

Birla Precision

Machining Center Tooling
Tapping Systems

ISO 9001 : 2015
ISO 14001 : 2015
CERTIFIED



BPT
B I R L A
P R E C I S I O N

BIRLA PRECISION

AT3 CLASS PRECISION ROTATING TOOL HOLDERS

AT3

WHAT DOES AT3 CLASS MEAN ?

According to the ISO standards, there are 7 Angular Tolerance (AT) grades, as given under.
ATD - Values in mm and **AT α** Angular Values in Seconds (").

TOLERANCE ZONES

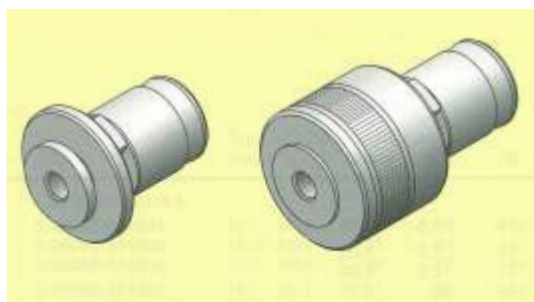
Taper		Gauges				Hi-Speed/Hi Accuracy Machining				Normal Machining		Utility Application			
		Master		Working											
		AT 0		AT 1		AT 2		AT 3		AT 4		AT 5		AT 6	
Size	Length	ATD	AT α	ATD	AT α	ATD	AT α	ATD	AT α	ATD	AT α	ATD	AT α	ATD	AT α
30	47,63	0,0006	0"	0,0010	4"	0,0015	6"	0,0023	10"	0,0038	16"	0,0061	26"	0,0095	41"
40	68,25	0,00069	0"	0,0011	3"	0,0017	5"	0,0028	8"	0,0043	13"	0,0069	21"	0,0109	33"
50	101,60	0,0011	0"	0,0017	2,5"	0,0020	4"	0,0033	6"	0,0051	10"	0,0081	16"	0,0127	26"

Tap Chuck



Tap Chuck

with tension and compression.
Tap adaption by quick change tap adaptor



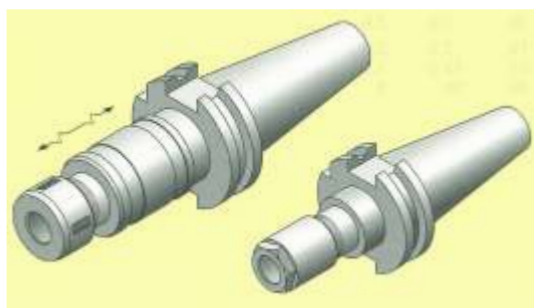
Quick Change Tap Adaptor

with and without overload clutch.



Solid Tap Chuck

Tap adaption by quick change tap adaptor.



Tap Collect Chuck

Tension and compression type.
Solid type



Tap Collect

are designed to withstand the high torque loads that occur in tapping operations. A property chucked tap is gripped and centered on its round shank, but driven on its square.

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Note:

Our products are under development for improvement & we keep right to change in catalogue without keeping you informed. Believe information given in the catalogue is true & correct, even then have no responsibility for error of any type.

Product Code Identification System

Tap Chuck

1.
Attachment

BT - MAS 403, JIS B 6339
DV - DIN 69871/1
CV - ANSI B5 50/ISO7388
HSK - Shank Style

4.
Adaptor & Chuck Size

Examples
1/2/3

6.
Metric Standard

M = Tool built to Metric Values
(blank) = Tool built to inch Values

BT

40

RC

1

080

M

2.
Shank Size

ISD Taper size :

30

40

50

HSK Taper :

50

63

100

3.
Adaptor Type

RC - Tension & Compression
- without Clutch

RS - Tension & Compression
- with Clutch

ST - Solid Type

RCN - Rapid Change Extension Type Tap
Adaptor Without Overload clutch

RSN - Rapid Change Extension Type Tap
Adaptor With Overload clutch

5.
Projection Length
from the Gauge Line

Tool Length

Tap Adaptor

1.
Adaptor Type

RC - Rapid Change Tap Adaptor Without
Overload clutch

RS - Rapid Change Tap Adaptor With
Overload clutch

RCN - Rapid Change Extension Type Tap
Adaptor Without Overload clutch

RSN - Rapid Change Extension Type Tap
Adaptor With Overload clutch

3.
Adaptor Type

TA - Tap Adaptor

5.
Tap Square 2.1

RC

1

TA

025

021

M

2.
Adaptor and
Chuck Size

0 - (For Tap - M1-M10)

