1	1,500	100	ER32	Medium	117.55
8.629.295	3:1	1,500	100	ER32	Long	130.25

## Internal Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
8.628.115	3:1	1,500	100	ER32	Short	104.85
8.627.122	3:1	1,500	100	ER32	Medium	117.55
8.627.247	3:1	1,500	100	ER32	Long	130.25

\*Refer to page 5 for machine and turret specifications.

Input RPM max 4,500  
Output RPM max 1,500

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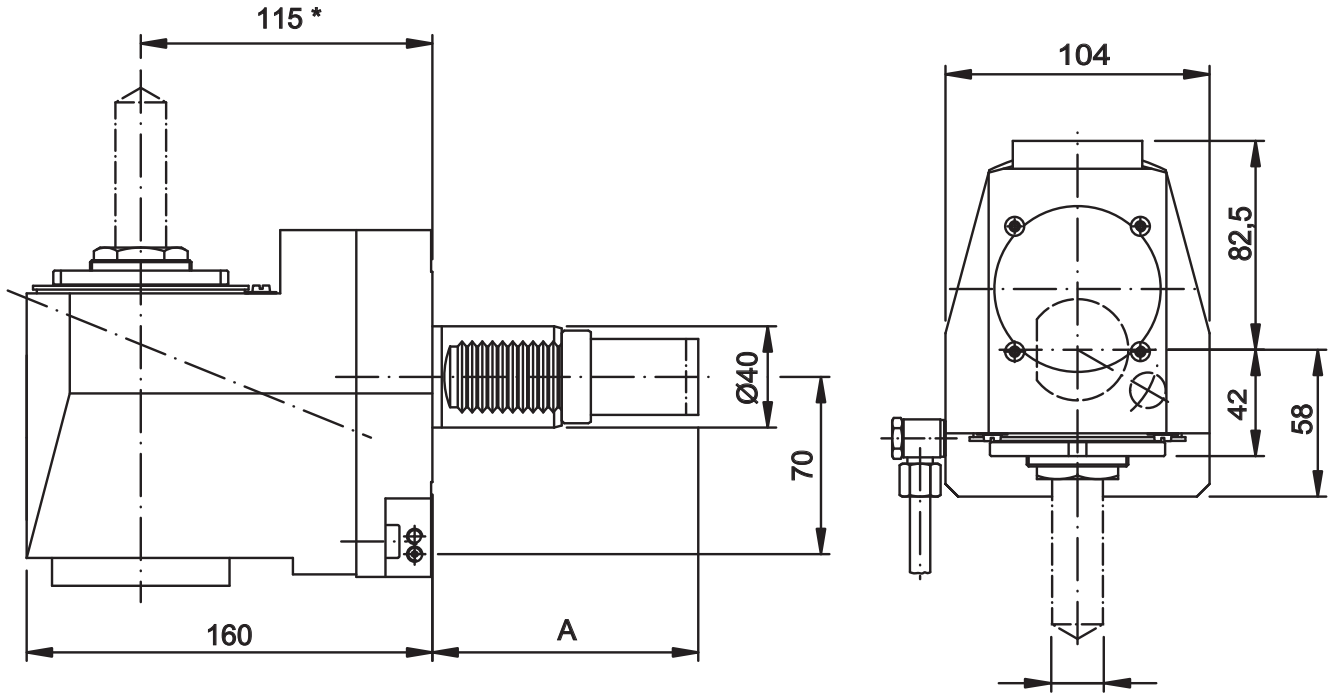
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# High Torque Radial Offset Mill/Drill ER32 Ratio 3:1

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
9.698.204	3:1	1,500	100	ER32	Short	104.85
9.698.209	3:1	1,500	100	ER32	Medium	117.55
9.698.295	3:1	1,500	100	ER32	Long	130.25

\*Refer to page 5 for machine and turret specifications.

Input RPM max 4,500  
Output RPM max 1,500

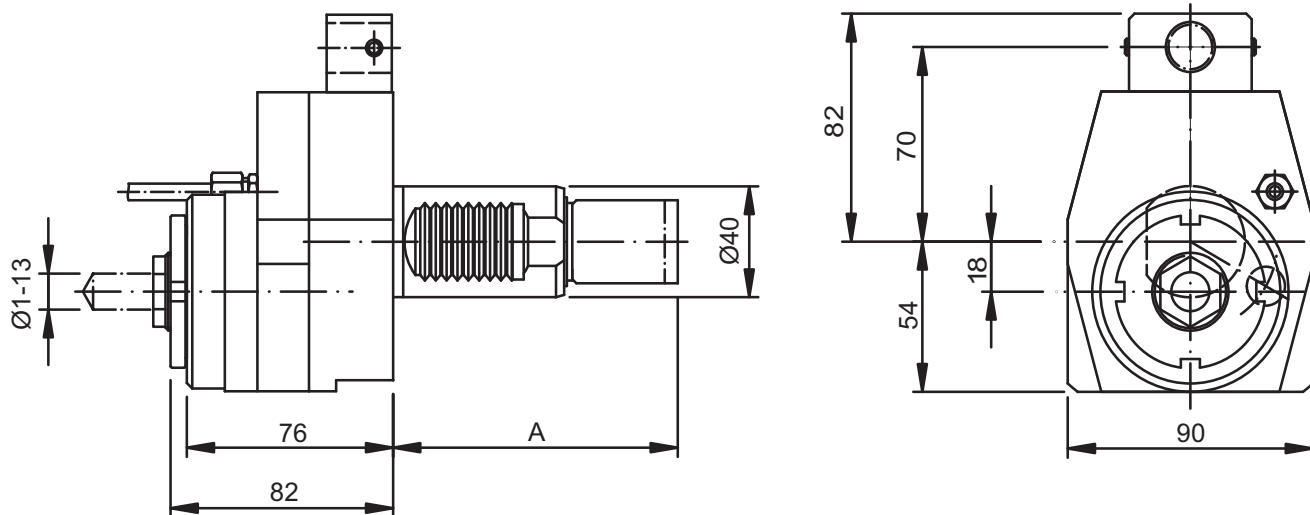
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# PRECI-FLEX® High Speed Axial Offset Mill/Drill With Collet Chuck

HAAS Tooling for CNC Turning Centers



## PRECI-FLEX® - External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.HSAS	1:2.5	10,000	16	ER20	Short	104.85
4.201.525	1:2.5	10,000	16	ER20	Medium	117.55
4.201.HSAL	1:2.5	10,000	16	ER20	Long	130.25

\*Refer to page 5 for machine and turret specifications.  
Output rotation is opposite input rotation.

