

TAPPING DEVICES



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TAPPING TECHNOLOGY

Good thread quality means that the profile must be geometrically correct and that the surface finish is good. To obtain full thread profile it is important that the axial force that affects the tap is very small. If the axial force exceeds a certain value the profile will be incomplete.

SPV SPINTEC's tapping attachments are due to the ball bearing floating designed to provide correct thread profile and counteract negative forces.

To obtain good thread finish it is necessary to use the correct tap as well as correct cutting speed. In most materials you receive a build up edge formation (BUE) in a certain cutting speed area which gives bad surface finish. The tapping lapse should follow either over or under the sectioned area, see Fig. 1. The aim should be for a tapping cycle that follows graph A. If the tapping lapse follows graph B there is a risk that the thread finish will be bad.

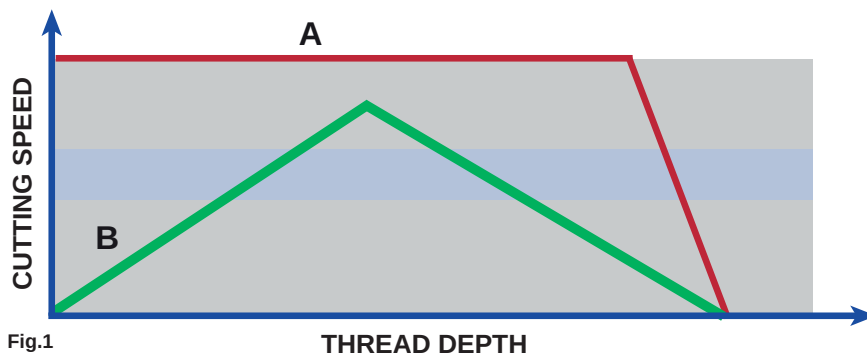
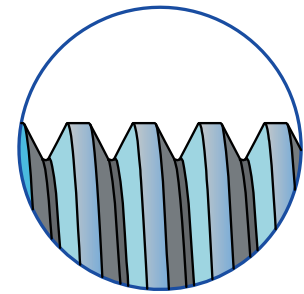
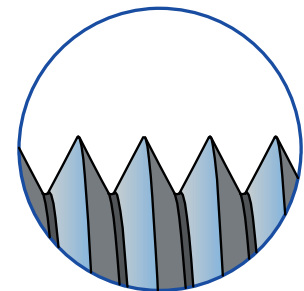


Fig.1



Incomplete profile



Full profile

When tapping in NC-controlled drilling- and milling machines you can use either synchronized tapping or conventional tapping.

SYNCHRONIZED TAPPING CYCLE

Synchronized tapping means that the spindle rotation speed x pitch are synchronized to the Z-movement of the machine. The tapping cycle always starts with an inoperative spindle. The advantage of synchronized tapping is accurate depth of the thread. The disadvantage is that the tapping cycle is slow. Fig. 2 shows that when trying to synchronize spindle- and Z-movement the retardation and acceleration will be limited. The tapping cycle will as a result of this be slow. The process follows graph B in Fig. 1 at the risk of incomplete thread profile. In case of modern machines with a very accurate synchronizing, rigid tapping is possible to use (the tap have no axial float). Normally when using synchronized tapping the tap must have an axial float to avoid big axial forces which gives incomplete thread profiles.

CONVENTIONAL TAPPING CYCLE

Conventional tapping cycle means that the spindle rotation and Z-movement must be programmed separately. The tapping cycle starts with full spindle rotation. The advantage is faster tapping cycle and that the tapping process can follow graph A in Fig. 1 which means that you receive a better thread finish. To obtain a full profile when tapping conventional, a tapping attachment with ball bearing drive and axial float must be used. Fig. 3 shows the tapping process at conventional tapping. As you can see from the picture the tapping process can follow graph A in Fig.1 which means better thread finish.

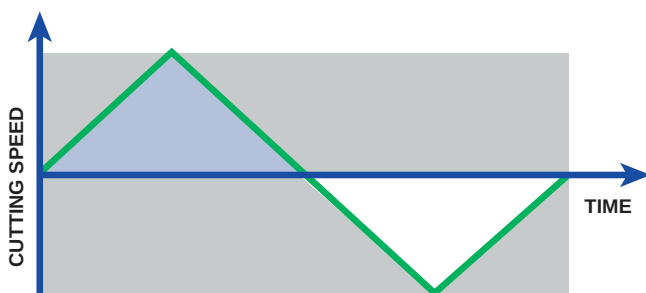


Fig. 2

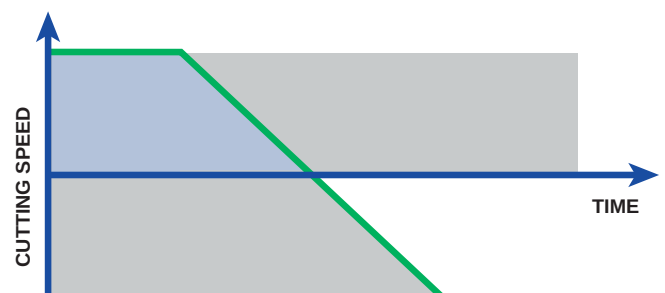


Fig. 3

WE KNOW TAPPING

SPV Spintec is a true pioneer when it comes to tapping attachment and chucks. We have customers on the market that have tapping units that are purchased from SPV over 40 years ago that are still in production. We still manufacture and refurbish these. Our range of tapping chucks covers the whole range from manual conventional tapping to synchronous tapping in modern NC machines.



OUR DIFFERENT TYPES OF TAPPING DEVICES



- Type CGS / CGS-C
Compact tapping device
with built-in floating



- Type ST / STF
Very slim design, with
or without floating



- Type GS
Slim tapping spindle
with adjustable floating



- Type SA
Powerfull tapping device
with floating and adjustable
torque-clutch



- Type SyncTapper
With mini-floating for
modern, rigid tapping

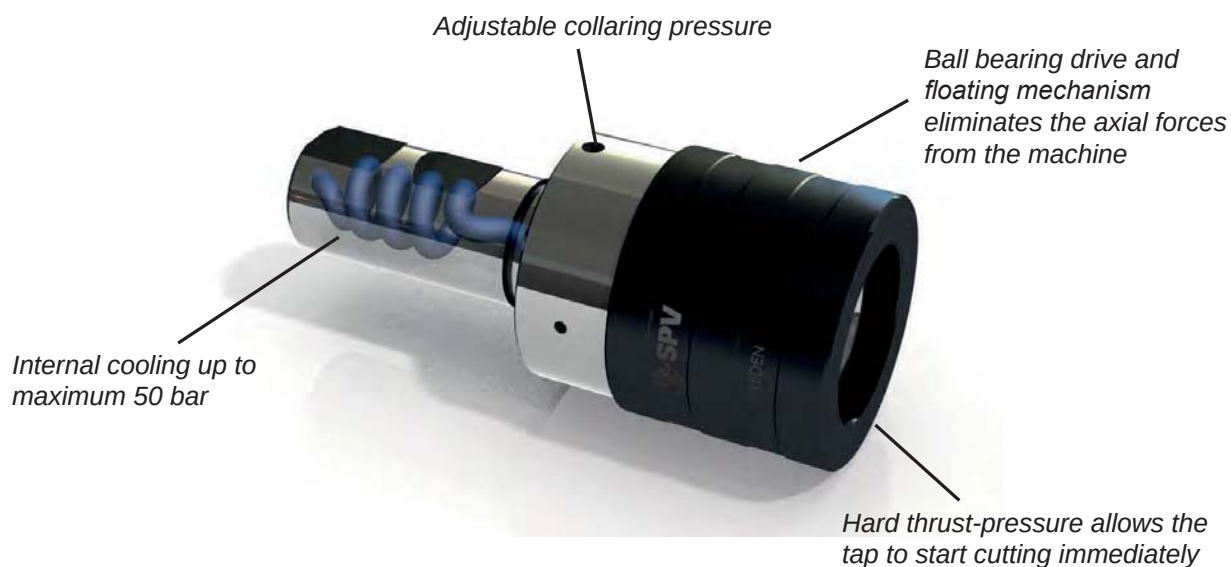


- Tap holders
Tapholders with quick-release
for fast tool changes.

TAPPING DEVICES

Type CGS / CGS-C

SUMMARY



Tap holders, see page 56 - 69

TAPPING RANGE	CGS-8	CGS-12	CGS-24	CGS-42
	M2 - M8 #0 - 5/16"	M3 - M16 1/8" - 5/8"	M7 - M36 5/16" - 1 1/8"	M18 - M42 3/4" - 1 5/8"

Type CGS with Weldon shank

	Type	D1 fäste	D Ømm	B mm	F mm	L2 Ømm	LT mm	LTK mm	Tap- holder	Article- number
	CGS-12	W-25	50	7	10	53	68	109	T-12 / TK-12	37622
	CGS-24	W-25	75	12	18	112	131	131	T-24 / TK-24	37623
	CGS-42	W-32	96	15	20	135	153	----	T-42 / TK-42	37624

Type CGS-C with Weldon shank (for internal cooling)

	Type	D1 fäste	D Ømm	B mm	F mm	L2 Ømm	LT mm	LTK mm	Tap- holder	Article- number
	CGS-12C	W-25	50	7	10	53	68	109	T-12 / TK-12	37590
	CGS-24C	W-25	75	12	18	112	131	131	T-24 / TK-24	37596
	CGS-42C	W-32	96	15	20	135	153	----	T-42 / TK-42	37597

Type CGS with Morse Taper shank

Type	Shank	D Ømm	B mm	F mm	L2 Ømm	LT mm	LTK mm	Tap holder	Article- number
CGS-8	MK1	40	5	10	48	60	95	T-8 / TK-8	26570
	MK2	40	5	10	50	62	97		26550
CGS-12	MK2	50	7	10	55	71	111	T-12 / TK-12	26296
	MK3	50	7	10	55	71	111		26298
CGS-24	MK3	75	12	18	94	113	164	T-24 / TK-24	26406
	MK4	75	12	18	94	113	164		26408
CGS-42	MK4	96	15	20	130	148	----	T-42	36332



Type CGS with Morse Taper shank for tie rod

Type	Shank thread	D Ømm	B mm	F mm	L2 Ømm	LT mm	LTK mm	Tap holder	Article- number
CGS-8	MK2 M10	40	5	10	50	62	97	T-8 / TK-8	26973
CGS-12	MK2 M10	50	7	10	55	71	111	T-12 / TK-12	36135
	MK3 M12	50	7	10	55	71	111		26975
CGS-24	MK3 M12	75	12	18	94	113	164	T-24 / TK-24	26977



Type CGS with cylindrical shank

Type	D1 Ømm L1 mm	D Ømm	B mm	F mm	L2 Ømm	LT mm	LTK mm	Tap holder	Article- number
CGS-8	15,88 42	40	5	10	45	57	92	T-8 / TK-8	26981
CGS-12	25,4 100	50	7	10	50	66	106	T-12 / TK-12	26439
CGS-24	25,4 100	75	12	18	89	108	159	T-24 / TK-24	26443



TAPPING DEVICES

Type ST / STF (SlimTapper)

SUMMARY

Slim design gives together with SPV SPINTEC:s Weldon extensions and short ISO/BT Weldon shanks, long and slim tapping chucks with high precision.



