

Tapping attachments for manual tapping application

**Drill-n-Tap**

For drilling and tapping with quick change spindle.

RX

Newest series for high production with heavy duty ball clutch.

**TC/DC**

Adjustable self feed for accurate depth control in shallow holes.

**X**

For general tapping with sensitive fiber clutch.

**SPD**

Positive drive for applications where torque control is not desirable. 1 to 1 reverse ratio simplifies adjustment of automatically controlled feed.

Tapping attachments for drilling and milling machines and pneumatic, hydraulic and electric spindles

Since 1952 Tapmatic has manufactured the world's most popular line of compact self-reversing tapping attachments. Our experience and commitment to quality make these tools an excellent value. Although there are other products available on the market, a Tapmatic head is still the most economical to use. Our customers know they can count on our tools for many, many years of service.

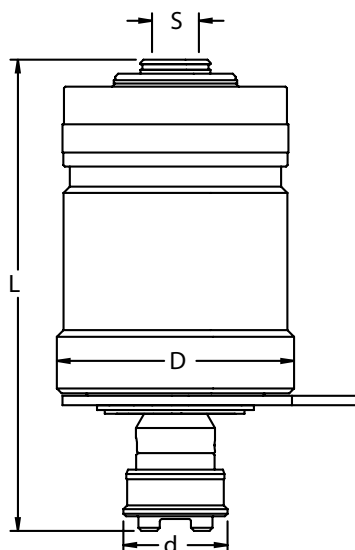
Tapmatic offers a complete program of self-reversing tapping attachments to meet the most difficult requirements. Ruggedly built, these Tapmatic tools provide higher production rates due to:

- decrease in tap breakage
- production of perfect threads
- reduced cycle time through increased 1.75:1 reverse speed
- longer tap life
- accurate depth control
- better thread quality
- consistent trouble free performance
- interchangeable mounts
- left hand versions available on request

**SPD-OC**

With quick change spindle. Recommended for pipe taps.

Self-reversing tapping attachment for drilling and tapping with high-speed reverse, pre-selective torque control and quick change



- for tapping and drilling
- great for combination drill-tap cutting tools.
- unique design for improved concentricity
- quick change for rapidly changing the cutting tool
- reduced cycle time when tapping thanks to 1.75 to 1 reverse speed
- less tap breakage due to pre-selective torque control
- adjustable self-feed and hard start for accurate depth control

How to Order

Please select the tapping attachment (A) and arbor (C) to fit your application. Choose an arbor to fit the thread or taper mount of the tapping attachment, with Morse Taper, R8 or straight shank to fit your machine. Please order quick change adapters and collets separately. Please order torque bars separately.

Dimensions

(A) Model	D mm	d mm	Self-feed mm T	Weight kg
Drill-n-Tap 30	60	25	2-4	0.8
Drill-n-Tap 50	80	35	2-5	2.0

Model	Order code	Tap Capacity (steel)	Adapter Size	Max. RPM	Mounts S		L
					Taper mounts	Thread. mounts	
Drill-n-Tap 30	014006	M1.4–M7 #0 - 1/4"	NR. 0	2000	JT6	1/2"–20	126
	014016				B16		
	014033				JT33		
	014050						
Drill-n-Tap 50	016006	M3–M12 #6 - 1/2"	NR. 1	1500	JT6	1/2"–20	159
	016016				B16		
	016033				JT33		
	016050						

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



Description	d1	d2
Nr. 0, P Type Tap Adapters	22	7
Nr. 1, P Type Tap Adapters	30	7



Order code	Adapter size	Collets Used	Clamping Ø	d1	d2
8138211N	Nr. 0	ER11	2.5-10	19	20-22
8208216	Nr. 1	ER16 (Mini nut)	2.5-10	22	24-27
8218220		ER20 (Mini nut)	2.5-13	28	35-38
8118220N		ER20 (Standard nut)	2.5-13	34	35-38

For tapping, the P type tap adapters may be used. Please order separately by tap size. See Pages 44-45.

The ER11, ER16 and ER20 quick change adapters use ER collets. They can be used together with ERGB (square drive collets) for tapping and with standard collets for holding center drills and drills. Please order separately.