Input RPM max 4,000  
Output RPM max 10,000

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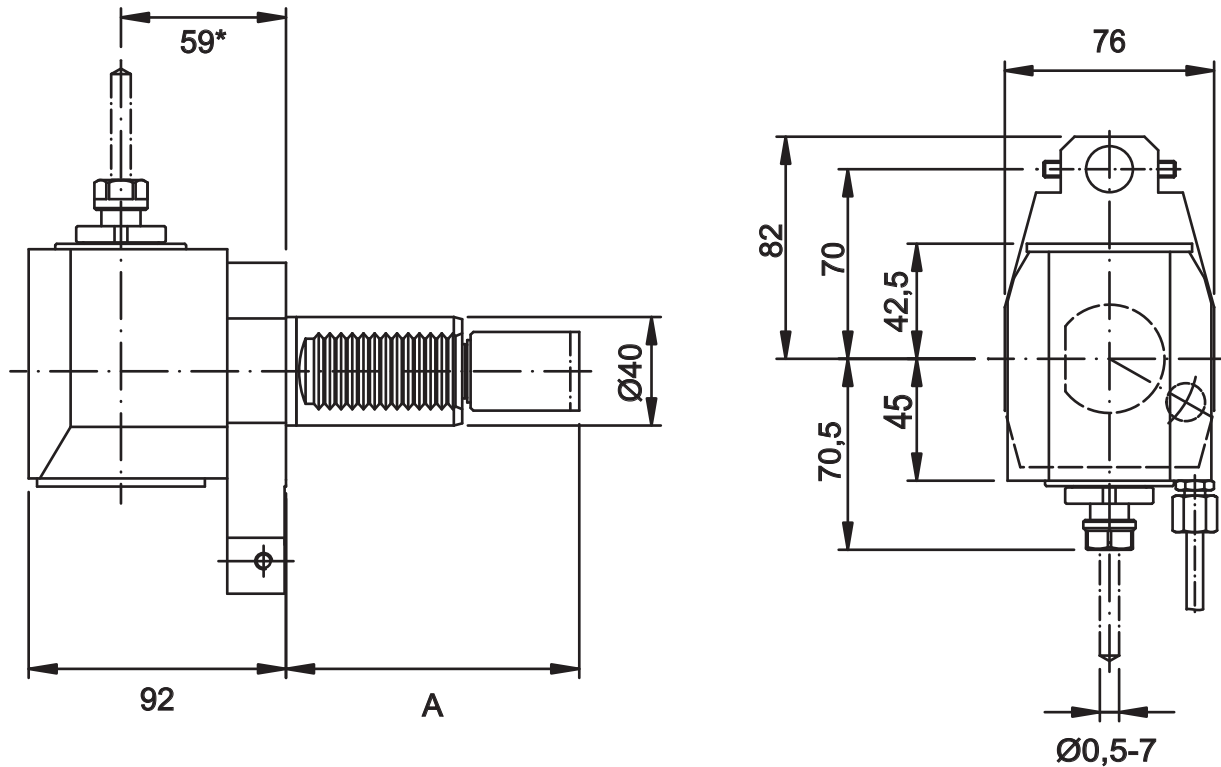
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# High Speed Radial Mill/Drill With Collet Chuck Ratio 1:2

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
9.608.187	1:2	8,000	20	ER11	Short	104.85
9.608.215	1:2	8,000	20	ER11	Medium	117.55

\*Refer to page 5 for machine and turret specifications.  
Output RPM equals 2 times input RPM.

Input RPM max 4,000  
Output RPM max 8,000

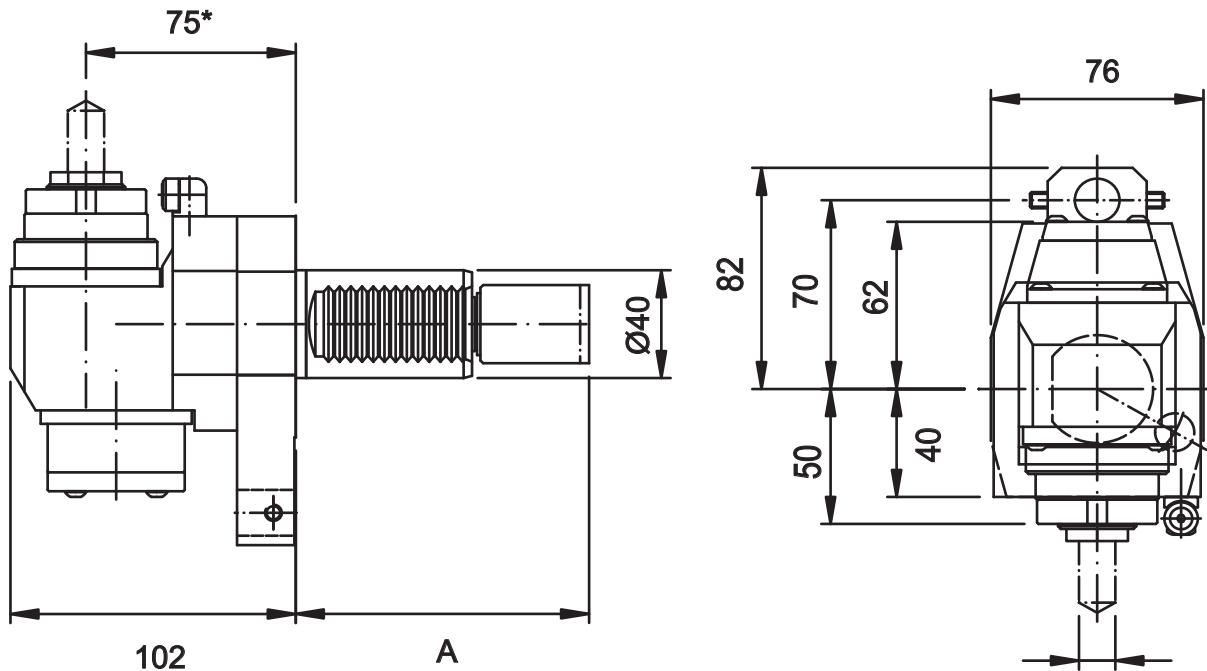
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# High Speed Radial Offset Mill/Drill With Collet Chuck Ratio 1:2.5

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
9.702.187	1:2.5	15,000	15	ER20	Short	104.85
9.702.215	1:2.5	15,000	15	ER20	Medium	117.55
9.702.303	1:2.5	15,000	15	ER20	Long	130.25

\*Refer to page 5 for machine and turret specifications.  
Output RPM equals 2 times input rpm.

Input RPM max 6,000  
Output RPM max 15,000

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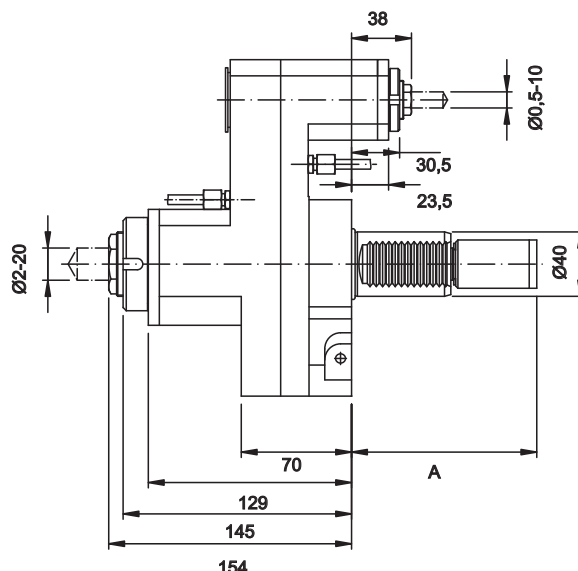
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# Main/Sub Axial Offset Double Sided Mill/Drill

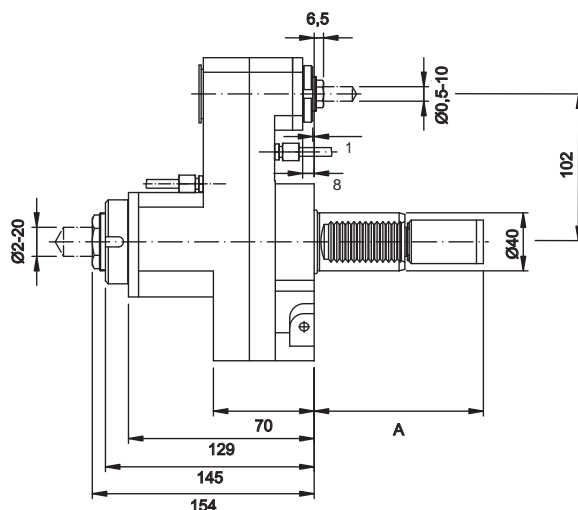
HAAS Tooling for CNC Turning Centers



## Long Version - External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.200.810	1:1	4,000	40	ER32 - ER16	Medium	117.55

\*Available for machines with sub spindle only.



