



Tap Holders

Our Tapping systems include tension-compression and rigid holders in all tapers and shanks. Coolant-thru available for both tension-compression and rigid style holders.

Rigid Tap Holders

- Excellent for fast tapping on synchronous cycles
- Made to fit all Bilz Standard style tap collets
- Quick and easy interchangeability of tap collets
- Retention balls and drive keys provide higher positioning accuracy and stronger gripping force, reducing the possibility of tap slippage



Coolant-Thru Type

- Sealed internal mechanism allows high pressure center thru coolant to flow without contaminating the internal components
- Chambered design also prevents back-flow of coolant back into the spindle at high pressure
- Maximum pressure is 750 psi

Tension Compression Tap Holders

- Adaptive with all Bilz tap system sizes.
- Will compensate for the machine spindle over rotating, tap elongation or minor mismatching between rotation and feed.
- Spring tension (downward pressure) will help lead and engage the tap for consistent and on size tapped holes.
- Tension Compression holders assure accuracy and control to make sure the hole is tapped exactly on the pitch of the tap. This is extremely beneficial when tapping critical hole threads with 2B and 3B dimensional call outs.
- Quick and easy interchangeability of tap collets, repeatable within .008" positioning accuracy.
- Retention balls and drive keys provide higher positioning accuracy and stronger gripping force reducing the possibility of tap slippage.

Coolant-Thru Type

- Sealed internal mechanism allows high pressure center thru coolant to flow without contaminating the internal components.
- Chambered design also prevents back-flow of coolant into the spindle at higher pressures.
- Maximum pressure is 500 psi.

CAT Tap Holders



T.I.R.: minimal



Speed: up to 5,000 RPM



Set-up: quick and easy



Coolant-Thru: thru-tap coolant



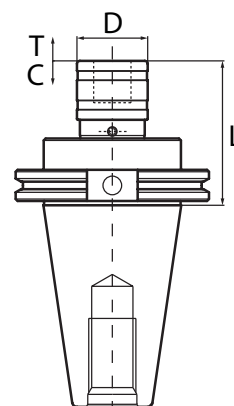
Tapping

- Made to fit all Bilz standard style tap collets
- Quick and easy interchangeability of tap collets
- Retention balls and drive keys provide higher positioning accuracy and stronger gripping force, reducing the possibility of tap slippage

Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

CAT40/50 Tension/Compression Tap Holders

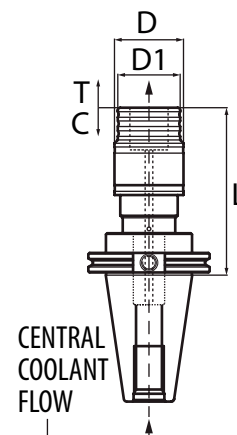
Part Number	Taper	Tap Range Hand	Pipe	System	L	D	T	C
C40S5-0562-2.93	CT40	#0-9/16"	1/8"	#1	2.93"	1.43"	0.29"	0.29"
C4005-0562-4.47	CT40	#0-9/16"	1/8"	#1	4.47"	1.25"	0.79"	0.39"
C40S5-0875-3.90	CT40	5/16-7/8"	1/4-1/2"	#2	3.90"	2.09"	0.49"	0.49"
C4005-0875-6.66	CT40	5/16-7/8"	1/4-1/2"	#2	6.66"	2.00"	0.85"	0.49"
C50S5-0562-2.93	CT50	#0-9/16"	1/8"	#1	2.93"	1.43"	0.29"	0.29"
C5005-0562-5.02	CT50	#0-9/16"	1/8"	#1	5.02"	1.25"	0.79"	0.39"
C50S5-0875-3.90	CT50	5/16-7/8"	1/4-1/2"	#2	3.90"	2.09"	0.49"	0.49"
C5005-0875-5.66	CT50	5/16-7/8"	1/4-1/2"	#2	5.66"	2.00"	0.85"	0.49"
C50S5-1375-5.75	CT50	13/16-1-3/8"	1/2-1"	#3	5.75"	3.07"	0.79"	0.79"
C5005-1375-7.72	CT50	13/16-1-3/8"	1/2-1"	#3	7.72"	2.87"	0.98"	0.59"



CAT40/50 Tension/Compression Tap Holders - Coolant-Thru

Part Number	Taper	Tap Range Hand	Pipe	System	L	D	D1	T	C
C4005-0562-3.98(C)	CT40	#0-9/16"	1/8"	#1	3.98"	1.57"	1.28"	0.27"	0.12"
C5005-0562-3.98(C)	CT50	#0-9/16"	1/8"	#1	3.98"	1.57"	1.28"	0.27"	0.12"
C5005-0875-5.39(C)	CT50	5/16-7/8"	1/4-1/2"	#2	5.39"	2.20"	1.99"	0.39"	0.20"

Note: Maximum pressure is 500 psi.



Tap Collets
Pages 168-179



Tap Spanner Wrench
Page 180



Tool Jaw
Page 234

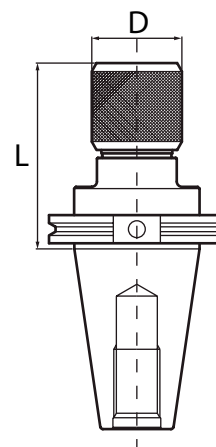
CAT Tap Holders

CAT40/50 Rigid Tap Holders

Part Number	Taper	Tap Range		System	L	D
		Hand	Pipe			
C40R5-0562-3.02	CT40	#0-9/16"	1/8"	#1	3.02"	1.25"
C40R5-0875-3.66	CT40	5/16-7/8"	1/4-1/2"	#2	3.66"	2.00"
C40R5-1375-4.72	CT40	13/16-1-3/8"	1/2-1"	#3	4.72"	2.87"
C50R5-0562-3.02	CT50	#0-9/16"	1/8"	#1	3.02"	1.25"
C50R5-0875-3.91	CT50	5/16-7/8"	1/4-1/2"	#2	3.91"	2.00"

Note:

- These holders are designed for use with synchronized machining centers.
- These holders have no tension or compression.

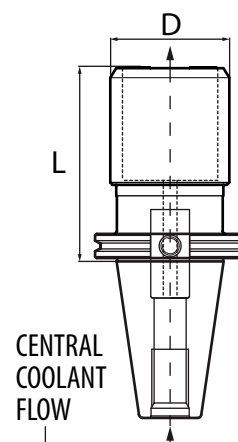


CAT40/50 Rigid Tap Holders - Coolant-Thru

Part Number	Taper	Tap Range		System	L	D
		Hand	Pipe			
C40R5-0562-2.87(C)	CT40	#0-9/16"	1/8"	#1	2.87"	1.26"
C40R5-0875-3.50(C)	CT40	5/16-7/8"	1/4-1/2"	#2	3.50"	1.97"
C50R5-0562-2.87(C)	CT50	#0-9/16"	1/8"	#1	2.87"	1.26"
C50R5-0875-3.50(C)	CT50	5/16-7/8"	1/4-1/2"	#2	3.50"	1.97"
C50R5-1375-5.00(C)	CT50	13/16-1-3/8"	1/2-1"	#3	5.00"	2.83"

Note:

- These holders are designed for use with synchronized machining centers.
- These holders have no tension or compression.
- Maximum pressure is 750 psi.



BT Tap Holders



T.I.R.: minimal



Speed: up to 5,000 RPM



Set-up: quick and easy



Coolant-Thru: thru-tap coolant



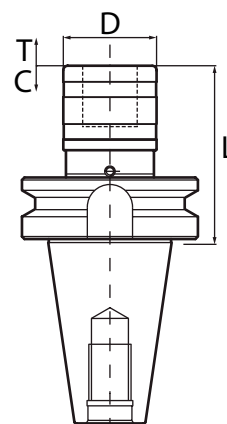
Tapping

- Made to fit all Bilz standard style tap collets
- Quick and easy interchangeability of tap collets
- Retention balls and drive keys provide higher positioning accuracy and stronger gripping force, reducing the possibility of tap slippage

Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

BT30/40 Tension/Compression Tap Holders

Part Number	Taper	Tap Range		System	L	D	T	C
		Hand	Pipe					
B30S5-0562-2.40	BT30	#0-9/16"	1/8"	#1	2.40"	1.43"	0.29"	0.29"
B40S5-0562-2.62	BT40	#0-9/16"	1/8"	#1	2.62"	1.43"	0.29"	0.29"
B4005-0562-4.33	BT40	#0-9/16"	1/8"	#1	4.33"	1.25"	0.79"	0.39"

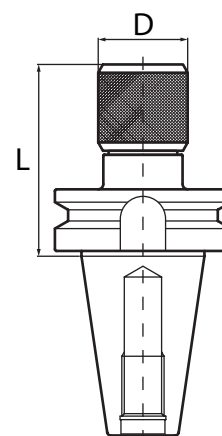


BT30/40 Rigid Tap Holders

Part Number	Taper	Tap Range		System	L	D
		Hand	Pipe			
B30R5-0562-2.44	BT30	#0-9/16"	1/8"	#1	2.44"	1.25"
B40R5-0562-3.02	BT40	#0-9/16"	1/8"	#1	3.02"	1.25"

Note:

- These holders are designed for use with synchronized machining centers.
- These holders have no tension or compression.



