

MASS TIMBER CUTTING TOOLS



Introducing North American’s first line of stock cutting tools, dedicated to the needs of the Mass Timber Industry. Royce//Ayr precision products are designed and manufactured in North America’s most comprehensive cutting tool production facility and supported by a technical team of application specialists.

- Complete tool selection and performance consultation for challenging applications
- Virtual or on-site application support to achieve optimal tool performance
- Balancing services for high RPM tooling
- Spindle health and assesment services



Polycrystalline Diamond Cutters and Routers



Precision Tool Holding Systems



Carbide Indexable Inserts Cutters and Routers



Advanced Solid Carbide Router Geometry



Saw Blades & Holders

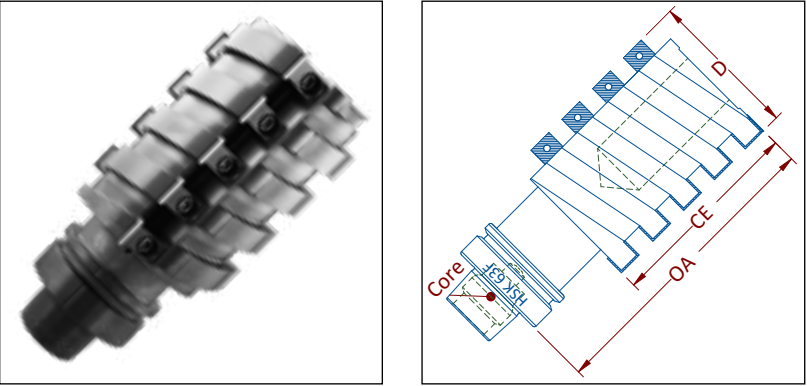


MADE IN NORTH AMERICA





Insert Hogging “510HI” Integrated Tool



Best suited for hogging solid wood on CNC routers. Inserts can be rotated when dull. Tool has spurs to allow rebating. Reduce cycle times by utilizing the high removal rates. Integrated tool design for maximum tool strength and reduced run out.

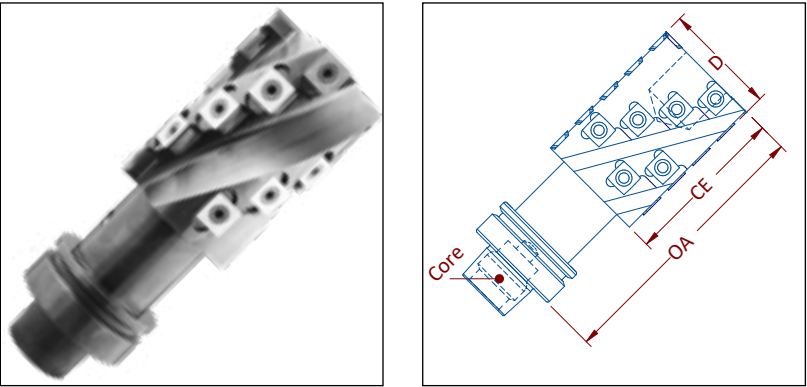
PART#	D	CE	Core	Z	OA
510HI-090.120.63F2	90mm	120mm	HSK63F	2+2+2	180mm

Weight: 10.9 lbs

Replacement Parts

PART#	Description
590-0150	insert knives
581-26800-12	gibs
580.HC-M5016	gib screws
592-1414	spur knives
580.CST-M4067.TX	spur screws

Insert Hogging “533FI” Integrated Tool



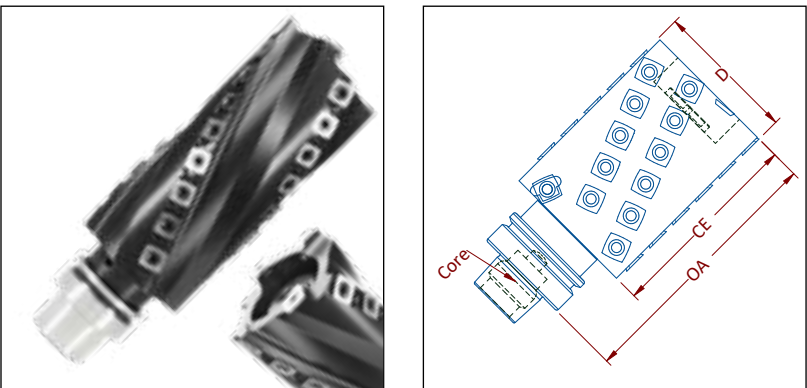
Best suited for hogging solid wood on CNC routers. Inserts can be rotated 4 times when dull. Tool has spurs to allow rebating. Reduce cycle times by utilizing the high removal rates. Integrated tool design for maximum tool strength and reduced run out. Lighter design than the 510HI tool above. Spiralex design allows smaller diameter.

PART#	D	CE	Core	Z	OA
533FI.070.100-63F2	70mm	100mm	HSK63F	2	170mm

Replacement Parts

PART#	Description
592-0007	insert knives
580.SHD-M5014-T20	knife screws
592-1414	spur knives
580.CST-M4067.TX	spur screws

Insert Hogging Lightweight Extended Tool



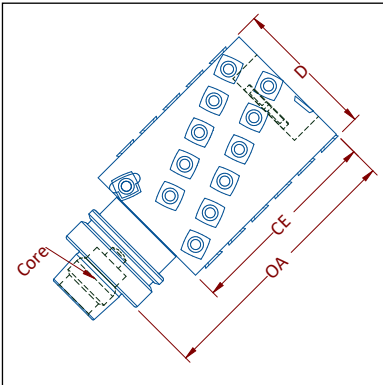
Best suited for hogging solid wood on CNC routers. Inserts can be rotated 4 times when dull. Tool has spurs to allow rebating. Reduce cycle times by utilizing the high removal rates. Aluminum body for lightweight design.