## Short Version - External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.200.815	1:1	4,000	40	ER32 - ER16	Medium	117.55

\*Available for machines with sub spindle only.

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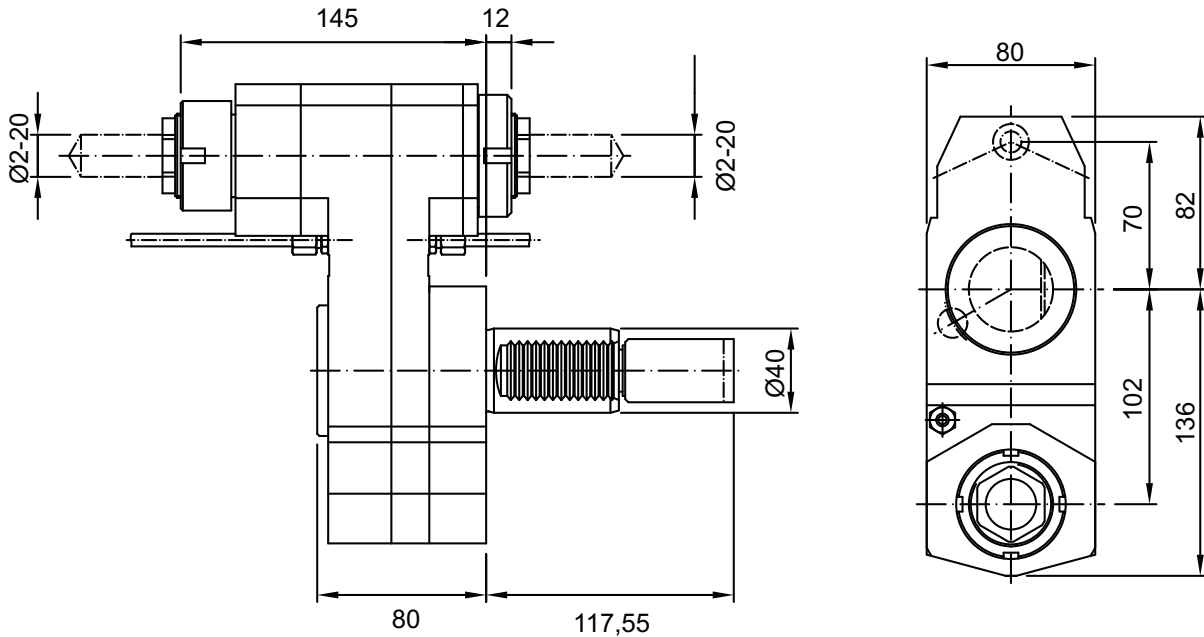
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# Axial Left Hand Offset Double Sided Mill/Drill

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.200.705	1:1	4,000	40	ER32	Medium	117.55

\*Refer to page 5 for machine and turret specifications.

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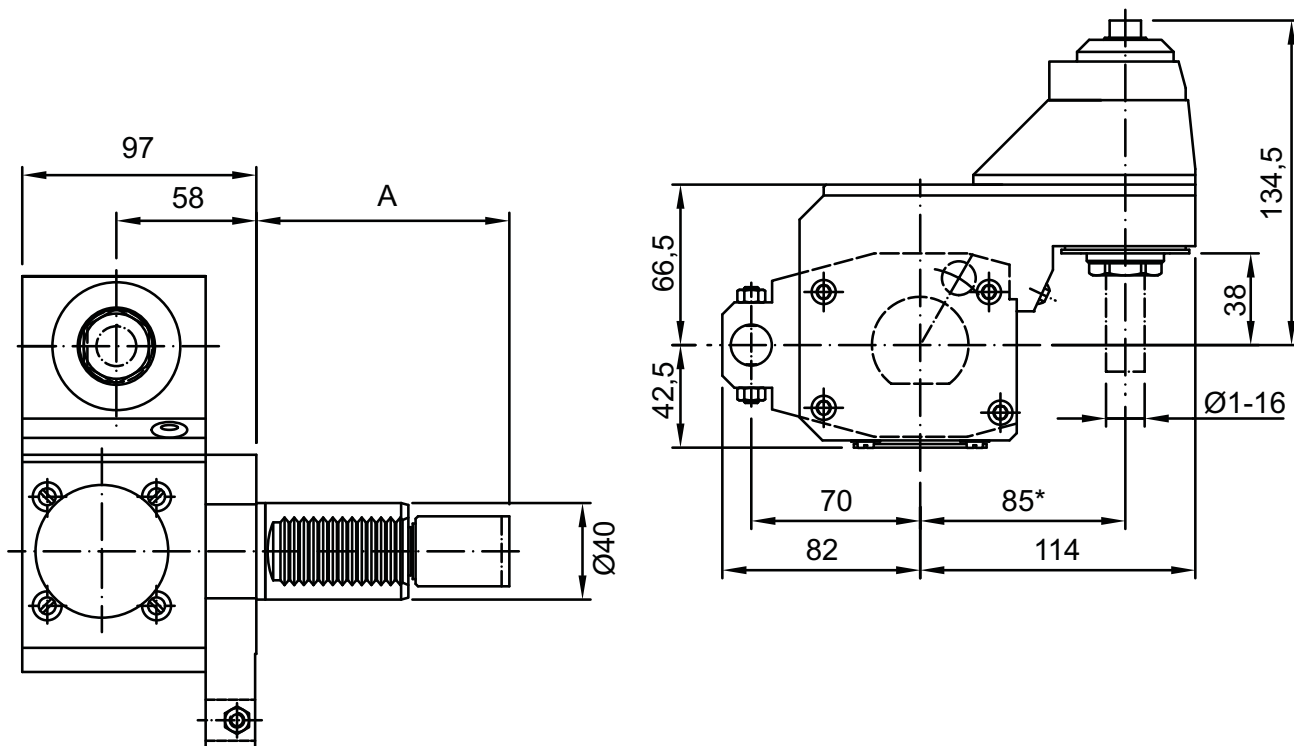
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# Y-Axis Keyseat Cutter Overhead Mill/Drill ER25 External Coolant

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
9.686.187	1.27:1	3,000	24	ER25	Short	104.85
9.686.215	1.27:1	3,000	24	ER25	Medium	117.55
9.686.303	1.27:1	3,000	24	ER25	Long	130.25

\*Refer to page 5 for machine and turret specifications.  
Output RPM equals 0.78 times input RPM.

