

Tapping attachments for manual tapping applications



**Drill-n-Tap**  
For drilling and tapping with quick change spindle.

**RX**  
Newest series for high production with heavy duty ball clutch.



**X**  
For general tapping with sensitive fiber clutch.



**TC/DC**  
Adjustable self feed for accurate depth control in shallow holes.

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



**SPD-OC**  
With quick change spindle. Recommended for pipe taps.

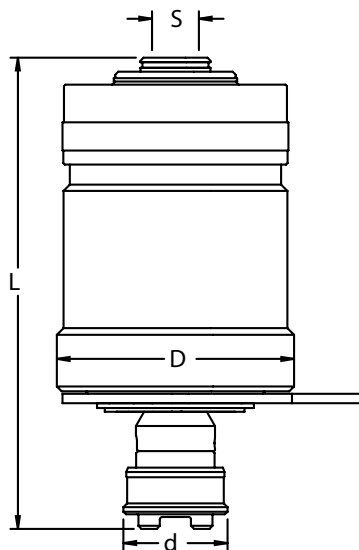
**Tapping attachments for drilling and milling machines and pneumatic, hydraulic and electric spindles**

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

**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	Tap Capacity (steel)	Adapter Size	Mounts S		Order code	L	Max. RPM
			Taper mounts	Thread. mounts			
Drill-n-Tap 30	M1.4–M7 #0 - 1/4"	NR. 0	JT6	1/2"–20	014006	126	2000
			B16		014016		
			JT33		014033		
Drill-n-Tap 50	M3–M12 #6 - 1/2"	NR. 1	JT6	1/2"–20	014050	159	1500
			B16		016006		
			JT33		016016		
					016033		
					016050	154	

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



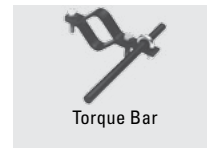
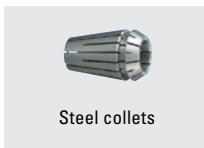
Description	d1	d2
Nr. 0, P Type Tap Adapters	22	7
Nr. 1, P Type Tap Adapters	30	7



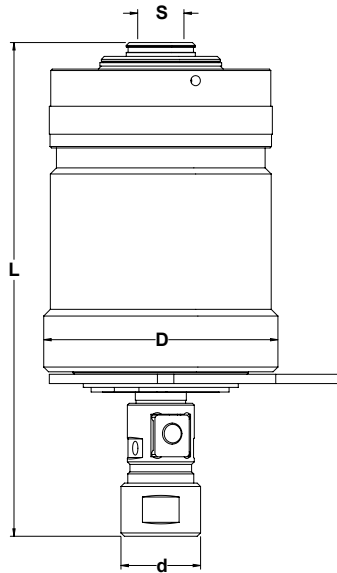
Order code	Adapter size	Collets Used	Clamping Ø	d1	d2
8138211N	Nr. 0	ER11	2.5-10	19	20-22
8208216	Nr. 1	ER16 (Mini nut)	2.5-10	22	24-27
8218220		ER20 (Mini nut)	2.5-13	28	35-38
8118220N		ER20 (Standard nut)	2.5-13	34	35-38

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.



# 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**

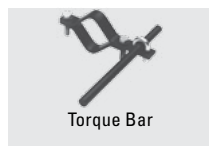
Model	D	d	Self-feed	Weight kg
Rx II 30	60	25	4	0.8
Rx II 50	80	35	5	2.0

(A) Model	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Mounts S		Order code	L	Max. RPM
			Taper mounts	Thread. mounts			
Rx II 30	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	JT6	1/2"-20	114006	109	2000
					B16		
			JT33	114033			
				114050			
Rx II 50	M3–M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.5-10.0)	JT6	1/2"-20	116006	169	1500
					B16		
			JT33	116033	164		
				116050			

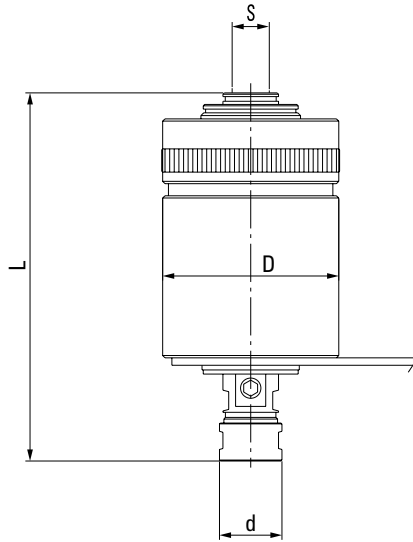
**Note:** When using Roll Form Taps the tool's capacity must be reduced by 25%. All dimensions are shown in mm. 25.4mm = 1".