1 - (For Tap - M3-M12)

2 - (For Tap - M8-M20)

3 - (For Tap - M14-M33)

4 - (For Tap - M22-M48)

7 - (For Tap - M6-M18)

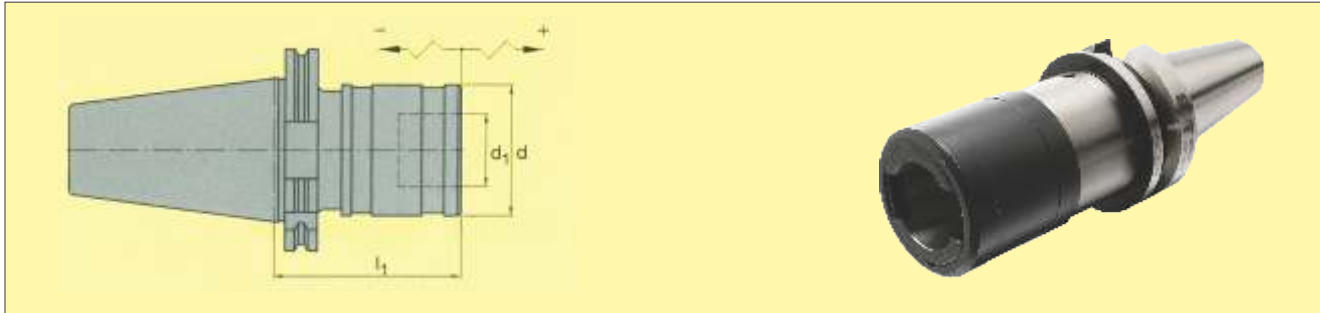
4.
Tap Shank
Ø 2.5

6.
Metric Standard

M = Tool built to Metric Values
(blank) = Tool built to inch Values

Tap Chuck - Tension & Compression

Adaptor Type - on ISO and HSK - Shanks



- Rapid Change Style
- Tension and Compression type
- **Order Example:**
BT30RC1061M

Catalogue No	Adaptor Type	Tap Capacity		l ₁	d	d ₁	Compression	Tension	Weight in Kg.
		Tap Size	Shanks				Minus L ₁	Plus L ₁	
BT30RC1061M	RC1/RS1	M1 to M14	2.5 to 11	61	36	19	7.5	7.5	0.8
BT40RC1067M	RC1/RS1	M1 to M14	2.5 to 11	67	36	19	7.5	7.5	2
BT40RC2094M	RC2/RS2	M5 to M24	6 to 18	94	53	31	12.5	12.5	2.2
BT40RC3163M	RC3 /RS3	M14 to M36	11 to 28	163	78	48	20	20	2.9
BT50RC1077M	RC1 /RS1	M1 to M14	2.5 to 11	77	36	19	7.5	7.5	3.1
BT50RC2102M	RC2/RS2	M5 to M24	6 to 18	102	53	31	12.5	12.5	3.9
BT50RC3141M	RC3/RS3	M14 to M36	11 to 28	141	78	48	20	20	4.7
DV30RC1058M	RC1/RS1	M1 to M14	2.5 to 11	58	36	19	7.5	7.5	0.70
DV40RC1059M	RC1/RS1	M1 to M14	2.5 to 11	59	36	19	7.5	7.5	1.8
DV40RC2097M	RC2/RS2	M5 to M24	6 to 18	97	53	31	12.5	12.5	2
DV40RC3149M	RC3/RS3	M14 to M36	11 to 28	149	78	48	20	20	2.7
DV50RC1059M	RC1/RS1	M1 to M14	2.5 to 11	59	36	19	7.5	7.5	2.9
DV50RC2083M	RC2/RS2	M5 to M24	6 to 18	83	53	31	12.5	12.5	3.7
DV50RC3138M	RC3/RS3	M14 to M36	11 to 28	138	78	48	20	20	4.5
HSK63ARC1105M	RC1/RS1	M1 to M14	2.5 to 11	105	39	19	7.5	7.5	1.3
HSK63ARC2140M	RC2/RS2	M4.5 to M24	6 to 18	140	60	31	10	10	2.2
HSK63ARC3203M	RC3/RS3	M14 to M36	11 to 28	203	86	48	17.5	17.5	4.9
HSK100ARC1112M	RC1/RS1	M1 to M14	2.5 to 11	112	39	19	7.5	7.5	3.6
HSK100ARC2144M	RC2/RS2	M4.5 to M24	6 to 18	144	60	31	10	10	4.1
HSK100ARC3210M	RC3/RS3	M14 to M36	11 to 28	210	86	48	17.5	17.5	6.9