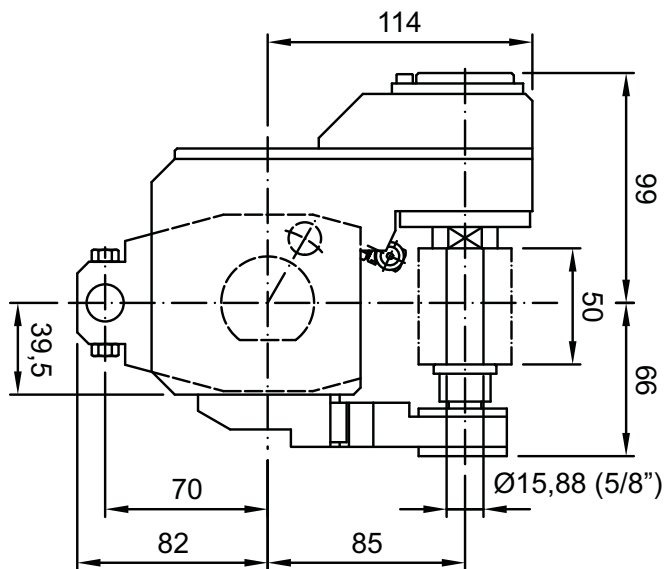
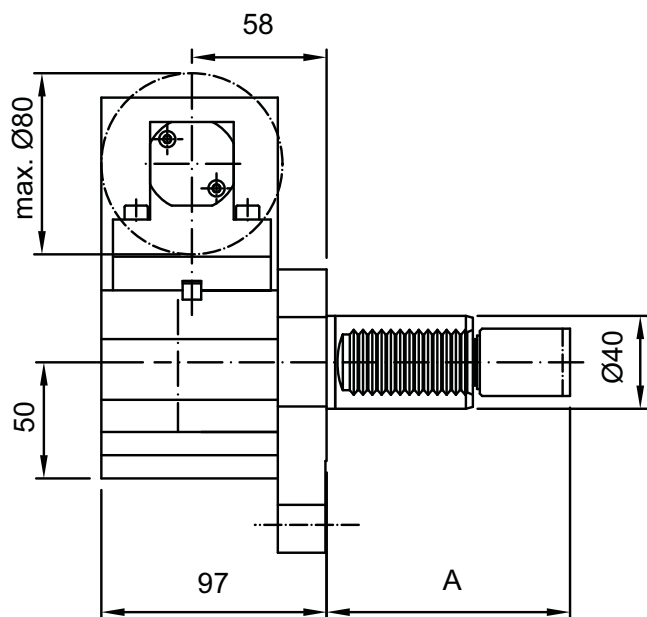
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# Gear Hobber / Slotting Saw 5/8 Arbor Diameter, External Coolant

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Arbor	Coupling Length	A
4.200.556	1.27:1	3,000	50	5/8"	Short	104.85
4.201.327	1.27:1	3,000	50	5/8"	Medium	117.55
4.201.328	1.27:1	3,000	50	5/8"	Long	130.25

\*Refer to page 5 for machine and turret specifications.  
Output RPM equals 0.78 times input RPM.

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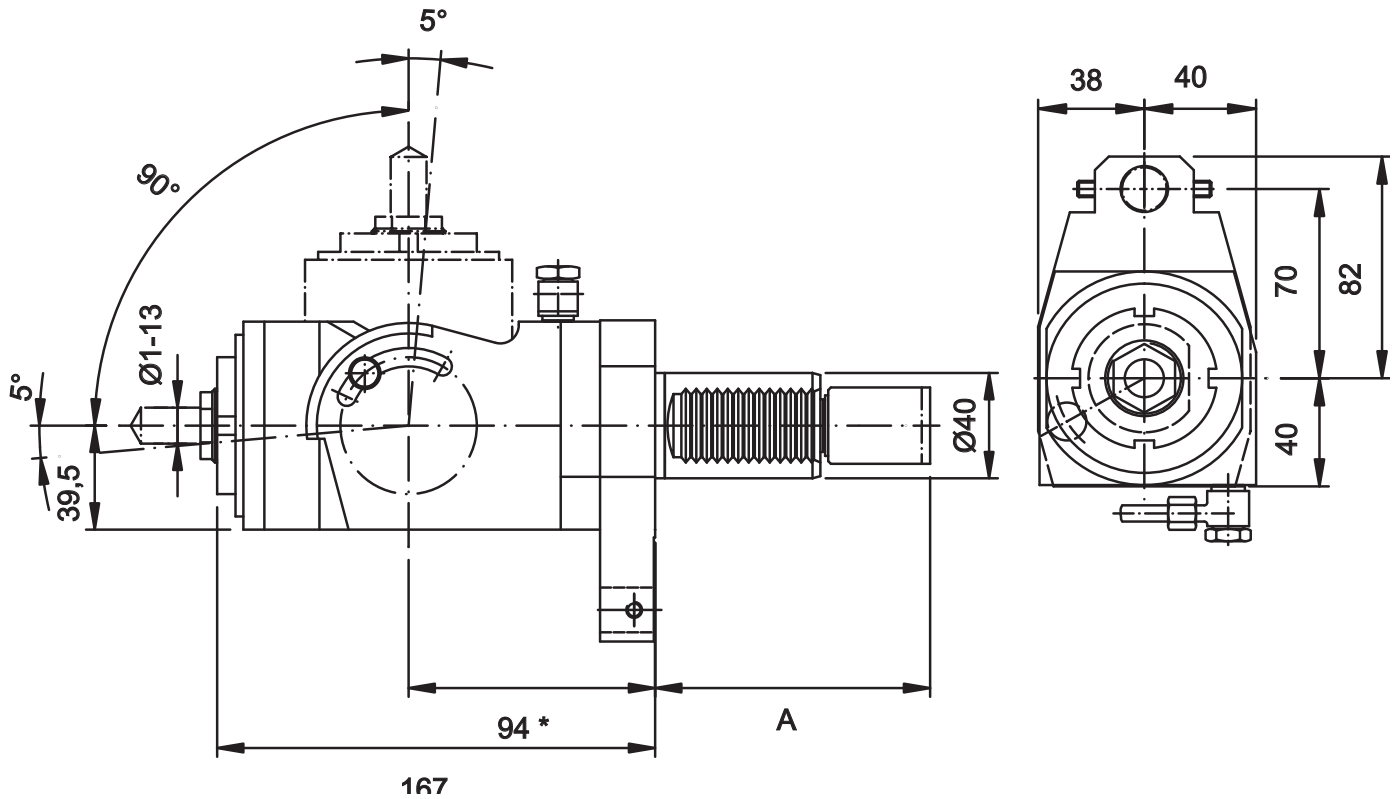
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# Angular Adjustable 0-90° Mill/Drill ER20 With Collet Chuck External Coolant

HAAS Tooling for CNC Turning Centers



## External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
8.760.187	1:1	4,000	30	ER20	Short	104.85
8.760.215	1:1	4,000	30	ER20	Medium	117.55
8.760.303	1:1	4,000	30	ER20	Long	130.25

\*Refer to page 5 for machine and turret specifications.