Tap Collets
Pages 168-179



Tap Spanner Wrench
Page 180



Tool Jaw
Page 234

HSK Tap Holders



T.I.R.: minimal



Speed: up to 5,000 RPM



Set-up: quick and easy



Coolant-Thru: thru-tap coolant



Tapping

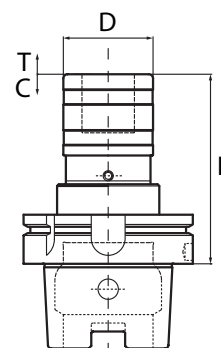
- Made to fit all Bilz standard style tap collets
- Quick and easy interchangeability of tap collets
- Retention balls and drive keys provide higher positioning accuracy and stronger gripping force, reducing the possibility of tap slippage

Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

HSK63A Tension/Compression Tap Holders - Coolant-Thru

Part Number	Tap Range Hand	Tap Range Pipe	System	L	D	T	C
HSK63A-TC0562-3.98C	#0-9/16"	1/8"	#1	3.98"	1.57"	0.29"	0.29"

Note: Coolant tube and coolant tube wrench are not included. See page 180 for more details.



Weldon Tap Holders



T.I.R.: minimal



Speed: up to 5,000 RPM



Set-up: quick and easy



Coolant-Thru: thru-tap coolant



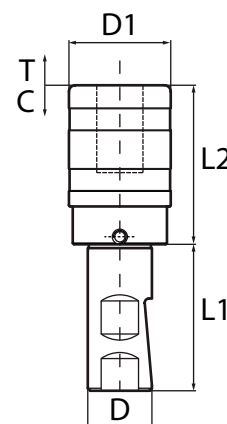
Tapping

- Made to fit all Bilz standard style tap collets
- Quick and easy interchangeability of tap collets
- Retention balls and drive keys provide higher positioning accuracy and stronger gripping force, reducing the possibility of tap slippage

Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

Weldon Shank Tension/Compression Tap Holders

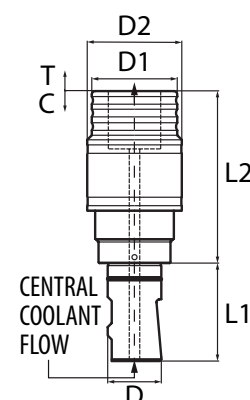
Part Number	Tap Range Hand	Tap Range Pipe	System	D	D1	L1	L2	T	C
W7505-0562-6.36	#0-9/16"	1/8"	#1	3/4"	1.25"	2.03"	4.33"	0.79"	0.39"
W1005-0562-6.41	#0-9/16"	1/8"	#1	1"	1.25"	2.28"	4.13"	0.79"	0.39"
W1055-0562-3.81	#0-9/16"	1/8"	#1	1"	1.43"	2.28"	1.53"	0.29"	0.29"
W1055-0875-4.76	5/16-7/8"	1/4-1/2"	#2	1"	2.09"	2.28"	2.48"	0.49"	0.49"
W1505-1375-10.5	13/16-1-3/8"	1/2-1"	#3	1-1/2"	2.87"	2.69"	7.81"	0.98"	0.59"
W1555-1375-6.55	13/16-1-3/8"	1/2-1"	#3	1-1/2"	3.07"	2.69"	3.86"	0.79"	0.79"



Weldon Shank Tension/Compression Tap Holders - Coolant-Thru

Part Number	Tap Range Hand	Tap Range Pipe	System	D	D1	D2	L1	L2	T	C
W1005-0562-4.88(C)	#0-9/16"	1/8"	#1	1"	1.29"	1.57"	2.28"	2.60"	0.27"	0.12"
W1005-0875-6.3(C)	5/16-7/8"	1/4-1/2"	#2	1"	1.99"	2.20"	2.28"	4.02"	0.39"	0.20"

Note: Maximum pressure is 500 psi.



Tap Collets
Pages 168-179



Tap Spanner Wrench
Page 180

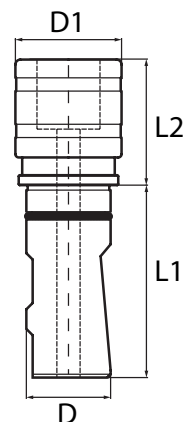
Weldon Tap Holders

Weldon Shank Rigid Tap Holders

Part Number	Tap Range		System	D	D1	L1	L2
	Hand	Pipe					
W10R5-0562-3.74	#0-9/16"	1/8"	#1	1"	1.26"	2.28"	1.46"
W10R5-0875-4.4	5/16-7/8"	1/4-1/2"	#2	1"	1.97"	2.28"	2.12"

Note:

- These holders are designed for use with synchronized machining centers.
- These holders have no tension or compression.

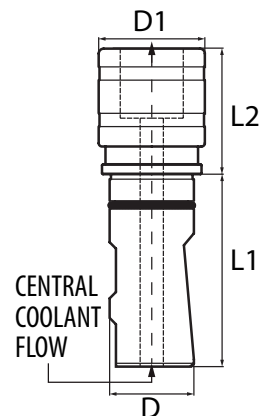


Weldon Shank Rigid Tap Holders - Coolant-Thru

Part Number	Tap Range		System	D	D1	L1	L2
	Hand	Pipe					
W75R5-0562-3.49(C)	#0-9/16"	1/8"	#1	3/4"	1.26"	2.03"	1.46"
W10R5-0562-3.77(C)	#0-9/16"	1/8"	#1	1"	1.26"	2.28"	1.49"

Note:

- These holders are designed for use with synchronized machining centers.
- These holders have no tension or compression.
- Maximum pressure is 750 psi.



Tap Collets
Pages 168-179



Tap Spanner Wrench
Page 180

NMTB and Straight Shank Tap Holders



T.I.R.: minimal



Tapping



Speed: up to 5,000 RPM



Set-up: quick and easy



Coolant-Thru: thru-tap coolant

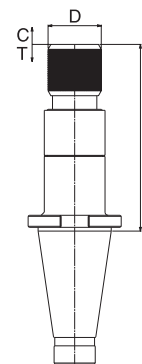
- Made to fit all Bilz standard style tap collets
- Quick and easy interchangeability of tap collets
- Retention balls and drive keys provide higher positioning accuracy and stronger gripping force, reducing the possibility of tap slippage

Please note that the maximum RPM listed in our catalog may vary depending on the toolholder shank, weight, balanceability and the G rating.

NMTB40 Tension/Compression Tap Holders

Part Number	Tap Range		System	L	D	T	C
	Hand	Pipe					
N4005-0562-3.90	#0-9/16"	1/8"	#1	3.90"	1.25"	0.79"	0.39"

Note: All NMTB toolholders flanges are qualified for use with Erickson Quick Change spindles.

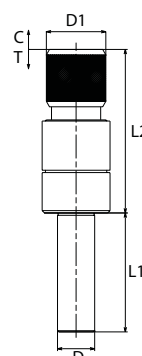


Straight Shank Tension/Compression Tap Holders

Part Number	Tap Range		System	D	D1	L1	L2	T	C
	Hand	Pipe							
S1005-0562-7.63	#0-9/16"	1/8"	#1	1"	1.25"	3.50"	4.13"	0.79"	0.39"
S1005-0875-9.05	5/16-7/8"	1/4-1/2"	#2	1"	2.00"	3.50"	5.55"	0.85"	0.49"

Note: Straight Shank tooling may be used to extend tooling reach for extended length operations.

- This option is less costly than extended length integral shank tooling.
- They may be used with any size machining center or lathe.
- When loaded into larger holders, their reduced O.D. permits tapping applications within large holes or whenever tight clearances are encountered.



