

WWW.VELOCITYPRODUCTS.COM



VELOCITY PRODUCTS  
**MILL TOOLHOLDING  
COLLETS & FIXTURES**





## Table of Contents

### CT40 Tool Holders ..... 4-5

ER Collet Chucks

- + *Shorty*
- + *Standard*
- + *Extended*
- + *Extra Extended*

Shell Mill Holder  
Test Bars & Storage  
Calibration Tools

### CT50 Tool Holders ..... 6-7

ER Collet Chucks

- + *Shorty*
- + *Standard*
- + *Extended*
- + *Extra Extended*

Shell Mill Holder  
Test Bars & Storage  
Calibration Tools

### ER Collets ..... 8-11

ER11, ER16, ER20, ER25, ER32, ER40

### Accessories ..... 12-13

CT40 Tool Fixture  
CT50 Tool Fixture  
CNC Chip Fan

**VELOCITY**

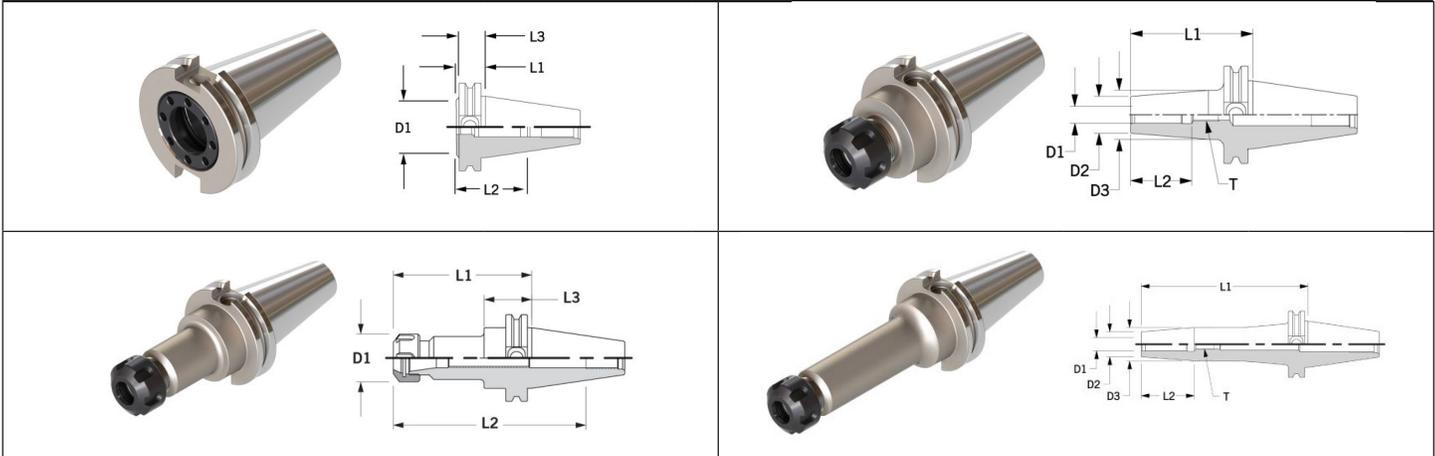
VELOCITYPRODUCTS.COM

# Velocity Mill Toolholding

## CAT40 Tool Holders



### CT40 Micro Precision® ER Collet Chucks



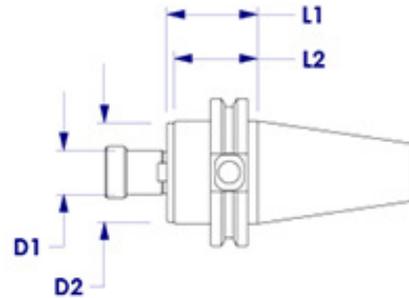
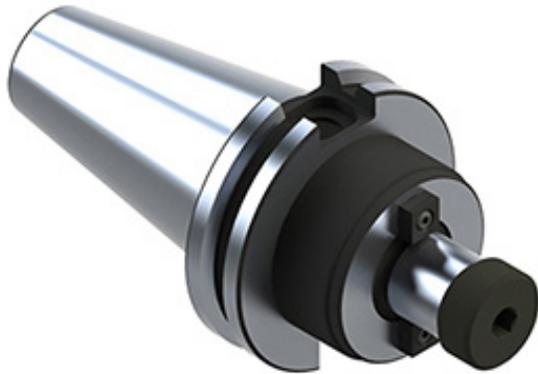
Part Number	Size	D1 (IN)	L1 (IN)	L2 (IN)	L3 (IN)
<b>CT40 Micro Precision® ER Collet Chucks: Shorty Gage Length</b>					
V03-E8-0641	ER32	1.97	0.75	2.32	-
<b>CT40 Micro Precision® ER Collet Chucks: Stub Gage Length</b>					