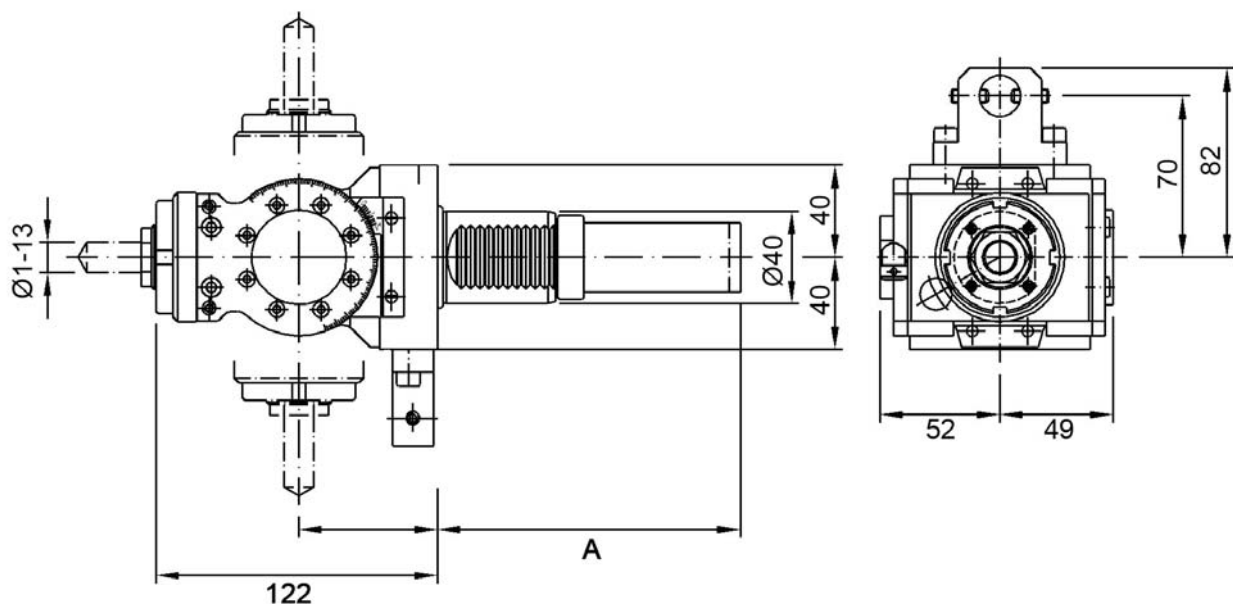
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# PRECI-FLEX® Angular Adjustable 0-90° Mill/Drill ER20 With Collet Chuck

HAAS Tooling for CNC Turning Centers



## PRECI-FLEX® External Coolant

Ref. No.*	Ratio	RPM	Nm Max.	Collet System	Coupling Length	A
4.201.AAM	1:1	6,000	13	ER20	Medium	117.55
4.201.462	1:1	6,000	13	ER20	Long	130.25

\*Refer to page 5 for machine and turret specifications.

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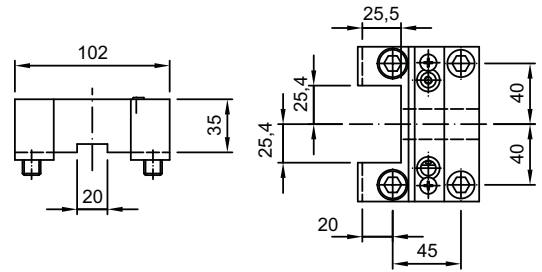
# BOLT-ON Turret

HAAS Tooling for CNC Turning Centers

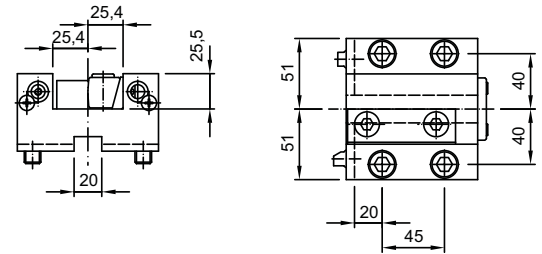
## BOLT-ON Turret

\*Bushings available, see page 32

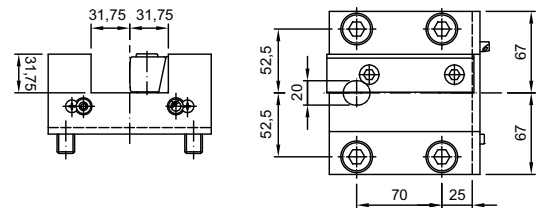
**Tool Holder, Axial**  
**Ext. Coolant (SL20/30, ST20/30)**  
7.070.058



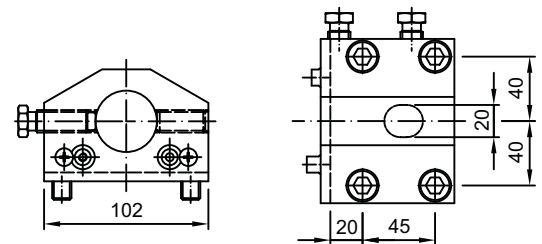
**Tool Holder, Radial**  
**Ext. Coolant (SL20/30, ST20/30)**  
7.070.055



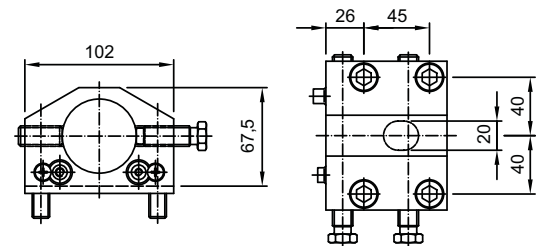
**Tool Holder, Radial**  
**Ext. Coolant (SL40)**  
7.070.124 - 1-1/4"  
7.071.265 - 32mm (metric)



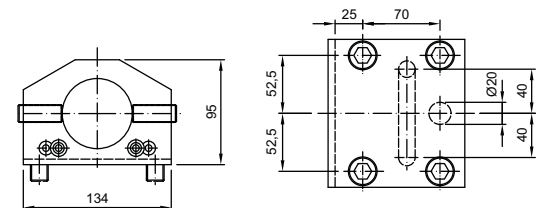
**Boring Bar Holder**  
**1-1/2" (SL20/30, ST20/30)**  
7.070.056 - External  
7.070.080 - External / Internal



**Boring Bar Holder**  
**2" (SL20/30, ST20/30)**  
7.071.380 - External  
7.071.383 - Internal



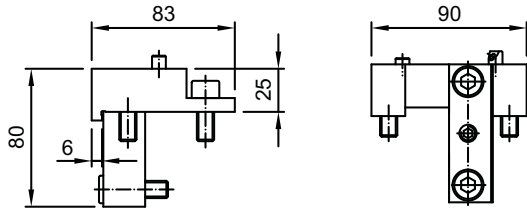
**Boring Bar Holder**  
**Ext. Coolant (SL40)**  
7.070.125 - 2-1/2"  
7.071.266 - 50mm (metric)



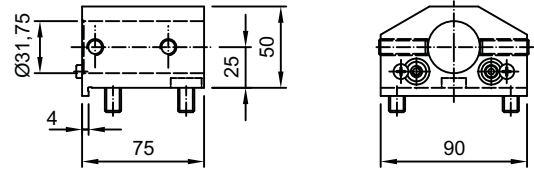
# Hybrid VB-12 Turret - BOLT-ON Tooling

HAAS Tooling for CNC Turning Centers

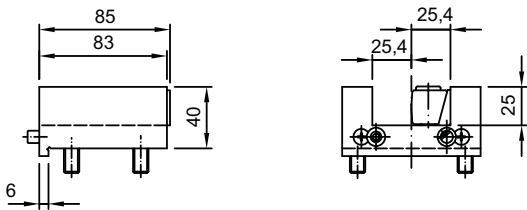
**TL15/25, SL-20/30, SL-40, ST-20/30(Y), DS-20/30(Y), ST-40**