TAPPING RANGE	ST / STF-12	ST / STF-16	ST / STF-20	ST / STF-30	ST / STF-33
	M3 - M12 1/8" - 1/2"	M3 - M16 1/8" - 5/8"	M8 - M20 5/16" - 3/4"	M8 - M33 5/16" - 1 1/4"	M10 - M33 5/16" - 1 1/4"

Type ST without floating (for internal cooling)

Fits SPV Spintec tapholders

	Type	D1 fäste	D Ømm	L Ømm	LT mm	Tap holder	Article- number
	ST-16 CT	W-25	32	30	45	T-12 / TK-12	37716
	ST-16 CLT	W-25	32	80	95	T-24 / TK-24	37721

Type ST without floating (for internal cooling)

Fits EU-tap holders

	Type	D1 fäste	D Ømm	L Ømm	LT mm	Tap holders	Article- number
	ST-12 CEU	W-25	30	35	42	EU-1	35804
	ST-12 CLEU	W-25	30	85	92	EU-1	35805
	ST-20 CEU	W-25	50	52	63	EU-2	35806
	ST-20 CLEU	W-25	50	102	113	EU-2	35814

Type STF with floating

For RubberFlex-collets

	Type	D1 fäste	D Ømm	B mm	F mm	Lmax Ømm	L mm	Tap holders	Article- number
	STF-12 J	W-25	32	2	10	86	51	J-420 -23	37709
	STF-16 J	W-25	40	2	10	90	51	J-440 -43	37710
	STF-33 J	W-32	56	4	15	144	89	J-461 -62	37711

B = spring loaded backward floating F = spring loaded forward floating

Fits SPV Spintec tap holders

Type STF without floating

Type	D1 fäste	D Ømm	B mm	F mm	L Ømm	LT mm	Tap holder	Article- number
STF-16 T	W-25	32	2	10	70	85	T-12	37717
STF-30 T	W-32	50	4	15	130	149	T-24	37740

B = spring loaded backward floating F = spring loaded forward floating



Fits EU-tap holders

Type STF with floating

Type	D1 fäste	D Ømm	B mm	F mm	L Ømm	LT mm	Tap holder	Article- number
STF-12 EU	W-25	30	2	10	73	80	EU-1	35807
STF-20 EU	W-25	50	2	10	90	101	EU-2	35808

B = spring loaded backward floating F = spring loaded forward floating



Fits SPV Spintec tap holders

Type STF with floating (for internal cooling)

Type	D1 fäste	D Ømm	B mm	F mm	L Ømm	LT mm	Tap holder	Article- number
STF-16 CT	W-25	32	2	10	74	89	T-12 / T-12C	37718
STF-30 CT	W-32	50	4	15	130	149	T-24 / T-24C	37741

B = spring loaded backward floating F = spring loaded forward floating



Fits EU-tap holders

Type STF with floating (for internal cooling)

Type	D1 fäste	D Ømm	B mm	F mm	L Ømm	LT mm	Tap holder	Article- number
STF-16 CEU	W-25	32	2	10	73	80	EU-1	35809
STF-30 CEU	W-25	50	2	10	90	101	EU-2	35810

B = spring loaded backward floating F = spring loaded forward floating



Type GS-E

SUMMARY

Internal taper makes it possible to combine with several different shanks such as Morse taper, cylindrical shank etc.

Infinitely adjustable free axial movement (floating) enables use with different pitch at multi-spindle tapping.



Hard thrust pressure makes the tap start cutting immediately.

Tap holders, see page 56 - 69

TAPPING RANGE	GS-8	GS-12	GS-24
	M2 - M8 #0 - 5/16"	M3 - M16 #8 - 5/8"	M10 - M33 5/16" - 1 1/8"

Type GS with adjustable floating

Type	K Int.taper	D Ømm	Lmin mm	Lmax mm	LTmin mm	LTmax mm	LTKmin mm	LTKmax mm	Tap holder	Article- number
GS-8E	B12	23	100	125	112	137	147	172	T-8 / TK-8	36470
GS-12E	B16	30	108	133	123	148	164	189	T-12 / TK-12	36478
GS-24E	B18	50	147	157	166	206	217	257	T-24 / TK-24	36487



Type	Floating backwards mm	Floating forwards mm
GS-8E	0 - 25 mm	25 - 0 mm
GS-12E	0 - 25 mm	25 - 0 mm
GS-24E	0 - 40 mm	40 - 0 mm

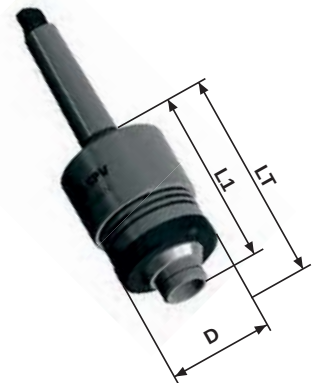


Tap holders, see page 56 - 61

TAPPING RANGE	SA-1E	SA-2E
	M6 - M16 1/4" - 5/8"	M14 - M30 9/16" - 1 1/8"

Type SA (for conventional machines)

Type	Shank type	D Ømm	B mm	F mm	L1 Ømm	LT mm	Tap holder	Article-number
SA-1E	MK2	70	9	18	119	136	T-12	22209
	MK3	70	9	18	118	135		22210
SA-2E	MK3	104	12	20	178	197	T-24	22428
	MK4	104	12	20	176,5	195,5		22263



B = spring loaded backward floating F = spring loaded forward floating

Type SA/NC (for CNC-machines)

Type	Shank type	D Ømm	B mm	F mm	L1 Ømm	LT mm	Tap holder	Article-number
SA-1E/NC	MK2	70	18	9	128	144	T-12	22209
	MK3	70	18	9	127	143		22210
SA-2E/NC	MK3	104	20	12	186	205	T-24	22428
	MK4	104	20	12	184,5	203,5		22263



B = spring loaded backward floating F = spring loaded forward floating

Type SyncTapper

SUMMARY

SyncTapper with mini-floating for Rigid Tapping.

Many new machines have a function called Rigid Tapping which means that the machine spindle is synchronized with the speed of the machine axis movement. However in many cases it is not 100% accurate which can impair on the thread quality and result in a bad surface finish.

To obtain full thread profile it is important that the axial force that affects the tap is very small. If the axial force exceeds a certain value the profile will be incomplete.

SPV Spintec's SyncTapper as a built-in rigid mini-floating of only 0,5 mm to counteract negative forces and allow the tap to cut the best way.

The tap is clamped by an ER-collet, making the setup much more stable than a conventional tap holder.



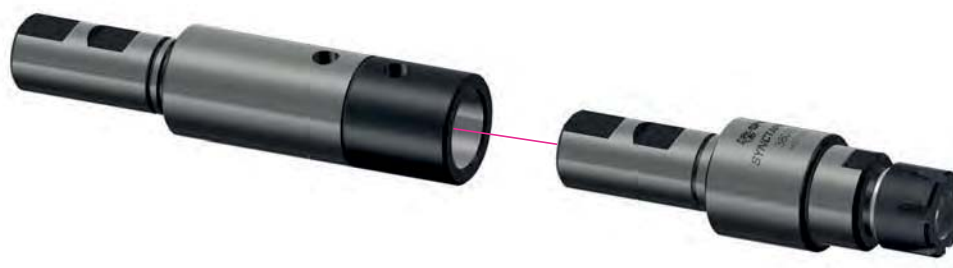
Type	Article-title	Article-number
SyncTapper	Tapping chuck SyncTapper, ER-20, Weldon-25, Length 76	38010

SyncTapper comes complete with clamping-nut and wrench.

Dimensions



Combinations



SyncTapper can easily be extended with our slimmed Weldon-extensions (see page 81)

SUMMARY



- Long clamping area improves rigidity and thread quality.
- The tap is controlled with precision which improves the thread quality.
- Internal cooling ducts for cooling along the tap (type TC)
- Built-in adjustable torque clutch (type TK)



Type T and TC
(page 56)



Type TK
(page 64)

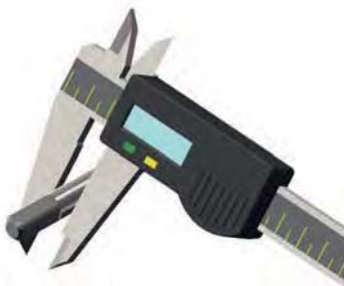


Type EU
(page 70)



Type EUK
(page 75)

TAP HOLDERS - Find the correct tap holder with 3 easy steps.



1. Measure the tap diameter



2. Measure the tap square

Handbook of Machine Tools

Chapter 10: Machine Tools

Section 10.1: Machine Tools

Table 10.1: Machine Tools

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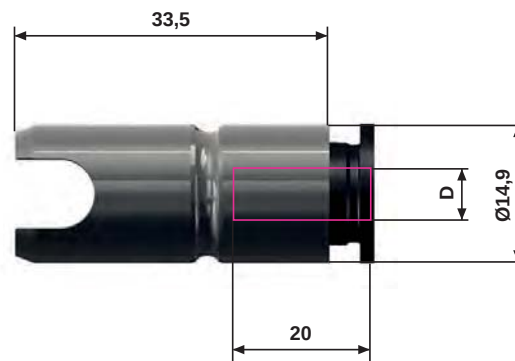
Table 10.1: Machine Tools

Tap holder type T-8

Tap holder type T-8 dimensions

Tapping range: **M2 - M8**
#0 - 5/16"

D: **Ø2,5 - 8,0 mm**



Tap holder type T-8 ISO

For taps according to **ISO-standard**

ISO M	UNC	UNF	Ø mm	# mm	Ø tum	# tum	Article- number
2	1-64	1-72	2,50	2,00	.098	.079	27279
2,2	2-56	2-64	2,80	2,24	.110	.088	27284
2,5	3-48	3-56	2,80	2,24	.110	.088	27284
3	4-40	4-48	3,15	2,50	.124	.098	27288
3,5	6-32	6-40	3,55	2,80	.140	.110	27293
4			4,00	3,15	.157	.124	27299
4,5	8-32	8-36	4,50	3,55	.177	.140	27307
5	10-24	10-32	5,00	4,00	.197	.157	27315
	12-24	12-28	5,60	4,50	.220	.177	27320
6	1/4"-20	1/4"-28	6,30	5,00	.248	.197	27328
7			7,10	5,60	.280	.220	27802
8	5/16"-18	5/16"-24	8,00	6,30	.315	.248	27809
11	7/16"-14	7/16"-20	8,00	6,30	.315	.248	27809

