

Tension/Compression tap holders with self feed and release to neutral

The **NC Series Tools** include a unique feature which allows you to control the tapping depth independent of the stopping position of the machine spindle. When the feed is paused with the spindle of the machine still rotating, the tap will continue into the hole for a short "self feed" distance, extending the tension float of the tap holder. Once this position is reached the drive of the tap holder releases and the tap stops. The machine spindle can then be stopped, reversed and retracted. The release feature is an accurate way to control tapping depth in blind holes and can be used on both CNC controlled machines or even on conventional machines where the operator is controlling the feed.

Tension/Compression tap chucks with modular straight shank, quick change and release to neutral



Tapping chuck with quick change spindle and self-release.

Features and Advantages

- tension compression
- releasable hard start for consistent depth control
- self-release for precise depth control independent of machine spindle stop
- quick-change version for fast tap changes without any wrenches

How to order

Please select the tapping chuck (A) and CAT, SK or BT shank (B), to fit your application. Standard adapters (C) shown in accessories section.

(A) NC Tapping Chuck with Straight Shank, Quick-Change Adapter

Model	Order code	Capacity (steel)	Shank	Adapter Size	Weight kg	D	L	Self-feed	
								self-release	Compression
NC0	34002	M2–M6	20 mm	Nr. 0	0.4	38	60	5	8
	34000	#4–1/4"	3/4"						
NC1	34012	M3–M12	25 mm	Nr. 1	1.2	51	85	5	15
	34010	#8–9/16"	1"						
NC2S	34022S	M5–M22	25 mm	Nr. 2	2.0	70	89	8	11
	34020S	5/16"–7/8"	1"						

NC150 large capacity, tension float with release to neutral and internal coolant system



(A) NC150 Tapping Chuck with Straight Shank, ER50 Steel Collet, Internal Coolant System

Model	Order code	Capacity (steel)	Shank	Collets	Weight kg	D	d	L	Self-feed	
									self-release	Compression
NC150	3415040	M22–M48	40 mm	ER50	4.0	88	78	227	9	

