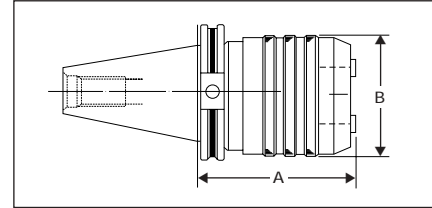


## TAPER-SHANK TAP HOLDERS

### RIGID TAP HOLDERS

Part No.	Description	A	B	Adapter
CTR4001	CAT40 / MRT#1	2.95	1.42	CWE 1
CTR4002	CAT40 / MRT#2	3.55	2.05	CWE 2
CTR5001	CAT50 / MRT#1	2.95	1.42	CWE 3
CTR5002	CAT50 / MRT#2	3.55	2.05	CWE 2
CTR5003	CAT50 / MRT#3	4.62	3.07	CWE 3
BTR3000	BT30 / MRT#0	3.38	1.02	CWE 0
BTR3001	BT30 / MRT#1	3.58	1.42	CWE 1
BTR3002	BT30 / MRT#2	4.16	2.05	CWE 2
BTR4001	BT40 / MRT#1	2.63	1.42	CWE 1
BTR4002	BT40 / MRT#2	3.23	2.05	CWE 2
BTR5001	BT50 / MRT#1	3.46	1.42	CWE 1
BTR5002	BT50 / MRT#2	4.05	2.05	CWE 2
BTR5003	BT50 / MRT#3	5.37	3.57	CWE 3



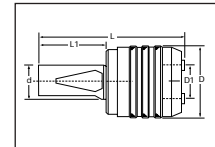
### TENSION-COMPRESSION TAP HOLDERS

Part No.	Description	A	B	Compensation		Adapter
				T	C	
CTC4001	CAT40 / MTC#1	2.95	1.42	0.30	0.30	CWE 1
CTC4002	CAT40 / MTC#2	3.85	2.16	0.49	0.49	CWE 2
CTC5001	CAT50 / MTC#1	3.26	1.42	0.30	0.30	CWE 1
CTC5002	CAT50 / MTC#2	3.85	2.16	0.49	0.49	CWE 2
CTC5003	CAT50 / MTC#3	5.79	3.07	0.79	0.79	CWE 3
BTC3001	BT30 / MTC#1	3.57	1.42	0.30	0.30	CWE 1
BTC3002	BT30 / MTC#2	4.48	2.16	0.49	0.49	CWE 2
BTC4001	BT40 / MTC#1	2.63	1.42	0.30	0.30	CWE 1
BTC4002	BT40 / MTC#2	3.54	2.16	0.49	0.49	CWE 2
BTC5002	BT50 / MTC#2	4.35	2.16	0.49	0.49	CWE 2
BTC5003	BT50 / MTC#3	5.61	3.07	0.79	0.79	CWE 3

## STRAIGHT-SHANK TAP HOLDERS

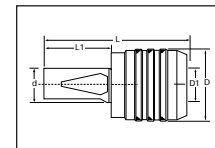
### RIGID TAP HOLDERS

Part No.	Description	d	D	D1	L	L1
MRT10000	MRT#0 / 1"	1.00	1.02	0.51	3.38	2.00
MRT07501	MRT#1 / 3/4"	0.75	1.42	0.75	3.15	1.57
MRT07502	MRT#2 / 3/4"	0.75	2.05	1.22	3.74	1.57
MRT10001	MRT#1 / 1"	1.00	1.42	0.75	3.58	2.01
MRT10002	MRT#2 / 1"	1.00	2.05	1.22	4.17	2.01
MRT15003	MRT#3 / 1-1/2"	1.50	3.07	2.36	6.25	3.00
MRT20004	MRT#4 / 2"	2.00	3.73	2.37	6.53	2.51



### TENSION-COMPRESSION TAP HOLDERS

Part No.	Description	d	D	D1	L	L1	Compensation	
							T	C
MTC07501	MTC#1 / 3/4"	0.75	1.42	0.75	3.15	1.57	0.30	0.30
MTC10001	MTC#1 / 1"	1.00	1.42	0.75	3.58	2.01	0.30	0.30
MTC10002	MTC#2 / 1"	1.00	2.16	1.22	4.49	2.01	0.49	0.49
MTC15003	MTC#3 / 1-1/2"	1.50	3.07	2.36	6.50	3.00	0.79	0.79



