

	<p>Description</p> <p>Self-reversing CNC tapping attachments For vertical and horizontal CNC machining centers, for continuous production. Extended spindles and interchangeable shanks available.</p>	<p>Model</p> <p>RCT50 RDTIC, RDT RCT150 RDTICXT, RDTXT RDTIC HSK RDTICXT HSK SPD CNC ASR, RSR</p>	<p>Page</p> <p>6-9 10-11 12 13 14 15 16 17</p>
	<p>Synchronized Tapping For rigid tapping on CNC machines with/without internal coolant, ER or QC-collets.</p>	<p>SFT SX</p>	<p>18-24 25</p>
	<p>Tension compression tap chucks For use on CNC machining centers, lathes and all machines with controlled feed when tapping cycle is not synchronized.</p>	<p>NSM TA TIC NC</p>	<p>26-27 28 29 30</p>
	<p>Self-reversing manual tapping attachments with pre-selective torque drive Automatic reverse with increased reverse ratio. For manually operated drilling and milling machines. Heavy duty self-reversing tapping attachment also for machines with automatic feed</p>	<p>RX X TC/DC SPD/SPD-QC</p>	<p>31-32 33 34 35</p>
	<p>In machine marking Marking tools for in machine marking. Dot peen marking tool. Stamping head.</p>	<p>TapWriter MH</p>	<p>36-37 38-39</p>
	<p>Quick-change adapters Modular accessories, compatible with the respective tapping attachment or chuck.</p>	<p>P - positive drive T - torque control TF - rubber flex</p>	<p>40-41 42 43</p>
	<p>Various accessories For use on attachments and chucks.</p>	<p>Rubber flex collets ER-GB ER Clamping nuts Sealing disks</p>	<p>43 44-45 46 47 47</p>
	<p>Various accessories For use and installation of attachments and chucks on intended machines.</p>	<p>Torque wrenches Torque Bars Mounting device CNC Shanks Arbors</p>	<p>48 48 48 49- 50</p>
	<p>Cutting fluids and dispensers DryCut Economiser Dispensers</p>	<p>DryCut Economiser</p>	<p>51 51</p>

Thread production on machining centers with constant speed tapping

CNC-Attachments



CST Constant Speed Tapping relies on a compact tapping attachment to provide tap reversal. The machine spindle runs in one direction at the exact programmed speed and reversal occurs within the tapping attachment instantaneously upon machine retraction. This avoids the inevitable RPM fluctuations which occur with reversal of the machine spindle. Benefits include the following...

Reduced Cycle Time

By eliminating the machine spindles need to decelerate, stop, reverse and reaccelerate twice for each tapped hole the tapping time is dramatically reduced.

Longer Tap Life, Improved Thread Quality

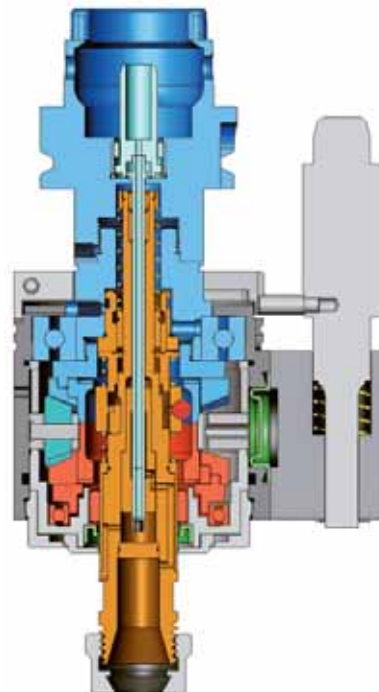
Constant speed tapping means that the tap is allowed to cut at the optimum speed continuously without deceleration at the bottom of the hole. The result is the longest tap life and improved thread quality.

Reduced Machine Spindle Wear

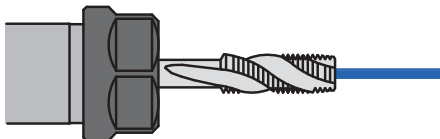
Tapping is the only operation requiring machine reversal. Using a Constant Speed Tapping Head eliminates this strain on the machine.

Reduced Energy Costs of up to 75 %

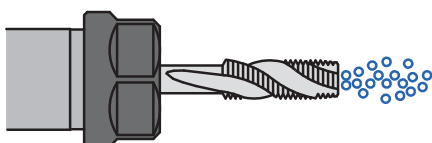
CST attachments reduce the energy costs required by machine spindle reversal by 75 %.



Two Through the Spindle Lubrication Options...



Standard balanced high pressure coolant through the spindle.