PART#	D	CE	Core	Z	OA
533H.090.120.63F2	90mm	200mm	POR	2+2+2	248mm

Replacement Parts

PART#	Description
592-0007-R50	insert knives
580.CST-M6016.ELBE	knife screws

Insert Hogging Lightweight Tool



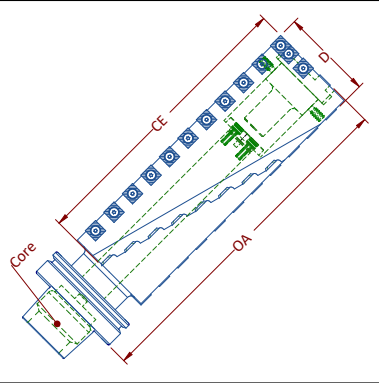
Best suited for hogging solid wood on CNC routers. Inserts can be rotated 4 times when dull. Tool has spurs to allow rebating. Reduce cycle times by utilizing the high removal rates. Aluminum body for lightweight design.

Replacement Parts

PART#	D	CE	Core	Z	OA
533H.090.120.63F2	90mm	128mm	HSK63F	2+2+2	170mm

PART#	Description
592-0007-R50	insert knives
580.CST-M6016.ELBE	knife screws

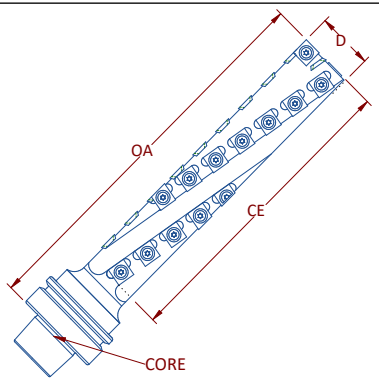
Insert Slow Spiral Hogger



Hogging and rebating CLT panels. For removing large amounts of material. Well suited for cutouts, holes and sizing of panels.

PART#	D	CE	Core	Z	OA
73616	89mm	280mm	POR	2+2	330mm

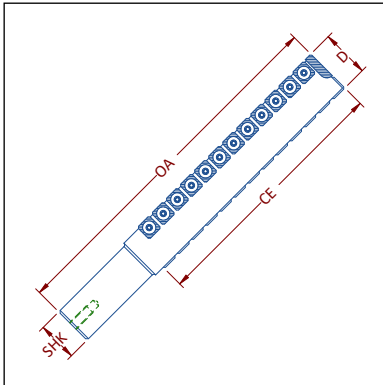
Insert Integrated Hogger



Hogging and rebating CLT panels. For removing large amounts of material. Well suited for cutouts, holes and sizing of panels.

PART#	D	CE	Core	Z	OA
69581	40mm	210mm	HSK63E or HSK63F	1+1+1	254mm

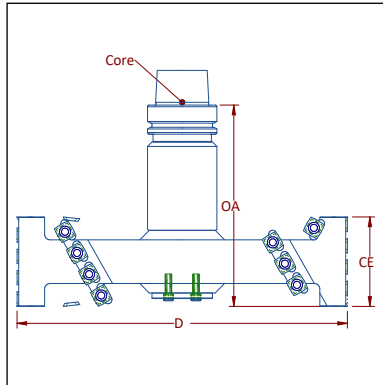
Insert Hogger



Hogging and rebating CLT panels, for removing large amounts of material. Well suited for cutouts and holes in panels. Indexable inserts can be rotated when dull.

PART#	D	CE	SHK	Z	OA
74701	30mm	160mm	25mm	1+1	228mm

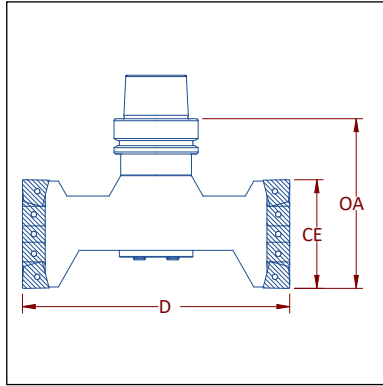
Hogging Rebating Spiral



Hogging and rebating CLT panels, for removing large amounts of material. Tool can surface material.

PART#	D	CE	Core	Z	OA
74435	300mm	80mm	POR	6+6+6	180mm

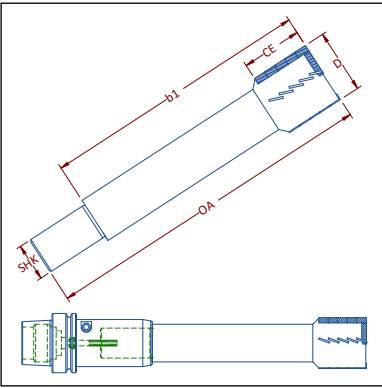
Hogging Rebating Heavy Cut



Hogging and rebating CLT panels, for removing large amounts of material. Tool can surface material.

PART#	D	CE	Core	Z	OA
72645	200mm	80mm	HSK63E or HSK63F	4+4+4	125mm

PCD Diamond Pocketing Tool



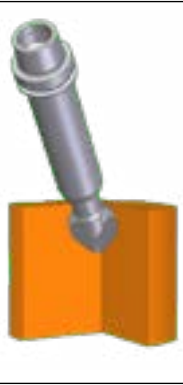
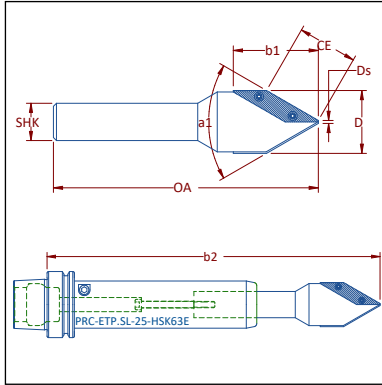
Polycrystalline Diamond Tool with 2+2 staggered wing design. excellent tool for interpolating and cutting deep pockets in mass timber. Diamond tips result in extended tool life and wear resistance.

TOOL HOLDER SOLD SEPERATE



PART#	D	CE	b1	SHK	Z	OA
D11036	54mm	50mm	227mm	1-1/4"	2+2	280mm
D10810	54mm	50mm	128mm	25mm	2+2	188mm

Corner Cleaning Tool



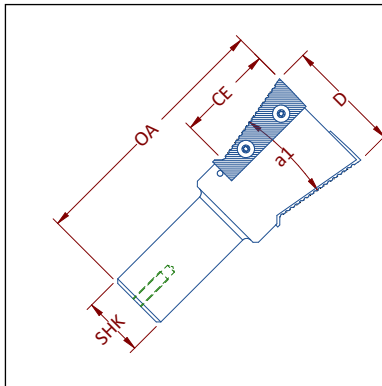
Insert router bit designed for cleaning corners of pockets and window cutouts in mass timber productions.

