

# Tension-Compression Tap Drivers

## For CNC Machining Centers Or CNC Lathes

**With  
Non-Synchronous  
Tap Cycles**



**NSM**  
For NC Machining  
& Turning Centers.  
Hard Start &  
Rubber-Flex  
Collet Chuck.  
Steel Collet  
Chuck available  
on special request.  
**Page 12**



**TA**  
For CNC or Conventional  
Lathes & Mills.  
Front Release  
Hard Start &  
Quick-Change  
Chuck.  
**Page 13**



**TIC**  
For CNC  
Machining Centers  
With Coolant  
Through.  
Front Release,  
Hard Start &  
Quick-Change  
Chuck.  
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**The Most Compact Tap Drivers Available.**

# NSM With Tension-Compression & Rubber-Flex Collet Chuck

## APPLICATIONS

Tension / Compression Tapping Units For NC Machining And Turning Centers. The NSM is the most compact tap driver available.

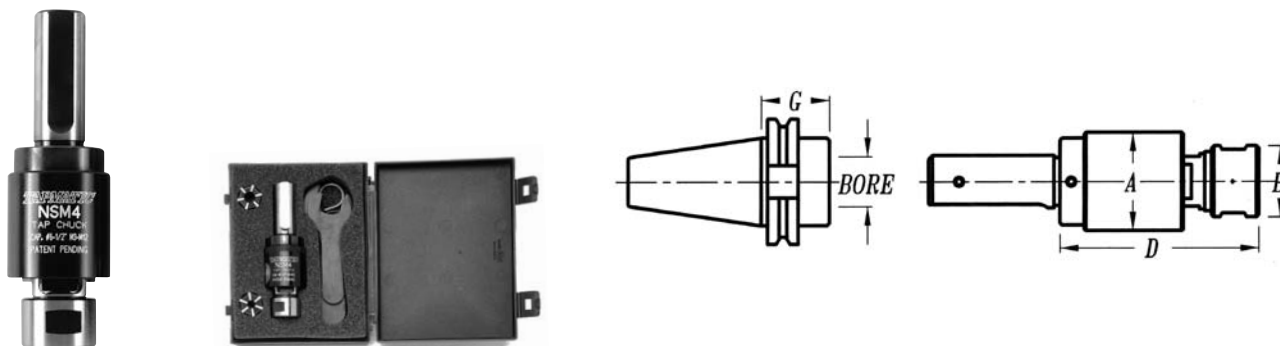
## FEATURES & ADVANTAGES

**Tap Holding System:** Uses Rubber-Flex Collets (only two required). ER Collet Chuck available on special request.

**Tension / Compression Compensation:** Provides greater thread accuracy and higher production rates.

**Compact Design:** For applications where space is limited.

**Releaseable Hard Start:** For accurate depth control.



Capacity In 1010 Mild Steel	Model	Shank	Catalog No.	Rubber-Flex Collet Series	Weight	A	B	D	Tension	Comp.
#0-1/4" M1.4-M6 Roll Form #10 Max	<b>NSM2</b>	5/8" SS	<b>35876</b>	#21000	.5 lb.	1.07	.750	2.20	.16	.25
		16mm SS	<b>35877</b>		.2 kg.	7mm	19mm	56mm	4mm	6.4mm
	<b>NSM2KIT</b>	5/8" SS	<b>35876KIT</b>	Includes Collets #21600 (#0-#8) & #21700 (#10-1/4")						
#6-1/2" M3-M12 Roll Form 3/8" Max NP 1/16", 1/8"	<b>NSM4</b>	3/4" SS	<b>35881</b>	#22000	.9 lb.	1.48	1.07	2.97	.25	.30
		20mm SS	<b>35882</b>		.4 kg.	38mm	27mm	76mm	6.4mm	7.6mm
	<b>NSM4 KIT</b>	3/4" SS	<b>35881KIT</b>	Includes Collets #22100 (#0-1/4") & #22200 (1/4"-1/2")						
#10-3/4" M5-M18 Roll Form 9/16" Max	<b>NSM6</b>	1" SS	<b>35886</b>	#24000	2.0 lb.	1.88	1.45	3.90	.37	.43
		25mm SS	<b>35887</b>		.9 kg.	48mm	37mm	99mm	9mm	11mm
1/2"-1 1/8" M10-M30 Roll Form 3/4" Max NP 1/2"	<b>NSM8</b>	1-1/2" SS	<b>35893</b>	#26000	5.6 lb.	2.50	2.25	5.15	.67	.54
		32mm SS	<b>35894</b>		2.5 kg.	63mm	57mm	131mm	17mm	14mm

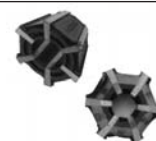
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**TAP DRIVER** This Page.

