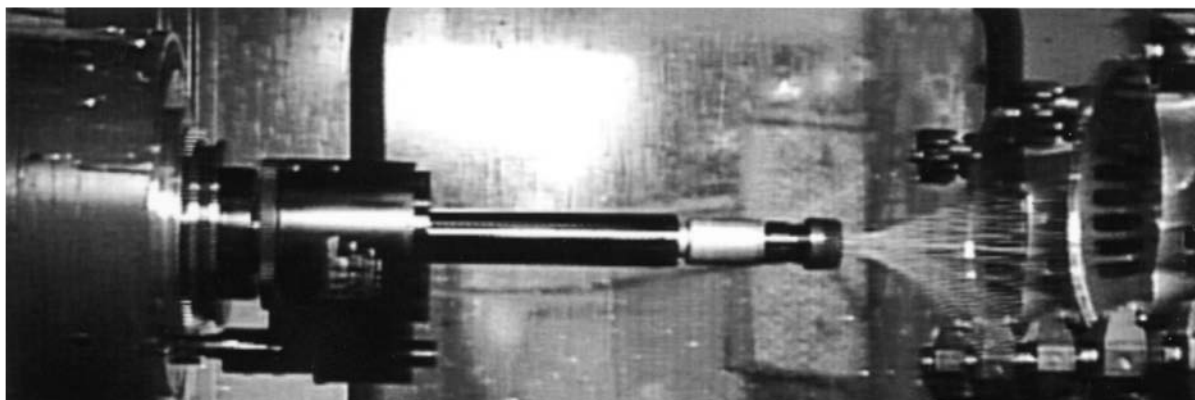


Manufacturers Worldwide Bring Us Their Toughest Tapping Problems

Tapmatic Has Helped Some Of The Biggest Companies In The World Tap Holes That Seemed Impossible- Without Extra Set-Ups.

High Production Tapping At The Highest Speeds, The Toughest Materials- Exotics, Stainless, High Silicon Aluminum, etc., Deep Blind Holes With Small Roll Form Taps, Adverse Coolant Conditions, High Pressure Coolant Through and Hard To Reach Holes.

**Please Give Us A Call And The Opportunity To Assist With Your Tapping Applications.
800/854-6019**



Special Purpose First & Only Self-Reversing Tapping Units For 4 Axis CNC Lathes

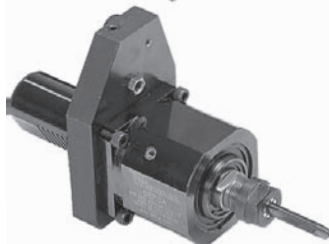
ASR & RSR Series With Steel Collet Chuck For 4 Axis CNC Lathes With Live Tooling.

Constant Speed
Instantaneous Coupling And Uncoupling between drive and reverse at speeds up to 2000 rpm.
Eliminate Machine Reversal Related Wear and Tear.
Compact Size: Usually no larger than conventional non-reversing tap driver.
Accurate Thread Depth

RSR
Right
Angle Head



ASR



ASR25 (#4-1/4", M2.5-M7)

Order No. 37030
Specifications On Request
 Order #11 Flex Steel Collets separately.

ASR50C (#10-1/2", M4.5-M12)

Order No. 32161
Specifications On Request
 Order #16 Square Drive Flex Steel Collets separately.

ASR50 (#10-1/2", M4.5-M12)

Order No. 37044
Specifications On Request

Order #16 Square Drive Flex Steel Collets separately. Order #20 Square Drive Flex Steel Collets separately

ASR65 (1/4"-5/8", M6-M16)

Order No. 37048
Specifications On Request

RSR50 (#10-1/2", M4.5-M12)

Order No. 37014
Specifications On Request
 Order #16 Square Drive Flex Steel Collets separately.

NOTES: Base Adapters to go with ASR & RSR available for adapting to the turret of your specific machine. Please specify Machine Manufacturer and Model Number for a price quote.

Special Purpose Self-Reversing Tapping Units For Machining Centers

For Smaller Tap Sizes With Coolant Through



Balanced High-Pressure, Coolant System
 Compact 57mm Diameter
 Renewable Drive System
 Dampened And Spring Biased Coupler
 Tapping Spindle Floats In Ball & Needle Bearings
 Unique Vacuum Suppressor
 Integral Orientation Collar and Stop Arm
 Accurate Thread Depth Repeatability
 Modular System
 Spindle Options: ER11 Heavy Duty Steel Spindle

RDTIC25HD (#4-1/4", M2.5-M6)		
Order No.	Shank	Specifications
4025111	1" SS	On Request
40252511		25mm SS
Order #11 Flex Steel Collets separately.		

For Limited Carousel Space



Balanced High-Pressure, Coolant System,
 Compact 65mm Diameter
 Renewable Drive System
 Dampened And Spring Biased Coupler
 Shock Absorber Gear Drive
 Tapping Spindle Floats In Ball & Needle Bearings
 Unique Vacuum Suppressor
 Integral Orientation Collar and Stop Arm
 Accurate Thread Depth Repeatability
 Modular System
 ER 16 High Speed Light Weight Spindle.

ID50 (#10-1/2", M4.5-M12)		
Order No.	Shank	Specifications
38640	1" SS	On Request
38642	25mm SS	
Order #16 Flex Steel Collets separately.		
(B) Stop Arm Assemblies		
Order No.	Shank	Specifications
717965	65mm	On Request
717980	80mm	

Please note that Tapmatic can supply stop arms ready to fit your machine and stop block. Please consult a Tapmatic Sales Engineer.