V03-E8-0651	ER11	0.63	2.00	3.57	-
V03-E8-0661	ER16	1.26	2.00	3.57	-
V03-E8-0151	ER20	1.38	2.55	4.12	1.38
V03-E8-0671	ER25	1.64	2.50	4.07	1.08
V03-E8-0161	ER32	1.97	2.70	4.25	1.38
V03-E8-0681	ER40	2.48	3.00	4.57	1.44
<b>CT40 Micro Precision® ER Collet Chucks: Standard Gage Length</b>					
V03-E8-0591	ER11	0.63	3.00	4.57	1.38
V03-E8-0601	ER16	1.26	2.88	4.45	1.38
V03-E8-0602	ER20	1.38	4.00	5.57	1.38
V03-E8-0603	ER25	1.64	4.00	5.57	1.38
V03-E8-0171	ER32	1.97	4.00	5.50	1.44
V03-E8-0631	ER40	2.48	4.00	5.57	1.44
<b>CT40 Micro Precision® ER Collet Chucks: Extended Gage Length</b>					
V03-E8-0691	ER16	1.26	4.88	6.45	1.38
V03-E8-0701	ER20	1.36	6.00	7.62	1.38
V03-E8-0711	ER25	1.64	6.00	7.57	1.38
V03-E8-0721	ER32	1.97	6.00	7.57	1.38
V03-E8-0731	ER40	2.48	6.00	7.57	1.44

# Velocity Mill Toolholding

## CAT40 Tool Holders



### CT40 Shell Mill Holder



Part Number	D1 (IN)	D2 (IN)	L1 (IN)	L2 (IN)
<b>CT40 Shell Mill Tool Holder: Standard Length</b>				
V03-E8-0741	0.500	1.44	1.50	1.38
V03-E8-0201	0.750	1.69	1.50	1.38
V03-E8-0211	1.000	2.19	2.06	1.44
V03-E8-0751	1.250	2.75	2.63	1.44
V03-E8-0761	1.500	3.81	3.00	1.44

