

**REVERSIBLE TAPPING ATTACHMENT**



SERIES 424:

- For use on vertical machines and machines with rotating non-reversing spindles.
- Right or Left hand tapping
- Smooth ball - clutch protects against tap breakage.
- Disengages smoothly and silently.
- Axial float ensures smooth tapping.
- Cushioned drive eliminates cross threading
- Planetary gear allows tap to retract 75% faster.
- Accurate depth control.
- Accurate batch and mass production.



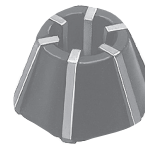
INCLUDES FREE COLLETS AND ARBOR

Order No.	Model No./ Capacity	Rubberflex Collets Included	Shank (Female)	Standard Arbor	Price
4240011	HR1	S161		1MTJT33	
4240012	1/16"-1/4"	S171	JT33	2MTJT33	
4240022	HR2	S212	JT6	2MTJT6	
4240023	1/8"-1/2"	S222		3MTJT6	
4240033	HR3	S413	JT3	3MTJT3	
4240034	5/16"-3/4"	S453		4MTJT3	
4240044	HR4	S613	JT4	4MTJT4	
4240045	9/16"-1-1/8"	S623		5MTJT4	

**RUBBER COLLETS**



SERIES 424:



Model No.	Capacity mm	Capacity Inch	Order No.	Price
S161	2.5 - 4.5	0.098 - 0.177	4240161	
S171	4.5 - 6.5	0.177 - 0.256	4240171	
S212	3.5 - 6.5	0.141 - 0.256	4240212	
S222	6.5 - 10.0	0.256 - 0.394	4240222	
S413	4.5 - 10.0	0.177 - 0.394	4240413	
S453	10.0 - 15.0	0.393 - 0.590	4240453	
S613	9.0 - 16.0	0.354 - 0.630	4240613	
S623	16.0 - 23.0	0.630 - 0.905	4240623	

\* Standard

MACHINE TOOL ACCESSORIES

**QUICK CHANGE TENSION & COMPRESSION TAPPING CHUCKS & COLLETS**



SERIES 424:

Tension and compression feature provides greater thread accuracy and higher production rates. Interchangeable with many other systems.



**HAND TAPPER**



SERIES 410:

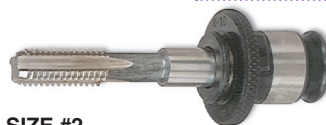


- Capacity: #6-5/8"**
- Assures straight perpendicular tapped holes using spiral pointed gun taps.
  - Furnished complete with tap guide, ground table (base), and tap spindle wrench.
  - Spindle - Hardened and precision ground.
  - 9 - adapters supplied - size #6, 8, 10, 1/4", 5/16", 3/8", 7/16", 1/2", 5/8".
  - No taps furnished.
  - Tray holds up to 12 adapters.

Specifications	Order No.	Price
Height	13"	
Clearance Height	7-7/8"	
Throat Depth	7-1/2"	4100010
Weight	47 lbs.	
Table	6-1/2 X 12-1/2"	

**Quick Change Positive Drive Tap Adapters**

Torque control tap adapters and Adapter Sizes #3 and #4 available. See our website or inquire.



ADAPTER SIZE #1

ADAPTER SIZE #2

TAP SIZE			Order No.	Price
Inch	mm	Pipe		
#6	1.6-3.5	-	3401036	
#8	4.0	-	3401041	
#10	4.5-5.0	-	3401048	
#12	-	-	3401054	
1/4	6.0, 6.3	-	3401063	
-	-	1/16, 1/8SS	3401098	
5/16	7.0, 8.0	-	3401079	
3/8	10.0	-	3401095	
7/16	11.0	-	3401111	
1/2	12.0, 12.5	-	3401127	
9/16	14.0	-	3401142	
-	-	1/8LS	3401096	

TAP SIZE			Order No.	Price
Inch	mm	Pipe		
5/16	7.0, 8.0	-	3402079	
7/16	11.0	-	3402111	
1/2	12.0, 12.5	-	3402127	
3/8	10.0	-	3402095	
9/16	14.0	-	3402142	
5/8	16.0	-	3402158	
11/16	18.0	-	3402174	
-	-	1/4	3402135	
3/4	-	-	3402190	
13/16	20.0	-	3402205	
-	-	1/2	3402209	
7/8	22.0	-	3402222	
-	-	3/8	3402166	

Straight Shank Chucks			
Shank Dia	Adapter Size	Order No.	Price
1	#1	4240001	
1	#2	4240002	
1-1/4	#2	4240003	

Morse Taper Shank Chucks			
Shank Dia	Adapter Size	Order No.	Price
1	#1	4240004	
2	#2	4240005	
3	#2	4240006	

CAT Shank Chucks			
Shank	Adapter Size	Order No.	Price
CAT40	#1	7338419	
	#2	7338431	
CAT50	#1	7338519	
	#2	7338531	



See page 537 for a complete selection of arbors.