## TAP HOLDER SHANKS

Part No.	Description	Taper	Bore	Projection From Gauge Line
CT400100	CAT40 / 1"	CAT-V40	1.00	1.37
CT500100	CAT50 / 1"	CAT-V50	1.00	1.37
CT500150	CAT50 / 1-1/2"	CAT-V5	1.50	1.37
BT300100	BT30 / 1"	BT30	1.00	2.00
BT400100	BT40 / 1"	BT40	1.00	1.40
BT500100	BT50 / 1"	BT50	1.00	1.87
BT500150	BT50 / 1-1/2"	BT50	1.50	1.87



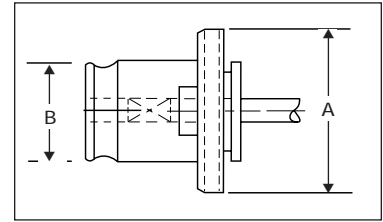
## POSITIVE-DRIVE TAP ADAPTERS

- Fully interchangeable with Bilz and other popular tapping systems
- Engineered for smooth operation and easy release



TAP ADAPTER  
DIMENSIONS

	A	B
CWE 0	0.87	0.51
CWE 1	1.18	0.75
CWE 2	1.89	1.22
CWE 3	2.75	1.89
CWE 4	3.62	2.36



Hand Tap Size	Tap Shank Dia.	Part No. CWE 0	Depth Tap Enters	Part No. CWE 1	Depth Tap Enters	Part No. CWE 2	Depth Tap Enters	Part No. CWE 3	Depth Tap Enters	Part No. CWE 4	Depth Tap Enters
0-6	0.141	000006	0.77	100006	0.85	200006	0.85				
#8	0.168	000008	0.84	100008	0.92	200008	0.92				
#10	0.194	000010	0.84	100010	0.92	200010	0.92				
#12	0.220	000012	0.87	100012	0.95	200012	0.95				
1/4	0.255	000250	0.87	100250	0.95	200250	0.95				
5/16	0.318			100312	0.98	200312	1.49				
3/8	0.381			100375	1.05	200375	1.56				
7/16	0.323			100437	1.08	200437	1.59				
1/2	0.367			100500	1.11	200500	1.62				
9/16	0.429			100562	1.17	200562	1.68				
5/8	0.480					200625	1.74				
11/16	0.542					200687	1.81				
3/4	0.590					200750	1.87				
13/16	0.652					200812	1.87	300812	2.42		
7/8	0.697					200875	1.93	300875	2.48		
15/16	0.760							300937	2.48		
1	0.800							301000	2.54	401000	3.60
1 - 1/8	0.896							301125	2.61	401125	3.70
1 - 1/4	0.021							301250	2.73	401250	3.79
1 - 3/8	1.108							301375	2.79	401375	3.86
1 - 1/2	1.233									401500	3.92
1 - 5/8	1.305									401625	3.72
1 - 3/4	1.430									401750	4.04
1 - 7/8	1.519									401875	4.04

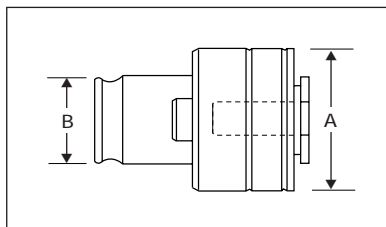
Pipe Tap Size	Tap Shank Dia.	Part No. CWE 1	Depth Tap Enters	Part No. CWE 2	Depth Tap Enters	Part No. CWE 3	Depth Tap Enters	Part No. CWE 4	Depth Tap Enters
1/8 - SS	0.313	105062	1.05	205062	1.49				
1/8 - LS	0.437	105063	1.05	205063	1.05				
1/4P	0.562			205125	1.18				
3/8P	0.700			205375	1.24	305375	1.32		
1/2P	0.687			205500	1.37	305500			
3/4P	0.906					301750	1.55	405750	2.20
1P	1.125					301100	1.68	4051000	2.40
1 1/4P	1.312							4051250	2.60
1 1/2P	1.500							4051500	2.60

NOTE: Metric, DIN and Japanese standard sizes upon special request.