Tap holder typ T-8 DIN

For taps accoring to **DIN**-standard

352 M	371 M	376 M	UNC UNF	353, 354 G (R)	Ø mm	# mm	Ø tum	# tum	Article- number
1-1,8	1-1,8	3,5	1/16"		2,50	2,10	.098	.083	27280
2	2	4	3/32"		2,80	2,10	.110	.083	27283
2,2	2,2		5/32"		2,80	2,10	.110	.083	27283
2,5	2,5				2,80	2,10	.110	.083	27283
3		5	1/8"		3,50	2,70	.138	.106	27292
3,5	3,5				4,00	3,00	.157	.118	27298
4	4	6	5/32"		4,50	3,40	.177	.134	27306
			7/32"		4,00	3,00	.157	.118	27298
5	5		7/32"		6,00	4,90	.236	.193	27324
			1/4"		4,50	3,40	.177	.134	27306
6	6		1/4"		6,00	4,90	.236	.193	27324
		7			5,50	4,30	.217	.169	27317
7					6,00	4,90	.236	.193	27324
	7		1/4"		7,00	5,50	.276	.217	27332
8		8	5/16"		6,00	4,90	.236	.193	27324
	8		5/16"		8,00	6,20	.315	.244	27808
9		9	3/8"	1/8"	7,00	5,50	.276	.217	27332
10		10			7,00	5,50	.276	.217	27332
11		11	7/16"		8,00	6,20	.315	.244	27808

Tap holder type T-8 ANSI

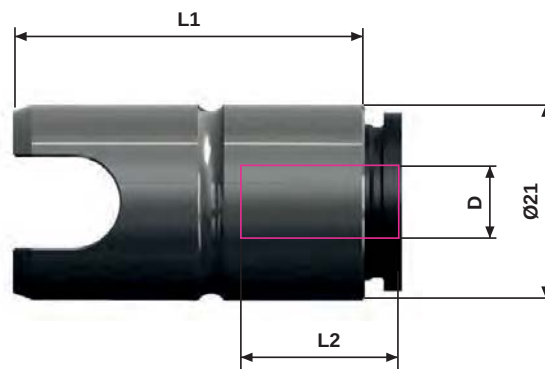
For taps according to **ANSI**-standard

UNC, UNF NC, NF	Ø mm	# mm	Ø tum	# tum	Artikel- nummer
0-6	3,58	2,79	.141	.110	27294
8	4,27	3,33	.168	.131	27305
10	4,93	3,86	.194	.152	27313
12	5,59	4,19	.220	.165	27319
1/4"	6,48	4,85	.255	.191	27330

Tap holder type T-12 / T-12C

Tap holder type T-12 dimensions

Tapping range	D Ø mm	L1 mm	L2 mm
M4 - M16 5/32" - 5/8"	4,0 - 7,0	36	20
	7,1 - 10,0	36	17
	10,5 - 12,5	37,5	17



Tap holder type T-12 / T-12C ISO

For taps according to **ISO-standard**

ISO M	UNC	UNF	Ø mm	# mm	Ø tun	# tun	T-12 Art.no	T-12C Art.no
3	4-40	4-48	3,15	2,50	.124	.098	27950	
3,5	6-32	6-40	3,55	2,80	.140	.110	37213	
4			4,00	3,15	.157	.124	22809	
4,5	8-32	8-36	4,50	3,55	.177	.140	22810	
5	10-24	10-32	5,00	4,00	.197	.157	20860	
	12-24	12-28	5,60	4,50	.220	.177	22811	
6	1/4"-20	1/4"-28	6,30	5,00	.248	.197	22812	22812C
7			7,10	5,60	.280	.220	22813	22813C
8	5/16"-18	5/16"-24	8,00	6,30	.315	.248	22814	22814C
9			9,00	7,10	.354	.280	22815	22815C
10	3/8"-16	3/8"-24	10,00	8,00	.394	.315	20887	20887C
11	7/16"-14	7/16"-20	8,00	6,30	.315	.248	22814	22814C
12	1/2"-13	1/2"-20	9,00	7,10	.354	.280	22815	22815C
14	9/16"-12	9/16"-18	11,20	9,00	.441	.354	22817	22817C
16	5/8"-11	5/8"-18	12,50	10,00	.492	.394	22259	22259C
18-20	3/4"-10	3/4"-16	14,00	11,20	.551	.441	36233*	

Tap holder type T-12 / T-12C DIN

For taps according to **DIN**-standard

352 M	371 M	376 M	UNF UNC	353, 354 G (R)	Ø mm	# mm	Ø tun	# tun	T-12 Art.no	T-12C Art.no
3		5	1/8"		3,50	2,70	.138	.106	20847	
3,5	3,5				4,00	3,00	.157	.118	20849	
4	4	6	5/32"		4,50	3,40	.177	.134	20854	20854C
			7/32"		4,00	3,00	.157	.118	20849	
5	5		7/32"		6,00	4,90	.236	.193	20865	20865C
			1/4"		4,50	3,40	.177	.134	20854	20854C
6	6		1/4"		6,00	4,90	.236	.193	20865	20865C
		7			5,50	4,30	.217	.169	20861	20861C
7					6,00	4,90	.236	.193	20865	20865C
	7		1/4"		7,00	5,50	.276	.217	20872	20872C
8		8	5/16"		6,00	4,90	.236	.193	20865	20865C
	8		5/16"		8,00	6,20	.315	.244	20875	20875C
9		9	3/8"	1/8"	7,00	5,50	.276	.217	20872	20872C
10		10			7,00	5,50	.276	.217	20872	20872C
	9		3/8"		9,00	7,00	.354	.276	20880	20880C
11		11	7/16"		8,00	6,20	.315	.244	20875	20875C
12		12	1/2"		9,00	7,00	.354	.276	20880	20880C
	10				10,00	8,00	.394	.315	20887	20887C
14		14	9/16"	1/4"	11,00	9,00	.433	.354	22255	22255C
16	12	16	5/8"	3/8"	12,00	9,00	.472	.354	22257	22257C

Tap holder type T-12 / T-12C ANSI

For taps according to **ANSI**-standard

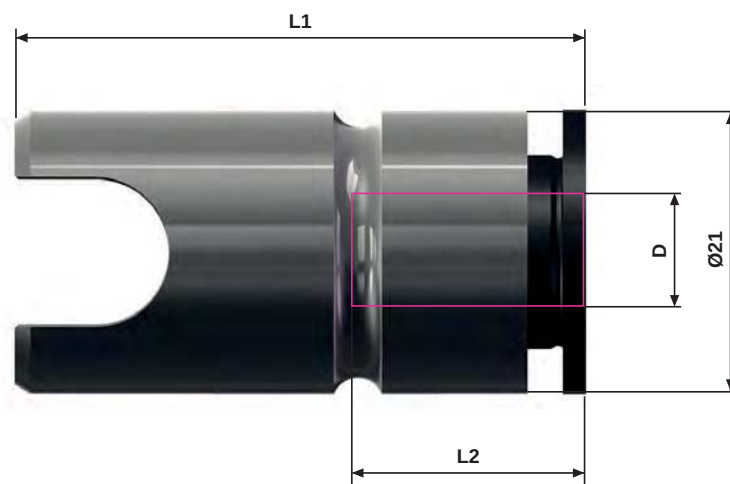
UNC, UNF NC, NF	NPTS	Ø mm	# mm	Ø tun	# tun	T-12 Art.no	T-12C Art.no
0-6		3,58	2,79	.141	.110	37382	
8		4,27	3,33	.168	.131	20853	
10		4,93	3,86	.194	.152	20858	
12		5,59	4,19	.220	.165	20862	
1/4"		6,48	4,85	.255	.191	20870	
5/16"		8,08	6,00	.318	.236	20877	
3/8"		7,47	5,59	.294	.220	29103	
3/8"		9,68	7,26	.381	.286	20886	
	1/8"	11,12	8,33	.437	.328	22256	
7/16"		8,20	6,15	.323	.242	20878	
1/2"		9,32	6,99	.367	.275	20883	
9/16"		10,90	8,18	.429	.322	22254	
5/8"		12,19	9,14	.480	.360	22258	

TAPPING DEVICES

Tap holder typ T-24 / T-24C

Tap holder type T-24 dimensions

Tapping range	D Ø mm	L1 mm	L2 mm
M8 - M36	8,0 - 20,32	65	30
5/8" - 1 3/8"	22,4 - 25,0	75	30



Tap holder type T-24 / T-24C ISO

For taps according to **ISO-standard**

ISO M	UNC	UNF	Ø mm	# mm	Ø tun	# tun	T-24 Art.no	T-24C Art.no
7			7,10	5,60	.280	.220	22839	22839C
8	5/16"-18	5/16"-24	8,00	6,30	.315	.248	22840	22840C
9			9,00	7,10	.354	.280	22841	22841C
10	3/8"-16	3/8"-24	10,00	8,00	.394	.315	22843	22843C
11	7/16"-14	7/16"-20	8,00	6,30	.315	.248	22840	22840C
12	1/2"-13	1/2"-20	9,00	7,10	.354	.280	22841	22841C
14	9/16"-12	9/16"-18	11,20	9,00	.441	.354	22844	22844C
16	5/8"-11	5/8"-18	12,50	10,00	.492	.394	22071	22071C
18			14,00	11,20	.551	.441	22845	22845C
20	3/4"-10	3/4"-16	14,00	11,20	.551	.441	22845	22845C
22	7/8"-9	7/8"-14	16,00	12,50	.630	.492	22846	22846C
24	1"-8	1"-12	18,00	14,00	.709	.551	22089	22089C
27	1 1/8"-7	1 1/8"-12	20,00	16,00	.787	.630	22096	22096C
30			20,00	16,00	.787	.630	22096	22096C
33	1 1/4"-7	1 1/4"-12	22,40	18,00	.882	.709	28528	28528C
36	1 3/8"-6	1 3/8"-12	25,00	20,00	.984	.787	36033	36033C

Tap holder type T-24 / T-24C DIN

For taps according to **DIN**-standard

352 M	371 M	376 M	UNF UNC	353, 354 G (R)	Ø mm	# mm	Ø t _{um}	# t _{um}	T-24 Art.no	T-24C Art.no
	7		1/4"		7,00	5,50	.276	.217	22050	22050C
	8		5/16"		8,00	6,20	.315	.244	22055	22055C
9		9	3/8"	1/8"	7,00	5,50	.276	.217	22050	22050C
10		10			7,00	5,50	.276	.217	22050	22050C
	9		3/8"		9,00	7,00	.354	.276	22062	22062C
11		11	7/16"		8,00	6,20	.315	.244	22055	22055C
12		12	1/2"		9,00	7,00	.354	.276	22062	22062C
	10				10,00	8,00	.394	.315	22843	22843C
14		14	9/16"	1/4"	11,00	9,00	.433	.354	22067	22067C
16	12	16	5/8"	3/8"	12,00	9,00	.472	.354	22069	22069C
18		18	11/16"		14,00	11,00	.551	.433	22075	22075C
			3/4"		14,00	11,00	.551	.433	22075	22075C
20		20	13/16"	1/2"	16,00	12,00	.630	.472	22081	22081C
22		22	7/8"	5/8"	18,00	14,50	.709	.571	22090	22090C
24		24	15/16"		18,00	14,50	.709	.571	22090	22090C
27		27	1"	3/4"	20,00	16,00	.787	.630	22096	22096C
30		30	1 1/8"	7/8"	22,00	18,00	.866	.709	28527	28527C
33		33	1 1/4"	1"	25,00	20,00	.964	.787	36033	36033C