### CT40 Test Bar



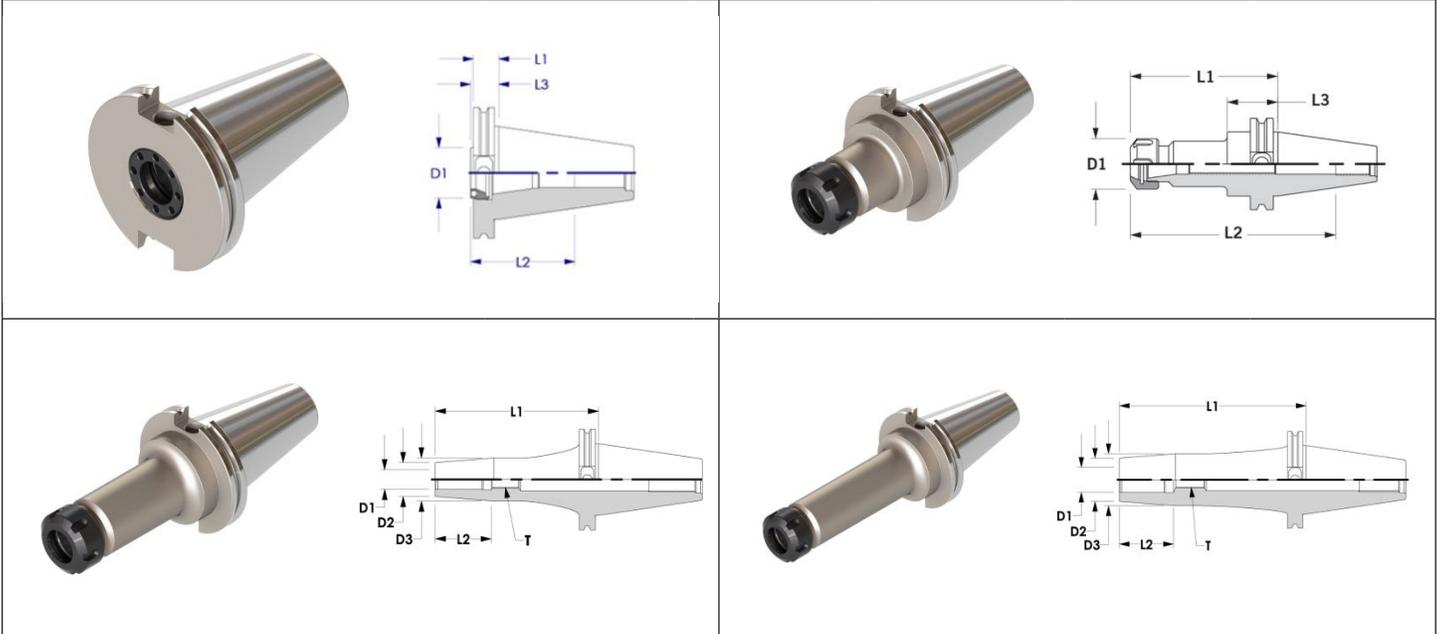
Part Number	D1 (IN)	L1 (IN)
<b>CT40 Test Bar</b>		
V03-E8-0771	2.00	10.00

### CT40 Blank Bar Holder



Part Number	D1 (IN)	L1 (IN)	L2 (IN)
<b>CT40 Blank Bar Holder</b>			
V03-E8-0781	2.50	6.00	1.44

### CT50 Micro Precision® ER Collet Chucks



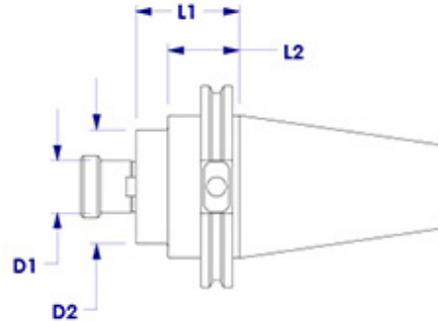
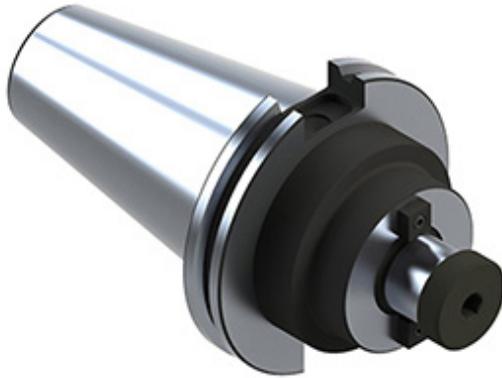
Part Number	Size	D1 (IN)	L1 (IN)	L2 (IN)	L3 (IN)
<b>CT50 Micro Precision® ER Collet Chucks: Shorty Gage Length</b>					
V03-E8-0641	ER32	1.97	0.75	3.00	0.75
<b>CT50 Micro Precision® ER Collet Chucks: Standard Gage Length</b>					
V03-E8-0791	ER16	1.26	4.88	7.13	1.38
V03-E8-0231	ER20	1.38	4.00	6.25	1.38
V03-E8-0801	ER25	1.64	4.00	6.25	1.38
V03-E8-0241	ER32	1.97	4.00	6.25	1.38
V03-E8-0251	ER40	2.48	4.00	6.25	1.38
<b>CT50 Micro Precision® ER Collet Chucks: Extended Gage Length</b>					
V03-E8-0821	ER16	1.26	6.88	9.13	1.38
V03-E8-0831	ER20	1.38	6.00	8.30	1.38
V03-E8-0841	ER25	1.64	6.00	8.25	1.38
V03-E8-0851	ER32	1.97	6.00	8.25	1.38
V03-E8-0861	ER40	2.48	6.00	8.25	1.38
<b>CT50 Micro Precision® ER Collet Chucks: Extra Extended Gage Length</b>					
V03-E8-0871	ER20	1.38	8.00	10.25	1.38
V03-E8-0881	ER32	1.97	8.00	10.25	1.38