RDT Ready To Run On Specific Machines Including The Following And Many Others.

RDT Units For Specific Machines With 80mm Offset and CAT 50.	RDT Units For Specific Machines With 65mm Offset and CAT 40.	RDT Units For FADAL Machines.
Cincinnati Milacron Maxim 500 and 630 Cincinnati Milacron Magnum 800 Mazak FH680 Mitsui Seiki HU63A Okuma MC500H Toyoda FA630	Haas VF1, VF2, VF3, VF4, LeBlond Makino A55, LeBlond Makino A55 Delta Series, Komo VMC40	RDT For FADAL VMC20, 40, 4020, 6030 Steel Collet Chuck Spindle RDT For FADAL VMC20, 40, 4020, 6030 Rubber-Flex Collet Chuck Spindle

Special Purpose: Self-Reversing Tapping Units For Hard To Reach Holes

RDTXT & RDTICXT Special Extra Long Extension Units Eliminate 2nd Operations On CNC Machining Centers. These heads clear fixturing and reach into cavities and hard to reach areas without 2nd operations.

For standard XT lengths
Please see pages 21 and 26.



RDTXT & RDTICXT Interchangeable Insert Spindle

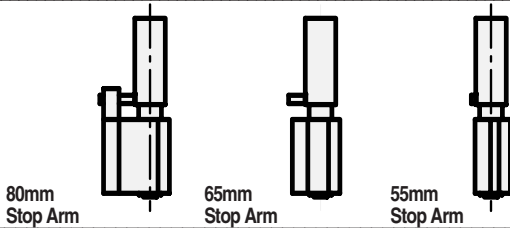
Capacity In 1010 Mild Steel	Model	Shank	Catalog No.	Inserts	*Rec. Max. Speed
#10-1/2" M4.5-M12 Roll Form 3/8" Max NP 1/16", 1/8"	RDTXT50	1" SS 25mm SS	39501318 395025318	Order Separately	1500 RPM
	RDTICXT50	1" SS 25mm SS	40501318 405025318	Order Separately	
#10-1/2" M4.5-M12 Roll Form 3/8" Max NP 1/16", 1/8"	With Internal Coolant				

Special lengths available on request.

**See recommended tapping speeds for specific tap size and workpiece material. Charts included in instructions sheets. Do not exceed maximum speed.*

Please Note: For RDTXT & RDTICXT maximum speed with ER20 Insert is 1500 RPM.

RDTIC models come with standard nuts which allow some coolant flow through collet slots. To restrict flow to the coolant hole of the tap and seal the collet slots, the tools may also be ordered with a sealing disk nut. Please add "S" to the end of the order numbers shown to specify tool with sealing disk nuts. ***Special Center Distances also available.**



Stop Arm Assemblies

*Center Distance	Catalog No. For RDT 50
55mm	395055
65mm	395065
80mm	395080

RSR VMC For Right Angle Access On Vertical CNC Machining Centers.

These units tap holes on the side of a part saving time and money by eliminating extra set ups.



All the same features and advantages as the RDT Constant Speed Tapping Attachments plus
Adjustable Tap Position: Position of the tap can be adjusted independently from the stop block position.

65mm Offset, Steel Collet Chuck

80mm Offset, Steel Collet Chuck

RSR50 (#10-1/2", M4.5-M12)

RSR50 (#10-1/2", M4.5-M12)

Order No.	Shank	Stop Arm	Order No.	Shank	Stop Arm
37020	1" SS	55 mm	37024	1" SS	80mm
37021	25mm SS		37025	25mm SS	

Order #16 Flex Steel Collets with square drive separately.

Stop Block Assembly
Tapered Stop Block For RSR VMC
Order No. 56014

Complete Specifications On Request

Special Purpose Tension/Compression Tapping Units

NC With Quick-Change Spindle And Self-Release

For Conventional or CNC Lathes and Mills Where Either The Tool Or Part Rotates



Self-Release: Within a fraction of a revolution allows accurate depth control without relying on machine spindle stop. Please note the self-release feature is only for blind holes.

Ball-Drive: Friction free design provides greater thread accuracy.

Releaseable Hard Start

Capacity In 1010 Mild Steel	Model	Shank	Catalog No.	Adapter	Specifications On Request
#4-1/4" (M1.4-M6) Roll Form #10 Max	NC-0	3/4" SS 20mm SS	34000 34002	#0	
#8-9/16" (M3-M12) Roll Form 3/8" Max, NP 1/16", 1/8"	NC-1	1" SS 25mm SS	34010 34012	#1	
5/16"-7/8" (M5-M22) Roll Form 9/16" Max, NP 1/4", 3/8"	NC-2S	1" SS 25mm SS	34020S 34022S	#2	

GS/NCL with Quick-Change Spindle And Releaseable Hard Start

For NC Machining and Turning Centers.



Capacity In 1010 Mild Steel	Model	Shank	Catalog No.	Adapter	Specifications On Request
#2-1/4" (M2-M6) Roll Form #10 Max	GS/NCL-0	3/4" SS	35850	#0	
#4-1/2" (M2.5-M12) Roll Form 3/8" Max NP 1/16", 1/8"	GS/NCL-1	1" SS	35851	#1	
5/16"-3/4" (M8-M18) Roll Form 3/8" Max	GS/NCL-2	1" SS	35852	#2	