Steel collets

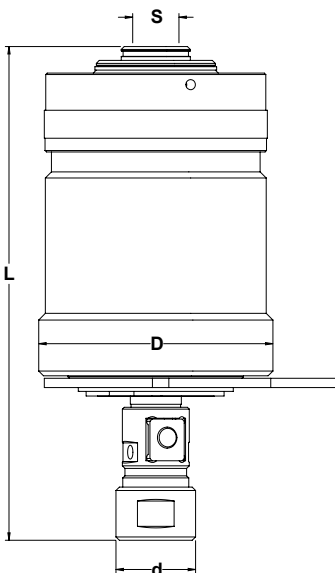


Arbors



Torque Bar

High production self-reversing tapping attachments with high-speed reverse and pre-selective torque control



- for high production tapping on drill press, and milling machines.
- unique design for improved concentricity.
- Rubber Flex collet spindle.
Only two collets required to cover the full tap capacity.
- reduced cycle time thanks to 1.75 to 1 reverse speed
- less tap breakage due to pre-selective torque control with heavy duty ball clutch
- easy adaptation with multiple interchangeable arbors

How to Order

Please select the tapping attachment (A) and arbor (C) to fit your application. Choose an arbor to fit the thread or taper mount of the tapping attachment, with Morse Taper, R8 or straight shank to fit your machine. Please order rubber flex collets and torque bars separately.

Dimensions

Model	D	d	Self-feed	Weight kg
Rx II 30	60	25	4	0.8
Rx II 50	80	35	5	2.0

(A)	Model	Order code	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Max. RPM	Mounts S		L
						Taper mounts	Thread. mounts	
	Rx II 30	114006	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	2000	JT6	1/2"-20	109
		114016				B16		
		114033				JT33		
		114050						
	Rx II 30	116006	M3–M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.5-10.0)	1500	JT6	1/2"-20	169
		116016				B16		164
		116033				JT33		
		116050						

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RF Multi-range Collets

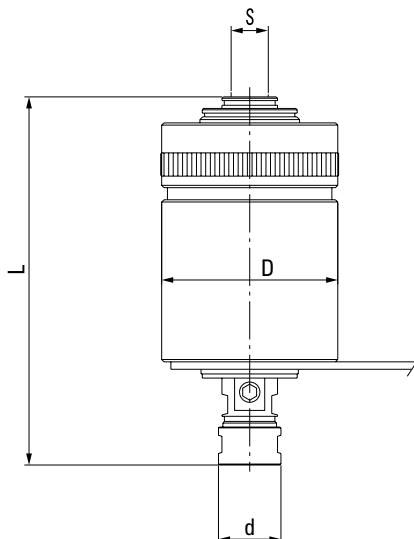


Arbors



Torque Bar

High production self-reversing tapping attachments with high-speed reverse and pre-selective torque control



- for hard to machine material and high torque applications like roll form tapping
- less tap breakage due to pre-selective torque control
- reduced cycle time through increased 1.75:1 reverse speed
- easy handling, compact design
- easy adaptation with multiple interchangeable arbors

How to Order

Please select the tapping attachment (A) and arbor (C) to fit your application. Choose an arbor to fit the thread or taper mount of the tapping attachment, with the Morse Taper, R8 or straight shank to fit your machine. Please order rubber flex collets and torque bars separately .

Dimensions

(A) Model	D mm	d mm	Self-feed mm T	Weight kg
RX30	53	19	3	0.7
RX50	76	27	5	1.8
RX70	88	36	7	3.0

Model	Order code	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Max. RPM	Mounts S		L
					Taper mounts	Thread. mounts	
RX 30	013006	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	2000	JT6	3/8"–24 1/2"–20	116
	013016				B16		
	013033				JT33		
	013037						
	013050						
RX 50	015006	M3–M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.5-10.0)	1500	JT6	1/2"–20	157
	015016				B16		
	015033				JT33		
	015050						
RX 70	017003	M5–M18 #10 - 3/4"	24100 (4.5-10) 24500 (10.0-15.0)	1200	JT3	1/2"–20 7/8"–20	182
	017050						
	017087						

Note: When using Roll Form Taps the tool's tapping capacity must be reduced by 25 %.
Special thread mounts are also available to fit Burgmaster machines.
All dimensions are shown in mm. 25.4mm = 1"