# Velocity Mill Toolholding

## CAT50 Tool Holders



### CT50 Shell Mill Holder



Part Number	D1 (IN)	D2 (IN)	L1 (IN)	L2 (IN)
<b>CT50 Shell Mill Tool Holder: Standard Length</b>				
V03-E8-00891	0.500	1.44	1.50	1.38
V03-E8-0901	0.750	1.69	1.50	1.38
V03-E8-0261	1.000	2.19	2.00	1.38
V03-E8-0271	1.250	2.75	1.50	N/A
V03-E8-0911	1.500	3.81	2.50	1.44
V03-E8-0921	2.000	4.88	3.00	1.44
V03-E8-0931	2.000	4.88	2.40	1.44

### CT50 Test Bar



Part Number	D1 (IN)	L1 (IN)
<b>CT50 Test Bar</b>		
V03-E8-0941	2.00	12.00

### CT50 Blank Bar Holder



Part Number	D1 (IN)	L1 (IN)	L2 (IN)
<b>CT50 Blank Bar Holder</b>			
V03-E8-0951	3.875	6.00	1.44

# Velocity Mill Toolholding

## ER Collets



### ER11 Standard Collets



Part Number	Description	Size Range (IN)	Ref. Size Range (MM)	In ER11-03ST SET	L1 (IN)	D1 (IN)
<b>Models &amp; Dimensions</b>						
ER11-F125	Standard Collet (IN)	0.106 - 0.125	2.7 - 3.2	Yes	0.709	0.461
ER11-F187	Standard Collet (IN)	0.168 - 0.187	4.3 - 4.8	Yes	0.709	0.461
ER11-F250	Standard Collet (IN)	0.231 - 0.250	5.9 - 6.4	Yes	0.709	0.461
ER11-03ST	3 Piece Standard Collet Set (IN)	-	-	-	-	-

### ER16 Standard Collets



Part Number	Description	Size Range (IN)	Ref. Size Range (MM)	In ER16-11ST SET	L1 (IN)	D1 (IN)
<b>Models &amp; Dimensions</b>						
ER16-F062	Standard Collet (IN)	0.043 - 0.062	1.1 - 1.6	Yes	1.083	0.679
ER16-F093	Standard Collet (IN)	0.054 - 0.093	1.4 - 2.4	Yes	1.083	0.679
ER16-F125	Standard Collet (IN)	0.086 - 0.125	2.2 - 3.2	Yes	1.083	0.679
ER16-F156	Standard Collet (IN)	0.117 - 0.156	3.0 - 4.0	Yes	1.083	0.679
ER16-F187	Standard Collet (IN)	0.148 - 0.187	3.8 - 4.7	Yes	1.083	0.679
ER16-F218	Standard Collet (IN)	0.179 - 0.218	4.5 - 5.5	Yes	1.083	0.679
ER16-F250	Standard Collet (IN)	0.211 - 0.250	5.4 - 6.4	Yes	1.083	0.679
ER16-F281	Standard Collet (IN)	0.242 - 0.281	6.1 - 7.1	Yes	1.083	0.679
ER16-F312	Standard Collet (IN)	0.273 - 0.312	6.9 - 7.9	Yes	1.083	0.679
ER16-F343	Standard Collet (IN)	0.304 - 0.343	7.7 - 8.7	Yes	1.083	0.679
ER16-F375	Standard Collet (IN)	0.336 - 0.375	8.5 - 9.5	Yes	1.083	0.679
ER16-11ST	11 Piece Standard Collet Set (IN)	-	-	-	-	-