Minimum Quantity Lubrication, available on request.

Patented Design

TAPMATIC tapping attachments are fitted with a patented reversing gear as well as a patented ball drive. The ball drive allows for an exact, vibration-free and immediate change over into reverse once the desired thread depth is reached.

Advantages of tapping attachments with automatic reversal

General Information

Thread cutting is the only machining operation which requires a change of direction for the retraction of the tool. Reversing the spindle causes wear and is a costly procedure for any machine.

RCT and RDT / RDT-IC tapping attachments

These reversing tapping attachments are specially designed for fast thread production on CNC machining centers. They eliminate reversal related machine wear and tear and reduce energy consumption. The patented ball drive with integrated planet gear for automatic reversal creates an almost constant cutting speed and eliminates the need to stop and reverse the machine spindle twice per tapped hole.

By using the RDT and RCT tapping attachments the cycle time is reduced and the life of the tap is increased. The IC-version allows coolant to flow directly through the tapping head.

Case history:

Original Application

Thread cutting on a horizontal machining center Fritz Werner TC800 with internal coolant.

Material

GG20

Tap

M6 standard thread HSS with TIN-AL coating

Thread

M6 standard thread, 9 mm deep, tapping drill \varnothing 5.05 and 12.5 mm deep

Speed with machine reversal

Rigid tapping with spindle reversal, programmed speed 1,200 RPM

Original Results

Cycle time of 6 min 34 sec for 68 threads

Change with TAPMATIC

Using a TAPMATIC tapping attachment RDT-IC50 with ER16 spindle, programmed speed 1,800 RPM.

Improvement

Cycle time reduced to 3 min 22 sec for 68 threads, tap life tripled.

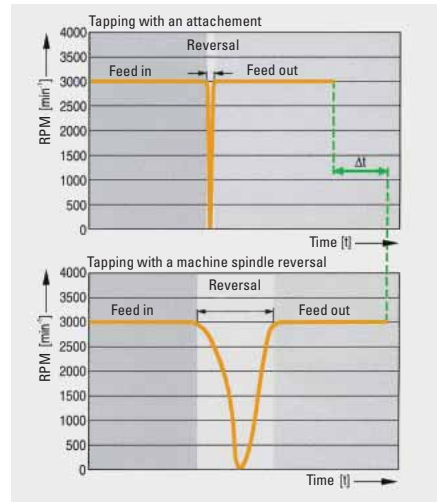
Advantage

Besides reducing the cycle time, tap life was considerably increased.

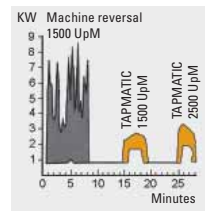
Results

- reduction of cycle time by 50%
- increase of production capacity
- tap life tripled
- less machine wear (no spindle reversals)
- roughly 75% energy savings by constant speed tapping

Constant speed tapping – the secret of longer tap life



Power consumption for 144 threads M8



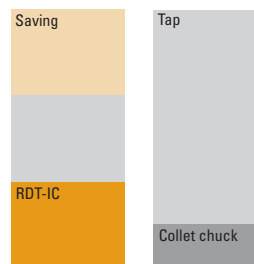
Energy cost saving of 75 %

Not only is the shorter cycle time of importance, but also the constant spindle direction. By changing the direction (decelerating and accelerating) of the spindle, higher spikes of power are needed, which can be prevented by constant spindle rotation.

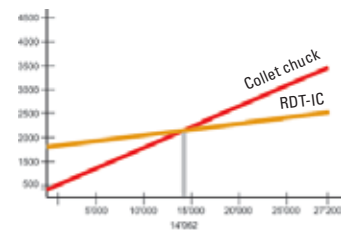
Cost Savings

Costs	Tapping attachment RDT-IC	Tension compression chuck with machine reversal
Number of threads/part	68	68
Number of parts	400	400
Cycle time per part/min	3.36	6.56
Cycle time in hours	22.4	43.7
Machine hourly rate in \$	95	95
Number of taps	22	65
Tap costs in \$	370	1093
Production costs in \$	2,117	4,132
Chuck costs in \$ (approx.)	2,025	600
Total costs in \$	4,512	5,825
Cost reduction in \$	1,313	

Total cost/year



Break Even Point



Conclusion

With the use of Tapmatic constant speed tapping, the cycle time is less, which increases productivity. Additionally, machine repair / downtime and energy costs are reduced and tap life is dramatically improved.