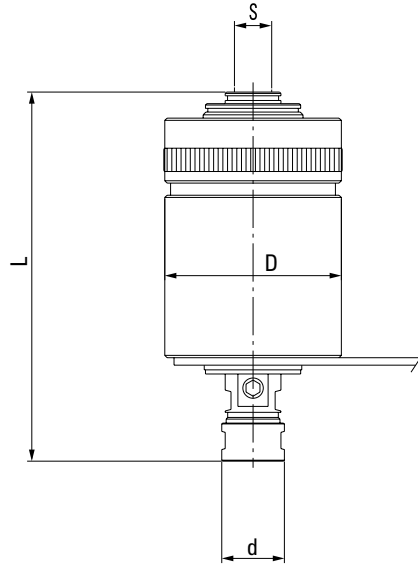
RF Multi-range Collets



Arbors



Torque Bar



- easy handling, compact design
- less tap breakage due to pre-selective torque control
- easy adaptation with multiple interchangeable arbors
- reduced cycle time through increased 1.75:1 reverse speed
- only 2 Rubber Flex collets per model required. (exception 100XB)

How to Order

Please select the tapping attachment (A) and arbor (C) to fit your application. Choose an arbor to fit the thread or taper mount of the tapping attachment, with the Morse Taper, R8 or straight shank to fit your machine. Please order rubber flex collets and torque bars separately.

Note: X models with Quick Change or ER collet chuck are also available on request.

Dimensions

Model	D	d	Self-feed	Weight kg
100XB	33	9	5	0.2
30X	48	19	3.5	0.5
50X	70	27	6	1.4
70X	76	36	9	2.1
90X	105	57	13	5.0

(A)	Model	Order code	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Max. RPM	Mounts S		L
						Taper mounts	Thread. mounts	
	100XB	16101	M0.5–M2, #0000-0	XB	2000	JT1		94
	30X	10306	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	2000	JT6		113
		10312				B12		
		10316				B16		
		10333				JT33		
		10331					5/16"–24*	104
		10337					3/8"–24	
		10350					1/2"–20	113
		10362					5/8"–16*	
		10375					3/4"–16*	
	50X	10506	M3–M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.5-10.0)	1500	JT6		153
		10516				B16		
		10533				JT33		
		10537					3/8"–24	148
		10550					1/2"–20	
		10562					5/8"–16*	
		10575					3/4"–16*	
	70X	10703	M5–M18 #10 - 5/8"	24100 (4.5-10) 24500 (10.0-15.0)	1200	JT3		176
		10718				B18		
		10750					1/2"–20	
		10762					5/8"–16*	
		10775					3/4"–16*	
		10787					7/8"–20	
	90X	10904	M10–M30 1/2" - 1 1/8"	26100 (10.0-16.0) 26200 (16.0-23.0)	600	JT4		219
		10915					1 1/2"–18	

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

* These special thread mounts are only for Burgmaster machines.

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



RF Multi-range Collets

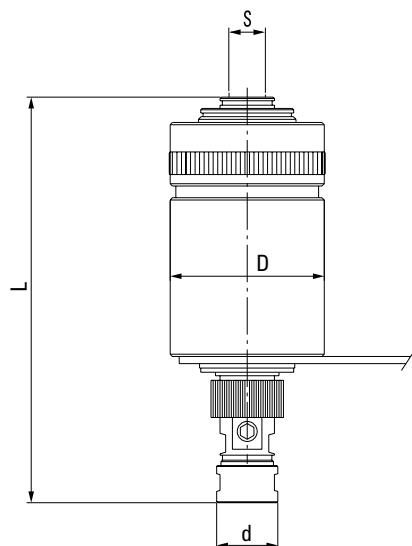


Arbors



Torque Bar

Self-reversing tapping attachments with high-speed reverse, pre-selective torque control and adjustment for shallow depth tapping



- adjustable depth control for shallow blind hole
- easy handling, compact design
- less tap breakage due to pre-selective torque control
- easy adaption with multiple interchangeable arbors
- reduced cycle time through increased 1.75:1 reverse speed
- only 2 Rubber Flex collets per model required.

How to Order

Please select the tapping attachment (A) and arbor (C) to fit your application. Choose an arbor to fit the thread or taper mount of the tapping attachment, with the Morse Taper, R8 or straight shank to fit your machine. Please order rubber flex collets and torque bars separately.