Note:

Also available in DO / DT/ VDI Shanks upon request

For quick change Tap Adaptor without overload clutch (RC) see page no. 5-6

For quick change Tap Adaptors with overload clutch (RS) see page no. 8-9

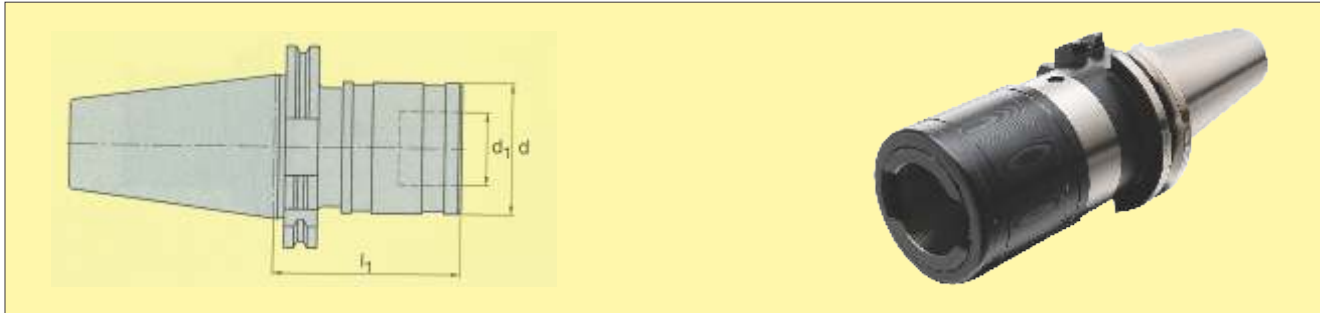
Quick change Tap Adaptors (RC/RS) must be order seperately

Pull stud must be order seperately

All details are subject to change without notice

Tap Chuck - Solid Type

Adaptor Type - On ISO and HSK - Shanks



- Rapid Change Style
- Solid type
- **Order Example:**
BT30STRC1060M

Catalogue No	Adaptor Type	Tap Capacity		l ₁	d	d ₁	Weight in Kg.
		Tap Size	Shanks				
BT30STRC1060M	RC1/RS1	M1 to M14	2.5 to 11	60	36	19	0.9
BT40STRC1072M	RC1/RS1	M1 to M14	2.5 to 11	72	36	19	1.4
BT40STRC2091M	RC2/RS2	M5 to M24	6 to 18	91	53	31	1.7
BT50STRC1075M	RC1/RS1	M1 to M14	2.5 to 11	75	36	19	3.8
BT50STRC2094M	RC2/RS2	M5 to M24	6 to 18	94	53	31	4
DV30STRC1092M	RC1/RS1	M1 to M14	2.5 to 11	92	36	19	0.8
DV40STRC1072M	RC1/RS1	M1 to M14	2.5 to 11	72	36	19	1.2
DV40STRC2091M	RC2/RS2	M5 to M24	6 to 18	91	53	31	1.5
DV50STRC1072M	RC1/RS1	M1 to M14	2.5 to 11	72	36	19	3.6
DV50STRC2091M	RC2/RS2	M5 to M24	6 to 18	91	53	31	3.8
HSK63ASTRC1105M	RC1/RS1	M1 to M14	2.5 to 11	105	36	19	1.4
HSK63ASTRC2140M	RC2/RS2	M5 to M24	6 to 18	140	53	31	2.2
HSK100ASTRC1112M	RC1/RS1	M1 to M14	2.5 to 11	112	36	19	3.6
HSK100ASTRC2144M	RC2/RS2	M5 to M24	6 to 18	144	53	31	4.1

Note:

Also available in DO / DT/ VDI Shanks upon request

For quick change Tap Adaptor without overload clutch (RC) see page no. 5-6

For quick change Tap Adaptors with overload clutch (RS) see page no. 8-9

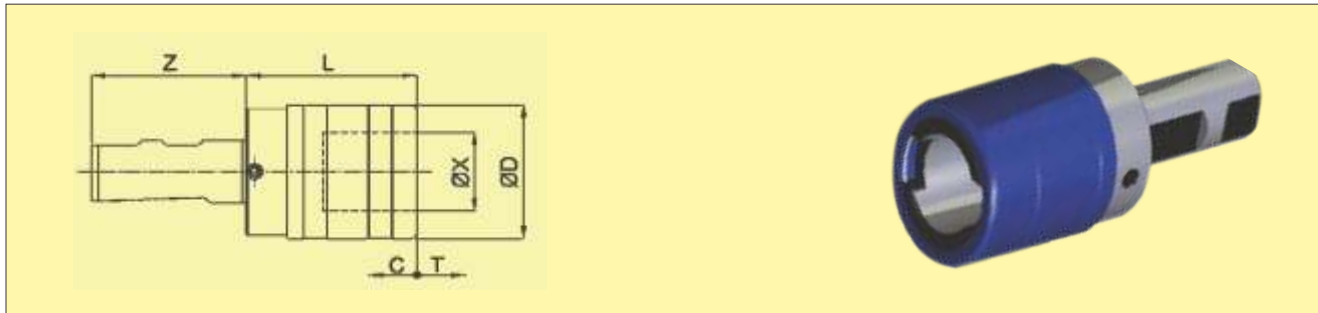
Quick change Tap Adaptors (RC/RS) must be order seperately

Pull stud must be order seperately

All details are subject to change without notice

Tap Chuck Tension & Compression

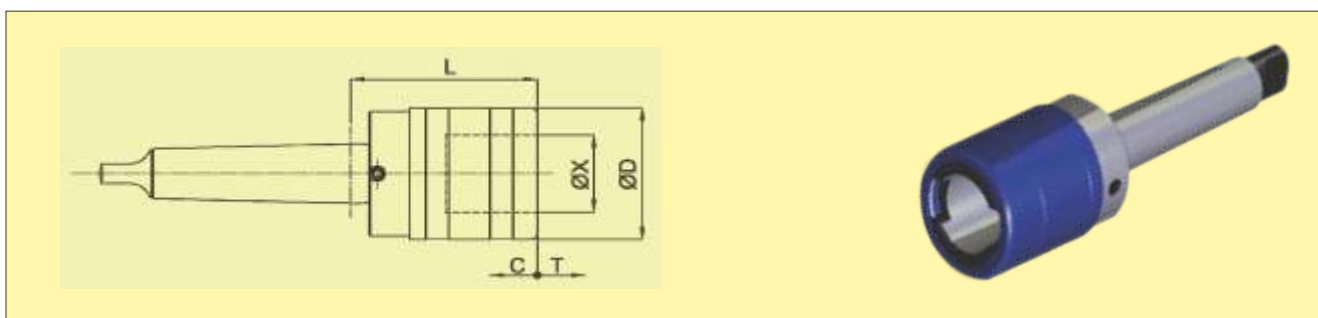
Adaptor Type - on Straight Shank



- Quick Change Tapping Chuck Tension & Compression Type
- **Order Example:**
WS200RC1039M

Catalogue No	Adaptor Type	Copemrssion	Tension	Type Size	ØX	ØD	Z	L
		Minus L1	Plus L1					
WS200RC1039M	RC1	7.5	7.5	M3 toM12	19	36	51	39
WS250RC1039M							53	
WS250RC2063M	RC2	12.5	12.5	M8 toM20	31	36	53	63
WS320RC2063M							60	
WS250RC3170M	RC3	20	20	M14 toM33	48	36	53	170
WS320RC3124M							60	124

Adaptor Type - on Morse Taper Shank



- Quick Change Tapping Chuck Tension & Compression Type
- **Order Example:**
MT2RC1047M

Catalogue No	Adaptor Type	Copemrssion	Tension	Type Size	ØX	ØD	L
		Minus L1	Plus L1				
MT2RC1047M	RC1	7.5	7.5	M3 toM12	19	36	47
MT3RC1047M							
MT3RC2071M	RC2	12.5	12.5	M8 toM20	31	53	71
MT4RC2072M							72
MT4RC3105M	RC3	20	20	M14 toM33	48	78	105
MT5RC3106M							106