Tap holder type T-24 / T-24C ANSI

For taps according to **ANSI**-standard

UNC, UNF NC, NF	NPTS	Ø mm	# mm	Ø t _{um}	# t _{um}	T-24 Art.no	T-24C Art.no
5/16"		8,08	6,00	.318	.236	22056	
3/8"		7,47	5,59	.294	.220	22052	
3/8"		9,68	7,26	.381	.286	27855	
	1/8"	11,12	8,33	.437	.328	36205	
7/16"		8,20	6,15	.323	.242	22057	
1/2"		9,32	6,99	.367	.275	22063	
9/16"		10,90	8,18	.429	.322	22066	
5/8"		12,19	9,14	.480	.360	22070	
9/16"	1/4"	14,27	10,69	.562	.421	36205	
3/4"		14,99	11,23	.590	.442	22077	
	1/2"	17,45	13,08	.687	.515	36206	
13/16"		16,56	12,42	.652	.489	22083	
7/8"		17,70	13,28	.697	.523	22087	
	3/8"	17,78	13,49	.700	.531	36207	
15/16"		19,30	14,48	.760	.570	22094	
1"		20,32	15,24	.800	.600	22097	
	3/4"	23,01	17,25	.906	.679	36208	
1 1/8"		22,76	17,07	.896	.672	28529	

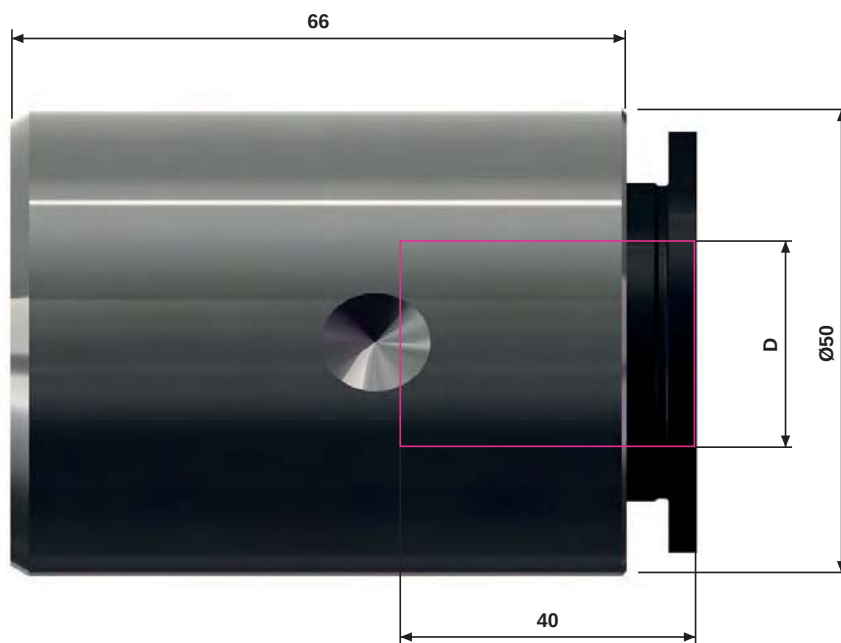
TAPPING DEVICES

Tap holder type T-42 / T-42C

Tap holder type T-42 dimensions

Tapping range: **M18 - M42**
3/4" - 1 5/8"

D: **Ø14,0 - 28,0 mm**



Tap holder type T-42 / T-42C ISO

For taps according to **ISO-standard**

ISO M	UNC	UNF	Ø mm	# mm	Ø tun	# tun	T-42 Art.no	T-42C Art.no
18			14,00	11,20	.551	.441	36252	36252C
20	3/4"-10	3/4"-16	14,00	11,20	.551	.441	36252	36252C
22	7/8"-9	7/8"-14	16,00	12,50	.630	.492	36255	36255C
24	1"-8	1"-12	18,00	14,00	.709	.551	36258	36258C
27	1 1/8"-7	1 1/8"-12	20,00	16,00	.787	.630	36261	36261C
30			20,00	16,00	.787	.630	36261	36261C
33	1 1/4"-7	1 1/4"-12	22,40	18,00	.882	.709	36264	36264C
36	1 3/8"-6	1 3/8"-12	25,00	20,00	.984	.787	36267	36267C
39	1 1/2"-6	1 1/2"-12	28,00	22,40	1.102	.882	36270	36270C
42			28,00	22,40	1.102	.882	36270	36270C

Tap holder type T-42 / T-42C DIN

For taps according to **DIN**-standard

352 M	371 M	376 M	UNF UNC	353, 354 G (R)	Ø mm	# mm	Ø t _{um}	# t _{um}	T-42 Art.no	T-42C Art.no
20		20	13/16"	1/2"	16,00	12,00	.630	.472	36254	36254C
22		22	7/8"	5/8"	18,00	14,50	.709	.571	36259	36259C
24		24	15/16"		18,00	14,50	.709	.571	36259	36259C
27		27	1"	3/4"	20,00	16,00	.787	.630	36261	36261C
30		30	1 1/8"	7/8"	22,00	18,00	.866	.709	36263	36263C
33		33	1 1/4"	1"	25,00	20,00	.984	.787	36267	36267C
36		36	1 3/8"	1 1/8"	28,00	22,00	1.102	.866	36269	36269C
39		39	1 1/2"		32,00	24,00	1.260	.945	36274	36274C
42		42	1 5/8"	1 1/4"	32,00	24,00	1.260	.945	36274	36274C

Tap holder type T-42 / T-42C ANSI

For taps according to **ANSI**-standard

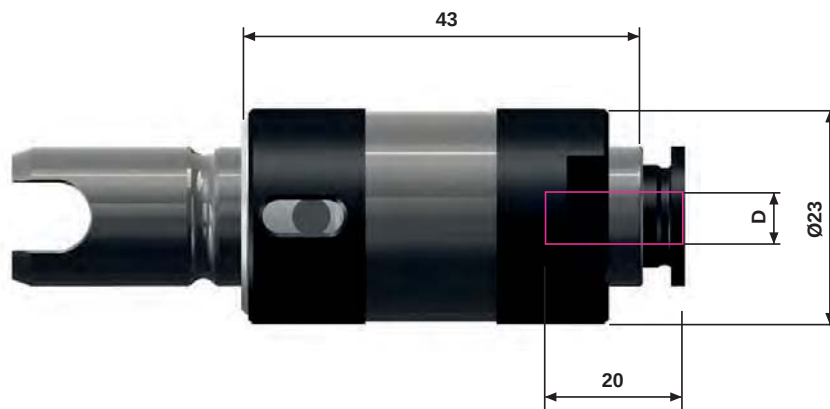
UNC, UNF NC, NF	NPTS	Ø mm	# mm	Ø t _{um}	# t _{um}	T-42 Art.no	T-42C Art.no
	1/2"	17,45	13,08	.687	.545	36256	
7/8"		17,70	13,28	.697	.523	36257	
15/16"		19,30	14,48	.760	.570	36260	
1"		20,32	15,24	.800	.600	36262	
	3/4"	23,01	17,25	.906	.679	36266	
1 1/8"		22,76	17,07	.896	.672	36265	
1 1/8"	1"	28,57	21,41	1.125	.843	36272	
1 1/4"		25,93	19,45	1.021	.766	36268	
1 3/8"		28,14	21,10	1.108	.831	36271	
1 1/2"		31,32	23,49	1.233	.925	36273	
1 5/8"		33,15	24,86	1.305	.979	36275	
	1 1/4"	33,33	24,99	1.312	.954	36318	

Tap holder type TK-8

Tap holder type TK-8 with built in torque-clutch

Tapping range: **M2 - M11**
1/16" - 7/16"

D: **Ø2,5 - 8,0 mm**



Tap holder type TK-8 ISO

For taps according to **ISO-standard**

ISO M	UNC	UNF	Ø mm	# mm	Ø tum	# tum	Article- number
2	1-64	1-72	2,50	2,00	.098	.079	29822
2,2	2-56	2-64	2,80	2,24	.110	.088	29823
2,5	3-48	3-56	2,80	2,24	.110	.088	29823
3	4-40	4-48	3,15	2,50	.124	.098	29824
3,5	6-32	6-40	3,55	2,80	.140	.110	29825
4			4,00	3,15	.157	.124	29826
4,5	8-32	8-36	4,50	3,55	.177	.140	29827
5	10-24	10-32	5,00	4,00	.197	.157	29828
	12-24	12-28	5,60	4,50	.220	.177	29829
6	1/4"-20	1/4"-28	6,30	5,00	.248	.197	29830
7			7,10	5,60	.280	.220	29831
8	5/16"-18	5/16"-24	8,00	6,30	.315	.248	29832
11	7/16"-14	7/16"-20	8,00	6,30	.315	.248	29832

Tap holder type TK-8 DIN

For taps according to **DIN**-standard

352 M	371 M	376 M	UNC UNF	353, 354 G (R)	Ø mm	# mm	Ø tum	# tum	Article- number
1-1,8	1-1,8	3,5	1/16"		2,50	2,10	.098	.083	29837
2	2	4	3/32"		2,80	2,10	.110	.083	29840
2,2	2,2		5/32"		2,80	2,10	.110	.083	29840
2,5	2,5				2,80	2,10	.110	.083	29840
3		5	1/8"		3,50	2,70	.138	.106	29847
3,5	3,5				4,00	3,00	.157	.118	29852
4	4	6	5/32"		4,50	3,40	.177	.134	29859
			7/32"		4,00	3,00	.157	.118	29852
5	5		7/32"		6,00	4,90	.236	.193	29874
			1/4"		4,50	3,40	.177	.134	29859
6	6		1/4"		6,00	4,90	.236	.193	29874
		7			5,50	4,30	.217	.169	29868
7					6,00	4,90	.236	.193	29874
	7		1/4"		7,00	5,50	.276	.217	29881
8		8	5/16"		6,00	4,90	.236	.193	29874
	8		5/16"		8,00	6,20	.315	.244	26887
9		9	3/8"	1/8"	7,00	5,50	.276	.217	29881
10		10			7,00	5,50	.276	.217	29881
11		11	7/16"		8,00	6,20	.315	.244	29887

Tap holder type TK-8 ANSI

For taps according to **ANSI**-standard

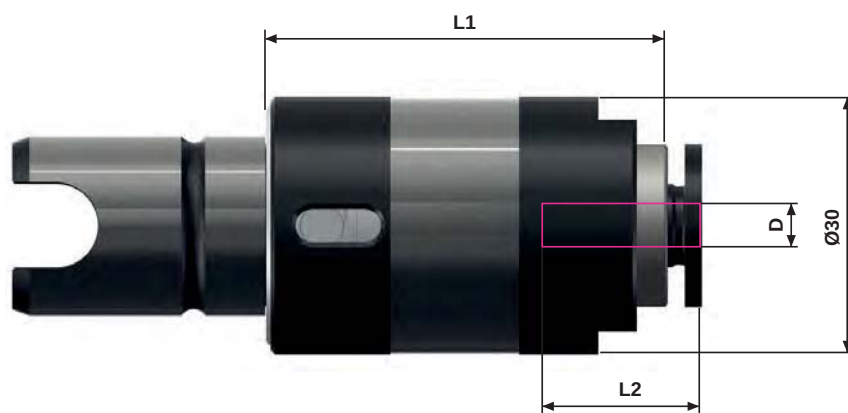
UNC, UNF NC, NF	Ø mm	# mm	Ø tum	# tum	Article- number
0-6	3,58	2,79	.141	.110	29848
8	4,27	3,33	.168	.131	29858
10	4,93	3,86	.194	.152	29865
12	5,59	4,19	.220	.165	29870
1/4"	6,48	4,85	.255	.191	29879
5/16"	8,08	6,00	.318	.236	36731