Replacement Parts

PART#	Description
592-0007	knives
580.CST-M4067.TX	knife screws

PART#	D	Ds	CE	a1	b1	b2	OA	SHK
73382	42mm	2mm	40mm	60°	57mm	HSK63F	317mm	25mm

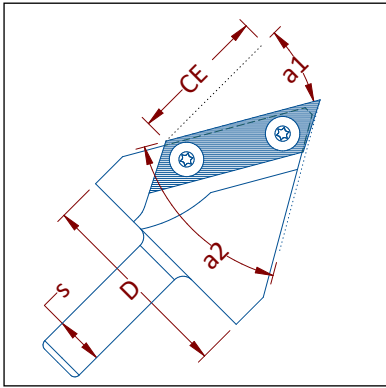
Dovetail Tool



Designed to produce precision dovetail joinery at high feedrates. Chipbreaking cutting edge geometry reduced cutting forces and reduces cross grain tearout

PART#	D	CE	OA	a1	Z	SHK
74434	60mm	2"	5-1/4"	20°	3	1-1/4"

V-Groove Router Bits



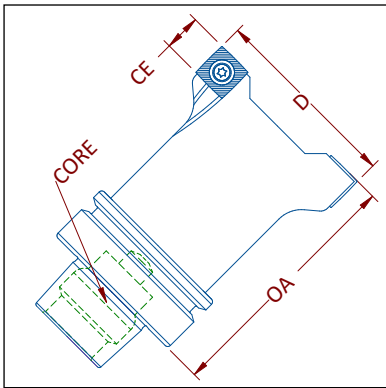
1 and 2 wing insert router with varying cutting angles. Great for doing folding applications on CNC routers in Solid Wood, MDF and Particle Board. 44.75° tool designed to produce 90° corner with a tight close on outside.

Replacement Parts

PART#	Description
580.RH-M3505.9	knife screws

PART#	D	CE	a1	a2	s	Z	Knife#
563-V23.060	35mm	1.675"	22.50°	45.00°	1/2	1	595V-6012R-23
563-V30.050	52mm	1.420"	30.00°	60.00°	1/2	1	595V-5012R-30
563-V45.030	40mm	.800"	45.00°	90.00°	1/2	1	595V-3012R
563-V45.050	75mm	1.360"	45.00°	90.00°	3/4	1	595V-5012R
563-V46.030	40mm	.800"	45.25°	90.50°	1/2	1	595V-3012R
563-V46.050	75mm	1.350"	45.25°	90.50°	3/4	1	595V-5012R
563.V60.030	57mm	.560"	60.00°	120.00°	1/2	1	595V-3012R
563-V60.050	90mm	.960"	60.00°	120.00°	3/4	1	595V-5012R
563-V65.050	95mm	.810"	65.00°	130.00°	3/4	1	595V-5012R
563-V75.030	62mm	.305"	75.00°	150.00°	1/2	2	590-0300
563-V75.050	100mm	.500"	75.00°	150.00°	3/4	2	590-0500

Insert Integrated Surfacing Tool “563SI”



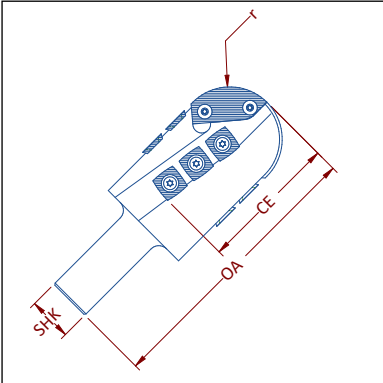
Insert router bit designed for surfacing and pocketing applications. “Integrated” tool design eliminates any run out and deflection generated by collet interface. Extremely rigid tool has radius inserts for improved bottom finish.

Replacement Parts

PART#	Description
592-0007	knives
580.CST-M4067.TX	knife screws

PART#	D	CE	CORE	OA	Z	Weight
563SI.075.14-63F3	3	.551"	HSK63F	100mm	3	4 lbs
563SI.100.14-63F3	4	.590"	HSK63F	100mm	3	4.5 lbs

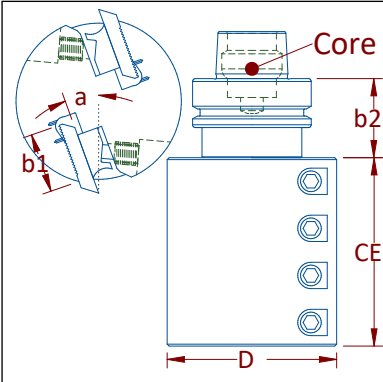
Ballnose Insert Tool



Ballnose tool for router mass timber. Radius inserts on tip are single use. Other inserts can be rotated 4 times.

PART#	D	CE	OA	r	Z	SHK
74066	60mm	80mm	160mm	30mm	2+2	25mm

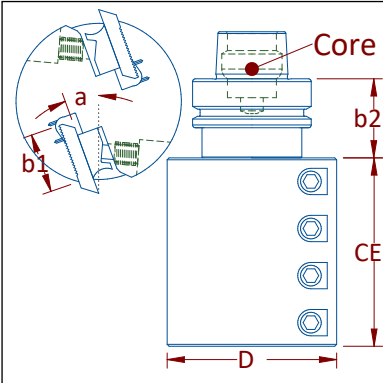
Integrated Corrugated Router Tool



Ideal for small jobs on 5-axis CNC routers. Standard 579 series corrugated knives can be run in head. Head can also support carbide Bak-Pak knives or carbide inlay knives. Knives are profiled per customer request. Ideal for profiling smaller jobs on CNC router.

PART#	D	CE	Core	b1	b2	a	Z	Weight
573R-090100R2-20	90mm	100mm	HSK63F	35mm	42mm	20°	2	10 lbs

Lightweight Corrugated Router Tool



Ideal for small jobs on 5-axis CNC routers. Standard 579 series corrugated knives can be run in head. Head can also support carbide Bak-Pak knives or carbide inlay knives. Knives are profiled per customer request. Ideal for profiling smaller jobs on CNC router. Aluminum body for reduced weight.