High speed tapping attachments with integral HSK shank and internal coolant system

The RCT50 models are our newest series of self-reversing tapping attachments for CNC machining centers. Many years of experience, in demanding high production applications, have gone into the development of the RCT. They are ruggedly built to provide years of service at high speed and include our newly developed high pressure internal coolant system.

RCT stands for Reduced Cycle Time tapping. For high production tapping there is no faster way to tap. Eliminating machine reversal also saves wear and tear to the machine spindle caused by stopping and reversing two times for every tapped hole. It also reduces power consumption by as much as 75%, making it the greenest and most economical way to tap holes.

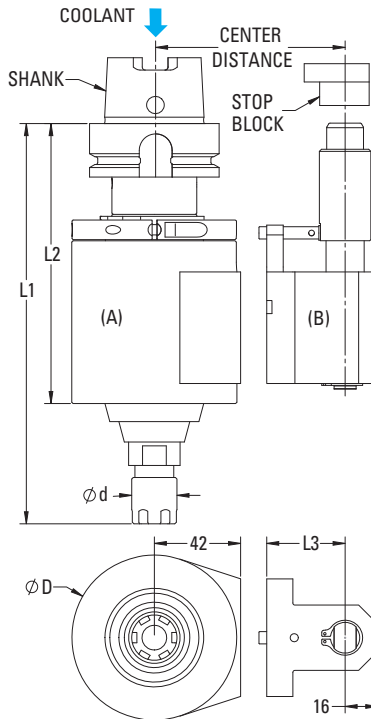
Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- rugged design for years of production, with little maintenance
- high pressure internal coolant system
- simple installation and programming

How to Order

Please select the Tapping attachment (A) and stop arm (B) to fit your machine. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.



(A) Tapping Attachment RCT HSK

Model	Order code	Capacity (steel)	Shank	Collets	Max. RPM	Weight kg	D	d	L1	L2
RCT50	0550H6316	M4.5-M12 #10-1/2"	HSK63A	ER16	2500	4.5	80	22	194	136
RCT50	0550H8016	M4.5-M12 #10-1/2"	HSK80A	ER16	2500	5.2	80	22	202	144
RCT50	0550H10016	M4.5-M12 #10-1/2"	HSK100A	ER16	2500	5.9	80	22	204	146

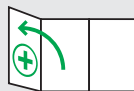
Notes: ER20 spindle also available on request. These internal coolant tools come standard with sealing nuts. When using Roll Form Taps the tool's capacity must be reduced 25%. All dimensions are shown in mm. 25.4mm = 1"

(B) Stop Arm Assembly

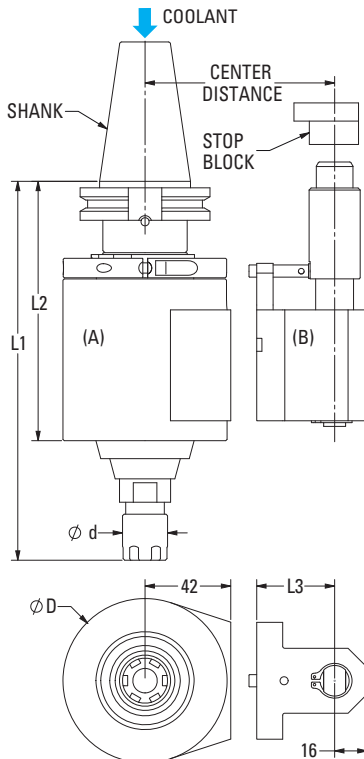
Center Distance (42+L3)	Order code RCT50	L3
55	055055	13
65	055065	23
80	055080	38



Stop Block
Page 55



High speed tapping attachments with integral shank and internal coolant system



Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- rugged design for years of production, with little maintenance
- high pressure internal coolant system
- simple installation and programming

How to Order

Please select the Tapping attachment (A) and stop arm (B) to fit your machine. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.

(A) Tapping Attachment RCT CAT, SK or BT



Model	Order code	Capacity (steel)	Shank	Collets	Max. RPM	Weight kg	D	d	L1	L2
RCT50	0550C4016	M4.5-M12 #10-1/2"	CAT40	ER16	2500	3.6	80	22	185	127
RCT50	0550C5016	M4.5-M12 #10-1/2"	CAT50	ER16	2500	5.4	80	22	185	127
RCT50	0550SK4016	M4.5-M12 #10-1/2"	SK40	ER16	2500	3.6	80	22	185	127
RCT50	0550SK5016	M4.5-M12 #10-1/2"	SK50	ER16	2500	5.4	80	22	185	127
RCT50	0550B4016	M4.5-M12 #10-1/2"	BT40	ER16	2500	3.6	80	22	185	127
RCT50	0550B5016	M4.5-M12 #10-1/2"	BT50	ER16	2500	6.3	80	22	196	139