Please order by catalog and tap size capacity. Tool capacity must be reduced by 25% when using roll form.

**NC ARBORS**  
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**RUBBER-FLEX  
COLLETS**  
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# TA With Tension-Compression & Quick-Change Spindle

## APPLICATION

For CNC Machining And Turning Centers  
Or Conventional Lathes And Mills.

## FEATURES & ADVANTAGES

**Tension/Compression Compensation:** Provides greater thread accuracy and higher production rates.

**Hard Start:** For accurate depth control.

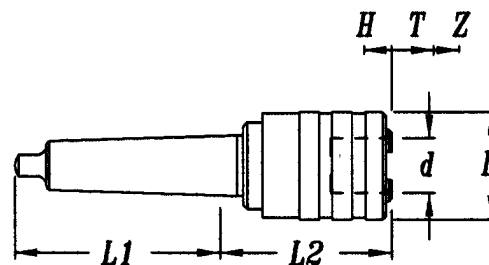
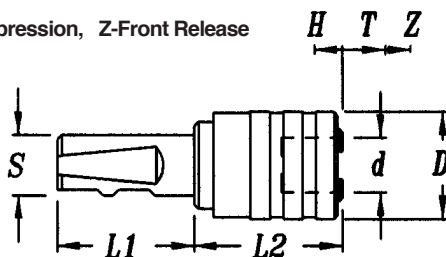
**Front Release:** If tension is accidentally over extended, adapter is released. Prevents damage to tap or workpiece.

**Short Length:** For limited space.

**Tap Holding:** Accepts Quick Change Tap Adapters



T- Tension, H- Compression, Z-Front Release



Capacity In 1010 Mild Steel	Model	Straight Shank	Catalog No.	Adapter Series	T	H	Z	D	d	L1	L2
#0-1/4' M1-M10	TA0-016	16mm	490016	#0	.30 7.5mm	.20 5mm	.07 1.7mm	1.14 29mm	.51 13mm	1.89 48mm	1.50 38mm
	TA1-020	20mm	491020	#1	.30 8mm	.20 5mm	.08 2.1mm	1.53 39mm	.75 19mm	1.93 49mm	1.53 39mm
5/16"-7/8" M4.5-M24	TA2-025	25mm	492025	#2	.59 15mm	.30 8.5mm	.11 2.8mm	2.20 56mm	1.22 31mm	2.24 57mm	2.48 63mm
	TA3-032	32mm	493032	#3	.92 23.5	.59 15mm	.16 4.1mm	3.19 81mm	1.89 48mm	2.4 61mm	4.88 124mm
7/8"-1 7/8" M22-M48	TA4-040	40mm	494040	#4	.98 25mm	.65 16.5mm	.22 5.7mm	3.90 99mm	2.36 60mm	2.80 71mm	5.33 135.5mm
Capacity In 1010 Mild Steel	Model	Straight Shank	Catalog No.	Adapter Series	T	H	Z	D	d	L1	L2
#0-1/4" M1-M10	TA0-MT2	MT2	490MT2	#0	.30 7.5mm	.20 5mm	.07 1.7mm	1.14 29mm	.51 13mm	2.95 75mm	1.77 45mm
	TA1-MT2	MT2	491MT2	#1	.30 8mm	.20 5mm	.08 2.1mm	1.53 39mm	.75 19mm	2.95 75mm	1.85 47mm
5/16"-7/8" M4.5-M24	TA1-MT3	MT3	491MT3	#1	.30 8mm	.20 5mm	.08 2.1mm	1.53 39mm	.75 19mm	3.70 94mm	1.85 47mm
	TA2-MT3	MT3	492MT3	#2	.59 15mm	.30 8.5mm	.11 2.8mm	2.20 56mm	1.22 31mm	3.70 94mm	2.80 71mm
13/16"-1 3/8" M14-M36	TA2-MT4	MT4	492MT4	#2	.59 15mm	.30 8.5mm	.11 2.8mm	2.20 56mm	1.22 31mm	4.60 117mm	2.83 72mm
	TA3-MT4	MT4	493MT4	#3	.92 23.5mm	.59 15mm	.16 4.1mm	3.19 81mm	1.89 48mm	4.62 117.5mm	4.13 105mm
7/8"-1 7/8" M22-M48	TA4-MT5	MT5	494MT5	#4	.98 25mm	.65 16.5mm	.22 5.7mm	3.90 99mm	2.36 60mm	5.88 149.5mm	4.58 116.5mm