**RF Rubber Flex Collets**

Tapping Head Capacity	RF Collet Order code	Clamping Capacity (mm)	Tap Capacity Metric Sizes (DIN 371, 374)	Tap Capacity Inch Sizes
M1.4-M7	21600	2.5-4.5	M1.6-M4	#0-#8
#0-1/4"	21700	4.5-6.5	M4-M6	#10-1/4"
M3-M12	22100	3.5-6.5	M3-M6	#0-1/4"
#6-1/2"	22200	6.5-10.0	M7-M12	5/16"-1/2"



# 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**

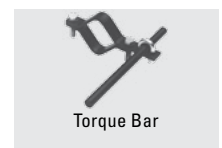
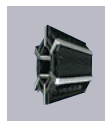
(A) Model	D mm	d mm	Self-feed mm T	Weight kg
RX30	53	19	3	0.7
RX50	76	27	5	1.8
RX70	88	36	7	3.0

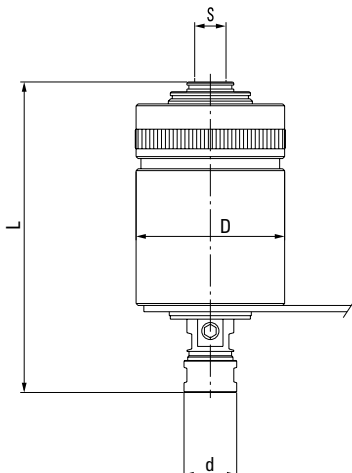
Model	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Mounts S		Order code	L	Max. RPM
			Taper mounts	Thread. mounts			
RX 30	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	JT6	3/8"–24 1/2"–20	013006	116	2000
			B16		013016		
			JT33		013033		
				013037			
RX 50	M3–M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.5-10.0)	JT6	1/2"–20	013050	157	1500
			B16		015006		
			JT33		015016		
				015033			
RX 70	M5–M18 #10 - 3/4"	24100 (4.5-10) 24500 (9.0-15.0)	JT3	1/2"–20 7/8"–20	015050	182	1200
					017003		
					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 Rubber Flex Collets**

Tapping Head Capacity	RF Collet Order code	Clamping Capacity (mm)	Tap Capacity Metric Sizes (DIN 371, 374)	Tap Capacity Inch Sizes
M1.4-M7 #0-1/4"	21600	2.5-4.5	M1.6-M4	#0-#8
	21700	4.5-6.5	M4-M6	#10-1/4"
M3-M12 #6-1/2"	22100	3.5-6.5	M3-M6	#0-1/4"
	22200	6.5-10.0	M7-M12	5/16"-1/2"
M5-M18 #10-3/4"	24100	4.5-10.0	M4-M12	#10-1/2"
	24500	9.0-15.0	M10-M18	1/2"-3/4"





- 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.

**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

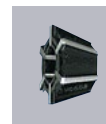
(A) Model	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Mounts S		Order code	L	Max. RPM	
			Taper mounts	Thread. mounts				
30X	M1.4-M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	JT6 B12 B16 JT33		10306	113	2000	
					10312			
					10316			
					10333			
					10331			104
					10337			
					10350			
50X	M3-M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.5-10.0)	JT6 B16 JT33		10362	153	1500	
					10375			
					10506			
					10516			
					10533			
					10537			148
					10550			
10562								
70X	M5-M18 #10 - 5/8"	24100 (4.5-10) 24500 (9.0-15.0)	JT3 B18		10575	176	1200	
					10703			
					10718			
					10750			
					10762			
					10775			
					10787			
90X	M10-M30 1/2" - 1 1/8"	26100 (10.0-16.0) 26200 (16.0-23.0)	JT4		10904	219	600	
					10915			
					10915			

**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 Rubber Flex Collets**

Tapping Head Capacity	RF Collet Order code	Clamping Capacity (mm)	Tap Capacity Metric Sizes (DIN 371, 374)	Tap Capacity Inch Sizes
M1.4-M7	21600	2.5-4.5	M1.6-M4	#0-#8
#0-1/4"	21700	4.5-6.5	M4-M6	#10-1/4"
M3-M12	22100	3.5-6.5	M3-M6	#0-1/4"
#6-1/2"	22200	6.5-10.0	M7-M12	5/16"-1/2"
M5-M18	24100	4.5-10.0	M4-M12	#10-1/2"
#10-3/4"	24500	9.0-15.0	M10-M18	1/2"-3/4"
M10-M30	26100	10.0-16.0	M10, M14-M20	9/16"-3/4"
1/2"-1 1/8"	26200	16.0-23.0	M20-M30	13/16"-1 1/8"