Notes: ER20 spindle also available on request. These internal coolant tools come standard with sealing nuts. When using Roll Form Taps the tool's capacity must be reduced 25%. All dimensions are shown in mm. 25.4mm = 1"

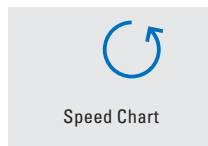
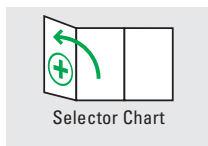
(B) Stop Arm Assembly



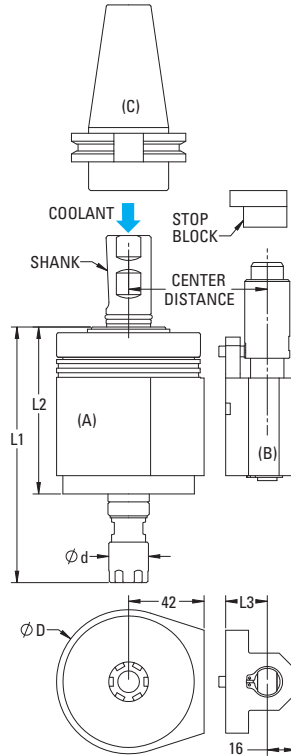
Center Distance (42+L3)	Order code	L3
55	055055	13
65	055065	23
80	055080	38



Stop Block
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High speed tapping attachments with modular straight shank and internal coolant system



Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- rugged design for years of production, with little maintenance
- high pressure internal coolant
- simple installation and programming
- large capacity

How to Order

Please select the Tapping attachment (A), stop arm (B) and CAT, SK, or BT shank (C), to fit your machine. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.

(A) Tapping Attachment RDTIC Cylindrical Shank



Model	Order code	Capacity (steel)	Shank	Collets	Max. RPM	Weight kg	D	d	L1	L2
RDTIC25	40252511	M2-M6	25 mm	ER11	4000	1.7	57	19	122	79
	4025111	#4-1/4"	1"							
RDTIC50	405025LW16MS	M4.5-M12	25 mm	ER16	2300	3.7	80	22	142	93
	40501LW16MS	#10-1/2"	1"							
RDTIC85HS	40852525S	M10-M20	25 mm	ER25	1500	4.4	80*	42	156	107
	4085125S	7/16"-3/4"	1"							
RDTIC85HD	40852532S	M12-M25	25 mm	ER32	1200	4.6	80*	50	162	107
	4085132S	1/2"-1"	1"							
RDTIC100	401002540S	M18-M27	25 mm	ER40	800	4.8	80*	63	168	107
	40100140S	3/4"-1"	1"							

■ on request

* Please note that the size 85 and 100 tools have an 80 mm square housing with Ø 102 mm across corners.

Notes: Other shanks are available on request.

These internal coolant tools come standard with sealing nuts.

To hold larger taps with RDT50 ER16, use standard collet 20953 and separate square drives packaged with tool.

Tools for ER20 collets are also available on request.

When using Roll Form Taps the tool's capacity must be reduced 25%.

All dimensions are shown in mm. 25.4mm = 1"

(B) Stop Arm Assembly



Center Distance (42+L3)	Order code RDTIC25	Order code RDTIC50	Order code RDTIC85 RDTIC100	L3
55	392555	395055		13
65	392565	395065	398565	23
80	392580	395080	398580	38



Stop Block
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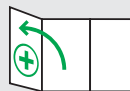
Interchangeable Steep Taper



Steel Collets



Sealing Gaskets



Selector Chart

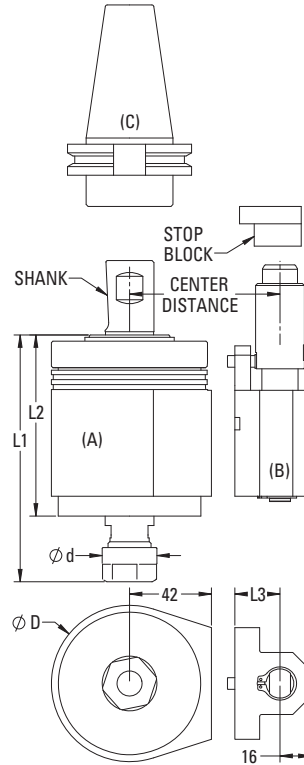


Speed Chart



Installation Programming

High speed tapping attachments with modular straight shank, without internal coolant system



Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- rugged design for years of production, with little maintenance
- simple installation and programming
- large capacity

How to Order

Please select the Tapping attachment (A), stop arm (B) and CAT, SK, or BT shank (C), to fit your machine. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.