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NC ARBORS  
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QUICK-CHANGE  
ADAPTERS  
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# TIC With Tension-Compression, Internal Coolant & Quick-Change Spindle

## APPLICATION

For CNC Machining Centers With Internal Coolant

## FEATURES & ADVANTAGES

**Internal Coolant System:** Up to 50 bar maximum

**Tension/Compression Compensation:** Provides greater thread accuracy and higher production rates.

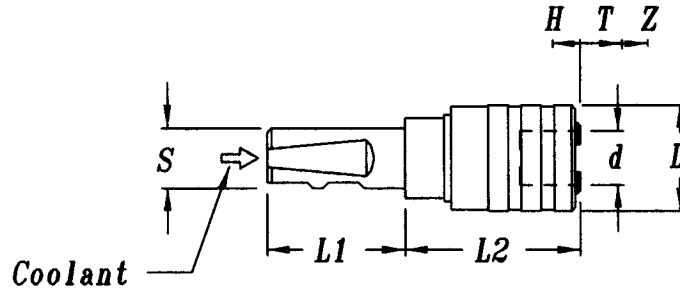
**Hard Start:** For accurate depth control.

**Front Release:** If tension is accidentally over extended, adapter is released. Prevents damage to tap or workpiece.

**Short Length:** For limited space.

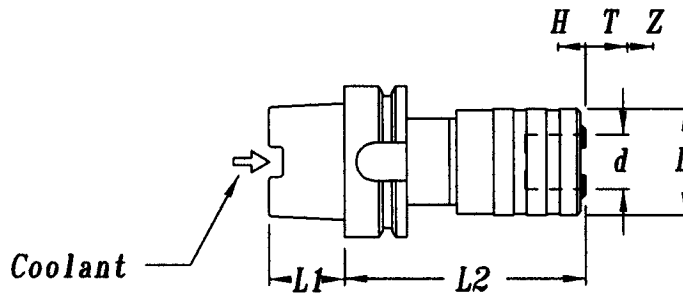
**Surface Protection:** Resistant to corrosion.

**Tap Holding:** Accepts Quick Change Tap Adapters



T- Tension  
H- Compression  
Z- Front Release

Capacity In 1010 Mild Steel	Model	Straight Shank	Catalog No.	Adapter Series	T	H	Z	D	d	L1	L2
#8-9/16" M3-M14	TIC1-025	25mm	49C1025	#1	.30 7.5mm	.20 5mm	.10 2.5mm	1.70 43mm	.45 19mm	2.24 57mm	2.44 62mm
5/16"-7/8" M4.5-M24	TIC2-025	25mm	49C2025	#2	.40 10mm	.28 7mm	.12 3mm	2.32 59mm	1.22 31mm	2.24 57mm	3.86 98mm



T- Tension  
H- Compression  
Z- Front Release

Capacity In 1010 Mild Steel	Model	HSK Shank	Catalog No.	Adapter Series	T	H	Z	D	d	L1	L2
#8-9/16" M3-M14	TIC1-HSK63A	63A	49C1H63	#1	.30 7.5mm	.20 5mm	.10 2.5mm	1.70 43mm	.75 19mm	1.26 32mm	3.66 93mm
	TIC1-HSK100A	100A	49C1H100							1.97 50mm	3.86 98mm
5/16"-7/8" M4.5-M24	TIC2-HSK63A	63A	49C2H63	#2	.40 10mm	.28 7mm	.12 3mm	2.32 59mm	1.22 31mm	1.26 32mm	5.12 130mm
	TIC2-HSK100A	100A	49C2H100							1.97 50mm	5.31 135mm

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QUICK-CHANGE  
ADAPTERS  
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