

An ER-20 Collet Holder Plate, Version 1.1

By R. G. Sparber

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This ER-20 collet holder plate took just a few minutes to make using some expanded PVC board² and a drill press.

Yes, there is a tiny trick: use a step drill.

I bought my PVC board from my Tempe, AZ Lowes (Marty Escarcega found the SKU: 209620). The local Home Depot didn't carry the board. Ken Strauss found it at Home Depot Canada (SKU 1000761916). Bob Butcher found it at his Colorado Home Depot (SKU 137214). Neal Schlee says an alternate name for this product is AZEK.

Paul Tegler suggests using nylon or Delrin cutting boards from your local "dollar" store. Of course, you could also use wood but probably need more space between the holes to provide adequate strength.

¹ You are free to distribute this article but not to change it.

² EverTrue 0.75-in x 3.5-in x 8-ft Exterior Paint Grade PVC S4S.



I compared the taper on an ER-20 collet with my selection of Harbor Freight™ step drills until I found a decent match.

Each hole was drilled down until about 0.2 inches of the drill was above the surface.



Starting with a piece of PVC board 3.5 inches wide, I cut off a 3.5 inches length. The lines are 0.9 inches on center and 0.4 inches from the outer edges.

The PVC board cuts like butter so in no time I was done drilling the 16 tapered holes. The set consists of 13 collets leaving me 3 extra positions for duplicates.

I welcome your comments and questions.

If you wish to be contacted each time I publish an article, email me with just "Article Alias" in the subject line.

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