# TORQUE CONTROL TAP ADAPTERS

## TAP ADAPTER DIMENSIONS

	A	B
CWES 0	0.91	0.51
CWES 1	1.26	0.75
CWES 2	1.97	1.22
CWES 3	2.84	1.89
CWES 4	3.74	2.37



Hand Tap Size	Part No. CWES 0	Part No. CWES 1	Part No. CWES 2	Part No. CWES 3	Part No. CWES 4
0-6	001006	101006			
8	001008	101008			
10	001010	101010			
12	001012	101012			
1/4	001250	101125			
5/16		101312	201312		
3/8		101375	201375		
7/16		101437	201437		
1/2		101500	201500		
9/16		101562	201562		
5/8			201625		
11/16			201687		
3/4			201750		
13/16			201812	310812	
7/8			201875	310875	
15/16				310937	
1				311000	411000
1 - 1/8				311125	411125
1 - 1/4				311250	411250
1 - 3/8				311375	411375
1 - 1/2					411500
1 - 5/8					411625
1 - 3/4					411750
1 - 7/8					411875

Pipe Tap Size	Part No. CWES 1	Part No. CWES 2	Part No. CWES 3	Part No. CWES 4
1/8 - SS	101062			
1/8 - LS	101063			
1/4 P		201126		
3/8 P		201376	311037	
1/2 P		201501	311050	
3/4 P			311075	415750
1" P			311100	4151000
1 1/4 P				4151250
1 1/2 P				4151500

## QUICK-CHANGE COOLANT-THROUGH TAP HOLDERS



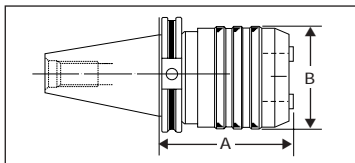
Uses *STANDARD TAP ADAPTERS* for oilhole taps in blind hole applications.



Uses *EXTERNAL COOLANT FLOW ADAPTERS* for standard taps in blind and through-hole applications.

- For use on machines with coolant through the spindle
- Rigid system for synchronous feed tapping
- Improves chip removal and prolongs tool life

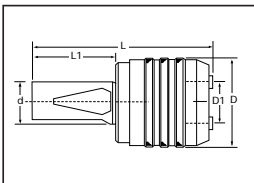
### TAPER SHANKS



Part No.	Description	A	B
CTK4001	CAT40 / MRK#1	2.95	1.42
CTK4002	CAT40 / MRK#2	3.55	2.05
CTK5001	CAT50 / MRK#2	2.95	1.42
CTK5002	CAT50 / MRK#3	3.55	2.05
BTK4001	BT40 / MRK#1	2.63	1.42
BTK4002	BT40 / MRK#2	3.23	2.05
BTK5001	BT50 / MRK#2	4.05	2.05
BTK5002	BT50 / MRK#3	5.37	3.57

### STRAIGHT-SHANK

Part No.	Description	d	D	D1	L	L1
MRK10001	MRK#1 / 1"	1.00	1.42	0.75	3.58	2.01
MRK10002	MRK#2 / 1"	1.00	2.05	1.22	4.17	2.01



### EXTERNAL COOLANT FLOW TAP ADAPTERS

Hand	Tap Shank Dia.	Part No. CWEK 1	Part No. CWEK 2
0-6	0.141	107006K	207006
8	0.168	107008K	207008
10	0.194	107010K	207010
12	0.220	107012K	207012
1/4	0.255	107125	207125
5/16	0.318	107312	207312
3/8	0.381	107375	207375
7/16	0.323	107437	207437
1/2	0.367	107500	207500
9/16	0.429	107562	207562
5/8	0.480		207625
11/16	0.542		207687
3/4	0.590		207750
13/16	0.652		207812
7/8	0.697		207875

Pipe Tap Size	Tap Shank Dia.	Part No. CWEK 1	Part No. CWEK 2
1/8 - SS	0.313	175062	275062
1/8 - LS	0.437	175063	275063
1/4	0.562		275125
3/8	0.700		275375
1/2	0.687		275500

NOTE: For standard adapters, see page 4.