PART#	D	CE	Core	b1	b2	a	Z	Weight
573RA-100150R2-20	90mm	150mm	HSK63F	35mm	46mm	20°	2	10.5 lbs

Solid Carbide Finisher Spiral



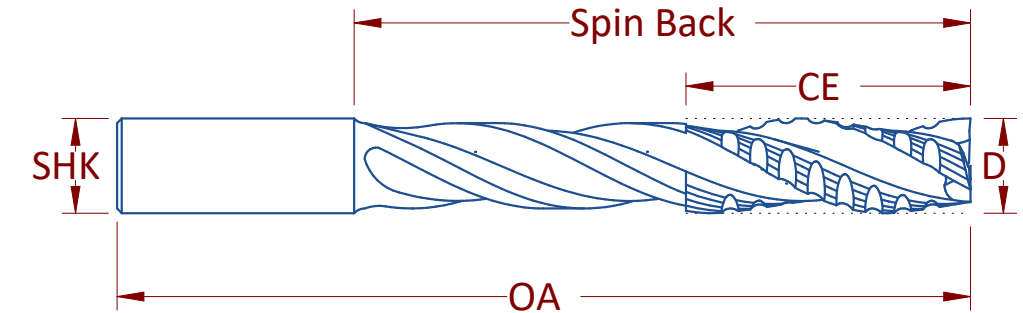
Finishing tool designed with chipbreaker / finisher geometry to reduce cross grain tear out. Very effective for machining endgrain on beams or any curved components with premium surface finish

METRIC

PART#	D	CE	Z	SHK	OA	SB	Rotation
72551	16mm	30mm	3	20mm	203mm	130mm	Right Hand
72567A	20mm	60mm	3	20mm	130mm	NO	Right Hand
72567B	20mm	60mm	3	20mm	180mm	130mm	Right Hand
R60-32304UM	25mm	140mm	3	25mm	200mm	NO	Right Hand
R60-32304UM-LH	25mm	140mm	3	25mm	200mm	NO	Left Hand
R60-32318UM	30mm	165mm	3	25mm	235mm	NO	Right Hand
R60-32319UM	30mm	165mm	3	1-1/4"	235mm	NO	Right Hand
69580	40mm	160mm	3	30mm	235mm	NO	Right Hand
R60-32322UM	40mm	190mm	3	30mm	250mm	NO	Right Hand
R60-32324UM	40mm	190mm	3	1-1/4"	250mm	NO	Right Hand

IMPERIAL

PART#	D	CE	Z	SHK	OA	SB	Rotation
R60-32108UM	3/4"	3-1/8"	3	3/4"	6"	NO	Right Hand

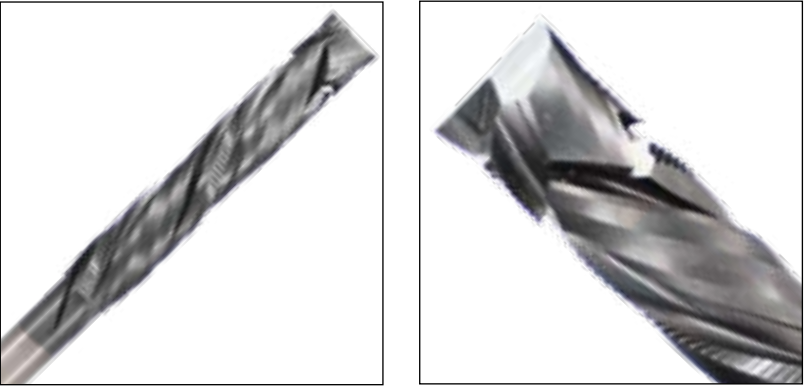


Diamond Hogging Spiral

Designed for mortising side of doors to hold lock sets. PCD cutting edge for long life in engineered materials. Solid carbide body.

PART #	DIA	CEL	LOF	SHK	OAL
R230-007	3/4	7/8	4-7/8	3/4	7

Solid Carbide Compression Rougher Finisher



Finishing tool designed with chipbreaker / finisher geometry to reduce cross grain tear out. Very effective for machining endgrain on beams or any curved components with premium surface finish. 2 Roughing flutes and 2 finishing flutes.

PART#	D	CE	SHK	OA	Z
T0024	40mm	230mm	1-1/4"	330mm	2+2

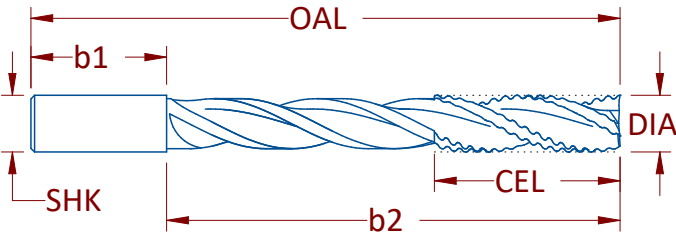


Designed for deep pocketing operations. Serrated tooth design to minimize horsepower required to cut. Spinback on tool allows relief to cut deep mortises.

Solid Carbide Hogging Spiral

PART #	DIA	CEL	b1	b2	SHK	OAL
R60-01732	3/8	1-1/8	1	3	3/8	4
R60-01742	1/2	1-1/2	1-1/2	4-1/2	1/2	6
R60-01751	5/8	2	2	5	5/8	7
R60-01751.LH	5/8	2	2	5	5/8	7
R60-01758	3/4	2	1-1/2	5-1/2	3/4	7

LH = left hand rotation



Carbide Tipped Hogging Spiral Tool



Hogging and rebating CLT panels, for removing large amounts of material. Well suited for cutouts and holes in panels. Carbide Tipped for more economical pricing.

PART#	D	CE	SHK	OA	Z
72482	40mm	182mm	1.25"	10"	256mm

Saw Blades



Sizing and length cutting in CLT panels. Various pinhole configurations available to fit most standard CLT blade holders.