(A) Tapping Attachment RDT Cylindrical Shank



Model	Order code	Capacity (steel)	Shank	Collets	Max. RPM	Weight kg	D	d	L1	L2
RDT15	3915258HD	M1-M3	25 mm	ER8	5000	1.7	57	12	97	79
	391518HD	#0-#6	1"							
RDT25	39252511	M2-M6	25 mm	ER11	4000	1.7	57	19	106	79
	3925111	#4-1/4"	1"							
RDT50	39502516	M4.5-M12	25 mm	ER16	2000	3.7	80	28	126	93
	3950116	10"-1/2"	1"							
RDT85HS	39852525	M10-M20	25 mm	ER25	1500	4.4	80*	42	151	107
	3985125	7/16"-3/4"	1"							
RDT85HD	39852532	M12-M25	25 mm	ER32	1200	4.6	80*	50	157	107
	3985132	1/2"-1"	1"							
RDT100	391002540	M18-M27	25 mm	ER40	800	4.8	80*	63	163	107
	39100140	3/4"-1"	1"							

* Please note that the size 85 and 100 tools have an 80 mm square housing with Ø 102 mm across corners.

Notes: When using Roll Form Taps the tool's capacity must be reduced 25 %.

To hold larger taps with RDT50 ER16, use standard collet 20953 and separate square drives packaged with tool.

All dimensions are shown in mm. 25.4mm = 1"

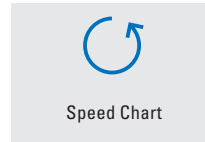
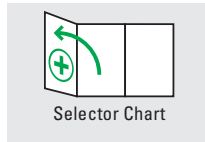
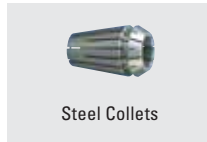
(B) Stop Arm Assembly



Center Distance (42+L3)	Order code RDT15 RDT25	Order code RDT50	Order code RDT85 RDT100	L3
55	392555	395055		13
65	392565	395065	398565	23
80	392580	395080	398580	38



Stop Block Page 55



Large capacity tapping attachments with modular straight shank and internal coolant system

The RCT150 is our new, large capacity self-reversing tapping attachment for CNC machining centers. Heavy duty precision gearing transmits high torque for reversing tap sizes up to M42. They are ruggedly built to provide years of service, and include high volume, high pressure internal coolant.

The RCT150 was developed for the large tapping applications required by the wind energy, heavy industry, and power generation fields. By eliminating machine spindle reversal, cycle time is dramatically improved, electrical power consumption is reduced by as much as 75% and wear and tear to the machine spindle caused by stopping and reversing twice for each tapped hole is eliminated.

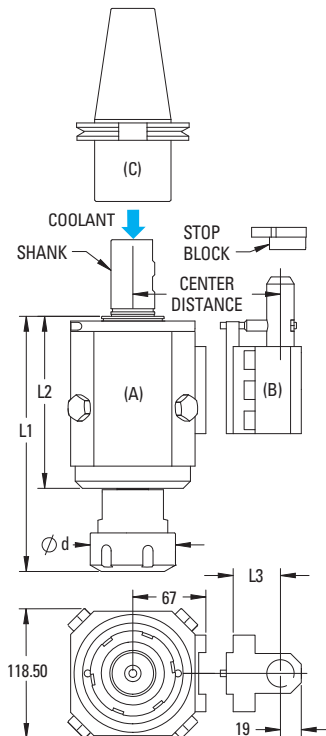
Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- rugged design for years of production, with little maintenance
- high pressure internal coolant system
- simple installation and programming

How to Order

Please select the Tapping attachment (A), stop arm (B) and CAT, SK, or BT shank (C), to fit your machine. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.



(A) Tapping Attachment RCT150 Cylindrical Shank

Model	Order code	Capacity (steel)	Shank	Collets	Max. RPM	Weight kg	d	L1	L2
RCT150	051504050	M25-M42 1"-1 5/8"	40 mm	ER50	500	6.2	78	234	158

Notes: When using Roll Form Taps the tool's capacity must be reduced 25%. All dimensions are shown in mm. 25.4mm = 1"

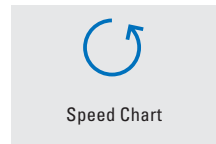
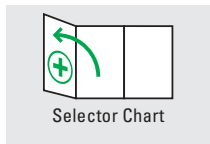
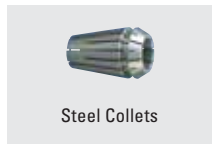
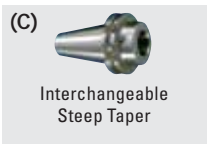