Tap Collets
Pages 168-179



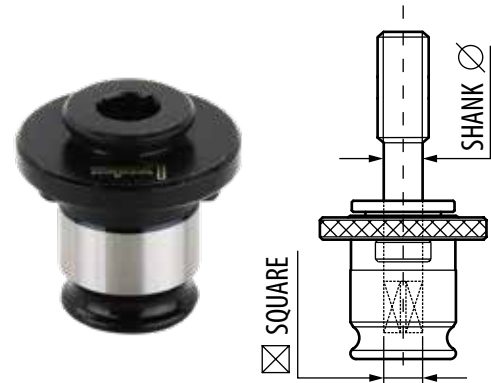
Tap Spanner Wrench
Page 180

Tap Collets

Positive Drive Tap Collets - U.S. Standard

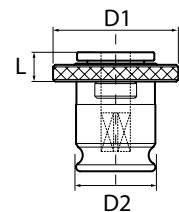
Standard collets are used for standard and coolant-thru tap holders, maximum 750 psi.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square ⊠
NT05-006	#1	#0-6	0.141"	0.110"
NT05-008	#1	#8	0.168"	0.131"
NT05-010	#1	#10, 3/16"	0.194"	0.152"
NT05-012	#1	#12	0.220"	0.165"
NT05-016	#1	1/4"	0.255"	0.191"
NT05-020	#1	5/16"	0.318"	0.238"
NT05-024	#1	3/8"	0.381"	0.286"
NT05-028	#1	7/16"	0.323"	0.242"
NT05-032	#1	1/2"	0.367"	0.275"
NT05-036	#1	9/16"	0.429"	0.322"
NT10-020	#2	5/16"	0.318"	0.238"
NT10-024	#2	3/8"	0.381"	0.286"
NT10-028	#2	7/16"	0.323"	0.242"
NT10-032	#2	1/2"	0.367"	0.275"
NT10-036	#2	9/16"	0.429"	0.322"
NT10-040	#2	5/8"	0.480"	0.360"
NT10-044	#2	11/16"	0.542"	0.406"
NT10-048	#2	3/4"	0.590"	0.442"
NT10-052	#2	13/16"	0.652"	0.489"
NT10-056	#2	7/8"	0.697"	0.523"
NT15-052	#3	13/16"	0.652"	0.489"
NT15-056	#3	7/8"	0.697"	0.523"
NT15-060	#3	15/16"	0.760"	0.570"
NT15-064	#3	1"	0.800"	0.600"
NT15-072	#3	1-1/8"	0.896"	0.672"
NT15-080	#3	1-1/4"	1.021"	0.766"
NT15-088	#3	1-3/8"	1.108"	0.831"



Dimensional Data

System	L	D1	D2
#1	0.27"	1.18"	0.75"
#2	0.43"	1.98"	1.22"
#3	0.55"	2.75"	1.89"



Note: See pages 182-183 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.

Positive Drive Tap Collet Sets

Part Number	Description
NT05-SET-10	10 Piece System #1 Positive Drive Tap Collet Set: 0-9/16" hand
NT10-SET-10	10 Piece System #2 Positive Drive Tap Collet Set: 5/16" - 7/8" hand
NT15-SET-07	7 Piece System #3 Positive Drive Tap Collet Set: 13/16" - 1-3/8" hand

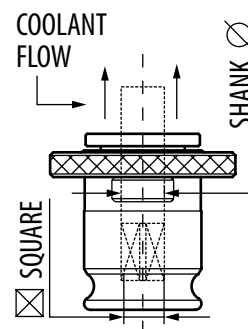


Tap Collets

Positive Drive Tap Collets - Slotted

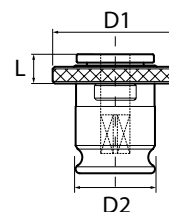
Slotted collets are designed for use with standard taps for coolant along the flute.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square ☒
NT05-006(S)	#1	#0-6	0.141"	0.110"
NT05-008(S)	#1	#8	0.168"	0.131"
NT05-010(S)	#1	#10, 3/16"	0.194"	0.152"
NT05-012(S)	#1	#12	0.220"	0.165"
NT05-016(S)	#1	1/4"	0.255"	0.191"
NT05-020(S)	#1	5/16"	0.318"	0.238"
NT05-024(S)	#1	3/8"	0.381"	0.286"
NT05-028(S)	#1	7/16"	0.323"	0.242"
NT05-032(S)	#1	1/2"	0.367"	0.275"
NT05-036(S)	#1	9/16"	0.429"	0.322"
NT10-020(S)	#2	5/16"	0.318"	0.238"
NT10-024(S)	#2	3/8"	0.381"	0.286"
NT10-028(S)	#2	7/16"	0.323"	0.242"
NT10-032(S)	#2	1/2"	0.367"	0.275"
NT10-036(S)	#2	9/16"	0.429"	0.322"
NT10-040(S)	#2	5/8"	0.480"	0.360"
NT10-044(S)	#2	11/16"	0.542"	0.406"
NT10-048(S)	#2	3/4"	0.590"	0.442"
NT10-052(S)	#2	13/16"	0.652"	0.489"
NT10-056(S)	#2	7/8"	0.697"	0.523"
NT15-052(S)	#3	13/16"	0.652"	0.489"
NT15-056(S)	#3	7/8"	0.697"	0.523"
NT15-060(S)	#3	15/16"	0.760"	0.570"
NT15-064(S)	#3	1"	0.800"	0.600"
NT15-072(S)	#3	1-1/8"	0.896"	0.672"
NT15-080(S)	#3	1-1/4"	1.021"	0.766"
NT15-088(S)	#3	1-3/8"	1.108"	0.831"



Dimensional Data

System	L	D1	D2
#1	0.27"	1.18"	0.75"
#2	0.43"	1.98"	1.22"
#3	0.55"	2.75"	1.89"



Note: See pages 182-182 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.

Tap Collets

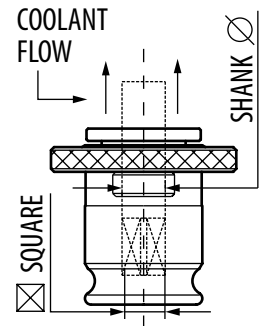
Positive Drive Pipe Tap Collets - U.S. Standard

Part Number	System	Tap Size	Tap Shank ø	Drive Square ☒
NTPT05-008S	#1	1/8"S	0.313"	0.234"
NTPT05-008L	#1	1/8"L	0.437"	0.328"
NTPT10-016	#2	1/4"	0.562"	0.421"
NTPT10-024	#2	3/8"	0.700"	0.531"
NTPT10-032	#2	1/2"	0.687"	0.515"
NTPT15-032	#3	1/2"	0.687"	0.515"
NTPT15-048	#3	3/4"	0.906"	0.679"
NTPT15-064	#3	1"	1.125"	0.843"



Positive Drive Pipe Tap Collets - Slotted

Part Number	System	Tap Size	Tap Shank ø	Drive Square ☒
NTPT05-008S(S)	#1	sm 1/8"	0.313"	0.234"
NTPT05-008L(S)	#1	lg 1/8"	0.437"	0.328"
NTPT10-016(S)	#2	1/4"	0.562"	0.421"
NTPT10-024(S)	#2	3/8"	0.700"	0.531"
NTPT10-032(S)	#2	1/2"	0.687"	0.515"
NTPT15-032(S)	#3	1/2"	0.687"	0.515"
NTPT15-048(S)	#3	3/4"	0.906"	0.679"
NTPT15-064(S)	#3	1/2"	1.125"	0.843"



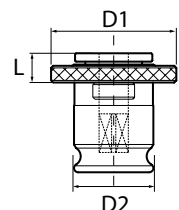
Positive Drive Pipe Tap Collet Sets

Part Number	Description
NTP05-SET-12	12 Piece System #1 Positive Drive Tap Collet Set: 0 - 9/16" hand and 1/8" pipe
NTPT10-SET-13	13 Piece System #2 Positive Drive Tap Collet Set: 5/16" - 1" hand and 1/4" - 1/22" pipe
NTPT15-SET-10	10 Piece System #3 Positive Drive Tap Collet Set: 13/16" - 1-3/8" hand and 1/2" - 1" pipe

Note: See pages 182-183 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.