## QUICK-CHANGE COOLANT-THROUGH TAP HOLDERS



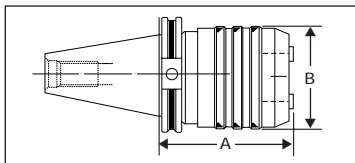
Uses *STANDARD TAP ADAPTERS* for oilhole taps in blind hole applications.



Uses *EXTERNAL COOLANT FLOW ADAPTERS* for standard taps in blind and through-hole applications.

- For use on machines with coolant through the spindle
- Rigid system for synchronous feed tapping
- Improves chip removal and prolongs tool life

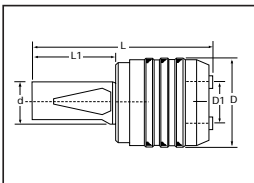
### TAPER SHANKS



Part No.	Description	A	B
CTK4001	CAT40 / MRK#1	2.95	1.42
CTK4002	CAT40 / MRK#2	3.55	2.05
CTK5001	CAT50 / MRK#2	2.95	1.42
CTK5002	CAT50 / MRK#3	3.55	2.05
BTK4001	BT40 / MRK#1	2.63	1.42
BTK4002	BT40 / MRK#2	3.23	2.05
BTK5001	BT50 / MRK#2	4.05	2.05
BTK5002	BT50 / MRK#3	5.37	3.57

### STRAIGHT-SHANK

Part No.	Description	d	D	D1	L	L1
MRK10001	MRK#1 / 1"	1.00	1.42	0.75	3.58	2.01
MRK10002	MRK#2 / 1"	1.00	2.05	1.22	4.17	2.01



### EXTERNAL COOLANT FLOW TAP ADAPTERS

Hand Tap Size	Tap Shank Dia.	Part No. CWEK 1	Part No. CWEK 2
0-6	0.141	107006K	207006
8	0.168	107008K	207008
10	0.194	107010K	207010
12	0.220	107012K	207012
1/4	0.255	107125	207125
5/16	0.318	107312	207312
3/8	0.381	107375	207375
7/16	0.323	107437	207437
1/2	0.367	107500	207500
9/16	0.429	107562	207562
5/8	0.480		207625
11/16	0.542		207687
3/4	0.590		207750
13/16	0.652		207812
7/8	0.697		207875

Pipe Tap Size	Tap Shank Dia.	Part No. CWEK 1	Part No. CWEK 2
1/8 - SS	0.313	175062	275062
1/8 - LS	0.437	175063	275063
1/4	0.562		275125
3/8	0.700		275375
1/2	0.687		275500

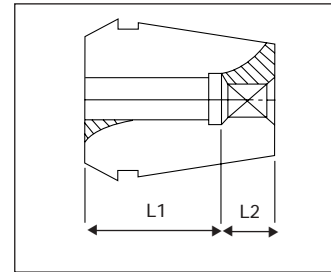
NOTE: For standard adapters, see page 4.

## RD/ER RIGID TAPPING COLLETS WITH SQUARE DRIVE

- Collet bore is exactly tool diameter for accuracy and rigidity
- Permit synchronous tapping operations using any standard collet chuck
- Available sealed for coolant-through applications

NOTE: Metric, DIN and Japanese standard sizes on request.

Tap Size Range	L1	L2				
		RTS 16	RTS 20	RTS 25	RTS 32	RTS 40
0-6 - 1/4	0.709	0.374	0.531	0.630	0.866	1.102
5/16 - 1/2	0.866		0.374	0.472	0.709	0.945
9/16 - 7/8	0.984			0.374	0.591	0.827
1"	1.102					0.709