**TAPPING UNITS**  
SERIES 670:

Collets must be ordered separately; see page 542.



Faster, more accurate tapping on any machine.  
Please inquire for any TAPMATIC items not shown.

**“X” WITH RUBBER-FLEX COLLET SPINDLE**

TORQUE CONTROL, SELF-REVERSING TAPPING UNITS

For Manually Operated Drilling and Milling Machines.

**FEATURES: & ADVANTAGES:**

- **SELF-FEED** - Permits the tap to act as its own lead screw to consistently produce gage perfect threads.
- **PRE-SELECTIVE TORQUE CONTROL** - A safety device which transmits machine power to the tap and helps prevent tap breakage.
- **RE-ENTRY CUSHION** - A cushioned drive to eliminate cross-threading.
- **RIGHT HAND TAPPING ONLY.**



Model	Capacity in 1010 Mild Steel	Collet Series	Mounts	Order No.	Price
30X *Rec Max Speed 2000 RPM	#0-1/4 M1.4-M6 Roll Form #10 Max.	21000 Series	JT6 JT33	6710306 6710333	
50X *Rec Max Speed 1500 RPM	#6-1/2 M3-M12 Roll Form 3/8" Max. NP 1/16", 1/8"	22000 Series	JT6 JT33	6710506 6710533	
70X *Rec Max Speed 1200 RPM	#10-5/8 M5-M16 Roll Form 1/2" Max.	24000 Series	JT3	6710703	
90X *Rec Max Speed 600 RPM	1/2 - 1-1/8" M10-M28 Roll Form 3/4" Max. NP 1/2"	26000 Series	JT4	6710904	

DIN and threaded mounts also available; please inquire.  
\*Run at speeds recommended by Tap Manufacturer, not to exceed this RPM.

**“RX SERIES” WITH RUBBER-FLEX COLLET CHUCK**

For Manually Operated Drilling and Milling Machines.

**FEATURES: & ADVANTAGES:**

- **INCREASED PRODUCTION**
- **NEW DURABLE, RUGGED DESIGN**
- **NEW HEAVY DUTY BALL CLUTCH**
- **PRE-SELECTIVE TORQUE DRIVE** - prevents tap breakage
- 1.75 x 1 Increased Reverse Speed
- **SELF-FEED** - Ensures gage perfect threads
- **RE-ENTRY CUSHION** - eliminates cross threading.



Model	Capacity in 1010 Mild Steel	Collet Series	Mounts	Order No.	Price
Rx 30 *Rec Max Speed 2000 RPM	#0-1/4 M1.4-M6 Roll Form #10 Max.	21000 Series	JT33 JT6 DIN B16	6713033 6713006	
Rx50 *Rec Max Speed 1500 RPM	#6-1/2 M3-M12 Roll Form 3/8" Max. NP 1/16", 1/8"	22200 Series	JT33 JT6 DIN B16	6715033 6715006	
Rx70 *Rec Max Speed 750 RPM	#10-3/4 M5-M18 Roll Form 9/16" Max.	24000 Series	JT3	6717003	

DIN and threaded mounts also available; please inquire.  
\*Run at speeds recommended by Tap Manufacturer, not to exceed this RPM.

**“SPD” WITH RUBBER-FLEX COLLET SPINDLE**

SHORT POSITIVE DRIVE, SELF-REVERSING TAPPING UNITS FOR N/C MACHINES WITH BORE CYCLES, AUTOMATED DRILL UNITS AND HIGH PRODUCTION MANUAL APPLICATIONS.

**FEATURES: & ADVANTAGES:**

- **POSITIVE DRIVE & REVERSE** - The full power of the machine is transmitted to the tap to eliminate slippage.
- **SHORT STROKE SELF-FEED** - Provides the minimum amount of float to compensate for lead error and still allows the tap to act as its own lead screw.
- **RE-ENTRY CUSHION** - Eliminates cross threading.



Model	Capacity in 1010 Mild Steel	Collet Series	*Rec. Max. Speed	Mounts	Order No.	Price
SPD3	#0-1/4" M1.4-M6 Roll Form #10 Max.	21000 Series	2000 RPM	JT6 JT33	6718306 6718333	
SPD5	#6-1/2" M3-M12 Roll Form 3/8" Max. NP 1/16", 1/8"	22000 Series	1500 RPM	JT6 JT33	6718506 6718533	
SPD7	#10-3/4" M5-M18 Roll Form 9/16" Max.	24000 Series	1200 RPM	JT3	6718703	
SPD9A	1/2 - 1-1/8" M10-M28 Roll Form 3/4" Max. NP 1/2"	26000 Series	600 RPM	JT4	6717904	

DIN and threaded mounts also available; please inquire.  
\* Run at speeds recommended by Tap Manufacturer, not to exceed this RPM.