Dimensional Data

System	L	D1	D2
#1	0.27"	1.18"	0.75"
#2	0.43"	1.98"	1.22"
#3	0.55"	2.75"	1.89"

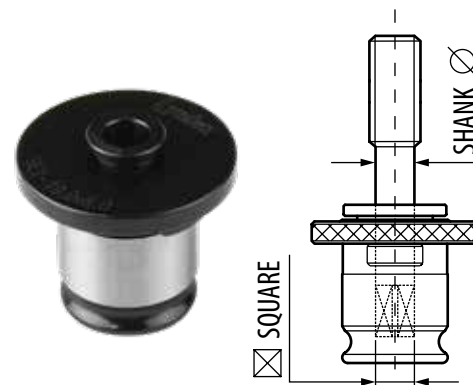


Tap Collets

Positive Drive Tap Collets - ISO Standard

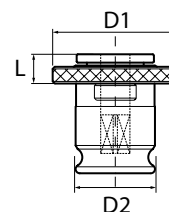
Standard collets are used for standard and coolant-thru tap holders, maximum 750 psi.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square □
SE1-2.24X1.8	#1	M3	2.24mm	1.80mm
SE1-2.50X2.0	#1	M3.5, M2	2.50mm	2.00mm
SE1-2.80X2.24	#1	M2.5, M2.2	2.80mm	2.24mm
SE1-3.15X2.50	#1	M4, M3	3.15mm	2.50mm
SE1-3.55X2.80	#1	M4.5, M3.5	3.55mm	2.80mm
SE1-4.0X3.15	#1	M5, M4	4.00mm	3.15mm
SE1-4.5X3.55	#1	M6	4.50mm	3.55mm
SE1-5.0X4.0	#1	M5	5.00mm	4.00mm
SE1-5.6X4.5	#1	M5	5.60mm	4.50mm
SE1-6.3X5.0	#1	M8, M6	6.30mm	5.00mm
SE1-7.1X5.6	#1	M7	7.10mm	5.60mm
SE1-8.0X6.3	#1	M11, M10, M8	8.00mm	6.30mm
SE1-9.0X7.1	#1	M12, M9	9.00mm	7.10mm
SE1-10.0X8.0	#1	M10	10.0mm	8.00mm
SE1-11.2X9.0	#1	M14	11.2mm	9.00mm
SE2-4.0X3.15	#2	M5, M4	4.00mm	3.15mm
SE2-4.5X3.55	#2	M6	4.50mm	3.55mm
SE2-5.0X4.0	#2	M5	5.00mm	4.00mm
SE2-5.6X4.5	#2	M5	5.60mm	4.50mm
SE2-6.3X5.0	#2	M8, M6	6.30mm	5.00mm
SE2-7.1X5.6	#2	M7	7.10mm	5.60mm
SE2-8.0X6.3	#2	M11, M10, M8	8.00mm	6.30mm
SE2-9.0X7.1	#2	M12, M9	9.00mm	7.10mm
SE2-10.0X8.0	#2	M10	10.0mm	8.00mm
SE2-11.2X9.0	#2	M14	11.2mm	9.00mm
SE2-12.5X10.0	#2	M16	12.5mm	10.0mm
SE2-14.0X11.2	#2	M20, M18	14.0mm	11.2mm
SE2-16.0X12.5	#2	M22	16.0mm	12.5mm
SE2-18.0X14.0	#2	M24	18.0mm	14.0mm
SE3-9.0X7.1	#3	M12, M9	9.00mm	7.10mm
SE3-10.0X8.0	#3	M10	10.0mm	8.00mm
SE3-11.2X9.0	#3	M14	11.2mm	9.00mm
SE3-12.5X10.0	#3	M16	12.5mm	10.0mm
SE3-14.0X11.2	#3	M20, M18	14.0mm	11.2mm
SE3-16.0X12.5	#3	M22	16.0mm	12.5mm
SE3-18.0X14.0	#3	M24	18.0mm	14.0mm
SE3-20.0X16.0	#3	M30, M27	20.0mm	16.0mm
SE3-22.4X18.0	#3	M33	22.4mm	18.0mm
SE3-25.0X20.0	#3	M36, M33	25.0mm	20.0mm



Dimensional Data

System	L	D1	D2
#1	0.27"	1.18"	0.75"
#2	0.43"	1.98"	1.22"
#3	0.55"	2.75"	1.89"



Note: See pages 182-183 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.

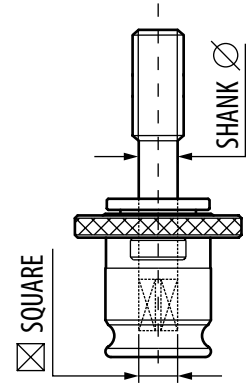


Tap Collets

Positive Drive Tap Collets - DIN 371/376 Standard

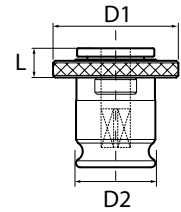
Standard collets are used for standard and coolant-thru tap holders, maximum 750 psi.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square □
SE1-2.5X2.1	#1	M1.4, M1.8, M3	2.50mm	2.10mm
SE1-2.8X2.1	#1	M2, M2.2, M2.5, M4	2.80mm	2.10mm
SE1-3.5X2.7	#1	M3, M5	3.50mm	2.70mm
SE1-4.0X3.0	#1	M3.5	4.00mm	3.00mm
SE1-4.5X3.4	#1	M4, M6	4.50mm	3.40mm
SE1-6.0X4.9	#1	M5, M6, M8	6.00mm	4.90mm
SE1-7.0X5.5	#1	M10	7.00mm	5.50mm
SE1-8.0X6.2	#1	M8, M10	8.00mm	6.20mm
SE1-9.0X7.0	#1	M12	9.00mm	7.00mm
SE1-10.0X8.0	#1	M10	10.0mm	8.00mm
SE1-11.0X9.0	#1	M14	11.0mm	9.00mm
SE2-2.8X2.1	#2	M2, M2.2, M2.5, M4	2.80mm	2.10mm
SE2-3.5X2.7	#2	M3, M5	3.50mm	2.70mm
SE2-4.0X3.0	#2	M3.5	4.00mm	3.00mm
SE2-6.0X4.9	#2	M5, M6, M8	6.00mm	4.90mm
SE2-7.0X5.5	#2	M10	7.00mm	5.50mm
SE2-8.0X6.2	#2	M8, M10	8.00mm	6.20mm
SE2-9.0X7.0	#2	M12	9.00mm	7.00mm
SE2-10.0X8.0	#2	M10	10.00mm	8.00mm
SE2-11.0X9.0	#2	M14	11.0mm	9.00mm
SE2-12.0X9.0	#2	M16	12.0mm	9.00mm
SE2-14.0X11.0	#2	M18	14.0mm	11.00mm
SE2-16.0X12.0	#2	M20	16.0mm	12.00mm
SE2-18.0X14.5	#2	M22, M24	18.0mm	14.50mm
SE3-9.0X7.0	#3	M12	9.00mm	7.00mm
SE3-10.0X8.0	#3	M10	10.00mm	8.00mm
SE3-11.0X9.0	#3	M14	11.0mm	9.00mm
SE3-12.0X9.0	#3	M16	12.0mm	9.00mm
SE3-14.0X11.0	#3	M18	14.0mm	11.0mm
SE3-16.0X12.0	#3	M20	16.0mm	12.0mm
SE3-18.0X14.5	#3	M22, M24	18.0mm	14.5mm
SE3-20.0X16.0	#3	M27, M30	20.0mm	16.0mm
SE3-22.0X18.0	#3	M30	22.0mm	18.0mm
SE3-25.0X20.0	#3	M33, M36	25.0mm	20.0mm
SE3-28.0X22.0	#3	M36	28.0mm	22.0mm



Dimensional Data

System	L	D1	D2
#1	0.27"	1.18"	0.75"
#2	0.43"	1.98"	1.22"
#3	0.55"	2.75"	1.89"



Note: See pages 182-183 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.