PART #	D	K	PT	Bore	Z	Strobes	Pinholes	Machine
S7528	500mm	4.4mm	3.25mm	75mm	28	2+2+2	6cs/m8/100mmBC, 2/8mm/100mmBC	
S7962	500mm	5.4mm	3.6mm	30mm	48	2	4/10.5mm/90mmBC, 8cs/m6/130mmBC, 8cs/m6/160mm	SCM Oikos
S7767	555mm	5.2mm	3.6mm	50mm	54	2	8cs/m8/170mmBC	Weinman
S6406	640mm	5.4mm	3.60mm	30mm	36	2+2	4/10.5mm/90mmBC, 8cs/m6 90mmBC 8cs/m6/160mmBC	Biesse Uni Team
S7388	750mm	7.2mm	5.00mm	30mm	60	2+2+2	4/10.5mm/90mmBC, 8cs/m6/90mmBC, 8cs/m6/160mmBC	Biesse Uni Team
S7772	800mm	7.4mm	5.15mm	40mm	48	2+2+2	2/12.14mm/200mmBC, 8/8.34mm/220mmBC	Hundegger PBA
S6405	850mm	8.0mm	6.00mm	30mm	42	2+2+2	4/10.5mm/90mmBC, 8cs/m6/90mmBC, 8cs/m6/160mmBC	Biesse Uni Team
S7866	850mm	7.8mm	5.50mm	30mm	60	2+2+2	2/8.5mm/140mmBC, 8cs/m8/140mmBC	Technowood
S6086	1000mm	6.5mm	5.00mm	60mm	80	None	4/9mm/90mmBC	

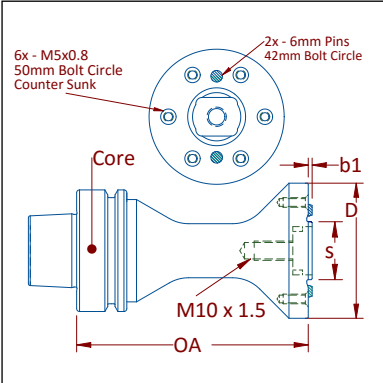
Saw Blade Holders



Saw holders for CLT machines. Can be made with various interfaces and bolt patterns.

PART#	D	d	Core	ph1	ph2	ph3	OA
7388-HOLDER	179mm	30mm	HSK63E	8 x CS for m6 160mm BC	8 x CS for m6 90mm BC	10mm pin on 90mm BC	57mm
Other configurations available upon request							

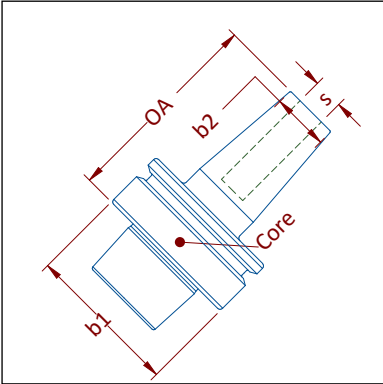
Standard Saw Arbor



Precision industrial saw arbor for CNC routers. Part includes cap and countersunk head mounting screws. Standard 30mm arbor and locking pins can be used to mount saw. If a flush mount is required 6 countersunk holes can be used with M5 screws for mounting. If flush mounting is required, saw needs to be modified with appropriate countersunk holes. If cap is used, selected 30mm bore RoyceAyr series S03 or S02 saws can be used.

PART#	D	s	b1	OA	Core
PRC-HSK63F-30120S	70mm	30mm	2mm	120mm	HSK63F

Shrink Fit Tool Holders HSK63F for CNC Routers



Shrink fit tool holders designed to fit on a variety of CNC machines with the HSK63F taper. Shrink fit provides superior clamping pressure and minimizes tool run out and vibration. Tool must be installed and removed using special heat shrink equipment.

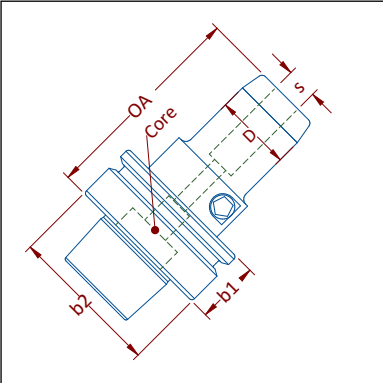
HSK 63E TAPERS AVAILABLE ON REQUEST



PART#	s	b1	OA	Core
PRC-SHRINK-HSK.1/4	1/4	63mm	80mm	HSK63F
PRC-SHRINK-HSK.3/8	3/8	63mm	95mm	HSK63F
PRC-SHRINK-HSK.1/2	1/2	63mm	95mm	HSK63F
PRC-SHRINK-HSK.1/2-S	1/2	63mm	76mm	HSK63F
PRC-SHRINK-HSK.5/8	5/8	63mm	95mm	HSK63F
PRC-SHRINK-HSK.3/4	3/4	63mm	100mm	HSK63F
PRC-SHRINK-HSK.3/4-S	3/4	63mm	76mm	HSK63F
PRC-SHRINK-HSK.1	1	63mm	115mm	HSK63F
PRC-SRK-HSK63E.1/2	1/2	63mm	75mm	HSK63E
PRC-SRK-HSK63E.3/4	3/4	63mm	75mm	HSK63E
PRC-SRK-HSK63E.5/4	1-1/4	63mm	105mm	HSK63E
PRC-SRK-HSK100A.5/4	1-1/4	100mm	120mm	HSK100A

PART#	s	b1	OA	Core
PRC-SRK-HSK63E.12M	12mm	63mm	75mm	HSK63E
PRC-SRK-HSK63E.16M	16mm	63mm	75mm	HSK63E
PRC-SRK-HSK63E.25M	25mm	63mm	90mm	HSK63E
PRC-SRK-HSK63E.30M	30mm	63mm	95mm	HSK63E
PRC-SRK-HSK63E.32M	32mm	63mm	90mm	HSK63E
PRC-SRK-HSK80EC.30M	30mm	80mm	95mm	HSK80EC
PRC-SRK-HSK80EC.32M	32mm	80mm	115mm	HSK80EC
PRC-SRK-HSK80EC.40M	40mm	80mm	115mm	HSK80EC

Hydraulic Tool Holders HSK63F



High precision hydraulic tool holders for a variety of different CNC machines. Hydraulic tool holders provide more rigidity and improved accuracy over conventional collet. Can provide up to 25% increase in tool life in optimum applications.