TAPPING DEVICES

Tap holder type TK-12

Tap holder type TK-12 with built in torque-clutch

Tapping-capacity	D Ø mm	L1 mm	L2 mm
M3 - M16 1/8" - 5/8"	4,0 - 7,0	47	20
	7,1 - 10,0	47	17
	10,5 - 12,5	54	17



Tap holder type TK-12 ISO

For taps according to **ISO-standard**

ISO M	UNC	UNF	Ø mm	# mm	Ø tun	# tun	Article- number
3	4-40	4-48	3,15	2,50	.124	.098	26590
4			4,00	3,15	.157	.124	29724
4,5	8-32	8-36	4,50	3,55	.177	.140	29725
5	10-24	10-32	5,00	4,00	.197	.157	29726
	12-24	12-28	5,60	4,50	.220	.177	29727
6	1/4"-20	1/4"-28	6,30	5,00	.248	.197	29728
7			7,10	5,60	.280	.220	29729
8	5/16"-18	5/16"-24	8,00	6,30	.315	.248	29730
9			9,00	7,10	.354	.280	29731
10	3/8"-16	3/8"-24	10,00	8,00	.394	.315	29733
11	7/16"-14	7/16"-20	8,00	6,30	.315	.248	29730
12	1/2"-13	1/2"-20	9,00	7,10	.354	.280	29731
14	9/16"-12	9/16"-18	11,20	9,00	.441	.354	36825
16	5/8"-11	5/8"-18	12,50	10,00	.492	.394	36828

Tap holder type TK-12 DIN

For taps according to **DIN**-standard

352 M	371 M	376 M	UNF UNC	353, 354 G (R)	Ø mm	# mm	Ø tum	# tum	Article- number
3		5	1/8"		3,50	2,70	.138	.106	29735
3,5	3,5				4,00	3,00	.157	.118	29737
4	4	6	5/32"		4,50	3,40	.177	.134	29742
			7/32"		4,00	3,00	.157	.118	29737
5	5		7/32"		6,00	4,90	.236	.193	29752
			1/4"		4,50	3,40	.177	.134	29742
6	6		1/4"		6,00	4,90	.236	.193	29752
		7			5,50	4,30	.217	.169	29748
7					6,00	4,90	.236	.193	29752
	7		1/4"		7,00	5,50	.276	.217	29759
8		8	5/16"		6,00	4,90	.236	.193	29752
	8		5/16"		8,00	6,20	.315	.244	29762
9		9	3/8"	1/8"	7,00	5,50	.276	.217	29759
10		10			7,00	5,50	.276	.217	29759
	9		3/8"		9,00	7,00	.354	.276	29769
11		11	7/16"		8,00	6,20	.315	.244	29762
12		12	1/2"		9,00	7,00	.354	.276	29769
	10				10,00	8,00	.394	.315	29733
14		14	9/16"	1/4"	11,00	9,00	.433	.354	36823
16	12	16	5/8"	3/8"	12,00	9,00	.472	.354	36826

Tap holder type TK-12 ANSI

For taps according to **ANSI**-standard

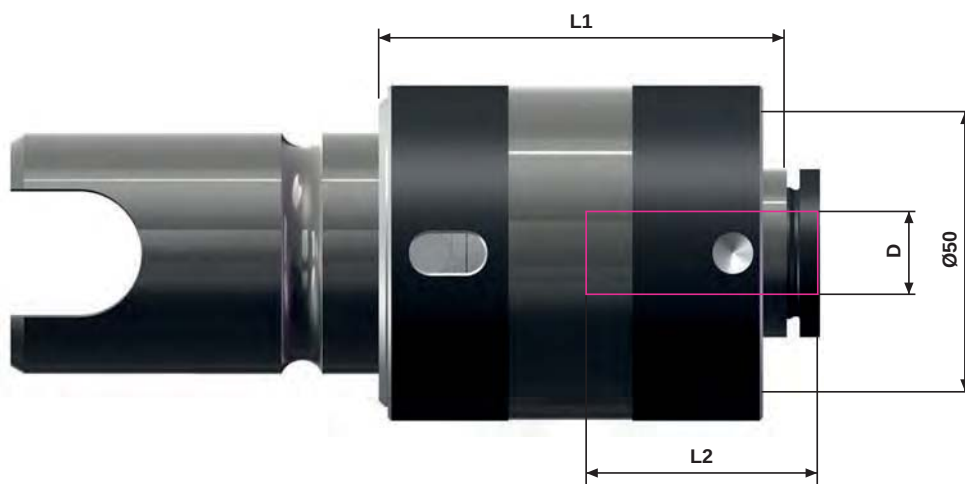
UNC, UNF NC, NF	NPTS	Ø mm	# mm	Ø tum	# tum	Article- number
8		4,27	3,33	.168	.131	29741
10		4,93	3,86	.194	.152	29746
12		5,59	4,19	.220	.165	29749
1/4"		6,48	4,85	.255	.191	29757
5/16"		8,08	6,00	.318	.236	29763
3/8"		9,68	7,26	.381	.286	29774
	1/8"	11,12	8,33	.437	.328	36824
7/16"		8,20	6,15	.323	.242	29765
1/2"		9,32	6,99	.367	.275	29771
9/16"		10,90	8,18	.429	.322	36822
5/8"		12,19	9,14	.480	.360	36827

TAPPING DEVICES

Tap holder type TK-24

Tap holder type TK-24 with built in torque-clutch

Tapping-capacity	D Ø mm	L1 mm	L2 mm
M6 - M30 1/4" - 1"	8,0 - 15,5	61	30
	16,0 - 20,32	76	30



Tap holder type TK-24 ISO

For taps according to **ISO-standard**

ISO M	UNC	UNF	Ø mm	# mm	Ø tum	# tum	Article- number
8	5/16"-18	5/16"-24	8,00	6,30	.315	.248	26095
9			9,00	7,10	.354	.280	26096
10	3/8"-16	3/8"-24	10,00	8,00	.394	.315	26098
11	7/16"-14	7/16"-20	8,00	6,30	.315	.248	26095
12	1/2"-13	1/2"-20	9,00	7,10	.354	.280	26096
14	9/16"-12	9/16"-18	11,20	9,00	.441	.354	26099
16	5/8"-11	5/8"-18	12,50	10,00	.492	.394	26100
18			14,00	11,20	.551	.441	26101
20	3/4"-10	3/4"-16	14,00	11,20	.551	.441	26101
22	7/8"-9	7/8"-14	16,00	12,50	.630	.492	26102
24	1"-8	1"-12	18,00	14,00	.709	.551	26103
27	1 1/8"-7	1 1/8"-12	20,00	16,00	.787	.630	26104
30			20,00	16,00	.787	.630	26104

Tap holder type TK-24 DIN

For taps according to **DIN**-standard

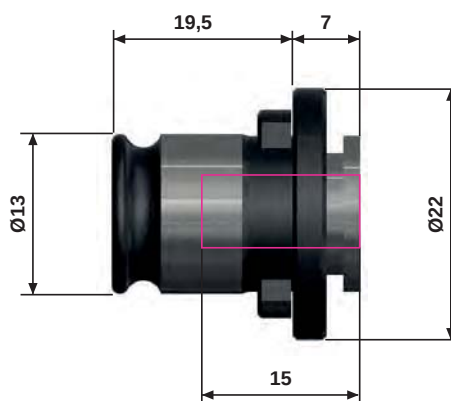
352 M	371 M	376 M	UNF UNC	353, 354 G (R)	Ø mm	# mm	Ø tum	# tum	Article- number
6	6		1/4"		6,00	4,90	.236	.193	26983
7					6,00	4,90	.236	.193	26983
	7		1/4"		7,00	5,50	.276	.217	26105
8		8	5/16"		6,00	4,90	.236	.193	26983
	8		5/16"		8,00	6,20	.315	.244	26110
9		9	3/8"	1/8"	7,00	5,50	.276	.217	26105
10		10			7,00	5,50	.276	.217	26105
	9		3/8"		9,00	7,00	.354	.276	26117
11		11	7/16"		8,00	6,20	.315	.244	26110
12		12	1/2"		9,00	7,00	.354	.276	26117
	10				10,00	8,00	.394	.315	26098
14		14	9/16"	1/4"	11,00	9,00	.433	.354	26124
16	12	16	5/8"	3/8"	12,00	9,00	.472	.354	26126
18		18	11/16"		14,00	11,00	.551	.433	26131
			3/4"		14,00	11,00	.551	.433	26131
20		20	13/16"	1/2"	16,00	12,00	.630	.472	26137
22		22	7/8"	5/8"	18,00	14,50	.709	.571	26145
24		24	15/16"		18,00	14,50	.709	.571	26145
27		27	1"	3/4"	20,00	16,00	.787	.630	26104

Tap holder type TK-24 ANSI

For taps according to **ANSI**-standard

UNC, UNF NC, NF	NPTS	Ø mm	# mm	Ø tum	# tum	Article- number
5/16"		8,08	6,00	.318	.236	26111
3/8"		7,47	5,59	.294	.220	26107
3/8"		9,68	7,26	.381	.286	26121
	1/8"	11,12	8,33	.437	.328	26125
7/16"		8,20	6,15	.323	.242	26112
1/2"		9,32	6,99	.367	.275	26118
9/16"		10,90	8,18	.429	.322	26123
5/8"		12,19	9,14	.480	.360	26127
9/16"	1/4"	14,27	10,69	.562	.421	26132
3/4"		14,99	11,23	.590	.442	26133
	1/2"	17,45	13,08	.687	.515	26141
13/16"		16,56	12,42	.652	.489	26139
7/8"		17,70	13,28	.697	.523	26143
	3/8"	17,78	13,49	.700	.531	26144
15/16"		19,30	14,48	.760	.570	26149
1"		20,32	15,24	.800	.600	26151

Tap holder type EU-0



Tap holder type EU-0 ISO

For taps according to **ISO**-standard

M	Ø mm	# mm	Ø tum	# tum	Article- number
2	2,50	2,00	.098	.079	72850
3	3,15	2,50	.124	.098	72852
3,5	3,55	2,80	.140	.110	72854
4	4,00	3,15	.157	.124	72856
5	5,00	4,00	.197	.157	72858
6	6,30	5,00	.248	.197	72860