(B) Stop Arm Assembly

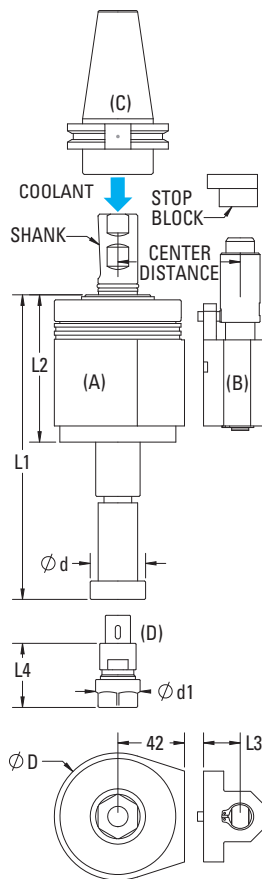
Center Distance (67+L3)	Order code RCT150	L3
80	0515080	13
110	05150110	43



Stop Block
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Extended length tapping attachments with modular straight shank



Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- extended length for difficult to reach holes
- rugged design for years of production, with little maintenance
- RDTICXT50 for high pressure internal coolant. RDTXT50 for machines without internal coolant
- simple installation and programming

How to Order

Please select the Tapping attachment (A), stop arm (B), shank (C) and collet chuck (D) to fit your application. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.

CNC-Attachments

(A) Tapping Attachment RDTICXT50 Cylindrical Shank, Internal Coolant System



Model	Order code	Capacity (steel)	Shank	Max. RPM	Weight kg	D	d	L1	L2
RDTICXT50	405025191	M4.5-M12	25 mm	2000	3.0	80	35	191	93
	40501191	#10-1/2"	1"						
RDTICXT50	405025255	M4.5-M12	25 mm	1800	3.2	80	35	255	93
	40501255	#10-1/2"	1"						

(A) Tapping Attachment RDTXT50 Cylindrical Shank, without Internal Coolant System

Modell	Order code	Capacity (steel)	Shank	Max. RPM	Weight kg	D	d	L1	L2
RDTXT50	395025191	M4.5-M12	25 mm	2000	3.0	80	35	191	93
	39501191	#10-1/2"	1"						
RDTXT50	395025255	M4.5-M12	25 mm	1800	3.2	80	35	255	93
	39501255	#10-1/2"	1"						

Notes: Special extended length tools are also available on request. When using Roll Form Taps the tool's capacity must be reduced 25 %. All dimensions are shown in mm. 25.4mm = 1"

(B) Stop Arm Assembly



Center Distance (42+L3)	Order code RDT50	L3
55	395055	13
65	395065	23
80	395080	38



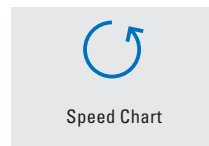
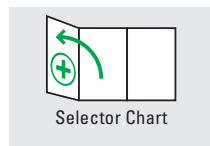
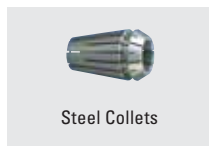
Stop Block
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(D) Collet Chuck



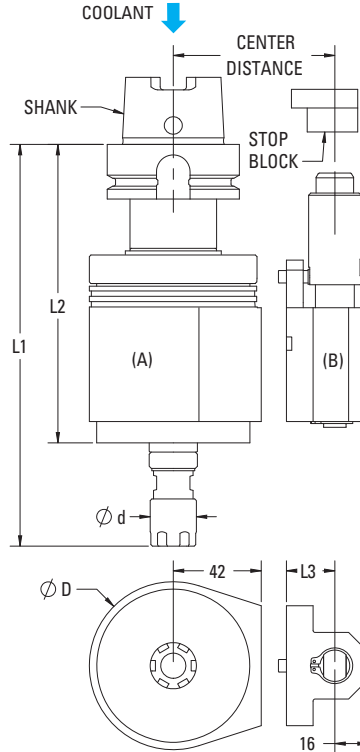
Collets	Order code Seal Nut	L4	d1
ER16	29378S	49	28
ER20	29391S	57	34

Collets	Order code Standard Nut	L4	d1
ER16	29378	44	28
ER20	29391	52	34



High speed tapping attachments with integral HSK shank and internal coolant system

CNC-Attachments



Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- rugged design for years of production, with little maintenance
- high pressure internal coolant
- simple installation and programming
- large capacity

How to Order

Please select the Tapping attachment (A) and stop arm (B) to fit your machine. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.