Imperial Sizes

PART#	s	D	OA	b1	b2	Core
PRC-ETP.G2-1/2-HSK63F	1/2	32mm	87mm	26mm	63mm	HSK63F
PRC-ETP.G2-5/8-HSK63F	5/8	38mm	87mm	26mm	63mm	HSK63F
PRC-ETP.G2-3/4-HSK63F	3/4	40mm	99mm	26mm	63mm	HSK63F
PRC-ETP.G2-1-HSK63F	1	45mm	103mm	26mm	63mm	HSK63F

Metric Sizes

PART#	s	D	OA	b1	b2	Core
PRC-ETP.G2-12-HSK63F	12mm	32mm	87mm	26mm	63mm	HSK63F
PRC-ETP.G2-20-HSK63F	20mm	40mm	99mm	26mm	63mm	HSK63F
PRC-ETP.G2-25-HSK63F	25mm	45mm	103mm	26mm	63mm	HSK63F

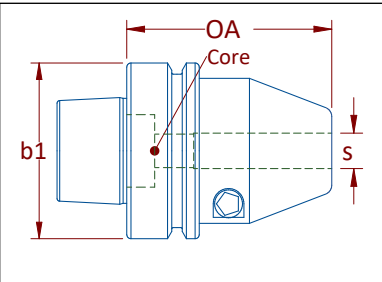
Compact Design

Imperial Sizes

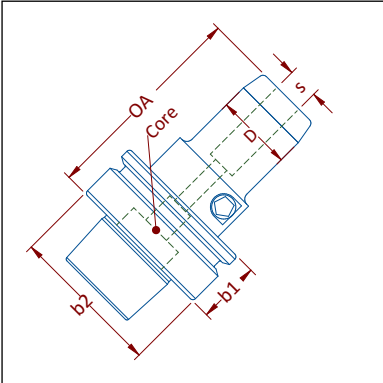
PART#	s	D	OA	b1	b2	Core
PRC-ETP.SM-1/2-HSK63F	1/2	22mm	75mm	26mm	63mm	HSK63F
PRC-ETP.SM-5/8-HSK63F	5/8	26mm	75mm	26mm	63mm	HSK63F
PRC-ETP.SM-3/4-HSK63F	3/4	30mm	75mm	26mm	63mm	HSK63F

Metric Sizes

PART#	s	D	OA	b1	b2	Core
PRC-ETP.SM-12-HSK63F	12mm	22mm	75mm	26mm	63mm	HSK63F
PRC-ETP.SM-16-HSK63F	16mm	26mm	75mm	26mm	63mm	HSK63F
PRC-ETP.SM-20-HSK63F	20mm	30mm	75mm	26mm	63mm	HSK63F



Hydraulic Tool Holders Heavy Grip



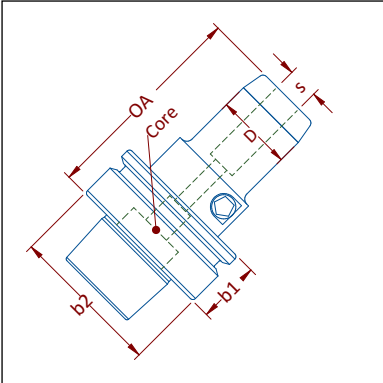
High precision hydraulic tool holders for a variety of different CNC machines. Hydraulic tool holders provide more rigidity and improved accuracy over conventional collet. Can provide up to 25% increase in tool life in optimum applications. Heavy Grip holders have increased clamping pressure for larger tools.



Imperial Sizes

PART#	s	D	OA	b2	Core
PRC-ETP.HG5/4-HSK63E	1-1/4"	80mm	109mm	63mm	HSK63E
PRC-ETP.HG5/4-HSK80F	1-1/4"	80mm	106mm	80mm	HSK80F

Hydraulic Tool Holders Slender Version



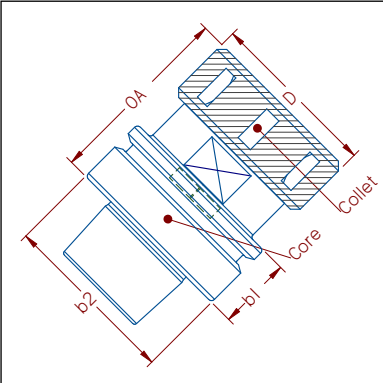
High precision hydraulic tool holders for a variety of different CNC machines. Hydraulic tool holders provide more rigidity and improved accuracy over conventional collet. Can provide up to 25% increase in tool life in optimum applications. Extended length holders for optimum reach.



Imperial Sizes

PART#	s	D	OA	b2	Core
PRC-ETP.SL-20-HSK63E	20mm	40mm	99mm	63mm	HSK63E
PRC-ETP.SL-25-HSK63E	25mm	50mm	200mm	63mm	HSK63E
PRC-ETP.SL5/4-HSK63E	1-1/4"	50mm	106mm	63mm	HSK63E
PRC-ETP.SL-25-HSK80F	25mm	50mm	300mm	80mm	HSK80F

Precision HSK63F Tool Holders for CNC Machines

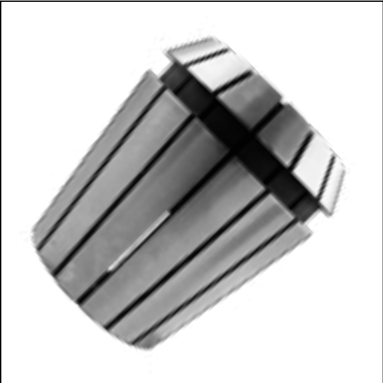


High precision tool holders for a variety of different CNC machines. Tool holders include nut but do not include collet.

PART#	D	OA	b1	b2	Core	Collet	Nut
PRC-HSK63F-16(ER32)	50mm	73mm	26mm	63mm	HSK63F	ER32	coated
PRC-HSK63F-16(ER32)L	50mm	73mm	26mm	63mm	HSK63F	ER32	coated
PRC-HSK63F-20(ER40)	63mm	77mm	26mm	63mm	HSK63F	ER40	coated
PRC-HSK63F-20 LH	63mm	77mm	26mm	63mm	HSK63F	ER40	coated
PRC-HSK63F-38 (ORT25)	58mm	73mm	26mm	63mm	HSK63F	ORT25 (SYOZ25)	bearing
PRC-HSK63F-38L (ORT25)	58mm	73mm	26mm	63mm	HSK63F	ORT25 (SYOZ25)	bearing

LH & L = Left hand rotation

Precision ER Collet



All collets conform to DIN 6388 standards. Collet should be snapped into the nut before screwing the nut onto the tool holder.