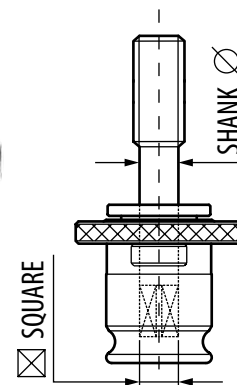


Tap Collets

Positive Drive Tap Collets - JIS Standard

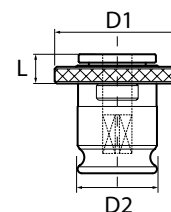
Standard collets are used for standard and coolant-thru tap holders, maximum 750 psi.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square □
SE1-3.0X2.5	#1	M2	3.00mm	2.50mm
SE1-4.0X3.2	#1	M3	4.00mm	3.20mm
SE1-5.0X4.0	#1	M4, M4.5	5.00mm	4.00mm
SE1-5.5X4.5	#1	M5, M5.5	5.50mm	4.50mm
SE1-6.0X4.5	#1	M6	6.00mm	4.50mm
SE1-6.2X5.0	#1	M7, M8	6.20mm	5.00mm
SE1-7.0X5.5	#1	M9, M10	7.00mm	5.50mm
SE1-8.0X6.0	#1	M11	8.00mm	6.00mm
SE1-8.5X6.5	#1	M12	8.50mm	6.50mm
SE1-9.5X7.0	#1	M13	9.50mm	7.00mm
SE1-10.5X8.0	#1	M14, M15	10.5mm	8.00mm
SE2-6.0X4.5	#2	M6	6.00mm	4.50mm
SE2-6.2X5.0	#2	M7, M8	6.20mm	5.00mm
SE2-7.0X5.5	#2	M9, M10	7.00mm	5.50mm
SE2-8.0X6.0	#2	M11	8.00mm	6.00mm
SE2-8.5X6.5	#2	M12	8.50mm	6.50mm
SE2-9.5X7.0	#2	M13	9.50mm	7.00mm
SE2-10.5X8.0	#2	M14, M15	10.5mm	8.00mm
SE2-12.5X10.0	#2	M16	12.5mm	10.0mm
SE2-13.0X10.0	#2	M17	13.0mm	10.0mm
SE2-14.0X11.0	#2	M18	14.0mm	11.0mm
SE2-15.0X12.0	#2	M20	15.0mm	12.0mm
SE2-17.0X13.0	#2	M22	17.0mm	13.0mm
SE3-10.5X8.0	#3	M14, M15	10.5mm	8.00mm
SE3-12.5X10.0	#3	M16	12.5mm	10.0mm
SE3-14.0X11.0	#3	M18	14.0mm	11.0mm
SE3-15.0X12.0	#3	M20	15.0mm	12.0mm
SE3-17.0X13.0	#3	M22	17.0mm	13.0mm
SE3-19.0X15.0	#3	M24, M25	19.0mm	15.0mm
SE3-20.0X15.0	#3	M26, M27	20.0mm	15.0mm
SE3-21.0X17.0	#3	M28	21.0mm	17.0mm
SE3-23.0X17.0	#3	M30	23.0mm	17.0mm
SE3-24.0X19.0	#3	M32	24.0mm	19.0mm
SE3-25.0X19.0	#3	M33	25.0mm	19.0mm
SE3-26.0X21.0	#3	M34, M35	26.0mm	21.0mm
SE3-28.0X21.0	#3	M36, M38	28.0mm	21.0mm



Dimensional Data

System	L	D1	D2
#1	0.27"	1.18"	0.75"
#2	0.43"	1.98"	1.22"
#3	0.55"	2.75"	1.89"



Note: See pages 182-183 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.



Tap Spanner Wrench
Page 180

Tap Collets

Torque Control Tap Collets - U.S. Standard

Standard collets are used for standard and coolant thru tap holders, maximum 750 psi.

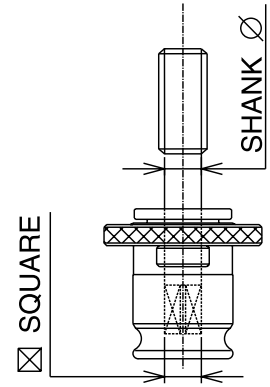
Part Number	System	Tap Size	Tap Shank Ø	Drive Square ⊠
T05-006	#1	#0-6	0.141"	0.110"
T05-008	#1	#8	0.168"	0.131"
T05-010	#1	#10	0.194"	0.152"
T05-012	#1	#12	0.220"	0.165"
T05-016	#1	1/4"	0.255"	0.191"
T05-020	#1	5/16"	0.318"	0.238"
T05-024	#1	3/8"	0.381"	0.286"
T05-028	#1	7/16"	0.323"	0.242"
T05-032	#1	1/2"	0.367"	0.275"
T05-036	#1	9/16"	0.429"	0.322"
T10-020	#2	5/16"	0.318"	0.238"
T10-024	#2	3/8"	0.381"	0.286"
T10-028	#2	7/16"	0.323"	0.242"
T10-032	#2	1/2"	0.367"	0.275"
T10-036	#2	9/16"	0.429"	0.322"
T10-040	#2	5/8"	0.480"	0.360"
T10-044	#2	11/16"	0.542"	0.406"
T10-048	#2	3/4"	0.590"	0.442"
T10-052	#2	13/16"	0.652"	0.489"
T10-056	#2	7/8"	0.697"	0.523"
T10-064*	#2	1"	0.800"	0.600"
T15-052	#3	13/16"	0.652"	0.489"
T15-056	#3	7/8"	0.697"	0.523"
T15-060	#3	15/16"	0.760"	0.570"
T15-064	#3	1"	0.800"	0.600"
T15-072	#3	1-1/8"	0.896"	0.672"
T15-080	#3	1-1/4"	1.021"	0.766"
T15-088	#3	1-3/8"	1.108"	0.831"

Note:

- *This collet is held with set screws.
- See pages 182-183 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.

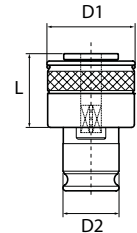
Positive Drive Pipe Tap Collet Sets

Part Number	Description
T05-SET-10	10 Piece System #1 Torque Control Tap Collet Set: #0 - 9/16" hand
T10-SET-10	10 Piece System #2 Torque Control Tap Collet Set: 5/16" - 7/8" hand
T15-SET-07	7 Piece System #3 Torque Control Tap Collet Set: 13/16" - 1-3/8" hand



Dimensional Data

System	L	D1	D2
#1	0.98"	1.28"	0.75"
#2	1.34"	1.99"	1.22"
#3	1.77"	2.83"	1.89"

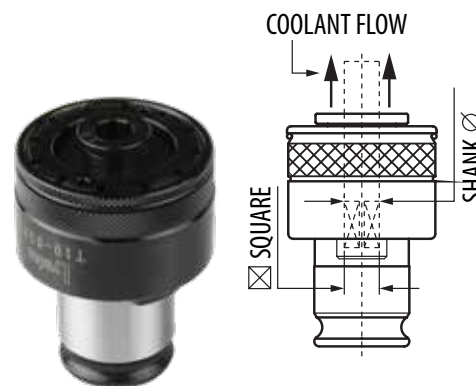


Tap Collets

Torque Control Tap Collets - Slotted

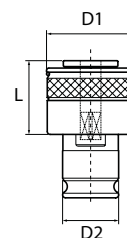
Slotted collets are designed for use with standard taps for coolant along the flute.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square □
T05-006(S)	#1	#0-6	0.141"	0.110"
T05-008(S)	#1	#8	0.168"	0.131"
T05-010(S)	#1	#10	0.194"	0.152"
T05-012(S)	#1	#12	0.220"	0.165"
T05-016(S)	#1	1/4"	0.255"	0.191"
T05-020(S)	#1	5/16"	0.318"	0.238"
T05-024(S)	#1	3/8"	0.381"	0.286"
T05-028(S)	#1	7/16"	0.323"	0.242"
T05-032(S)	#1	1/2"	0.367"	0.275"
T05-036(S)	#1	9/16"	0.429"	0.322"
T10-020(S)	#2	5/16"	0.318"	0.238"
T10-024(S)	#2	3/8"	0.381"	0.286"
T10-028(S)	#2	7/16"	0.323"	0.242"
T10-032(S)	#2	1/2"	0.367"	0.275"
T10-036(S)	#2	9/16"	0.429"	0.322"
T10-040(S)	#2	5/8"	0.480"	0.360"
T10-044(S)	#2	11/16"	0.542"	0.406"
T10-048(S)	#2	3/4"	0.590"	0.442"
T10-052(S)	#2	13/16"	0.652"	0.489"
T10-056(S)	#2	7/8"	0.697"	0.523"
T10-064(S)*	#2	1"	0.800"	0.600"
T15-052(S)	#3	13/16"	0.652"	0.489"
T15-056(S)	#3	7/8"	0.697"	0.523"
T15-064(S)	#3	1"	0.800"	0.600"
T15-072(S)	#3	1-1/8"	0.896"	0.672"
T15-080(S)	#3	1-1/4"	1.021"	0.766"
T15-088(S)	#3	1-3/8"	1.108"	0.831"



Dimensional Data

System	L	D1	D2
#1	0.98"	1.28"	0.75"
#2	1.34"	1.99"	1.22"
#3	1.77"	2.83"	1.89"



Note:

- *This collet is held with set screws.
- See pages 182-183 for details about dimensions cross over for ANSI, DIN, ISO, JIS Specification Taps.