See page 537 for a complete selection of arbors.

**TAPPING UNITS**  
SERIES 670:

Collets must be ordered separately; see below.



Faster, more accurate tapping on any machine. Please inquire for any TAPMATIC items not shown.

**TC/DC WITH RUBBER-FLEX COLLET SPINDLE**

SERIES 670:

Self-Reversing, Depth Control Tapping Units For Manually Operated Drilling And Milling Machines.

**Adjustable Depth Control:**

For shallow hole, controlled depth tapping. This provides an adjustable means of reducing or increasing the amount of self-feed required for any specific tapping operation. The self-feed of these units may be reduced to as little as .078.

**ORDER INFORMATION:**

- Please order by Order No. and tap size capacity.
- Order Rubber-Flex collets and arbors separately.
- Always mount a torque bar to keep the tapping attachment's stop arm from rotating; See page 541.



**FEATURES & ADVANTAGES:**

- **Pre-selective Torque Drive:** Prevents tap breakage.
- **1.75 x 1 Reverse Ratio:** Increases productivity.
- **Self-feed:** Ensures gauge perfect threads.
- **Re-Entry Cushion:** Eliminates cross-threading.
- **Right Hand Tapping Only.**

Capacity** 1010 Mild Steel	Model	Mount†	Collet Series	*Rec. Max. Speed	Adj. Self Feed	Order No.	Price
#0-1/4" M1.4-M6 Roll Form #10 Max	30TC/DC	#33JT #6JT	21000 Series	2000 RPM	.078-.140"	14333 14306	
#6-1/2" M3-M12 Roll Form 3/8" Max NP 1/16", 1/8"	50TC/DC	#33JT #6JT	22000 Series	1500 RPM	.078-.235"	14533 14506	
#10-5/8" M5-M16 Roll Form 1/2" Max	70TC/DC	#3 JT	24000 Series	1200 RPM	.078-.375"	14703	

\*Run at speed recommended by manufacturer, not to exceed this RPM.

† Threaded mounts available, please inquire.

\*\*Tool capacity must be reduced by 25% when using roll form taps.

**NSM WITH RUBBER-FLEX COLLET CHUCK**

TENSION/COMPRESSION TAPPING UNITS FOR NC MACHINING AND TURNING CENTERS. THE NSM IS THE MOST COMPACT TAP DRIVER AVAILABLE.

**FEATURES & ADVANTAGES:**

- **Tap Holding System:** Uses Rubber-Flex Collets. Only two required.
- **Tension/Compression Compensation:** Provides greater thread accuracy and higher production rates.
- **Compact Design:** For applications where space is limited.
- **Releasable Hard Start:** For accurate depth control.



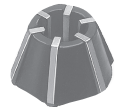
**ORDERING INFORMATION:**

- Please order by Order No. and Tap Size Capacity.
- Order Rubber-Flex collets separately. See below.

Capacity in 1010 Mild Steel*	Model	Shank	Collet Series	Order No.	Price
#0-1/4" M1.4-M6 Roll Form #10 Max	NSM2	5/8" SS	21000 Series	6735876	
#6-1/2" M3-M12 Roll Form 3/8" Max NP 1/16", 1/8"	NSM4	3/4" SS	22000 Series	6735881	
#10-3/4" M5-M18 Roll Form 3/4" Max	NSM6	1" SS	24000 Series	6735886	
1/2" - 1-1/8" M10-M30 Roll Form 3/4" Max NP 1/2"	NSM8	1-1/2" SS	26000 Series	6735893	

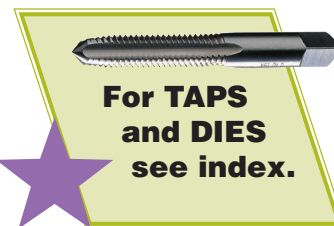
\* Tool capacity must be reduced by 25% when using roll form taps.

**RUBBER-FLEX COLLETS FOR TAPMATIC UNITS**



Collet Series	Collet Range Tap Size	Shank Size	Order No.	Price
#21000 Series for attachments with capacities (#0-1/4")	#0-#8	.098-.177	6721600*	
	#10-1/4"	.177-.256	6721700*	
		.040-.098	6721500	
#22000 Series for attachments with capacities (#6-1/2")	#0-1/4"	.139-.257	6722100*	
	1/4" - 1/2"	.253-.383	6722200*	
		.090-.180 .194-.318	6722300 6722000	
#24000 Series for attachments with capacities (#10-3/4")	#10-1/2"	.176-.383	6724100*	
	5/16" - 5/8"	.280-.500 .110-.280 .393-.590	6724000* 6724300 6724500	
#26000 Series for attachments with capacities (1/2" - 1-1/8")	1/2" - 3/4"	.360-.630	6726100	
	7/8" - 1-1/8"	.630-.900	6726200	

\* Standard





**TAPPING ACCESSORIES**

SERIES 670:



Faster, more accurate tapping on any machine. Please inquire for any TAPMATIC items not shown.