Imperial Sizes

SIZE	ER11	ER16	ER20	ER25	ER32	ER40
1/32	PRC-310.0031					
1/16	PRC-310.0063	PRC-320.0063	PRC-330.0063	PRC-340.0063	PRC-350.0063	
1/8	PRC-310.0125	PRC-320.0125	PRC-330.0125	PRC-340.0125	PRC-350.0125	PRC-375.0125
3/16	PRC-310.0188	PRC-320.0188	PRC-330.0188	PRC-340.0188	PRC-350.0188	PRC-375.0188
1/4		PRC-320.0250	PRC-330.0250	PRC-340.0250	PRC-350.0250	PRC-375.0250
5/16		PRC-320.0313	PRC-330.0313	PRC-340.0313	PRC-350.0313	PRC-375.0313
3/8		PRC-320.0375	PRC-330.0375	PRC-340.0375	PRC-350.0375	PRC-375.0375
7/16			PRC-330.0438	PRC-340.0438	PRC-350.0438	PRC-375.0438
1/2			PRC-330.0500	PRC-340.0500	PRC-350.0500	PRC-375.0500
9/16				PRC-340.0563	PRC-350.0563	PRC-375.0563
5/8				PRC-340.0625	PRC-350.0625	PRC-375.0625
3/4					PRC-350.0750	PRC-375.0750
7/8						PRC-375.0875
1						PRC-375.1000

Metric Sizes

SIZE	ER11	ER16	ER20	ER25	ER32	ER40
3mm	PRC-310.M030	PRC-320.M030	PRC-330.M030	PRC-340.M030	PRC-350.M030	
4mm	PRC-310.M040	PRC-320.M040	PRC-330.M040	PRC-340.M040	PRC-350.M040	PRC-375.M040
6mm	PRC-310.M060	PRC-320.M060	PRC-330.M060	PRC-340.M060	PRC-350.M060	PRC-375.M060
8mm		PRC-320.M080	PRC-330.M080	PRC-340.M080	PRC-350.M080	PRC-375.M080
9mm		PRC-320.M090	PRC-330.M090	PRC-340.M090	PRC-350.M090	PRC-375.M090
10mm		PRC-320.M100	PRC-330.M100	PRC-340.M100	PRC-350.M100	PRC-375.M100
12mm			PRC-330.M120	PRC-340.M120	PRC-350.M120	PRC-375.M120
13mm				PRC-340.M130	PRC-350.M130	PRC-375.M130
14mm				PRC-340.M140	PRC-350.M140	PRC-375.M140
16mm					PRC-350.M160	PRC-375.M160
19mm					PRC-350.M190	PRC-375.M190
20mm					PRC-350.M200	PRC-375.M200
25mm						PRC-375.M250

Precision SYOZ Collet



All collets conform to DIN 6388 standards. Collet should be snapped into the nut before screwing the nut onto the tool holder.

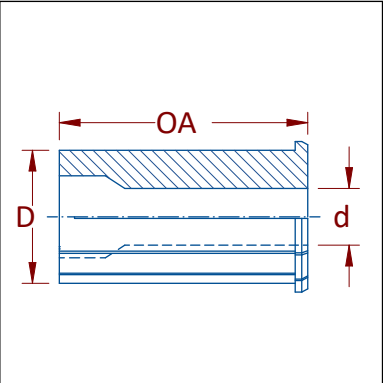
Imperial

SIZE	SYOZ 20	SYOZ 25
1/8	PRC-410.0125	PRC-400.0125
3/16	PRC-410.0188	PRC-400.0188
1/4	PRC-410.0250	PRC-400.0250
5/16		PRC-400.0313
3/8	PRC-410.0375	PRC-400.0375
7/16		PRC-400.0438
1/2	PRC-410.0500	PRC-400.0500
9/16		PRC-400.0563
5/8		PRC-400.0625
3/4		PRC-400.0750
7/8		PRC-400.0875
1		PRC-400.1000

Metric

SIZE	SYOZ 25
3mm	PRC-400.M030
4mm	PRC-400.M040
5mm	PRC-400.M050
6mm	PRC-400.M060
8mm	PRC-400.M080
9mm	PRC-400.M090
10mm	PRC-400.M100
12mm	PRC-400.M120
13mm	PRC-400.M130
14mm	PRC-400.M140
16mm	PRC-400.M160
19mm	PRC-400.M190
20mm	PRC-400.M200
25mm	PRC-400.M250