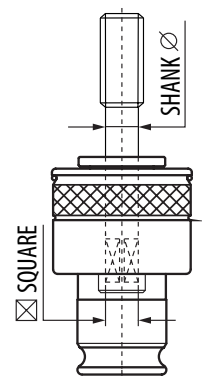


Tap Spanner Wrench
Page 180

Tap Collets

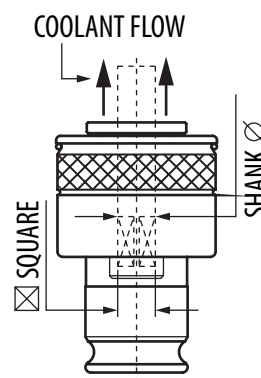
Torque Control Pipe Tap Collets - U.S. Standard

Part Number	System	Tap Size	Tap Shank Ø	Drive Square ☒
TPT05-008S	#1	1/8"S	0.313"	0.234"
TPT05-008L	#1	1/8"L	0.437"	0.328"
TPT10-016	#2	1/4"	0.562"	0.421"
TPT10-024	#2	3/8"	0.700"	0.531"
TPT10-032	#2	1/2"	0.687"	0.515"
TPT15-032	#3	1/2"	0.687"	0.515"
TPT15-048	#3	3/4"	0.906"	0.679"
TPT15-064	#3	1"	1.125"	0.843"



Torque Control Pipe Tap Collets - Slotted

Part Number	System	Tap Size	Tap Shank Ø	Drive Square ☒
TPT05-008S(S)	#1	1/8"S	0.313"	0.234"
TPT05-008L(S)	#1	1/8"L	0.437"	0.328"
TPT10-016(S)	#2	1/4"	0.562"	0.421"
TPT10-024(S)	#2	3/8"	0.700"	0.531"
TPT10-032(S)	#2	1/2"	0.687"	0.515"
TPT15-032(S)	#3	1/2"	0.687"	0.515"
TPT15-048(S)	#3	3/4"	0.906"	0.679"

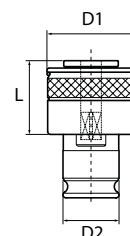


Torque Control Pipe Tap Collet Sets

Part Number	Description
TP05-SET-12	12 Piece System #1 Torque Control Tap Collet Set: #0-9/16" hand and 1/8" pipe
TP10-SET-13	13 Piece System #2 Torque Control Tap Collet Set: 5/16" - 7/8" hand and 1/4" - 1/2" pipe
TP15-SET-10	10 Piece System #3 Torque Control Tap Collet Set: 13/16" - 1-3/8" hand and 1/2" - 1" pipe

Dimensional Data

System	L	D1	D2
#1	0.98"	1.28"	0.75"
#2	1.34"	1.99"	1.22"
#3	1.77"	2.83"	1.89"

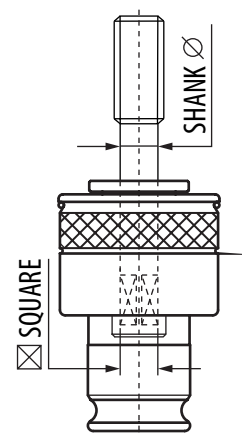


Tap Collets

Torque Control Tap Collets - ISO Standard

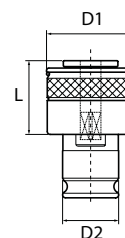
Standard collets are used for standard and coolant-thru tap holders, maximum 750 psi.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square □
SES1-2.50X2.0	#1	M3.5, M2	2.50mm	2.00mm
SES1-3.15X2.50	#1	M4, M3	3.15mm	2.50mm
SES1-3.55X2.80	#1	M4.5, M3.5	3.55mm	2.80mm
SES1-4.0X3.15	#1	M5, M4	4.00mm	3.15mm
SES1-4.5X3.55	#1	M6	4.50mm	3.55mm
SES1-5.0X4.0	#1	M5	5.00mm	4.00mm
SES1-6.3X5.0	#1	M8, M6	6.30mm	5.00mm
SES1-7.1X5.6	#1	M7	7.10mm	5.60mm
SES1-8.0X6.3	#1	M11, M10, M8	8.00mm	6.30mm
SES1-9.0X7.1	#1	M12, M9	9.00mm	7.10mm
SES1-10.0X8.0	#1	M10	10.0mm	8.00mm
SES1-11.2X9.0	#1	M14	11.2mm	9.00mm
SES2-5.0X4.0	#2	M5	5.00mm	4.00mm
SES2-6.3X5.0	#2	M8, M6	6.30mm	5.00mm
SES2-7.1X5.6	#2	M7	7.10mm	5.60mm
SES2-8.0X6.3	#2	M11, M10, M8	8.00mm	6.30mm
SES2-9.0X7.1	#2	M12, M9	9.00mm	7.10mm
SES2-10.0X8.0	#2	M10	10.0mm	8.00mm
SES2-11.2X9.0	#2	M14	11.2mm	9.00mm
SES2-12.5X10.0	#2	M16	12.5mm	10.0mm
SES2-14.0X11.2	#2	M20, M18	14.0mm	11.2mm
SES2-16.0X12.5	#2	M22	16.0mm	12.5mm
SES2-18.0X14.0	#2	M24	18.0mm	14.0mm
SES3-10.0X8.0	#3	M10	10.0mm	8.00mm
SES3-11.2X9.0	#3	M14	11.2mm	9.00mm
SES3-12.5X10.0	#3	M16	12.5mm	10.0mm
SES3-18.0X14.0	#3	M24	18.0mm	14.0mm
SES3-20.0X16.0	#3	M30, M27	20.0mm	16.0mm
SES3-25.0X20.0	#3	M36, M33	25.0mm	20.0mm
SES3-28.0X22.4	#3	M42, M39	28.0mm	22.4mm



Dimensional Data

System	L	D1	D2
#1	0.98"	1.28"	0.75"
#2	1.34"	1.99"	1.22"
#3	1.77"	2.83"	1.89"