Tap holder type EU-0 DIN

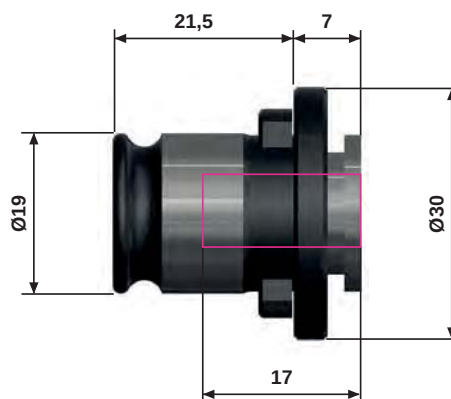
For taps according to **DIN**-standard

352 M	Ø mm	# mm	Ø tum	# tum	Article- number
1-1,8	2,50	2,10	.098	.083	72850
2	2,80	2,10	.110	.083	72851
2,5	2,80	2,10	.110	.083	72851
3	3,50	2,70	.138	.106	72853
3,5	4,00	3,00	.157	.118	72855
4	4,50	3,40	.177	.134	72857
5	6,00	4,90	.236	.193	72859
6	6,00	4,90	.236	.193	72859
7	6,00	4,90	.236	.193	72859
8	6,00	4,90	.236	.193	72859
9	7,00	5,50	.276	.217	72861
10	7,00	5,50	.276	.217	72861
11	8,00	6,20	.315	.244	72862

Tap holder type EU-0 ANSI

For taps according to **ANSI**-standard

352 M	Ø mm	# mm	Ø tum	# tum	Article- number
0-6	3,58	2,79	.141	.110	72863
8	4,27	3,33	.168	.131	72864
10	4,93	3,86	.194	.152	72865
12	5,59	4,19	.220	.165	72866
1/4"	6,48	4,85	.225	.191	72867



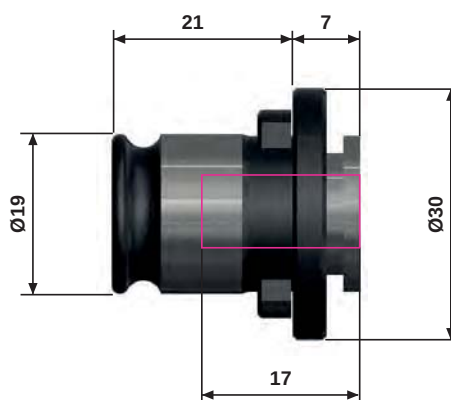
Tap holder type EU-1 ISO

For taps according to **ISO**-standard

M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
3	3,15	2,50	.124	.098	73002
3,5	3,55	2,80	.140	.110	73004
4	4,00	3,15	.157	.124	73006
4,5	4,50	3,55	.177	.140	73009
5	5,00	4,00	.197	.157	73011
6	6,30	5,00	.248	.197	73015
7	7,10	5,60	.280	.220	73018
8	8,00	6,30	.315	.248	73029
9	9,00	7,10	.354	.280	73022
10	10,00	8,00	.394	.315	73025
11	8,00	6,30	.315	.248	73029
12	9,00	7,10	.354	.280	73022

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Tap holder type EU-1



Tap holder type EU-1 DIN

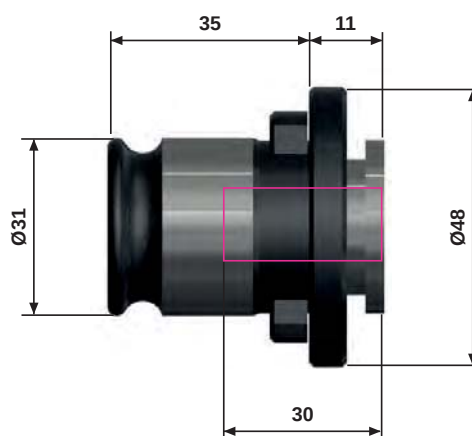
For taps according to **DIN**-standard

352 M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
3	3,50	2,70	.138	.106	73003
3,5	4,00	3,00	.157	.118	73005
4	4,50	3,40	.177	.134	73008
5	6,00	4,90	.236	.193	73014
6	6,00	4,90	.236	.193	73014
7	6,00	4,90	.236	.193	73014
8	6,00	4,90	.236	.193	73014
9	7,00	5,50	.276	.217	73017
10	7,00	5,50	.276	.217	73017
11	8,00	6,20	.315	.244	73019
12	9,00	7,00	.354	.276	73022
14	11,00	9,00	.433	.354	73027

Tap holder type EU-1 ANSI

For taps according to **ANSI**-standard

UNC, UNF NC, NF	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
0-6	3,58	2,79	.141	.110	73091
8	4,27	3,33	.168	.131	73007
10	4,93	3,86	.194	.152	73010
12	5,59	4,19	.220	.165	73012
1/4"	6,48	4,85	.225	.191	73016
5/16"	8,08	6,00	.318	.236	73020
3/8"	9,68	7,26	.381	.286	73024
7/16"	8,20	6,15	.323	.242	73021
1/2"	9,32	6,99	.367	.275	73023
9/16"	10,90	8,18	.429	.322	73026



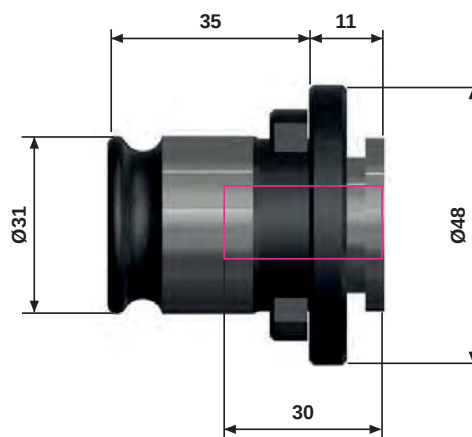
Tap holder type EU-2 ISO

For taps according to **ISO-standard**

M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
6	6,30	5,00	.248	.197	73033
7	7,10	5,60	.280	.220	73035
8	8,00	6,30	.315	.248	73036
9	9,00	7,10	.354	.280	73039
10	10,00	8,00	.394	.315	73042
11	8,00	6,30	.315	.248	73036
12	9,00	7,10	.354	.280	73039
14	11,20	9,00	.441	.354	73045
16	12,50	10,00	.492	.394	73048
18	14,00	11,20	.551	.441	73051
20	14,00	11,20	.551	.441	73051
22	16,00	12,50	.630	.492	73055

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Tap holder type EU-2



Tap holder type EU-2 DIN

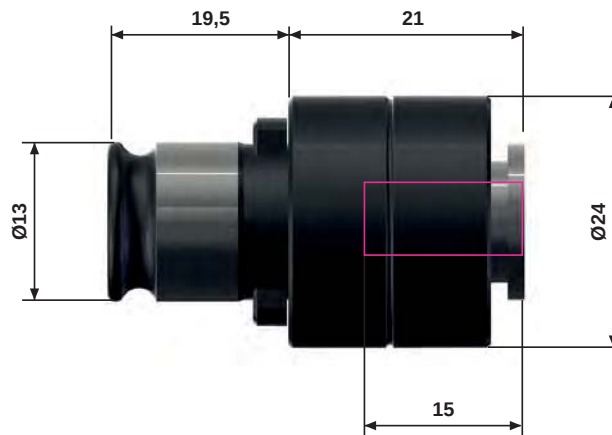
For taps according to **DIN**-standard

352 M	Ø mm	# mm	Ø tum	# tum	Article- number
5	6,00	4,90	.236	.193	73032
6	6,00	4,90	.236	.193	73032
7	6,00	4,90	.236	.193	73032
8	6,00	4,90	.236	.193	73232
9	7,00	5,50	.276	.217	73034
10	7,00	5,50	.276	.217	73034
11	8,00	6,20	.315	.244	73036
12	9,00	7,00	.354	.276	73039
14	11,00	9,00	.433	.354	73044
16	12,00	9,00	.472	.354	73046
18	14,00	11,00	.551	.433	73050
20	16,00	12,00	.630	.472	73054
22	18,00	14,50	.709	.571	73061

Tap holder type EU-2 ANSI

For taps according to **ANSI**-standard

UNC, UNF NC, NF	NPTS	Ø mm	# mm	Ø tum	# tum	Article- number
5/16"		8,08	6,00	.318	.236	73037
3/8"		9,68	7,26	.381	.286	73041
7/16"		8,20	6,15	.323	.242	73038
1/2"		9,32	6,99	.367	.275	73040
9/16"		10,90	8,18	.429	.322	73043
5/8"		12,19	9,14	.480	.360	73047
3/4"		14,99	11,23	.590	.442	73053
11/16"		17,45	13,08	.687	.515	73057
13/16"		15,56	12,42	.652	.489	73056
7/8"		17,07	13,28	.697	.523	73058
	3/8"	17,78	13,49	.700	.531	73059



Tap holder type EUK-0 ISO

For taps according to **ISO**-standard

M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
2	2,50	2,00	.098	.079	72950
3	3,15	2,50	.124	.098	72952
3,5	3,55	2,80	.140	.110	72954
4	4,00	3,15	.157	.124	72956
5	5,00	4,00	.197	.157	72958
6	6,30	5,00	.248	.197	72960

Tap holder type EUK-0 DIN

For taps according to **DIN**-standard

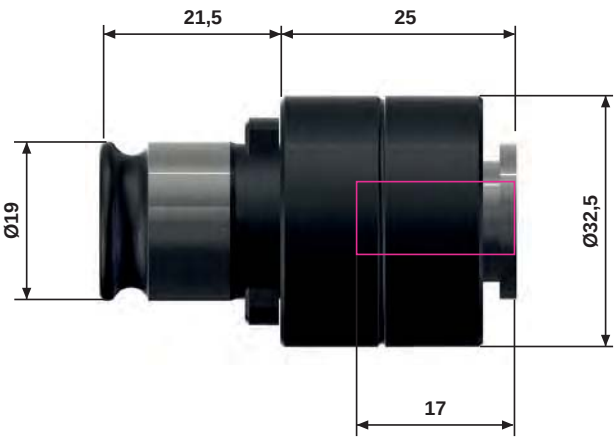
352 M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
1-1,8	2,50	2,10	.098	.083	72950
2	2,80	2,10	.110	.083	72951
2,5	2,80	2,10	.110	.083	72951
3	3,50	2,70	.138	.106	72953
3,5	4,00	3,00	.157	.118	72955
4	4,50	3,40	.177	.134	72957
5	6,00	4,90	.236	.193	72959
6	6,00	4,90	.236	.193	72959
7	6,00	4,90	.236	.193	72959
8	6,00	4,90	.236	.193	72959
9	7,00	5,50	.276	.217	72961
10	7,00	5,50	.276	.217	72961
11	8,00	6,20	.315	.244	72962

Tap holder type EUK-0 ANSI

For taps according to **ANSI**-standard

UNC, UNF NC, NF	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
0-6	3,58	2,79	.141	.110	72963
8	4,27	3,33	.168	.131	72964
10	4,93	3,86	.194	.152	72965
12	5,59	4,19	.220	.165	72966
1/4"	6,48	4,85	.225	.191	72967

Tap holder type EUK-1



Tap holder type EUK-1 ISO

For taps according to **ISO-standard**

M	Ø mm	# mm	Ø tum	# tum	Article-number
3	6,00	4,90	.236	.193	73032
3,5	6,00	4,90	.236	.193	73032
4	6,00	4,90	.236	.193	73032
4,5	6,00	4,90	.236	.193	73232
5	7,00	5,50	.276	.217	73034
6	7,00	5,50	.276	.217	73034
7	8,00	6,20	.315	.244	73036
8	9,00	7,00	.354	.276	73039
9	11,00	9,00	.433	.354	73044
10	12,00	9,00	.472	.354	73046
11	14,00	11,00	.551	.433	73050
12	16,00	12,00	.630	.472	73054