Hydraulic Reduction Collets



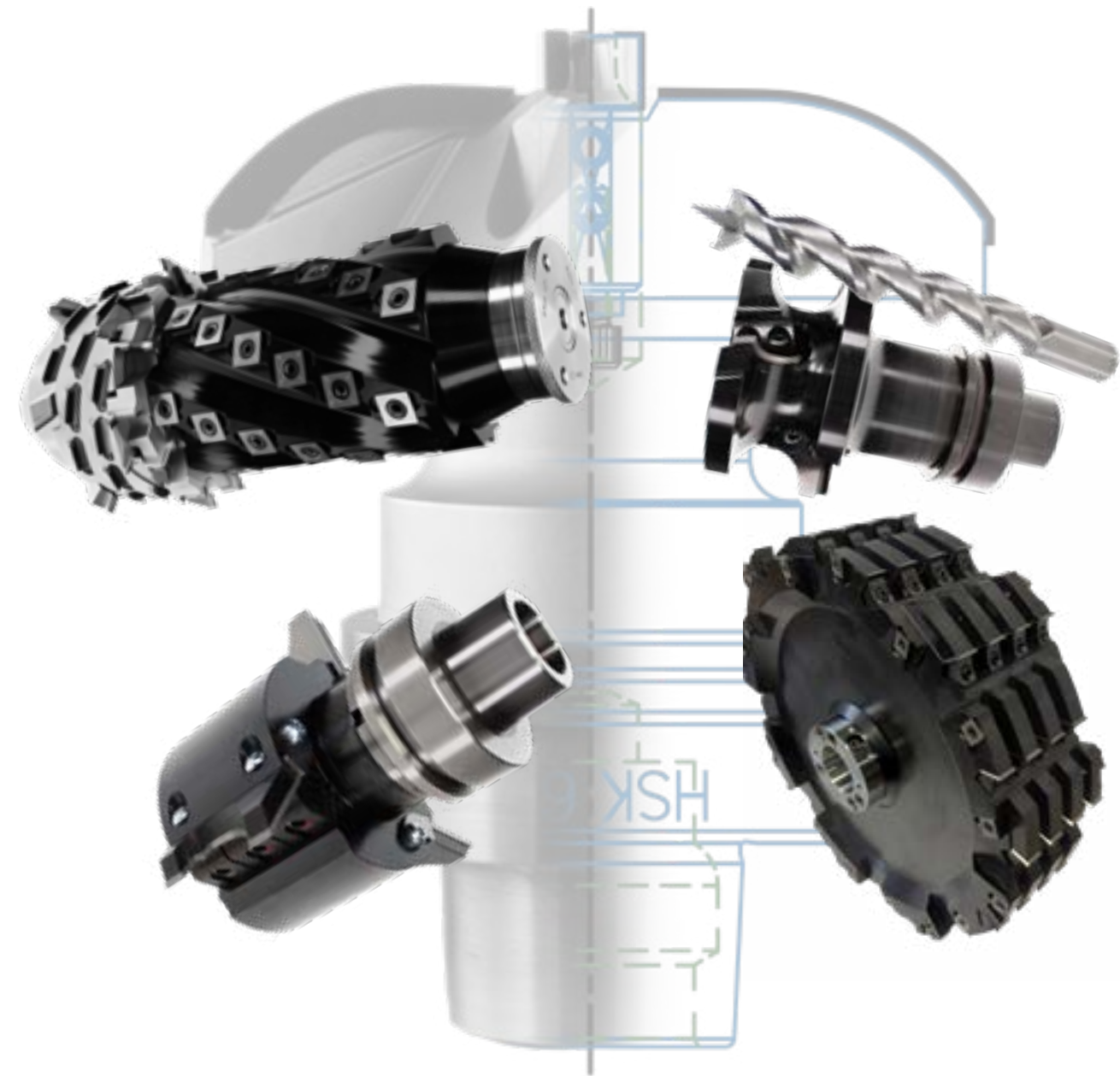
Hydraulic reduction collets for use in hydraulic holders. Works to run smaller diameter shanks in larger hydraulic holders. Also works in Turbotec holder.

PART#	D	d	OA	PART#	D	d	OA
PRC-460.050.0250	1/2	1/4	2-1/8	PRC-460.075.0375	3/4	3/8	2-1/8
PRC-460.050.0375	1/2	3/8	2-1/8	PRC-460.075.0500	3/4	1/2	2-1/8
PRC-460.075.0250	3/4	1/4	2-1/8	PRC-460.075.0625	3/4	5/8	2-1/8

Custom Tooling

Did not find what you are looking for? We can produce a custom tool to meet your needs. Over 30% of our products are custom tooling. A sales representative would be more than happy to discuss your needs and utilize our experienced technical application specialists. The process is simple regardless if you need a brazed carbide, insertable carbide or polycrystalline diamond (PCD).

- 1) Contact your Royce Ayr representative to discuss your need
- 2) A quotation will be sent as soon as possible for you to review
- 2) If the quotation is approved, provide any drawings or samples required for the order
- 3) A drawing will be sent within 2-5 business days depending on the complexity
- 4) Once the drawing is finalized and we have received your approval we will proceed with production

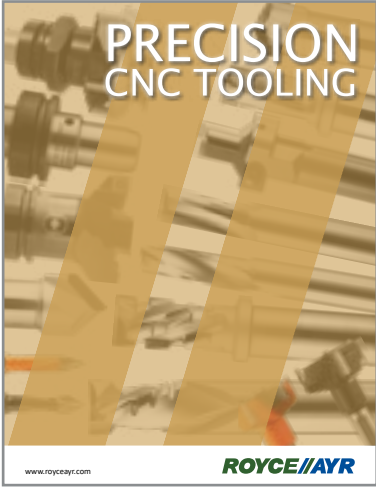
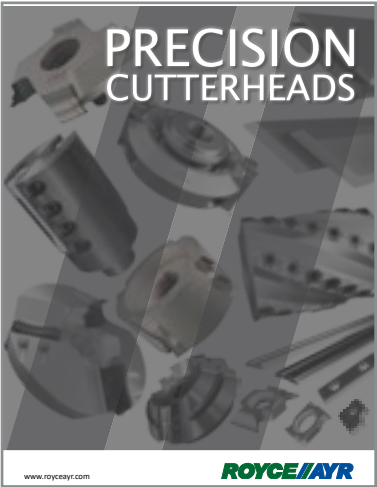
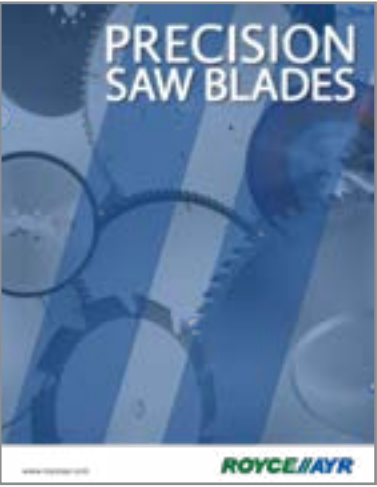


Precision Sharpening Services

Royce Ayr is capable of sharpening cutting tools back to original factory performance levels to keep them cutting as good as new. Same advanced machinery used to manufacture the tooling is used for servicing the tools.



Other Products Available





CDN 405 Sheldon Drive,
Cambridge, ON, N1T 2B7

USA 6391 Walmore Road,
Niagara Falls, NY, 14304

ROYCE//AYR

P.800.959.5641 | F.519.623.9371

CARBIDE | PCD

tooling@royceayr.com | www.royceayr.com

Revision-04
2026-08