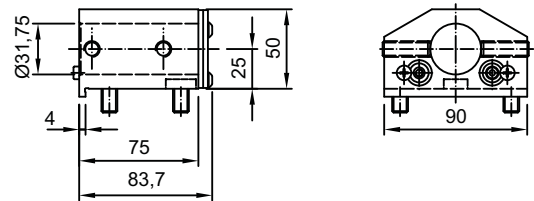
**Tool Holder, Axial**  
7.070.075 - Ext. Coolant



**Boring Bar Holder, Radial**  
7.070.069 - Ext. Coolant



**Tool Holder, Radial**  
7.070.085 - Ext. Coolant



**Boring Bar Holder, Radial**  
7.070.082 - Ext. Coolant



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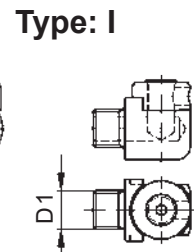
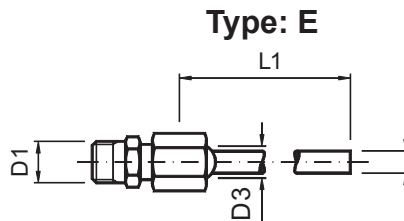
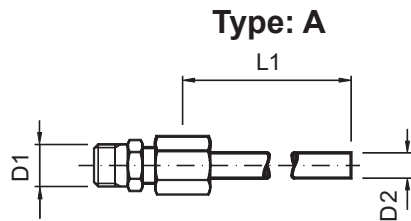
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# Live Tooling Accessories

HAAS Tooling for CNC Turning Centers

## Coolant Fittings for Live Tool Holders

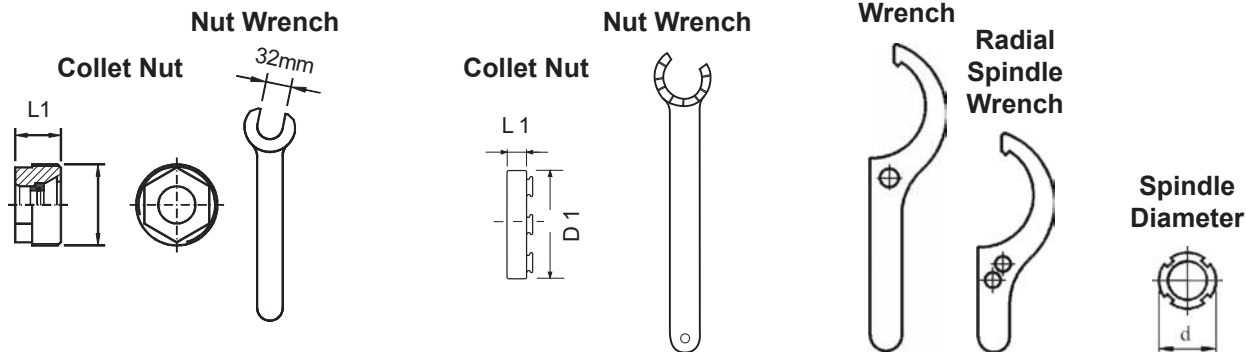
Tool No.	Type	D1 Thr'd	D2	D3/Nozzle	L1	Part No.
4.200.954, 4.200.956, 4.200.958	A	M8 x 1	5	-	60	218.844.220
4.200.955, 4.200.957, 4.200.959 New Version	E or I	M10 x 1	6	10/M6	90	0.000.135



## Collet Nuts and Wrenches for all standard live tooling

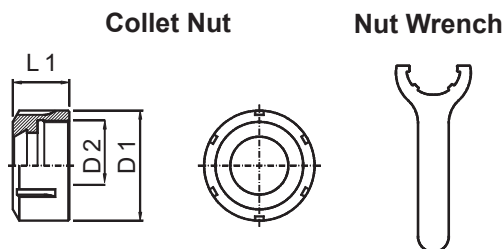
Description of Nuts	Collet	D1 Thr'd	P/N Nut	P/N Wrench A	L1
ER32-A Hex	ER32	M40 x 1.5	12946	SW32	17.7
ER32AX Nut	ER32	M40 x 1.5	3332.60000	7117.32000	9.8

Description of Nuts	P/N	D
Axial Spindle Wrench	0.000.413	52-55
Radial Spindle Wrench	0.000.349	52-75



## Collet Nuts and Wrenches for fixed collet chucks

Description of Nuts	Collet	D1 OD	D2 Thr'd	P/N Nut	P/N Wrench	L1
UM/ER25 (E223.040.220)	ER25	42	M32 x 1.5	3425.00000	7111.25000	20
UM/ER32 (E223.035.220)	ER32	50	M40 x 1.5	3432.00000	7111.32000	22.5
UM/ER40 (E223.045.220)	ER40	63	M50 x 1.5	3440.00000	7111.40000	25.5



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# Bushings

HAAS Tooling for CNC Turning Centers

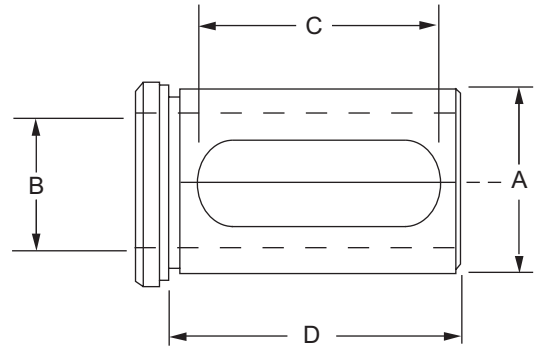
Part No.	A	B	C	D
----------	---	---	---	---

EX125037CS	1 1/4"	3/8"	1 3/4"	2 1/8"
EX125050CS		1/2"		
EX125062CS		5/8"		
EX125075CS		3/4"		
EX125100CS		1"		

EX150050CS	1 1/2"	1/2"	2 1/8"	2 1/2"
EX150062CS		5/8"		
EX150075CS		3/4"		
EX150100CS		1"		
EX150125CS		1 1/4"		

EX200050CS	2"	1/2"	2 5/8"	3"
EX200062CS		5/8"		
EX200075CS		3/4"		
EX200100CS		1"		
EX200125CS		1 1/4"		
EX200150CS		1 1/2"		
EX200175CS		1 3/4"		

EX250050C	2 1/2"	1/2"	3 1/8"	3 1/2"
EX250062C		5/8"		
EX250075C		3/4"		
EX250100C		1"		
EX250125C		1 1/4"		
EX250150C		1 1/2"		
EX250175C		1 3/4"		
EX250200C		2"		
EX250225C		2 1/4"		



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# Collets

## HAAS Tooling for CNC Turning Centers

Diameter (inches)	ER16 Part No.	ER20 Part No.	ER25 Part No.	ER32 Part No.	ER40 Part No.
1/16"	1116.01592	N/A	N/A	N/A	N/A
1/8"	1116.03182	1120.03182	1125.03182	1132.03182	1140.03182
3/16"	1116.04762	1120.04762	1125.04762	1132.04762	1140.04762
1/4"	1116.06352	1120.06352	1125.06352	1132.06352	1140.06352
5/16"	1116.07942	1120.07942	1125.07942	1132.07942	1140.07942
3/8"	1116.09532	1120.09532	1125.09532	1132.09532	1140.09532
7/16"	N/A	1120.11112	1125.11112	1132.11112	1140.11112
1/2"	N/A	1120.12702	1125.12702	1132.12702	1140.12702
9/16"	N/A	N/A	1125.14292	1132.14292	1140.14292
5/8"	N/A	N/A	1125.15882	1132.15882	1140.15882
11/16"	N/A	N/A	N/A	1132.17462	1140.17462
3/4"	N/A	N/A	N/A	1132.19052	1140.19052
13/16"	N/A	N/A	N/A	1132.20642	1140.20642
7/8"	N/A	N/A	N/A	N/A	1140.22232
1"	N/A	N/A	N/A	N/A	1140.25402