Tap holder type EUK-1 DIN

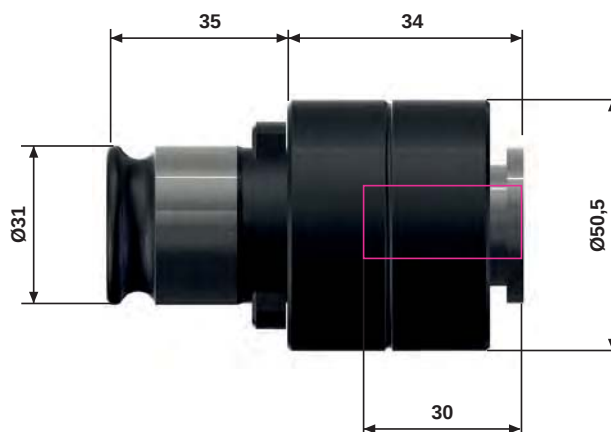
For taps according to **DIN**-standard

352 M	371 M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
3		3,50	2,70	.138	.106	73103
3,5		4,00	3,00	.157	.118	73105
4		4,50	3,40	.177	.134	73108
5		6,00	4,90	.236	.193	73114
6		6,00	4,90	.236	.193	73114
7		6,00	4,90	.236	.193	73114
8		6,00	4,90	.236	.193	73114
9		7,00	5,50	.276	.217	73117
10		7,00	5,50	.276	.217	73117
11		8,00	6,20	.315	.244	73119
12		9,00	7,00	.354	.276	73122
	10	10,00	8,00	.394	.315	73125
14		11,00	9,00	.433	.354	73127

Tap holder type EUK-1 ANSI

For taps according to **ANSI**-standard

UNC, UNF NC, NF	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
8	4,27	3,33	.168	.131	73107
10	4,393	3,86	.194	.152	73110
12	5,59	4,19	.220	.165	73112
1/4"	6,48	4,85	.225	.191	73116
5/16"	8,08	6,00	.318	.236	73120
3/8"	9,68	7,26	.381	.286	73124
7/16"	8,20	6,15	.323	.242	73121
1/2"	9,32	6,99	.367	.275	73123
9/16"	10,50	8,18	.429	.322	73126



Tap holder type EUK-2 ISO

For taps according to **ISO-standard**

M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
6	6,30	5,00	.248	.197	73133
7	7,10	5,60	.280	.220	73135
8	8,00	6,30	.315	.248	73136
9	9,00	7,10	.354	.280	73139
10	10,00	8,00	.394	.315	73142
11	8,00	6,30	.315	.248	73136
12	9,00	7,10	.354	.280	73139
14	11,20	9,00	.441	.354	73145
16	12,50	10,00	.492	.394	73148
18	14,00	11,20	.551	.441	73151
20	14,00	11,20	.551	.441	73151
22	16,00	12,50	.630	.492	73155

Tap holder type EUK-2 DIN

For taps according to **DIN**-standard

352 M	371 M	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
5		6,00	4,90	.236	.193	73132
6		6,00	4,90	.236	.193	73132
7		6,00	4,90	.236	.193	73132
8		6,00	4,90	.236	.193	73132
9		7,00	5,50	.276	.217	73134
10		7,00	5,50	.276	.217	73134
11		8,00	6,20	.315	.244	73136
12		9,00	7,00	.354	.276	73139
	10	10,00	8,00	.394	.315	73142
14		11,00	9,00	.433	.354	73144
16		12,00	9,00	.472	.354	73146
18		14,00	11,00	.551	.433	73150
20		16,00	12,00	.630	.482	73154
22		18,00	14,50	.709	.571	73161

Tap holder type EUK-2 ANSI

For taps according to **ANSI**-standard

UNC, UNF NC, NF	Ø mm	# mm	Ø t _{um}	# t _{um}	Article- number
5/16"	8,08	6,00	.318	.236	73137
3/8"	9,68	7,26	.381	.286	73141
7/16"	8,20	6,15	.323	.242	73138
1/2"	9,32	6,99	.367	.275	73140
9/16"	10,90	8,18	.429	.322	73143
5/8"	12,19	9,14	.480	.360	73147
3/4"	14,99	11,23	.590	.442	73153
1 1/16"	17,45	13,08	.687	.515	73157
1 3/16"	15,56	12,42	.652	.489	73156
7/8"	17,07	13,28	.697	.523	73158

Tap holder type T-ER



As the industry gets modernized and more machines can handle so called Rigid Tapping the demand for more stable tap holders has increased.

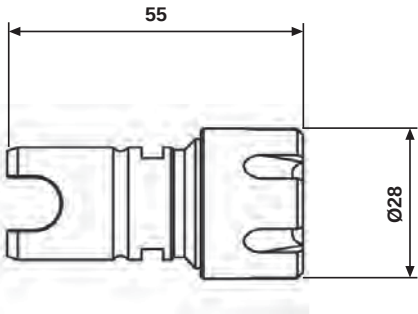
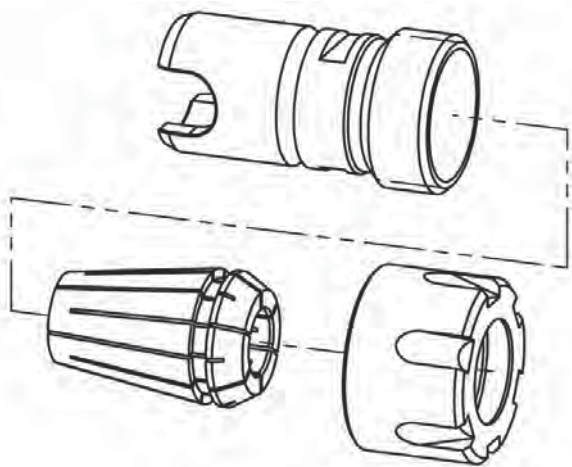
SPV Spintec has always been very responsive for the customers' comments and opinions. Therefore we have developed a completely new type of tap holder to meet today's modern machinery.

Our new tap holder type T-ER has been provided with a collet chuck type ER-20 in the front end which allows a very stable and accurate clamping of the tool.

At the same time it follows our previous standard of tapping devices and can easily be combined with our different types of tapping chucks. It still has the advantage of the quick and simple tool changes.

Article number

Tap holder T-12 ER-20 Art.no	Clamping nut ER-20 mini Art.no	Wrench for ER-20 mini nut Art.no	Wrench T-12 body Art.nr
36946	245.24.ER20M	CH.28.ER20M	*17710



SPV Spintec has developed a new type of tap holder adapted for threading dies.

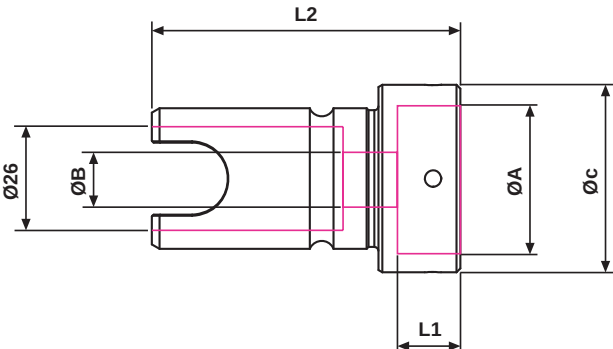
The new threading die holders are available for our standard size T-24 and fits dies from M3 to M24 from M3 to M24.

Being tailored to our ordinary tapping chuck program it can easily be combined with our different types of chucks, both with the floating movement and fixed models.

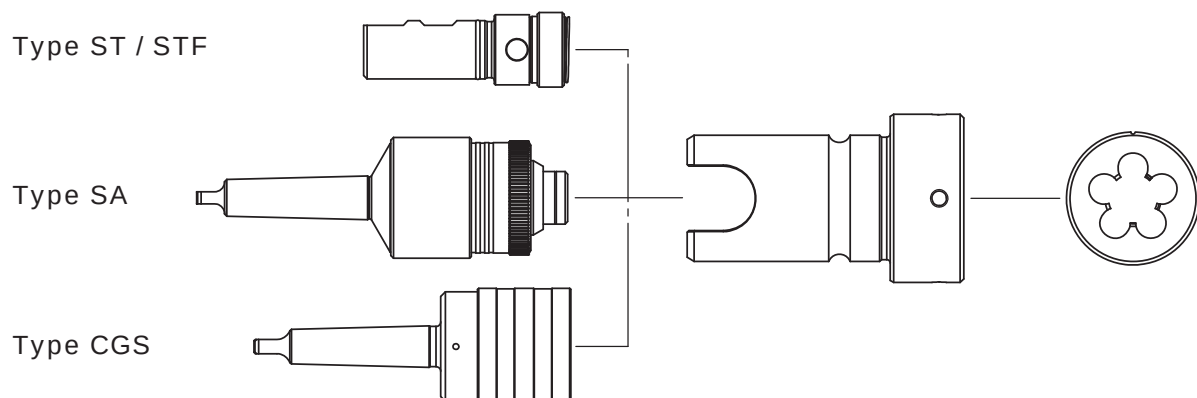
There is also a possibility to get the torque clutch function when combined with our SA tapping chuck.



Dimensions, article number

	ØA mm	ØB mm	Øc mm	L1 mm	L2 mm	Capacity	Article- number
	20	14	35	5	76	M3 - M4	22903
	20	14	35	7	76	M5 - M6	22905
	25	14	35	9	76	M8	22908
	30	26	40	11	76	M10	22910
	38	26	48	14	79	M12 - M14	22912
	45	26	55	18	83	M16 - M20	22916
	55	26	65	22	87	M24	22924

Possible combinations



C-chucks



Quick-change chucks type C

Fits SPV Spintec tap holders

Type	Internal taper	ØD mm	L tum	ØD tum	L tum	Tap holder	Article-number
C-8	J1	23	47	.905	1.850	T-8 / TK-8	28194
	B12	23	47	.905	1.850		36724
C-12	J2	30	49	1.181	1.930	T-12 / TK-12	20777
	B12	30	48	1.181	1.850		36583
	B16	30	53	1.181	2.085		36817
C-24	B18	50	87	1.968	3.425	T-24 / TK-24	27866



Arbors

Fits C-chucks

Type	mount, taper etc.	L mm	Article-number
B12	MK 2		27419
	Cyl. Ø10 x 46		27421
	TR 16 x 1,5	26	27587*
B16	MK 1		21104
	MK 2		20823
	MK 3		20824
	Cyl. Ø25 x 127		23092
	TR 16 x 1,5	28	21113*
	TR 20 x 2	28	21114*
	TR 28 x 2	30	21115*
B18	MK 2		22265
	MK 3		22266
	MK 4		22267
	TR 28 x 2	30	22269*
	TR 36 x 2	36	22070*

* adjustment ring included



Weldon extensions

Hole through for internal cooling

Shank Weldon Ø	Internal Weldon Ø mm	ØD mm	L mm	ØD tum	L tum	Article- number
25	25	36	100	1.417	3.937	37800
25	25	36	150	1.417	5.905	37799