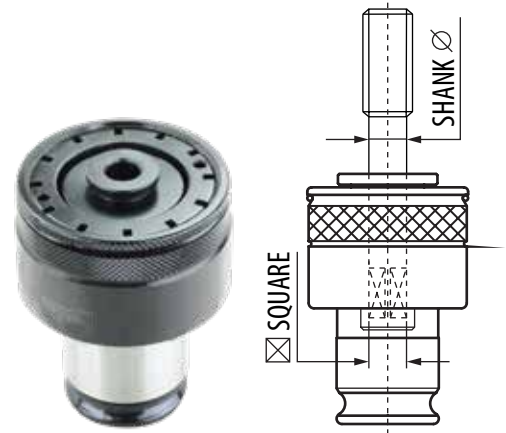


Tap Collets

Torque Control Tap Collets - DIN 371/376 Standard

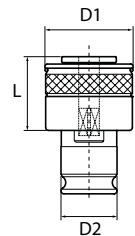
Standard collets are used for standard and coolant-thru tap holders, maximum 750 psi.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square ⊠
SES1-2.5X2.1	#1	M1.4, M1.8, M3	2.50mm	2.10mm
SES1-2.8X2.1	#1	M2, M2.2, M2.5, M4	2.80mm	2.10mm
SES1-3.5X2.7	#1	M3, M5	3.50mm	2.70mm
SES1-4.0X3.0	#1	M3.5	4.00mm	3.00mm
SES1-4.5X3.4	#1	M4, M6	4.50mm	3.40mm
SES1-6.0X4.9	#1	M5, M6, M8	6.00mm	4.90mm
SES1-7.0X5.5	#1	M10	7.00mm	5.50mm
SES1-8.0X6.2	#1	M8, M10	8.00mm	6.20mm
SES1-9.0X7.0	#1	M12	9.00mm	7.00mm
SES1-10.0X8.0	#1	M10	10.0mm	8.00mm
SES1-11.0X9.0	#1	M14	11.0mm	9.00mm
SES2-3.5X2.7	#2	M3, M5	3.50mm	2.70mm
SES2-4.0X3.0	#2	M3.5	4.00mm	3.00mm
SES2-4.5X3.4	#2	M4, M6	4.50mm	3.40mm
SES2-6.0X4.9	#2	M5, M6, M8	6.00mm	4.90mm
SES2-7.0X5.5	#2	M10	7.00mm	5.50mm
SES2-8.0X6.2	#2	M8, M10	8.00mm	6.20mm
SES2-9.0X7.0	#2	M12	9.00mm	7.00mm
SES2-10.0X8.0	#2	M10	10.0mm	8.00mm
SES2-11.0X9.0	#2	M14	11.0mm	9.00mm
SES2-12.0X9.0	#2	M16	12.0mm	9.00mm
SES2-14.0X11.0	#2	M18	14.0mm	11.0mm
SES2-16.0X12.0	#2	M20	16.0mm	12.0mm
SES2-18.0X14.5	#2	M22, M24	18.0mm	14.5mm
SES3-8.0X6.2	#2	M8, M10	8.00mm	6.20mm
SES3-9.0X7.0	#3	M12	9.00mm	7.00mm
SES3-10.0X8.0	#3	M10	10.0mm	8.00mm
SES3-11.0X9.0	#3	M14	11.0mm	9.00mm
SES3-12.0X9.0	#3	M16	12.0mm	9.00mm
SES3-14.0X11.0	#3	M18	14.0mm	11.0mm
SES3-16.0X12.0	#3	M20	16.0mm	12.0mm
SES3-18.0X14.5	#3	M22, M24	18.0mm	14.5mm
SES3-20.0X16.0	#3	M27, M30	20.0mm	16.0mm
SES3-22.0X18.0	#3	M30	22.0mm	18.0mm
SES3-25.0X20.0	#3	M33, M36	25.0mm	20.0mm
SES3-28.0X22.0	#3	M36	28.0mm	22.0mm



Dimensional Data

System	L	D1	D2
#1	0.98"	1.28"	0.75"
#2	1.34"	1.99"	1.22"
#3	1.77"	2.83"	1.89"

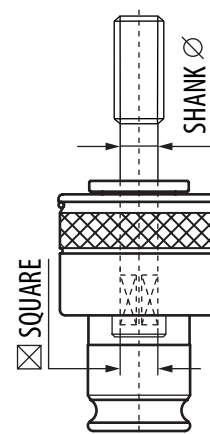


Tap Collets

Torque Control Tap Collets - JIS Standard

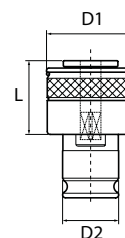
Standard collets are used for standard and coolant-thru tap holders, maximum 750 psi.

Part Number	System	Tap Size	Tap Shank Ø	Drive Square □
SES1-3.0X2.5	#1	M2	3.00mm	2.50mm
SES1-4.0X3.2	#1	M3	4.00mm	3.20mm
SES1-5.0X4.0	#1	M4, M4.5	5.00mm	4.00mm
SES1-5.5X4.5	#1	M5, M5.5	5.50mm	4.50mm
SES1-6.0X4.5	#1	M6	6.00mm	4.50mm
SES1-6.2X5.0	#1	M7, M8	6.20mm	5.00mm
SES1-8.0X6.0	#1	M11	8.00mm	6.00mm
SES1-8.5X6.5	#1	M12	8.50mm	6.50mm
SES1-10.5X8.0	#1	M14, M15	10.5mm	8.00mm
SES2-6.2X5.0	#2	M7, M8	6.20mm	5.00mm
SES2-8.0X6.0	#2	M11	8.00mm	6.00mm
SES2-8.5X6.5	#2	M12	8.50mm	6.50mm
SES2-10.5X8.0	#2	M14, M15	10.5mm	8.00mm
SES2-12.5X10.0	#2	M16	12.5mm	10.00mm
SES2-14.0X11.0 (JIS)	#2	M18	14.0mm	11.0mm
SES2-15.0X12.0	#2	M20	15.0mm	12.0mm
SES2-17.0X13.0	#2	M22	17.0mm	13.0mm
SES3-12.5X10.0	#3	M16	12.5mm	10.0mm
SES3-15.0X12.0	#3	M20	15.0mm	12.0mm
SES3-19.0X15.0	#3	M24, M25	19.0mm	15.0mm
SES3-20.0X15.0	#3	M26, M27	20.0mm	15.0mm
SES3-23.0X17.0	#3	M30	23.0mm	17.0mm
SES3-28.0X21.0	#3	M36, M38	28.0mm	21.0mm



Dimensional Data

System	L	D1	D2
#1	0.98"	1.28"	0.75"
#2	1.34"	1.99"	1.22"
#3	1.77"	2.83"	1.89"



Tap Holder Accessories

Tap Collet Reducers

Part Number	Description
CRE-2/1	System #2 Reduction Adapter to System #1
CRE-3/2	System #3 Reduction Adapter to System #2



Tap Collet Racks

Part Number	Description
RACK-ER20/1TAP	System #1 Tap Collet Rack, 24 piece capacity
RACK-ER32/2TAP	System #2 Tap Collet Rack, 32 piece capacity



Spanner Wrench for Tap Holders

Part Number	Description
T05-SPAN	Fits System #1 Torque Control Tap Collets
T10-SPAN	Fits System #2 Torque Control Tap Collets
T15-SPAN	Fits System #3 Torque Control Tap Collets



Coolant Tube Wrench for HSK Holders

Part Number	Description
HSK63-WRENCH	Wrench for HSK40 Coolant Tube



Coolant Tube for HSK Holders

Part Number	Description
HSK63-TUBE	Coolant Tube for HSK63 holder



Tapping - Technical Details

Tap Shank Standards

- Tap shanks are manufactured to many international standards, each specified by their country of origin. Although most taps sold in North America comply with the ANSI B94.9 standard, we appreciate your assistance to help further qualify the matching tap collet necessary by providing the round shank size and the drive square dimensions.
- Please note not all taps were designed to be held in a tap collet compliant to ANSI, ISO, DIN or JIS standards. Please call us to discuss more advanced alternatives for tapping.

Tap Collet Systems

- All Lyndex-Nikken tap collets are based on the "Bilz" standard quick-change system and will interchange with other manufacturers compliant to the same standard.
- Lyndex-Nikken does not offer tap collets for the Intertap system.
- Please take into consideration the nature of each application before determining which system (system 1, 2 or 3) suits your needs. If the same tap collet size is offered within two different systems, we recommend that harder materials should utilize a larger tap collet series to help sustain the required torque capacity and rigidity for the operation.

Positive Drive Tap Collets and Holders

- Positive Drive Tap Collets should only be used on equipment that have the ability to synchronize spindle rotation and spindle feed, commonly referred to as "Direct Tapping", "Rigid Tapping" or "Electronic Lead Screw Tapping".
- Positive Drive tapping systems do not have the tension and compression ability as a traditional float mechanism and therefore offer no protection from overloads such as under-sized holes, wornout taps or misplaced cored holes in castings.
- Rigid Tap Holders must only be used with Positive Drive Tapping Collets. The use of Rigid Tap holders on non-synchronized machinery will result in poor threads and/or damage to tapping holder or collets.