Clamping Range		ER16	ER20	ER25	ER32	ER40
(mm)	(inches)	Part No.	Part No.	Part No.	Part No.	Part No.
1.0 - 0.5	0.039 - 0.019	1116.01000	1120.01000	1125.01000	N/A	N/A
2 - 1	0.079 - 0.039	1116.02000	1120.02000	1125.02000	1132.02000	N/A
3 - 2	0.118 - 0.079	1116.03000	1120.03000	1125.03000	1132.03000	1140.03000
4 - 3	0.157 - 0.118	1116.04000	1120.04000	1125.04000	1132.04000	1140.04000
5 - 4	0.197 - 0.157	1116.05000	1120.05000	1125.05000	1132.05000	1140.05000
6 - 5	0.236 - 0.197	1116.06000	1120.06000	1125.06000	1132.06000	1140.06000
7 - 6	0.276 - 0.236	1116.07000	1120.07000	1125.07000	1132.07000	1140.07000
8 - 7	0.315 - 0.276	1116.08000	1120.08000	1125.08000	1132.08000	1140.08000
9 - 8	0.354 - 0.315	1116.09000	1120.09000	1125.09000	1132.09000	1140.09000
10 - 9	0.394 - 0.354	1116.10000	1120.10000	1125.10000	1132.10000	1140.10000
11 - 10	0.433 - 0.394	N/A	1120.11000	1125.11000	1132.11000	1140.11000
12 - 11	0.472 - 0.433	N/A	1120.12000	1125.12000	1132.12000	1140.12000
13 - 12	0.512 - 0.472	N/A	1120.13000	1125.13000	1132.13000	1140.13000
14 - 13	0.551 - 0.512	N/A	N/A	1125.14000	1132.14000	1140.14000
15 - 14	0.591 - 0.551	N/A	N/A	1125.15000	1132.15000	1140.15000
16 - 15	0.630 - 0.591	N/A	N/A	1125.16000	1132.16000	1140.16000
17 - 16	0.669 - 0.630	N/A	N/A	N/A	1132.17000	1140.17000
18 - 17	0.709 - 0.669	N/A	N/A	N/A	1132.18000	1140.18000
19 - 18	0.748 - 0.709	N/A	N/A	N/A	1132.19000	1140.19000
20 - 19	0.787 - 0.748	N/A	N/A	N/A	1132.20000	1140.20000
21 - 20	0.827 - 0.787	N/A	N/A	N/A	N/A	1140.21000
22 - 21	0.866 - 0.827	N/A	N/A	N/A	N/A	1140.22000
23 - 22	0.906 - 0.866	N/A	N/A	N/A	N/A	1140.23000
24 - 23	0.945 - 0.906	N/A	N/A	N/A	N/A	1140.24000
25 - 24	0.984 - 0.945	N/A	N/A	N/A	N/A	1140.25000
26 - 25	1.027 - 0.984	N/A	N/A	N/A	N/A	1140.26000

\*\*Other Collet sizes are available upon request. Please contact our sales office for more information.

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# PRECI-FLEX® Adapter Change

HAAS Tooling for CNC Turning Centers

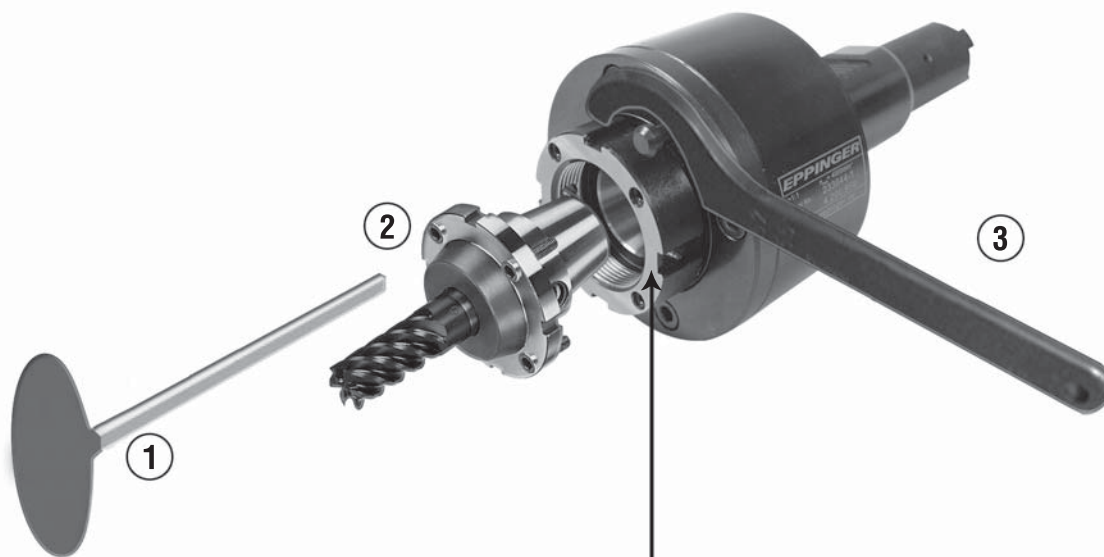
## PRECI-FLEX® Adapter Change

Remove four screws from base holder. Wipe taper and flat mounting surface of adapter and base holder.

With T-Wrench (1) install and tighten four screws (2) using spanner wrench (3) to keep spindle from rotating.

### CAUTION:

Adapter flange must be flush with mounting surface of base holder.



Tool Change Without Removing Adapter

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# PRECI-FLEX® Adapter Kit

HAAS Tooling for CNC Turning Centers



Size	Starter Kit
ER25	0.001.002
ER32	0.001.003
ER40	0.001.004
ER50	0.001.005

- Please Note: All kits include
  - Shell Mill
  - Collet Chuck Extended
  - Weldon Shank Standard