RubberFlex collets for Jacobs-chucks

Fits tapping device	Collets	Ø mm	# mm	ØD tum	# tum	Article- number
ST-12 J /	J 420	4,5 - 8,0	2,3 - 8,0	.180 - .310	.090 - .310	17953
STF-12 J	J 421	3,5 - 6,5	2,3 - 8,0	.140 - .260	.090 - .310	18058
	J 422	6,5 - 10,0	2,3 - 8,0	.260 - .390	.090 - .310	17936
ST-16 J /	J 443	2,8 - 7,1	3,0 - 10,0	.110 - .280	.120 - .360	22195
STF-16 J	J 441	4,5 - 9,7	3,0 - 10,0	.180 - .380	.120 - .360	22197
	J 440	7,1 - 12,7	3,0 - 10,0	.280 - .500	.120 - .360	22196
ST-33 J /	J 461	10,0 - 16,0	8,0 - 18,0	.390 - .630	.315 - .710	37443
STF-33 J	J 462	16,0 - 23,0	8,0 - 18,0	.630 - .905	.315 - .710	37444



Nut and key for Jacobs-chucks

Nut type	ØD tum	Article- number	Key for nut to type	Article- number
ST-12 J /	32	41826	ST-12 J /	41827
STF-12 J			STF-12 J	
ST-16 J /	40	95207	ST-16 J /	95208
STF-16 J			STF-16 J	
ST-33 J /	56	37441	ST-33 J /	37442
STF-33 J			STF-33 J	

Operation - type CGS / CGS-C

■ Type CGS

An important function on our tapping CGS-chuck is the opportunity to set the collaring pressure. To achieve good thread quality it is important that the collaring pressure is adapted to the size of tap you are using and also relative to the type of material you are processing.

A hard collaring pressure makes the tap start to cut directly when feeding into the material.

Keep in mind that the tapping device is always set to maximum value when delivered.

■ 1. Releasing the collaring pressure

Loosen both of the screws counter clockwise just as much on both sides.

■ 2. Set the maximum collaring pressure

Push the outer sleeve so that the sliding-body reaches the bottom (A) and screw down both of the screws clockwise to stop (B). Finally unscrew both of them one round (counter clockwise).

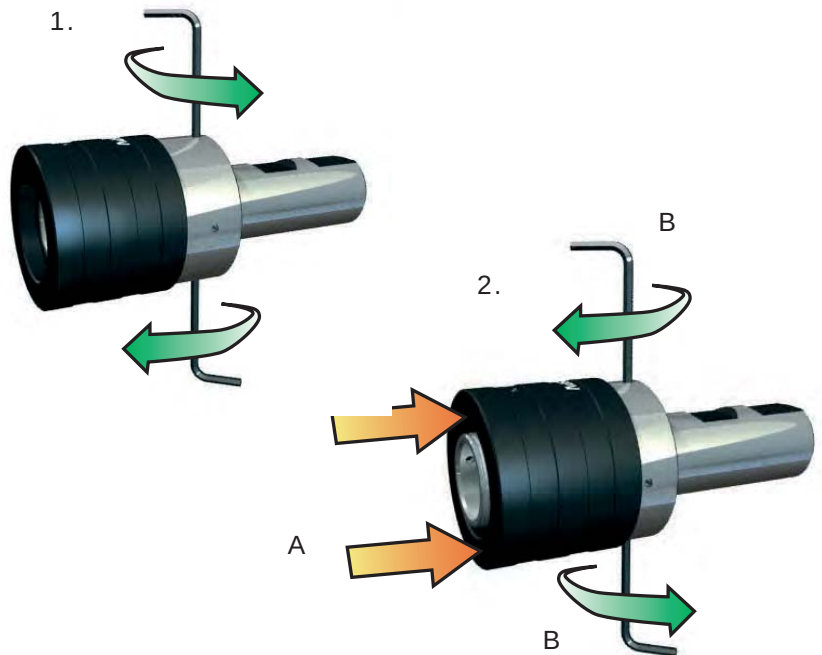
■ Guideline values for standard steel

M3 - M8	40 - 80 N
M9 - M16	80 - 170 N
M18 - M30	170 - 200 N

■ Tapping chuck type CGS-C for internal cooling

The type CGS-C is designed to be used with internal cooling and manages a coolant pressure at **max 50 Bar**. CGS-C can be used with our tap holders type T and TC depending on which type of cooling you want.

Adjustable collaring pressure



CGS-C equipped with a tap holder type TC provides cooling along the shaft of the tap.



CGS-C equipped with tap holder type T provides cooling through for taps with internal cooling ducts.

■ Type GS

The tapping spindle type GS has an adjustable ball-bearing, axial movement (floating) which eliminates the machine spindles axial forces. This enables the use of taps with different pitch in multi-spindle machines. A hard collaring pressure makes the tap starting to cut directly when feeding into the material.

A major advantage of the GS is that the floating can be adjusted forward or backward to achieve the best results.

■ Putting into operation

The tapping chuck has an internal taper for assembling on to an arbor shaft, or directly on to the machine spindle. The internal taper is prepared with two holes for fixing it against the arbor. We always recommend fixation to the arbor taper by dowelling.

When mounting into a machine, please follow the 4 steps of the instruction.

1. Before assembling on a taper the floating movement shall be compressed to prevent the internal components from damages. Screw clockwise to the bottom.

2. Clean the internal taper and machine taper properly before assembling of the Tapping chuck.

3. Assembly with a hard push. Do not use a hammer or other violent treatment.

4. Re-tighten the floating screw counter clockwise and fix the taper by dowelling. Now the floating can be adjusted for best performance.

■ Adjusting the floating

The tapping chuck can be adjusted to allow full floating backwards, forwards or in both directions. Use an Allen key for adjustment, clockwise turning extend the forward movement and counter clockwise turning extend the backwards movement.

The tapping spindles total floating is:

GS-8	25 mm
GS-12	25 mm
GS-24	40 mm



■ Accessories

The tapping spindle type GS can be used along with SPV Spintecs tap holders type T and type TK.



IMPORTANT!

*To disassemble and assemble the unit, special tools are required.
Always send the device to SPV Spintec for service and repair.*

Operation - type SA / SA-NC

■ Type SA / SA-NC

Our tapping device type SA is available in two different models. A standard version (SA) and for CNC-machines (SA-NC). Both models have an adjustable torque-clutch. The SA-NC also have an extended backwards floating, and adjustable collaring pressure.

To achieve good thread quality it is important that the collaring pressure is adapted to the size of tap you are using and also relative to the type of material you are processing.

■ Adjusting the torque-clutch.

1. Clamp the tapping device in a Vice. We recommend that you clamp over the Morse Taper tounge to prevent damages on the device.
2. Release the locking screw (C).
3. Attach a torque-key (A) with an adjustment-adaptor (B) in the front of the tapping device.
4. Requested torque is received by turning the clutch sleeve (D) clockwise for increasing and counter clockwise for decreasing the torque.
5. Retighten the locking screw (C).

(adjustment-adaptor (B) can be bought separately.)

■ Adjusting the collaring pressure (SA-NC)

The collaring pressure is adjustable with an Allen key. Clockwise turning will increase and counterclockwise turning will decrease the collaring pressure.

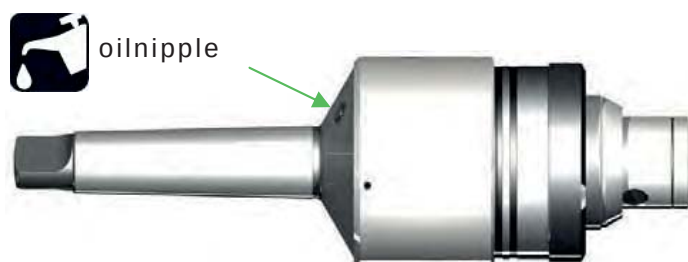
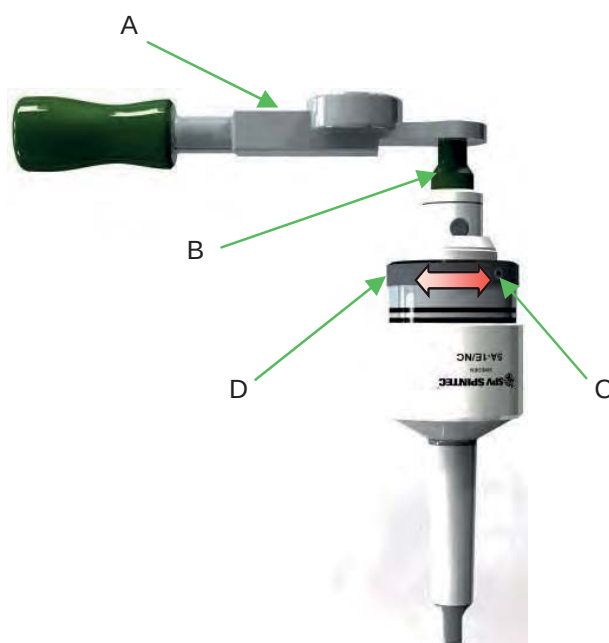
A hard collaring pressure makes the tap start to cut directly when feeding into the material.

Keep in mind that the tapping device is always set to maximum value when delivered.

■ Service and maintenance

Lubricate the tapping device by the oil nipple. Use only the prescribed lubrication.

Lubrication interval: Once a week is recommended for continuous and hard usage.



We recommend: Castrol Magna BD68

Thread M	UNC	W	Recommended torque Nm	Inch-lbs	Harder material that is difficult to process
M2			0,3	2,4	
M3	#4		0,5	5,2	+ 20 %
	#5	1/8"	0,9	7,8	
	#6		1,6	14	
M4		5/32"	1,8	16	
	#8		2,0	18	
M5			2,5	22	
	#10		3,0	28	
M6	#12		4,4	38	+ 30 %
	1/4"	1/4"	6,5	56	
M8			9,0	78	
	5/16"	5/16"	11,5	100	
M10	3/8"	3/8"	14,0	122	
	7/16"	7/16"	22,0	190	
M12			23,0	200	
M14			30,0	260	
	1/2"	1/2"	33,0	285	
M16	9/16"	9/16"	35,0	305	
	5/8"	5/8"	45,0	390	
M18			55,0	475	
M20	3/4"	3/4"	65,0	565	+ 50 %
M22			75,0	650	
	7/8"	7/8"	85,0	740	
M24			105,0	910	
M27	1"	1"	120,0	1040	
M30	1 1/8"	1 1/8"	150,0	1300	
	1 1/4"	1 1/4"	196,0	1700	
	1 3/8"	1 3/8"	261,0	2260	
	1 1/2"	1 1/2"	266,0	2475	

Rörgänga	Recommended torque Nm	Inch-lbs	Harder material that is difficult to process
1/8"	5,5	48	
1/4"	15,0	130	
3/8"	20,0	170	
1/2"	45,0	390	
5/8"	50,0	435	+ 50 %
3/4"	58,0	505	
7/8"	65,0	565	
1"	112,0	970	
1 1/8"	128,0	1110	
1 1/4"	142,0	1230	