**“SFT” WITH STEEL COLLET SPINDLE FOR RIGID TAPPING**

Non-Reversing Units For Synchronous Tapping on CNC Machines.

**FEATURES & ADVANTAGES:**

Tapmatic's unique SynchroFlex tap drivers with internal coolant feature a precision machined flexor between the shank and the chuck. This design compensates axially and radially for the unavoidable minute discrepancies between the machine feed & traverse and the actual thread pitch & hole location.

Any deviation at all from the correct feed rate for the thread pitch or the precise hole location results in added wear on the tap. SynchroFlex allows the tap to reproduce itself exactly for maximum life and better thread quality.

**Coolant Through the Spindle Capability**

Standard SFT (shown) - up to 140 PSI or 10 bar.  
High Pressure SFTHP - up to 700 PSI or 50 bar available, please inquire.



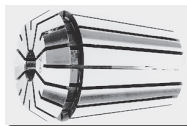
**ORDERING INFORMATION:**

- Order NC arbors separately. Tapmatic NC arbors provide the shortest overall length.
- Tool capacity must be reduced by 25% when using roll form taps.

Capacity 1010 Mild Steel	Model	Mount	Steel Collet Series	Order No.	Price
#2 - #10 M2 - M5	SFT10	1" SS	#11 Series	4310111	
#10-1/2" M5 - M12	SFT50	1" SS	#20 Series	4350120	
1/2" - 3/4" M12 - M20	SFT75	1" SS	#25 Series	4375125	

**Steel Collet without Square Drive for X**

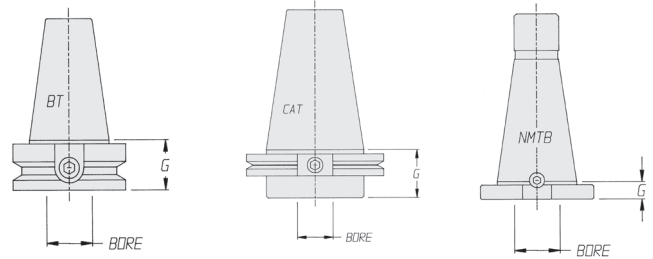
Please select Square Drive Collets whenever possible.



For #11 Series Collets see page 547 - 548.

Steel Collets w/o Internal Square Drive	Tap Size	Shank Size	Order No.	Price
#20 Series	#8	.168"	6721019	
	#10	.194	6721020	
	#12	.220	6721021	
	1/4"	.255	6721022	
	5/16"	.318	6721023	
	7/16"	.323	6721024	
#25 Series	1/2"	.367	6721025	
	3/8"	.381	6721026	
	7/16"	.323	6721030	
	1/2"	.367	6721032	
	3/8"	.381	6721034	
	9/16"	.429	6721036	
	5/8"	.480	6721038	
	11/16"	.542	6721040	
3/4"	.590	6721044		

**NC ARBORS FOR TAPMATIC HEADS**



NC ARBORS			
Arbor	Bore	Order No.	Price
CAT-40	1"	6723951	
CAT-45	1"	6723954	
CAT-50	1"	6723953	
CAT-50	1-1/2"	6723957	
BT-30	1"	6723949	
BT-35	1"	6723958	
BT-40	1"	6723952	
BT-45	1"	6723956	
BT-50	1"	6723955	
NMTB-40	1"	6723950	
CAT-40 Extended	5/8"	6723981	
CAT-50 Extended	5/8"	6723983	
BT-40 Extended	5/8"	6723982	
BT-50 Extended	5/8"	6723984	
Reducing Sleeve	1" to 3/4" (O.D.) to Bore	6723921	

**TORQUE BARS**

**TORQUE BARS FOR USE WITH SELF-REVERSING TAPPING ATTACHMENTS ON CONVENTIONAL MILLING MACHINES AND DRILL PRESSES**

Always mount a torque bar to keep the tapping attachment's stop arm from rotating. The torque bar should be securely mounted to the table or quill of your machine. The torque bar installation must be stronger than the largest tap. Please see instructions packaged with tapping attachments.

**Quill Mount Torque Bars -**

Clamp around Quill of Machine

Machine Quill Diameter	Tap Capacity	Order No.	Price
1-1/2" - 2-3/8"	1/2"	29099	
2-3/8" - 4-1/2"	3/4"	9290991	



**Table Mount Torque Bars -**

Mount to the "T" Slots of Table

Tap Capacity	Order No.	Price
3/4"	29097	
1-3/4"	29096	