# Velocity Mill Toolholding

## ER Collets



### ER20 Standard Collets



Part Number	Description	Size Range (IN)	Ref. Size Range (MM)	In ER20-15ST SET	L1 (IN)	D1 (IN)
<b>Models &amp; Dimensions</b>						
ER20-F062	Standard Collet (IN)	0.043 - 0.062	1.1 - 1.6	Yes	1.24	0.839
ER20-F093	Standard Collet (IN)	0.054 - 0.093	1.4 - 2.4	Yes	1.24	0.839
ER20-F125	Standard Collet (IN)	0.086 - 0.125	2.2 - 3.2	Yes	1.24	0.839
ER20-F156	Standard Collet (IN)	0.117 - 0.156	3.0 - 4.0	Yes	1.24	0.839
ER20-F187	Standard Collet (IN)	0.148 - 0.187	3.8 - 4.7	Yes	1.24	0.839
ER20-F218	Standard Collet (IN)	0.179 - 0.218	4.5 - 5.5	Yes	1.24	0.839
ER20-F250	Standard Collet (IN)	0.211 - 0.250	5.4 - 6.4	Yes	1.24	0.839
ER20-F281	Standard Collet (IN)	0.242 - 0.281	6.1 - 7.1	Yes	1.24	0.839
ER20-F312	Standard Collet (IN)	0.273 - 0.312	6.9 - 7.9	Yes	1.24	0.839
ER20-F343	Standard Collet (IN)	0.304 - 0.343	7.7 - 8.7	Yes	1.24	0.839
ER20-F375	Standard Collet (IN)	0.336 - 0.375	8.5 - 9.5	Yes	1.24	0.839
ER20-F406	Standard Collet (IN)	0.367 - 0.406	9.3 - 10.3	Yes	1.24	0.839
ER20-F437	Standard Collet (IN)	0.398 - 0.437	10.1 - 11.1	Yes	1.24	0.839
ER20-F468	Standard Collet (IN)	0.429 - 0.468	10.9 - 11.9	Yes	1.24	0.839
ER20-F500	Standard Collet (IN)	0.461 - 0.500	11.7 - 12.7	Yes	1.24	0.839
ER20-15ST	15 Piece Standard Collet Set (IN)	-	-	-	-	-

# Velocity Mill Toolholding

## ER Collets



### ER25 Standard Collets



Part Number	Description	Size Range (IN)	Ref. Size Range (MM)	In ER11-03ST SET	L1 (IN)	D1 (IN)
<b>Models &amp; Dimensions</b>						
ER32-F125	Standard Collet (IN)	0.086 - 0.125	2.2 - 3.2	Yes	1.575	1.313
ER32-F187	Standard Collet (IN)	0.148 - 0.187	3.8 - 4.7	Yes	1.575	1.313
ER32-F250	Standard Collet (IN)	0.211 - 0.250	5.4 - 6.4	Yes	1.575	1.313
ER32-F312	Standard Collet (IN)	0.273 - 0.312	6.9 - 7.9	Yes	1.575	1.313
ER32-F375	Standard Collet (IN)	0.336 - 0.375	8.5 - 9.5	Yes	1.575	1.313
ER32-F437	Standard Collet (IN)	0.398 - 0.437	10.1 - 11.1	Yes	1.575	1.313
ER32-F500	Standard Collet (IN)	0.461 - 0.500	11.7 - 12.7	Yes	1.575	1.313
ER32-F562	Standard Collet (IN)	0.523 - 0.562	13.3 - 14.3	Yes	1.575	1.313
ER32-F625	Standard Collet (IN)	0.586 - 0.625	14.9 - 15.9	Yes	1.575	1.313
ER32-F687	Standard Collet (IN)	0.648 - 0.687	16.5 - 17.4	Yes	1.575	1.313
ER32-F750	Standard Collet (IN)	0.711 - 0.750	18.0 - 19.0	Yes	1.575	1.313
ER32-11ST	11 Piece Standard Collet Set (IN)	-	-	-	-	-