RF Multi-range Collets

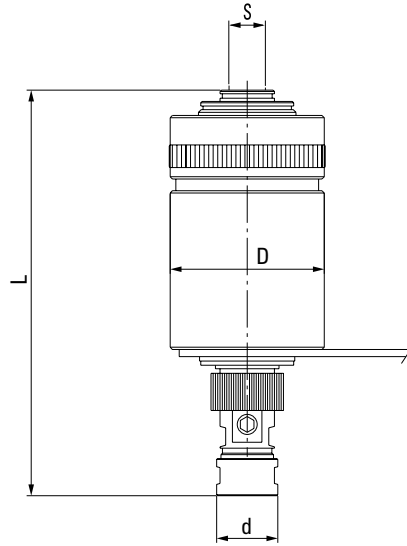


Arbors



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**

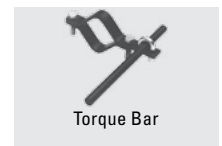
Model	D	d	Self-feed	Weight kg
30TC/DC	48	19	1.5-3.5	0.5
50TC/DC	70	27	2-6	1.2
70TC/DC	76	36	3-9	2.3

(A) Model	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Mounts S		Order code	L	Max. RPM
			Taper mounts	Thread. mounts			
30TC/DC	M1.4-M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	JT6	5/16"-24* 3/8"-24 1/2"-20 5/8"-16*	14306	122	2000
			B12		14312		
			B16		14316		
			JT33		14333	113	
					14331		
					14337		
50TC/DC	M3-M12 #6 - 1/2"	22100 (3.5-6.5) 22200 (6.4-10.0)	JT6	3/8"-24 1/2"-20 5/8"-16*	14506	169	1500
			B16		14516		
			JT33		14533		
					14537	191	
					14550		
					14562		
70TC/DC	M5-M18 #10 - 5/8"	24100 (4.5-10) 24500 (9.0-15.0)	JT3	1/2"-20 5/8"-16* 7/8"-20	14703	191	1200
			B18		14718		
					14750		
					14762		
					14787		

**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 Rubber Flex Collets**

Tapping Head Capacity	RF Collet Order code	Clamping Capacity (mm)	Tap Capacity Metric Sizes (DIN 371, 374)	Tap Capacity Inch Sizes
M1.4-M7 #0-1/4"	21600	2.5-4.5	M1.6-M4	#0-#8
	21700	4.5-6.5	M4-M6	#10-1/4"
M3-M12 #6-1/2"	22100	3.5-6.5	M3-M6	#0-1/4"
	22200	6.5-6.5	M7-M12	5/16"-1/2"
M5-M18 #10-3/4"	24100	4.5-10.0	M4-M12	#10-1/2"
	24500	9.0-15.0	M10-M18	1/2"-3/4"



**Tapping attachments with automatic reversal for conventional machines**



**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

**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

**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	Capacity (steel)	Collets Rubber Flex Order Code (Shank Ø)	Mounts S		Order code	L mm	Max. RPM
			Taper mounts	Thread. mounts			
SPD-3	M1.4–M7 #0 - 1/4"	21600 (2.5-4.5) 21700 (4.5-6.5)	JT6 B16 JT33		18306	118	2000
					18316		
					18333		
					18337		
					18350		
SPD-5	M3–M12 #6 - 1/2"	22100 3.5-6.5) 22200 (6.5-10.0)	JT6 B16 JT33		18506	148	1500
					18516		
					18533		
					18537		
					18550		
SPD-7	M5–M18 #10 - 5/8"	24100 (4.5-10.0) 24500 (9.0-15.0)	JT3		18575	148	1200
					18587		
					18703		
					18750		
					18762		
SPD-9A	M10–M30 1/2" - 1 1/8"	26100 (10.0-16.0) 26200 (16.0-23.0)	JT4	1 1/2"–18	18787	175	600
					17904		
					17915		
					228		
					200		
SPD-3 QC	M1.4–M7 #0 - 1/4"	Nr 0	B16 JT33		18216	109	2000
					18233		
					18237		
					18250		
					18262		
SPD-5 QC	M3–M12 #6 - 1/2"	Nr 1	B16 JT33		18275	109	1500
					18416		
					18433		
					18450		
					18462		
SPD-7 QC	M5–M18 #10 - 5/8"	Nr 2	JT3		18487	130	1200
					18603		
					18650		
					18662		
					18687		
SPD-9 QC	M10–M30 1/2" - 1 1/8"	Nr 3	JT4		17804	217	600
					17815		
SPD-11 QC	M22–M42, 3/4" - 2"	Nr 4			18100	236	400

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



RF Multi-range Collets



Torque Bar



Arbors



Quick-Change Adapters