Dimensions

Model	D	d	Self-feed	Weight kg
30TC/DC	48	19	1.5–3.5	0.5
50TC/DC	70	27	2–6	1.2
70TC/DC	76	36	3–9	2.3

(A)	Model	Order code	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Max. RPM	Mounts S		L
						Taper mounts	Thread. mounts	
	30TC/DC	14306	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	2000	JT6		122
		14312				B12		
		14316				B16		
		14333				JT33		
		14331					5/16"–24*	113
		14337					3/8"–24	
		14350					1/2"–20	122
		14362					5/8"–16*	
	50TC/DC	14506	M3–M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.4-10.0)	1500	JT6		169
		14516				B16		
		14533				JT33		
		14537					3/8"–24	
		14550					1/2"–20	
		14562					5/8"–16*	
	70TC/DC	14703	M5–M18 #10 - 5/8"	24100 (4.5-10) 24500 (10.0-15.0)	1200	JT3		191
		14718				B18		
		14750					1/2"–20	
		14762					5/8"–16*	
		14787					7/8"–20	

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

* These special thread mounts are only for Burgmaster machines.

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



RF Multi-range Collets



Arbors



Torque Bar

Tapping attachments with automatic reversal for conventional machines



Dimensions

Model	D mm	d mm	Self-feed mm	Weight kg
SPD-3	53	19	3	0.5
SPD-5	69	27	5	1.4
SPD-7	76	36	7	2.1
SPD-9A	103	57	10	5.0
SPD-3 QC	53	28	3	0.5
SPD-5 QC	69	36	5	1.4
SPD-7 QC	76	54	7	2.1
SPD-9A QC	103	76	10	5.0
SPD-11 QC	146	90	13	14.0

Features and Advantages

- rugged design
- short lengths
- 1:1 reverse speed
- for heavy applications like drill tapping or roll form tapping
- SPD QC also recommended for pipe taps

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

* These special thread mounts are only for Burgmaster machines.

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

Model	Order code	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Max. RPM	Mounts S		L mm
					Taper mounts	Thread. mounts	
SPD-3	18306	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	2000	JT6	3/8"-24 1/2"-20 5/8"-16*	118
	18316				B16		
	18333				JT33		
	18337						105
	18350						113
	18362						
SPD-5	18506	M3–M12 #6 - 1/2"	22100 3.5-6.5) 22200 (6.5-10.0)	1500	JT6	3/8"-24 1/2"-20 3/4"-16* 7/8"-20	148
	18516				B16		
	18533				JT33		
	18537						138
	18550						
	18575						
SPD-7	18587	M5–M18 #10 - 5/8"	24100 (4.5-10.0) 24500 (10.0-15.0)	1200	JT3	1/2"-20 5/8"-16* 7/8"-20	148
	18703						175
	18750						162
	18762						
SPD-9A	18787	M10–M30 1/2" - 1 1/8"	26100 (10.0-16.0) 26200 (16.0-23.0)	600	JT4	1 1/2"-18	175
	17904						228
	17915						200
SPD-3 QC	18216	M1.4–M7 #0 - 1/4"	Nr 0	2000	B16	3/8"-24 1/2"-20 5/8"-16* 3/4"-16*	109
	18233				JT33		
	18237						96
	18250						104
	18262						
	18275						109
SPD-5 QC	18416	M3–M12 #6 - 1/2"	Nr 1	1500	B16	1/2"-20 5/8"-16* 7/8"-20	130
	18433				JT33		
	18450						122
	18462						
	18487						130
SPD-7 QC	18603	M5–M18 #10 - 5/8"	Nr 2	1200	JT3	1/2"-20 5/8"-16* 7/8"-20	159
	18650						147
	18662						
	18687						159
SPD-9 QC	17804	M10–M30 1/2" - 1 1/8"	Nr 3	600	JT4	1 1/2"-18	217
	17815						189
SPD-11 QC	18100	M22–M42, 3/4" - 2"	Nr 4	400		2 1/4"-10	236

Note: SPD-11 QC Recommended capacity 1 1/2" steel, 2" aluminum

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Torque Bar



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Quick-Change Adapters