### ER32 Standard Collets



Part Number	Description	Size Range (IN)	Ref. Size Range (MM)	In ER16-11ST SET	L1 (IN)	D1 (IN)
<b>Models &amp; Dimensions</b>						
ER32-F125	Standard Collet (IN)	0.086 - 0.125	2.2 - 3.2	Yes	1.575	1.313
ER32-F187	Standard Collet (IN)	0.148 - 0.187	3.8 - 4.7	Yes	1.575	1.313
ER32-F250	Standard Collet (IN)	0.211 - 0.250	5.4 - 6.4	Yes	1.575	1.313
ER32-F312	Standard Collet (IN)	0.273 - 0.312	6.9 - 7.9	Yes	1.575	1.313

# Velocity Mill Toolholding

## ER Collets



### ER32 Standard Collets (Continued)

Part Number	Description	Size Range (IN)	Ref. Size Range (MM)	In ER16-11ST SET	L1 (IN)	D1 (IN)
<b>Models &amp; Dimensions</b>						
ER32-F375	Standard Collet (IN)	0.336 - 0.375	8.5 - 9.5	Yes	1.575	1.313
ER32-F437	Standard Collet (IN)	0.398 - 0.437	10.1 - 11.1	Yes	1.575	1.313
ER32-F500	Standard Collet (IN)	0.461 - 0.500	11.7 - 12.7	Yes	1.575	1.313
ER32-F562	Standard Collet (IN)	0.523 - 0.562	13.3 - 14.3	Yes	1.575	1.313
ER32-F625	Standard Collet (IN)	0.586 - 0.625	14.9 - 15.9	Yes	1.575	1.313
ER32-F687	Standard Collet (IN)	0.648 - 0.687	16.5 - 17.4	Yes	1.575	1.313
ER32-F750	Standard Collet (IN)	0.711 - 0.750	18.0 - 19.0	Yes	1.575	1.313
ER32-11ST	11 Piece Standard Collet Set (IN)	-	-	-	-	-

### ER40 Standard Collets



Part Number	Description	Size Range (IN)	Ref. Size Range (MM)	In ER40-15ST SET	L1 (IN)	D1 (IN)
<b>Models &amp; Dimensions</b>						
ER40-F125	Standard Collet (IN)	0.086 - 0.125	2.2 - 3.2	Yes	1.811	1.614
ER40-F187	Standard Collet (IN)	0.148 - 0.187	3.8 - 4.7	Yes	1.811	1.614
ER40-F250	Standard Collet (IN)	0.211 - 0.250	5.4 - 6.4	Yes	1.811	1.614
ER40-F312	Standard Collet (IN)	0.273 - 0.312	6.9 - 7.9	Yes	1.811	1.614
ER40-F375	Standard Collet (IN)	0.336 - 0.375	8.5 - 9.5	Yes	1.811	1.614
ER40-F437	Standard Collet (IN)	0.398 - 0.437	10.1 - 11.1	Yes	1.811	1.614
ER40-F500	Standard Collet (IN)	0.461 - 0.500	11.7 - 12.7	Yes	1.811	1.614
ER40-F562	Standard Collet (IN)	0.523 - 0.562	13.3 - 14.3	Yes	1.811	1.614
ER40-F625	Standard Collet (IN)	0.586 - 0.625	14.9 - 15.9	Yes	1.811	1.614
ER40-F687	Standard Collet (IN)	0.648 - 0.687	16.5 - 17.4	Yes	1.811	1.614
ER40-F750	Standard Collet (IN)	0.711 - 0.750	18.0 - 19.0	Yes	1.811	1.614
ER40-F812	Standard Collet (IN)	0.774 - 0.812	19.7 - 20.6	Yes	1.811	1.614
ER40-F875	Standard Collet (IN)	0.836 - 0.875	21.2 - 22.2	Yes	1.811	1.614
ER40-F937	Standard Collet (IN)	0.899 - 0.937	22.8 - 23.8	Yes	1.811	1.614
ER40-F100	Standard Collet (IN)	0.961 - 1.000	24.4 - 25.4	Yes	1.811	1.614
ER40-15ST	15 Piece Standard Collet Set (IN)	-	-	-	-	-

# Velocity Mill Toolholding

## Accessories

# LOKUMA

Collet Tool Fixture for CT40



**Part Number**

V03-E8-0281

**CT40 Dimensions (IN)**

6.40 x 4.75 (H x W)

**List Price**

Contact Velocity Sales

### Quick and Easy Lock-in System

The fastest and easiest on the market, securely locking your tool in place in seconds.