## Interchangeable PRECI-FLEX® Adapters



Standard Collet



Tapping Collet



Collet Chuck



Collet Chuck Extended



Collet Chuck Extended



Weldon Shank Standard



Weldon Shank Extended



Shell Mill



Whistle Notch



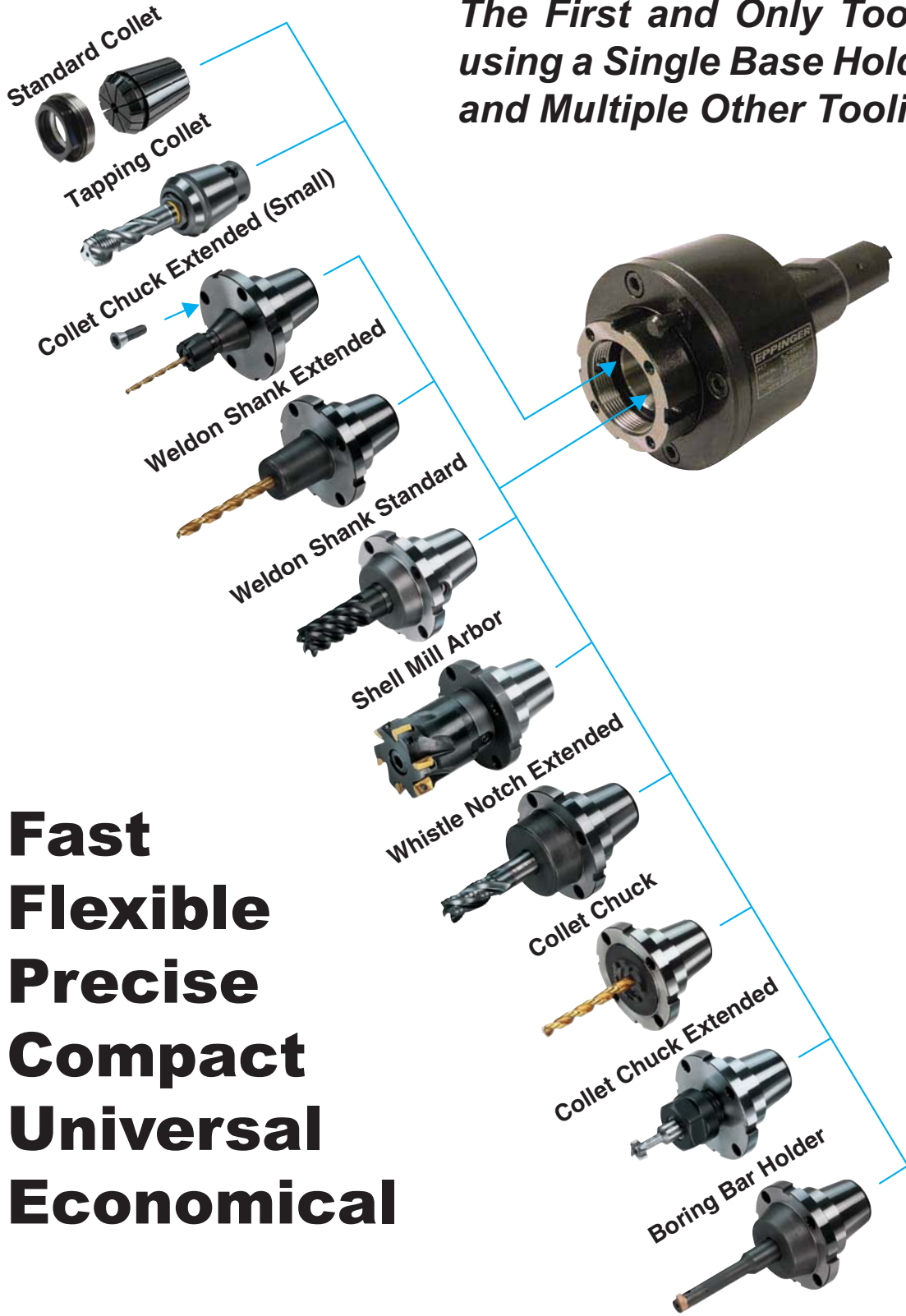
Boring Bar Holder

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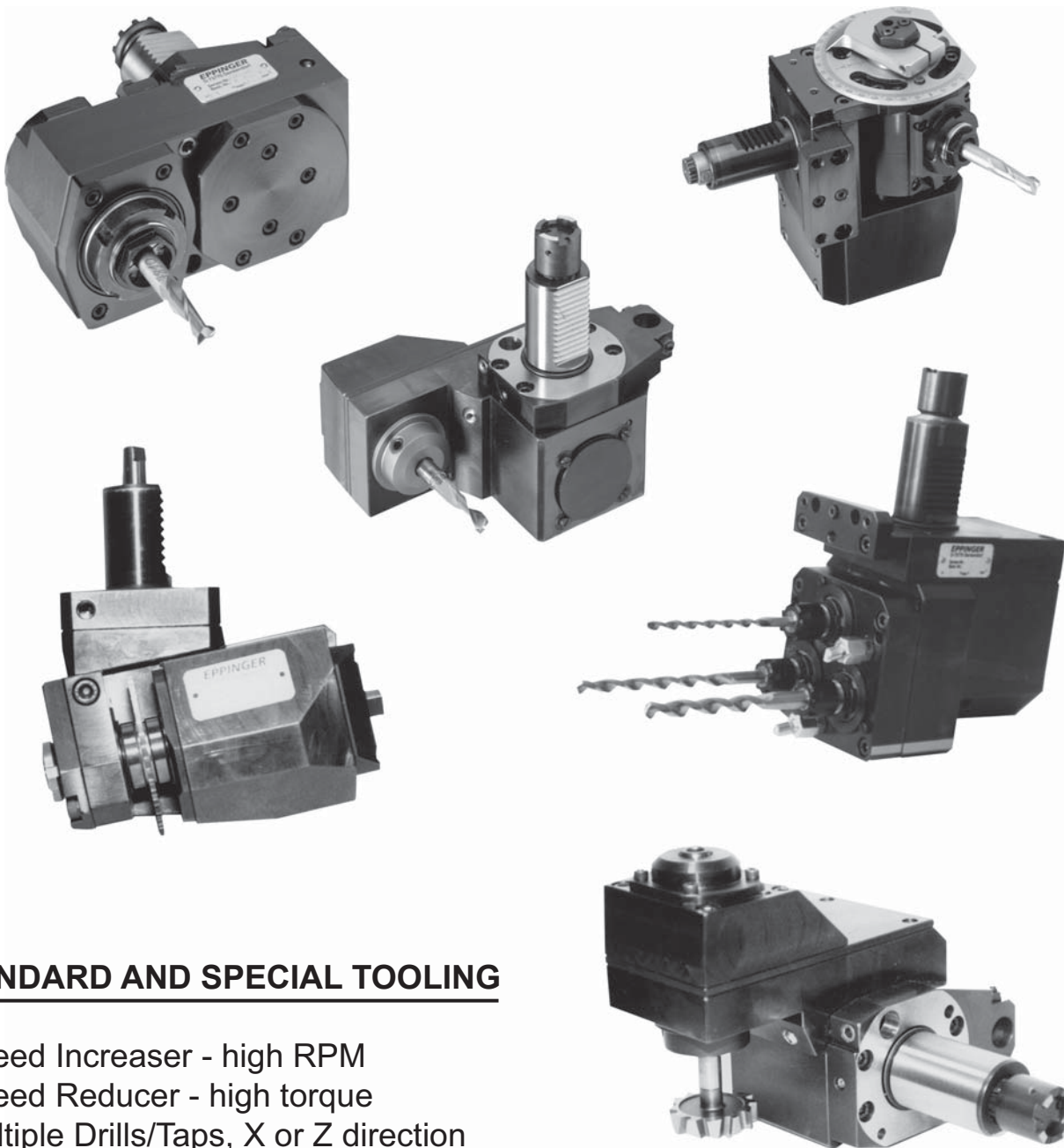
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using a Single Base Holder for Collet  
and Multiple Other Tooling Adapters*



- **Fast**
- **Flexible**
- **Precise**
- **Compact**
- **Universal**
- **Economical**



### STANDARD AND SPECIAL TOOLING

- Speed Increaser - high RPM
- Speed Reducer - high torque
- Multiple Drills/Taps, X or Z direction
- Y-axis Cutter Heads (Woodruff  
Keyseat Cutter)
- Slanted or straight slotting heads
- Y-adjustable mill/drill for x-axis
- X-Z - adjustable mill/drill

## Contact Information

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