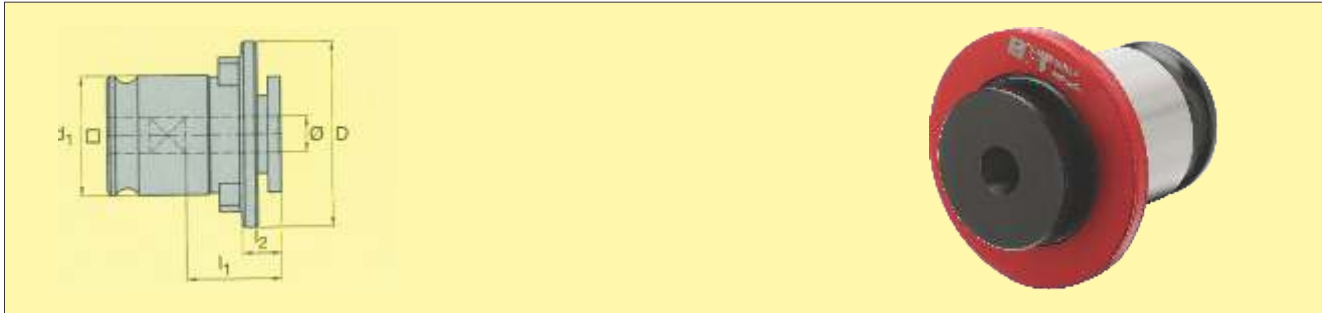
Note:

For quick change Tap Adaptor without overload clutch (RC) see page no. 5-6
For quick change Tap Adaptors with overload clutch (RS) see page no. 8-9
Quick change Tap Adaptors (RC/RS) must be order seperately

All details are subject to change without notice

Quick Change Tap Adaptor

Without overload clutch



- Rapid Change Style
- Solid positive drive
- For taps with ISO specifications - ISO 529/8283

• **Order Example:**

RC1TA028023M025

Catalogue No	Adaptor Type	Adaptor Size	Tap ISO 529/8283			d ₁	D	l ₁	l ₂
			M	Ø	□				
RC1TA028023M025	RC1	1	M2.2,M2.5	2.80	2.24	19.00	30.00	17.00	7.00
RC1TA032025M030	RC1	1	M3,M4	3.15	2.50	19.00	30.00	17.00	7.00
RC1TA036028M035	RC1	1	M3.5,M4.5	3.55	2.80	19.00	30.00	17.00	7.00
RC1TA040032M040	RC1	1	M4,M5	4.00	3.15	19.00	30.00	17.00	7.00
RC1TA045036M060	RC1	1	M4.5,M6	4.50	3.55	19.00	30.00	17.00	7.00
RC1TA050040M050	RC1	1	M5	5.00	4.00	19.00	30.00	17.00	7.00
RC1TA056045M000	RC1	1	UNC-UNF 12	5.60	4.50	19.00	30.00	17.00	7.00
RC1TA063050M060	RC1	1	M6,M8	6.30	5.00	19.00	30.00	17.00	7.00
RC1TA071056M070	RC1	1	M7	7.10	5.60	19.00	30.00	17.00	7.00
RC1TA080063M080	RC1	1	M8,M10,M11	8.00	6.30	19.00	30.00	17.00	7.00
RC1TA090071M090	RC1	1	M9,M12	9.00	7.10	19.00	30.00	17.00	7.00
RC1TA100080M100	RC1	1	M10	10.00	8.00	19.00	30.00	17.00	7.00
RC2TA063050M060	RC2	3	M6,M8	6.30	5.00	31.00	48.00	30.00	11.00
RC2TA071056M070	RC2	3	M7	7.10	5.60	31.00	48.00	30.00	11.00
RC2TA080063M080	RC2	3	M8,M10,M11	8.00	6.30	31.00	48.00	30.00	11.00
RC2TA090071M090	RC2	3	M9,M12	9.00	7.10	31.00	48.00	30.00	11.00
RC2TA100080M100	RC2	3	M10	10.00	8.00	31.00	48.00	30.00	11.00
RC2TA112090M140	RC2	3	M14	11.20	9.00	31.00	48.00	30.00	11.00
RC2TA125100M160	RC2	3	M16	12.50	10.00	31.00	48.00	30.00	11.00
RC2TA140112M180	RC2	3	M18,M20	14.00	11.20	31.00	48.00	30.00	11.00
RC2TA160125M220	RC2	3	M22	16.00	12.50	31.00	48.00	30.00	11.00
RC2TA180140M240	RC2	3	M24	18.00	14.00	31.00	48.00	30.00	11.00
RC3TA112090M140	RC3	4	M14	11.20	9.00	48.00	70.00	44.00	14.00
RC3TA125100M160	RC3	4	M16	12.50	10.00	48.00	70.00	44.00	14.00
RC3TA140112M180	RC3	4	M18,M20	14.00	11.20	48.00	70.00	44.00	14.00
RC3TA160125M220	RC3	4	M22	16.00	12.50	48.00	70.00	44.00	14.00
RC3TA180145M240	RC3	4	M24	18.00	14.00	48.00	70.00	44.00	14.00
RC3TA200160M300	RC3	4	M27,M30	20.00	16.00	48.00	70.00	44.00	14.00
RC3TA224180M330	RC3	4	M33	22.00	18.00	48.00	70.00	44.00	14.00
RC3TA250200M360	RC3	4	M36	25.00	20.00	48.00	70.00	44.00	14.00