### Made in the U.S.A.

Produced and assembled entirely in the United States using all domestic materials.

### Economical

Innovative, affordable, and time-saving for all machining centers

Collet Tool Fixture for CT50



**Part Number**

V03-E8-0291

**CT50 Dimensions (IN)**

9.0 x 11.0 (H x W)

**List Price**

Contact Velocity Sales

# Velocity Mill Toolholding

## Accessories

**OKUMA**

### Velocity CNC Chip Cleaning Fan



Part Number	Shank Size	Operating Speed	Tool Length	Ø With Open Blades
V04-F6-2311	0.750"	5,000 - 8,000 RPM	5.5" (142mm)	10.0" (254mm)



### Product Detail

Keep your machining area chip-free with the Velocity CNC Chip Cleaning Fans. Designed for simple spindle attachment, these fans clear away chips efficiently, complemented by a through-coolant system for enhanced cleaning. Installation is easy: fit the fan into an endmill or collet holder, store it in the machine's automatic tool changer (ATC), and use it as needed.

## Chip & Coolant Cleaning Made Easy

Our chip cleaning fan operates at 5,000 to 8,000 RPM (with 6,000 RPM optimal for most applications), generating high-speed airflow to clear chips and coolant from the work area. Combined with Through-Spindle-Coolant, it keeps the workpiece and machine table clean, reducing tool damage and ensuring CNC precision.

Built for durability, the fan features a 4140 steel mounting shank for a secure fit on Okuma machines and glass fiber-reinforced nylon blades for long-lasting performance. Its through-coolant function delivers a powerful clean, minimizing downtime. Installation is effortless: just mount it in an endmill or collet holder, & it's ready to go.

**VELOCITY**

VELOCITYPRODUCTS.COM

## Velocity Mill Toolholding: Exclusively for Okuma

Velocity Products, a leading supplier in the machine tool industry, is proud to offer the most comprehensive inventory of mill toolholding solutions for Okuma in North America. As the official OEM supplier of startup tooling kits for Okuma machines, Velocity Products has built a strong reputation for precision and reliability. Developed in collaboration with Okuma America, Okuma Japan, and Okuma Europe, Velocity Tooling ensures seamless integration with Okuma multitasking machines and machining centers. These premium toolholders are engineered for maximum performance and longevity.

## Innovative Velocity Toolholding Technology

Velocity toolholders are designed with accuracy and efficiency in mind. Each ER Collet Chuck, Shell Mill Holder, and Test Bar undergoes strict quality assurance, ensuring superior rigidity and runout control. Live tools are pre-run-in from the factory for immediate use, and internal coolant tools are pressure-tested for reliability. All Velocity tools feature greased-for-life components, eliminating customer maintenance. To ensure the highest precision, every tool is CMM-inspected and serialized for traceability.



## Three-Year Warranty

Velocity Tooling is meticulously designed for longevity, withstanding even the most demanding applications. Backed by a Three-Year Factory Warranty, Velocity guarantees to repair or replace any defective toolholder, reinforcing its commitment to quality and customer satisfaction. All service and repairs are performed in the United States at Velocity's certified repair facility, ensuring fast turnaround times.