Hand Tap Size	Part No. By Collet Series				
	RD 16	RD 20	RD 25	RD 32	RD 40
0-6	161-141	201-141	251-141	321-141	401-141
8	161-168	201-168	251-168	321-168	401-168
10	161-194	201-194	251-194	321-194	401-194
12	161-220	201-220	251-220	321-220	401-220
1/4	161-255	201-255	251-255	321-255	401-255
5/16	161-318	201-318	251-318	321-318	401-318
3/8		201-381	251-381	321-381	401-381
7/16		201-323	251-323	321-323	401-323
1/2		201-367	251-367	321-367	401-367
9/16			251-429	321-429	401-429
5/8			251-480	321-480	401-480
11/16				321-542	401-542
3/4				321-590	401-590
13/16				321-652	401-652
7/8					401-697
15/16					401-760
1					401-800



Pipe Tap Size	Part No. By Collet Series				
	RD 16	RD 20	RD 25	RD 32	RD 40
1/8 PIPE - SS			251-313	321-313	401-313
1/8 PIPE - LS			251-437	321-437	401-437
1/4 PIPE				321-562	401-562
3/8 PIPE					401-700
1/2 PIPE					401-687

## RDG/TG RIGID TAPPING COLLETS WITH SQUARE DRIVE

- Collet bore is exactly tool diameter for accuracy and rigidity
- Permit synchronous tapping operations using any standard collet chuck
- Available sealed for coolant-through applications

NOTE: Metric, DIN and Japanese standard sizes on request.



Hand Tap Size	Part No. By Collet Series		
	RDG 75	RDG 100	RDG 150
0-6	52001	72001	
8	52002	72002	
10	52003	72003	
12	52004	72004	
1/4	52005	72005	
5/16	52007	72007	
3/8	52008	72010	
7/16	52009	72008	
1/2	52010	72009	
9/16	52011	72011	
5/8	52013	72013	92001
11/16	52014	72014	
3/4	52015	72016	92002
13/16		72017	
7/8		72019	92003
15/16		72021	
1		72022	92004
1-1/8			92005
1-1/4			92006
1-3/8			92007
1-1/2			92008

Pipe Tap Sizes	Part No. By Collet Series		
	RDG 75	RDG 100	RDG 150
1/8 PIPE-SS	52006	72006	
1/8 PIPE-LS	52012	72012	
1/4 PIPE	52016	72015	92009
3/8 PIPE		72020	92010
1/2 PIPE		72018	92012
3/4 PIPE			92013
1 PIPE			92014
1-1/4 PIPE			92015

## RDT AXIAL COMPENSATING TAPPING COLLETS

- RDT Tapping Collets permit tapping operations using standard RD/ER collet holders
- Quick-change tap removal with solid square drive. Allows tap replacement without removing the tap collet from the chuck, while maintaining consistent tap gage length
- Friction-free ball bearing drive with axial compensation. Helps deter tap breakage on machines with synchronous feed or machines requiring axial compensation



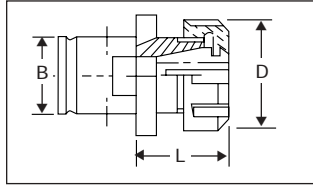
PATENT PENDING

Tap Size	Tap Shank Diameter	Part Number By Collet Series				
		RDT 16	RDT 20	RDT 25	RDT 32	RDT 40
#0-6	0.141	160-141	200-141T	250-141	320-141	400-141
#8	0.168	160-168	200-168	250-168	320-168	400-168
#10	0.194	160-194	200-194	250-194	320-194	400-194
#12	0.220		200-220	250-220	320-220	400-220
1/4"	0.255		200-255	250-255	320-255	400-255
5/16"	0.318			250-318	320-318	400-318
3/8"	0.381			250-381	320-381	400-381
7/16"	0.323			250-323	320-323	400-323
1/2"	0.367			250-367	320-367	400-367
9/16"	0.429				320-429	400-429
5/8"	0.480					400-480
11/16"	0.542					400-542
1/8 PIPE-LS	0.437				320-437	400-437
1/4 PIPE	0.562					400-562

NOTE: Metric, DIN and Japanese sizes available upon request.