(A) Tapping Attachment RDTIC HSK Shank



Model	Order code	Capacity (steel)	Shank	Collets	Max. RPM	Weight kg	D	d	L1	L2
RDTIC50	4050H63LW16MS	M4.5–M12	HSK63A	ER16	2300	4.4	80	22	192	143
	4050H80LW16MS	#10–1/2"	HSK80A			5.2			196	147
	4050H100LW16MS		HSK100A			5.9			198	149
RDTIC85HS	4085H6325S	M10–M20	HSK63A	ER25	1500	5.1	80*	42	206	157
	4085H8025S	7/16"–3/4"	HSK80A			5.8			210	161
	4085H10025S		HSK100A			6.6			212	163
RDTIC85HD	4085H6332S	M12–M25	HSK63A	ER32	1200	5.3	80*	50	212	157
	4085H8032S	1/2"–1"	HSK80A			6.1			216	161
	4085H10032S		HSK100A			6.8			218	163
RDTIC100	40100H6340S	M18–M27	HSK63A	ER40	800	5.5	80*	63	218	157
	40100H8040S	3/4"–1"	HSK80A			6.3			222	161
	40100H10040S		HSK100A			7.0			224	163

■ on request

* Please note that the size 85 and 100 tools have an 80 mm square housing with Ø 102 mm across corners.

Notes: Other shanks are available on request.
 These internal coolant tools come standard with sealing nuts.
 Tools for ER20 collets are also available on request.
 When using Roll Form Taps the tool's capacity must be reduced 25%.
 All dimensions are shown in mm. 25.4mm = 1"

(B) Stop Arm Assembly



Center Distance (42+L3)	Order code RDTIC50	Order code RDTIC85	L3
55	395055		13
65	395065	398565	23
80	395080	398580	38



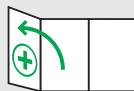
Stop Block
Page 55



Steel Collets



Sealing Gaskets



Selector Chart

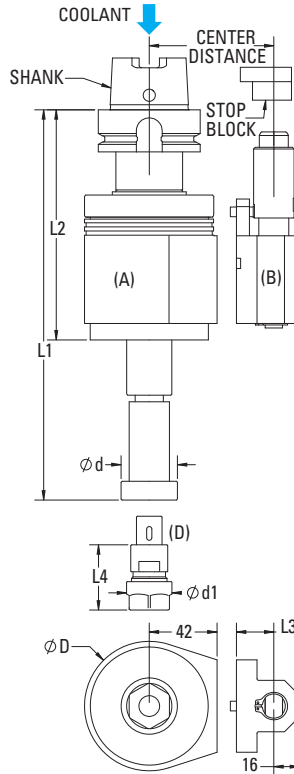


Speed Chart



Installation Programming

Extended length tapping attachments with integral HSK shank and internal coolant system



Features and Advantages

- high speed self-reversing tapping for fastest cycle time
- extended length for difficult to reach holes
- rugged design for years of production, with little maintenance
- RDTICXT50 for high pressure internal coolant
- simple installation and programming

How to Order

Please select the Tapping attachment (A), stop arm (B) and collet chuck (D) to fit your application. Accessories like steel collets, sealing gaskets and stop blocks are not included. Please order these separately.

Tapmatic can provide a complete tool ready to fit your machine. Please simply provide the information shown on installation page 55, fill in the form on the back cover or contact us directly.

(A) Tapping Attachment RDTICXT50 HSK Shank, Internal Coolant System



Model	Order code	Capacity (steel)	Shank	Max. RPM	Weight kg	D	d	L1	L2
RDTICXT50	4050H63241	M4.5–M12	HSK63A	2000	3.7	80	35	241	143
	4050H80245	#10–1/2"	HSK80A		4.5			245	147
	4050H100247		HSK100A		5.3			247	149
RDTICXT50	4050H63305	M4.5–M12	HSK63A	1800	3.9	80	35	305	143
	4050H80309	#10–1/2"	HSK80A		4.7			309	147
	4050H100311		HSK100A		5.5			311	149

Notes: Special extended length tools are also available on request. When using Roll Form Taps the tool's capacity must be reduced 25%. All dimensions are shown in mm. 25.4mm = 1"

(B) Stop Arm Assembly



Center Distance (42+L3)	Order code RDT50	L3
55	395055	13
65	395065	23
80	395080	38