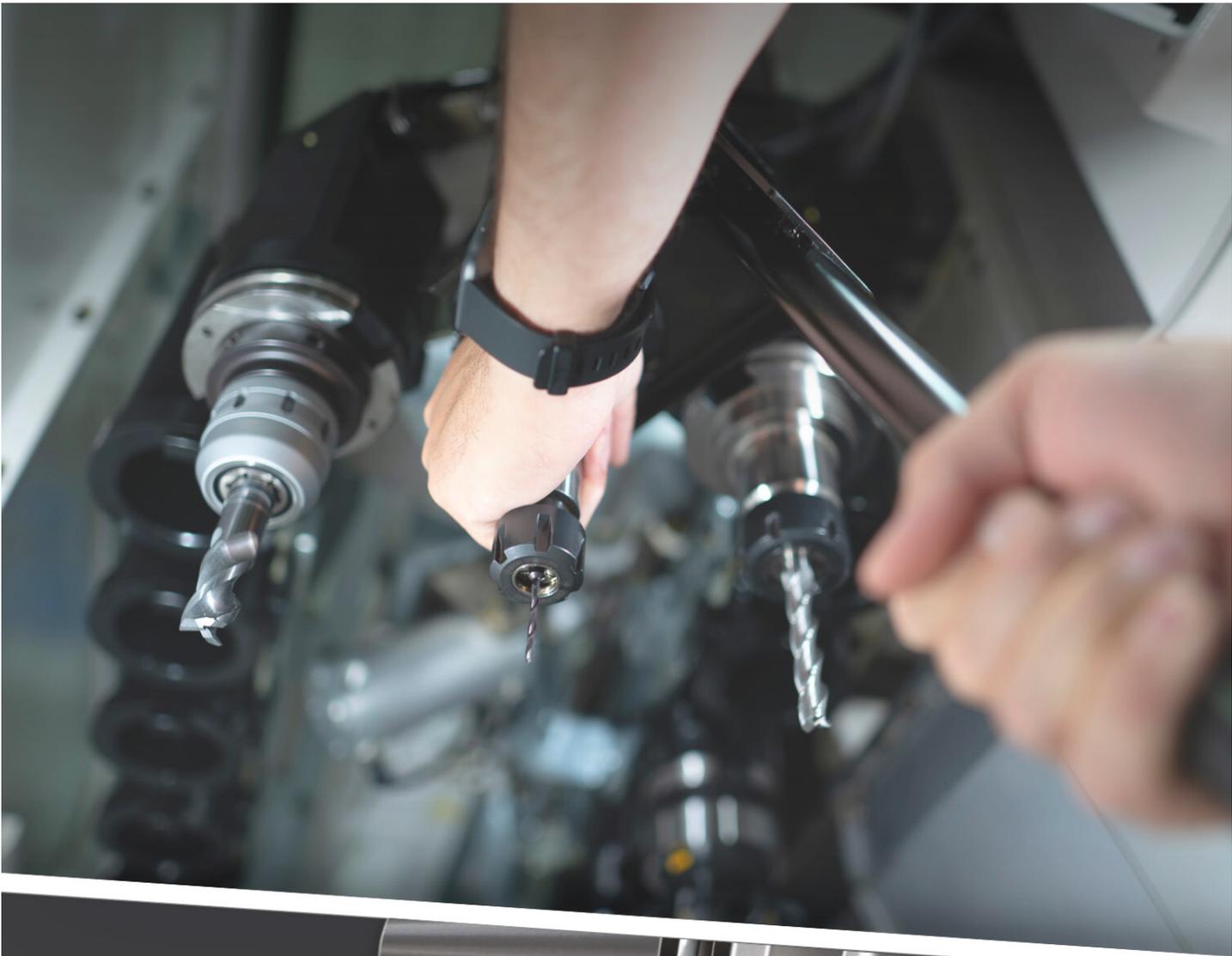
## Continuous Improvement & Customer Support

Velocity Products is committed to innovation and ongoing product development. With direct collaboration between Velocity engineers and Okuma teams worldwide, toolholding solutions continuously evolve to meet the latest machining advancements. Additionally, Velocity provides:

- Technical support & training
- Application guidance for tool selection
- Custom solutions for specialized machining

Velocity Tooling is the exclusive toolholding solution for Okuma machining centers, delivering precision, reliability, and innovation in every toolholder. Whether it's ER collet chucks, shell mill holders, or advanced milling solutions, Velocity provides Okuma users with the best-in-class tooling solutions to maintain a competitive edge.





VELOCITY PRODUCTS  
**MILL TOOLHOLDING  
COLLETS & FIXTURES**

---

Velocity Products • 3611 Jack Kendall Way, Huntsville, AL 35806 • 256-258-5549

[www.velocityproducts.com](http://www.velocityproducts.com) • [sales@velocityproducts.com](mailto:sales@velocityproducts.com)

© Velocity Products • Specifications subject to change without notice