## BF ADAPTERS FOR RD/ER COLLETS

- Quick-change adapters are interchangeable with Bilz and other popular tapping systems
- Collets permit holding ANSI and metric sizes
- Can be used for tapping and drilling

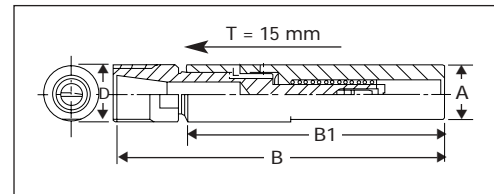


Part No.	Collet Series	Tap Range	B		L		D	
			(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)
BF0 1113	RD 11	0-6 - 1/4"	13	0.51	28	1.10	19	0.75
BF1 1619	RD 16	0-6 - 1/2"	19	0.75	25	1.35	28	1.10
BF2 2531	RD 25	0-6 - 3/4"	31	1.22	34	1.34	42	1.65
BF3 3248	RD 32	0-6 - 15/16"	48	1.89	48	1.89	50	1.97
BF3 4048*	RD 40	0-6 - 1-1/8"	48	1.89			63	2.48

\*NOTE: Available upon special request.

## FLOATING TAP HOLDERS

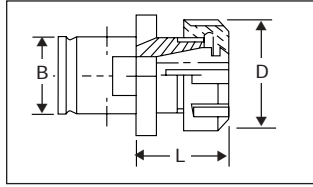
- Permits tapping using RD/ER 16 collet system
- Ideally suited for applications on Swiss and Japanese automats and lathes



Part No.	A		B		B1		D		Tension		Nut	Wrench
	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)		
2016100	20	0.79	176	6.93	100	3.94	28	1.10	15	0.59	RD 16 H	GS 25
222016	22	0.88	135	5.31	100	3.94	28	1.10	15	0.59	RD 16 H	GS 25
0341660		3/4	136	5.35	60	2.36	28	1.10	15	0.59	RD 16 H	GS 25
0341665		3/4	100	3.94	65	2.56	22	0.87	15	0.59	RD 16 M	E 16 M
0341600		3/4	176	6.93	100	3.94	28	1.10	15	0.59	RD 16 H	GS 25

## BF ADAPTERS FOR RD/ER COLLETS

- Quick-change adapters are interchangeable with Bilz and other popular tapping systems
- Collets permit holding ANSI and metric sizes
- Can be used for tapping and drilling

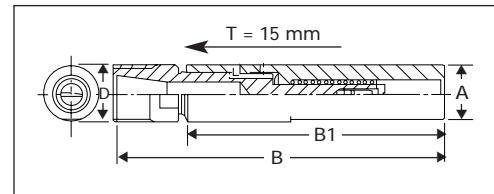


Part No.	Collet Series	Tap Range	B		L		D	
			(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)
BF0 1113	RD 11	0-6 - 1/4"	13	0.51	28	1.10	19	0.75
BF1 1619	RD 16	0-6 - 1/2"	19	0.75	25	1.35	28	1.10
BF2 2531	RD 25	0-6 - 3/4"	31	1.22	34	1.34	42	1.65
BF3 3248	RD 32	0-6 - 15/16"	48	1.89	48	1.89	50	1.97
BF3 4048*	RD 40	0-6 - 1-1/8"	48	1.89			63	2.48

\*NOTE: Available upon special request.

## FLOATING TAP HOLDERS

- Permits tapping using RD/ER 16 collet system
- Ideally suited for applications on Swiss and Japanese automats and lathes