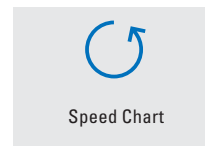
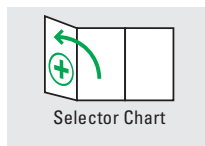
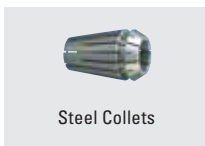
(D) Collet Chuck



Collets	Order code Seal Nut	L4	d1
ER16	29378S	49	28
ER20	29391S	57	34



Stop Block
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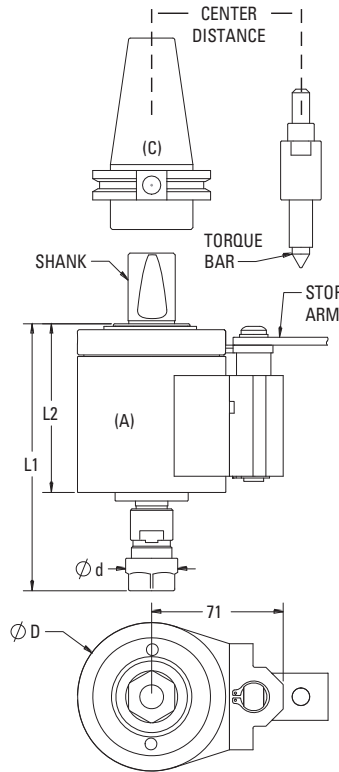
Economical tapping attachments with modular straight shank

The SPD CNC are low cost, self-reversing tapping attachments for CNC machining centers. They use ER collets and employ a simple stop arm system for easy installation on machines with automatic tool change.

The SPD CNC were developed specifically for short run job shop applications. Their low cost make them economical to use, and they provide all the advantages associated with the elimination of machine spindle reversal. Faster cycle time, elimination of machine spindle wear and tear due to reversal, lower energy costs and longer tap life.

- faster cycle time
- eliminates machine reversal for lower energy costs and reduced wear to machine spindle
- ER collets
- simple installation with torque bar and stop arm
- Stop Arm Assembly included
- simple programming

Please select the Tapping attachment and CAT, SK or BT shank to fit your machine. Please order accessories like collets, and torque bars separately. Please note the tool comes with a stop arm that can be modified or you can also order a readymade stop arm to fit your machine's bolt circle. Torque bar holders are not included and need to be ordered according to the bolt size of your machine.



(A) Tapping Attachment SPD CNC Cylindrical Shank

Model	Order code	Shank	Capacity (steel)	Collets	Max. RPM	Weight kg	d	L1	L2
SPD CNC3	0283251152	25 mm	M2-M6	ER11	2000	1.7	19	106	73
	0283111152	1"	#4-1/4"						
SPD CNC5	0285251652	25 mm	M4.5-M12	ER16	1500	3.7	28	140	91
	028511652	1"	#10-1/2"						

Notes: The SPD CNC tools include a stop arm assembly, but it is possible to use the RDT25 and 50 stop arm assemblies with them as well. When using Roll Form Taps the tool's capacity must be reduced 25%. All dimensions are shown in mm. 25.4mm = 1"



Stop Arm Plate

Order code	Center distance mm
723420	53-69
723421	68-77
723422	74-88
723423	86-100



Torque Bar Holder Assemblies

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(C)



Interchangeable Steep Taper



Steel Collets



Selector Chart



Speed Chart



Installation Programming

Tapping attachments with VDI shank for CNC lathes



Model RSR



Model ASR

Features and Advantages

- automatic reversal for faster cycle time
- lower energy cost
- improves tap life
- steel collets ER-GB (ER)
- modular VDI shank acc. to DIN 69880 (VDI3425)

Application

On CNC-lathes with live tools and VDI shank.

Radial Tapping Attachment RSR

Model	Order code	Capacity (steel)	Collets ER	Max. RPM
RSR50	37014	M4.5–M12	ER16	2500

Axial Tapping Attachment ASR

Model	Order code	Capacity (steel)	Collets ER	Max. RPM
ASR25	37030	M2.5–M7	ER11	3000
ASR50	32161	M4.5–M12	ER16	2500
ASR65	37048	M6–M16	ER20	1500

Note: Steel collets and VDI shank have to be ordered separately. The VDI shank is manufactured specifically for your lathe. When using Roll Form Taps the tools capacity must be reduced by 25%. Dimensions for the attachments available on request.

Right angle tapping attachment RSR50 VMC



- self-reversing right angle tapping attachment for machining centers
- capacity: M4.5–M12
- simple installation and programming, suitable for machines with automatic tool change
- automatic reversal for faster cycle time
- lower energy cost
- improves tap life
- eliminates secondary tapping operations
- on request