Tap Dimensional Data

Shank Diameter		Square Diameter		U.S.		JIS	DIN 371	DIN 376	ISO
Inch	Metric	Inch	Metric	Metric	Inch	Metric	Metric	Metric	Metric
0.088	2.2	0.070	1.8				M3		
0.098	2.5	0.078	2.0				M3.5, M2		
0.098	2.5	0.083	2.1						M1 - M1.8
0.109	2.8	0.088	2.2				M2.5, M2.2		
0.110	2.8	0.083	2.1						M2 - M2.5
0.123	3.2	0.098	2.5				M4, M3		
0.138	3.5	0.106	2.7						M3
0.139	3.6	0.109	2.8				M4.5, M3.5		
0.141	3.6	0.110	2.8	M1.6 - M3.5	#0 - #6				
0.156	4.0	0.123	3.2				M5, M4		
0.157	4.0	0.118	3.0						M3.5
0.168	4.3	0.131	3.3	M4	#8				
0.176	4.5	0.139	3.6				M6		
0.177	4.5	0.134	3.4						M4
0.194	4.9	0.152	3.9	M5	#10				
0.196	5.0	0.156	4.0				M5		
0.197	5.0	0.157	4.0			M4			
0.217	5.5	0.177	4.5			M5			
0.219	5.6	0.176	4.5				M5		
0.220	5.6	0.165	4.2		#12				
0.225	5.7	0.191	4.9	M6	1/4"				
0.236	6.0	0.193	4.9					M8	
0.236	6.0	0.177	4.5			M6			
0.236	6.0	0.193	4.9						M5, M6
0.244	6.2	0.197	5.0			M7, M8			
0.246	6.3	0.196	5.0				M8, M6		
0.276	7.0	0.217	5.5			M9, M10		M10	
0.278	7.1	0.219	5.6				M7		
0.313	8.0	0.246	6.3				M11, M10, M8		
0.315	8.0	0.236	6.0			M11			
0.315	8.0	0.244	6.2						M8
0.318	8.1	0.238	6.0	M7, M8	5/16"				
0.323	8.2	0.242	6.1		7/16"				
0.335	8.5	0.256	6.5			M12			
0.352	9.0	0.278	7.1				M12, M9		
0.354	9.0	0.276	7.0					M12	
0.367	9.3	0.275	7.0	M12	1/2"				
0.381	9.7	0.286	7.3	M10	3/8"				
0.391	10.0	0.313	8.0				M10		
0.394	10.0	0.315	8.0						M10
0.413	10.5	0.315	8.0			M14, M15			
0.429	10.9	0.322	8.2	M14	9/16"				
0.433	11.0	0.354	9.0					M14	
0.438	11.2	0.352	9.0				M14		
0.451	11.5	0.406	10.3	M18	11/16"				
0.472	12.0	0.354	9.0					M16	
0.480	12.2	0.360	9.1	M16	5/8"				
0.489	12.5	0.391	10.0				M16		
0.492	12.5	0.394	10.0			M16			

Tap Dimensional Data

Shank Diameter		Square Diameter		U.S.		JIS	DIN 371	DIN 376	ISO
Inch	Metric	Inch	Metric	Metric	Inch	Metric	Metric	Metric	Metric
0.512	13.0	0.394	10.0			M17			
0.547	14.0	0.438	11.2				M20, M18		
0.551	14.0	0.433	11.0			M18		M18	
0.590	15.0	0.442	11.2		3/4"				
0.591	15.0	0.472	12.0			M20			
0.626	16.0	0.489	12.5				M22		
0.630	16.0	0.472	12.0					M20	
0.652	16.6	0.489	12.4	M20	13/16"				
0.669	17.0	0.512	13.0			M22			
0.697	17.7	0.523	13.3	M22	7/8"				
0.704	18.0	0.547	14.0				M24		
0.709	18.0	0.571	14.5					M22, M24	
0.748	19.0	0.591	15.0			M25			
0.760	19.3	0.570	14.5	M24	15/16"				
0.782	20.0	0.626	16.0				M30, M27		
0.787	20.0	0.630	16.0					M27	
0.787	20.0	0.591	15.0			M26, M27			
0.800	20.3	0.600	15.2	M25	1"				
0.827	21.0	0.669	17.0			M28			
0.866	22.0	0.709	18.0					M30	
0.876	22.4	0.704	18.0				M33		
0.896	22.8	0.672	17.1	M27	1-1/16"				
0.906	23.0	0.669	17.0			M30			
0.945	24.0	0.748	19.0			M32			
0.978	25.0	0.782	20.0				M36, M33		
0.984	25.0	0.787	20.0					M33	
0.984	25.0	0.748	19.0			M33			
1.021	25.9	0.766	19.5	M30	1-3/16"				
1.024	26.0	0.827	21.0			M34, M35			
1.095	28.0	0.876	22.4				M42, M39		
1.102	28.0	0.866	22.0					M36	
1.102	28.0	0.827	21.0			M36, M38			
1.108	28.1	0.831	21.1	M33	1-5/16"				
1.181	30.0	0.906	23.0			M39, M40			
1.260	32.0	0.945	24.0					M39, M42	
1.260	32.0	1.024	26.0			M42			
1.417	36.0	1.142	29.0					M45, M48	
1.575	40.0	1.260	32.0					M52	

Torque Control Tap Collet Torque Specifications

Preset Torque for Tap Collets - ANSI

Tap Size	Torque Setting (ft./lbs.)	Tap Size	Torque Setting (ft./lbs.)	Tap Size	Torque Setting (ft./lbs.)
#0-1	0.14	1/4"	4	13/16"	57
#2	0.22	5/16"	7	7/8"	72
#3	0.29	3/8"	12	15/16"	77
#4	0.36	7/16"	16	1"	101
#5	0.58	1/2"	24	1-1/8"	145
#6	0.72	9/16"	29		
#8	1	5/8"	36		
#10	2	11/16"	44		
#12	3	3/4"	51		

Preset Torque for Tap Collets - ISO

Tap Shank x Square	Tap Size	Torque Setting (N.m)	
2.24 x 1.8	M 3	0.5	○
2.5 x 2	M 2	0.3	■
	M 3.5	0.8	○
2.8 x 2.24	M 2.2	0.35	■
	M 2.5	0.4	○
3.15 x 2.5	M 3	0.5	■
	M 4	1.2	○
3.55 x 2.8	M 3.5	0.8	■
	M 4.5	1.6	○
4 x 3.15	M 4	1.2	■
	M 5	2	○
4.5 x 3.55	M 4.5	1.6	■
	M 6	4	○
5 x 4	M 5	2	○
5.6 x 4.5	M 7	6	○
6.3 x 5	M 6	4	■
	M 8	8	○
7.1 x 5.6	M 7	6	○
	M 10	16	■
8 x 6.3	M 8	8	○
	M 10	16	■
	M 11	18	■
9 x 7.1	M 9	12	■
	M 12	22	○
10 x 8	M 10	16	○
11.2 x 9	M 14	36	○
12.5 x 10	M 16	40	○
	M 20	70	■
14 x 11.2	M 18	63	○
16 x 12.5	M 22	80	○
18 x 14	M 24	125	○
20 x 16	M 30	220	○
22.4 x 18	M 33	240	○
25 x 20	M 33	240	○
	M 36	280	■
28 x 22.4	M 39	320	○
	M 42	420	■

Preset Torque for Tap Collets - DIN

Tap Shank x Square	Tap Size	Torque Setting (N.m)	
2.5 x 2.1	M 1.8	0.3	○
	M 3	0.5	■
2.8 x 2.1	M 2	0.3	■
	M 2.2	0.35	■
	M 2.5	0.4	○
	M 4	1.2	■
3.5 x 2.7	M 3	0.5	○
	M 5	2	■
4 x 3	M 3.5	0.8	○
4.5 x 3.4	M 4	1.2	○
	M 6	4	■
6 x 4.9	M 5	2	■
	M 6	4	■
	M 8	8	○
7 x 5.5	M 10	16	○
8 x 6.2	M 8	8	○
	M 11	18	■
9 x 7	M 12	22	○
10 x 8	M 10	16	○
11 x 9	M 14	36	○
12 x 9	M 16	40	○
14 x 11	M 16	40	■
	M 18	63	○
16 x 12	M 20	70	○
18 x 14.5	M 22	80	■
	M 24	125	○
20 x 16	M 27	140	○
22 x 18	M 30	220	○
25 x 20	M 33	240	○
	M 36	280	■
28 x 22	M 36	280	○

Note:

○ - Standard setting

■ - Setting on request

Preset Torque for Tap Collets - JIS

Tap Shank x Square	Tap Size	Torque Setting (N.m)
3 x 2.5	M 2	0.6
4 x 3.2	M 3	1
5 x 4	M 4	2.3
5.5 x 4.5	M 5	3.6
6 x 4.5	M 6	5.9
6.2 x 5	M 8	12
7 x 5.5	M 10	22
8 x 6	M 11	25
8.5 x 6.5	M 12	31
9.5 x 7	M 13	39
10.5 x 8	M 14	46
12.5 x 10	M 16	51
13 x 10	M 17	67
14 x 11	M 18	80
15 x 12	M 20	88
17 x 13	M 22	98
19 x 15	M 24	132
20 x 15	M 27	157
21 x 17	M 28	175
23 x 17	M 30	225
24 x 19	M 32	235
25 x 19	M 33	245
26 x 21	M 34	265
28 x 21	M 36	304