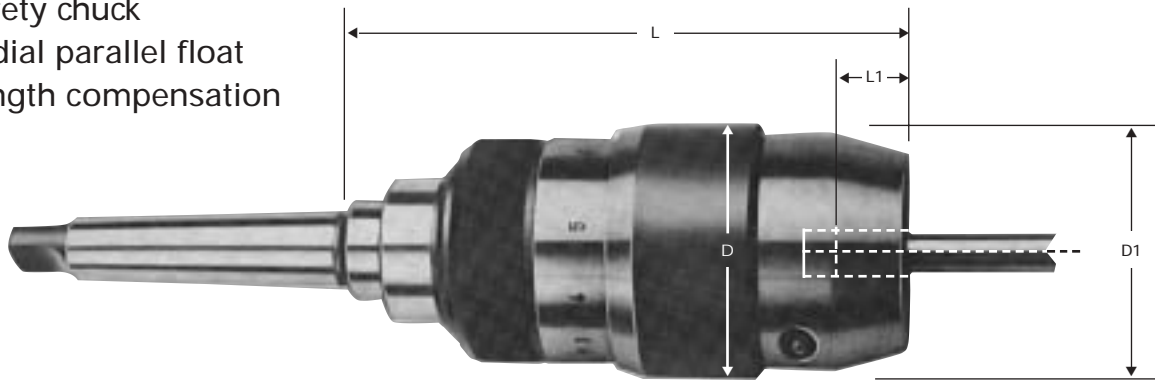


Part No.	A		B		B1		D		Tension		Nut	Wrench
	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)	(mm.)	(in.)		
2016100	20	0.79	176	6.93	100	3.94	28	1.10	15	0.59	RD 16 H	GS 25
222016	22	0.88	135	5.31	100	3.94	28	1.10	15	0.59	RD 16 H	GS 25
0341660		3/4	136	5.35	60	2.36	28	1.10	15	0.59	RD 16 H	GS 25
0341665		3/4	100	3.94	65	2.56	22	0.87	15	0.59	RD 16 M	E 16 M
0341600		3/4	176	6.93	100	3.94	28	1.10	15	0.59	RD 16 H	GS 25

## CDSPL ALL-PURPOSE TAPPING ATTACHMENT

For tapping operations on reversible drilling and tapping machines, lathes, mills, and others.

- Double chucking
- Safety chuck
- Radial parallel float
- Length compensation



### PRODUCT FEATURES

The Centaur CDSPL provides a wide-range, twin chucking head for the direct clamping of taps. There is no need for separate collets. An adjustable safety torque clutch helps prevent tap breakage. Radial parallel float compensates for misalignment between hole and tap. Length compensation on compression and tension compensates for the difference between machine feed and tap pitch.

**Chucking.** High concentricity, firm clamping, safe torque drive and large clamping range. CDSPL can accommodate standard square-ended taps. The tap is clamped by two adjustable sets of jaws. The four jaw set provides positive drive at the tap square. The three jaw set centers the tap perfectly. The two jaw sets move independently of one another, providing proper clamping despite any differential in the relation between the tap round shank and square.

**Safety Torque Clutch.** The safety clutch is infinitely variable to the required tap size torque by simply adjusting to scale. The safety clutch disengages when the preset torque is exceeded. After disengagement, there is virtually no torque on the tap, minimizing clutch wear. This prevents tool breakage. Blind holes can be bottom tapped under full rotation of the spindle. Reversing the spindle, the clutch re-engages and the tap is automatically withdrawn.

**Radial Parallel Float.** This ball-bearing float device guarantees threads to exact tolerance. It also protects misaligned taps against side thrust. It automatically centers after every tapping operation.

**Length Compensation.** Ball-cage length compensation provides smooth axial movement, even in the presence of maximum torque. This free axial movement prevents damage to thread flanks when the feed rate and tap pitch do not match. It also permits cutting small threads on heavy machines. The length compensation positions at zero point and is therefore also suitable for machine feed.

NOTE: CDSPL tapping attachment is suitable for right-hand threads only. For left-hand threads on request.

Part No.	Shank	Tap Range			Float	Length Comp.		D	D1	L	L1
		Metric	Inch	Pipe		Comp.	Tens.				
CDSPL-12-MT2	MT2	M3-M12	#6 - 1/2	1/8	0.039	0.393	0.787	2.283	2.086	5.314	0.708
CDSPL-12-MT3	MT3										-
CDSPL-12-SS1	1"										0.787
CDSPL-20-MT3	MT3	M8-M20	1/4 - 3/4	1/8 - 1/2	0.058	0.0393	0.787	3.267	2.992	6.732	0.905
CDSPL-20-MT4	MT4										-
CDSPL-20-SS1	1"										1.102
QCSPL-30-MT4*	MT4	M14-M30	13/16 - 1-3/8	3/4 - 1	0.078	0.393	1.181	4.173	2.835	10.080	
QCSPL-30-MT5*	MT5										

\* NOTE: Uses CWE3 Adapters. See page 4.

Keys	Part No.
CDSPL12	CDSPLK12
CDSPL20	CDSPLK20