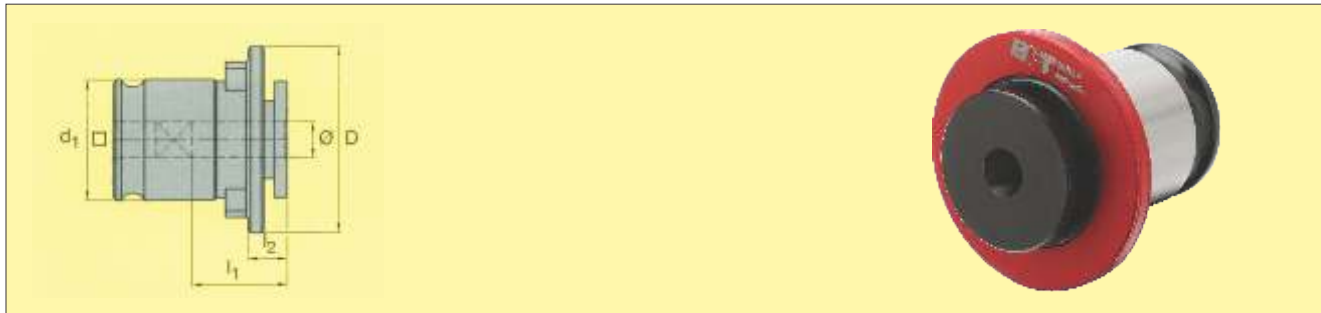
Note:

Tap Adaptor with coolant supply channel upon request

All details are subject to change without notice

Quick Change Tap Adaptor

Without overload clutch



- Rapid Change Style
- Solid positive drive
- For taps with DIN specifications - DIN 371/374/376
- **Order Example:**
RC1TA025021M010

Catalogue No	Adaptor Type	Adaptor Size	Tap DIN 371/374/376			d ₁	D	I ₁	I ₂
			M	Ø	□				
RC1TA025021M010	RC1	1	M1 to M1.8, M3 to M3.5	2.50	2.10	19.00	30.00	17.00	7.00
RC1TA028021M020	RC1	1	M2.5, M4	2.80	2.10	19.00	30.00	17.00	7.00
RC1TA035027M030	RC1	1	M3, M5	3.50	2.70	19.00	30.00	17.00	7.00
RC1TA040030M035	RC1	1	M3.5	4.00	3.00	19.00	30.00	17.00	7.00
RC1TA045034M040	RC1	1	M4, M5	4.50	3.40	19.00	30.00	17.00	7.00
RC1TA060049M050	RC1	1	M5, M6, M7, M8	6.00	4.90	19.00	30.00	17.00	7.00
RC1TA070055M100	RC1	1	M10	7.00	5.50	19.00	30.00	17.00	7.00
RC1TA080062M080	RC1	1	M8	8.00	6.20	19.00	30.00	17.00	7.00
RC1TA090070M120	RC1	1	M12	9.00	7.00	19.00	30.00	17.00	7.00
RC1TA100080M100	RC1	1	M10	10.00	8.00	19.00	30.00	17.00	7.00
RC1TA110090M140	RC1	1	M14	11.00	9.00	19.00	30.00	17.00	7.00
RC2TA060049M050	RC2	3	M5, M6, M7, M8	6.00	4.90	31.00	48.00	30.00	11.00
RC2TA070055M100	RC2	3	M10	7.00	5.50	31.00	48.00	30.00	11.00
RC2TA080062M080	RC2	3	M8	8.00	6.20	31.00	48.00	30.00	11.00
RC2TA090070M120	RC2	3	M12	9.00	7.00	31.00	48.00	30.00	11.00
RC2TA100080M100	RC2	3	M10	10.00	8.00	31.00	48.00	30.00	11.00
RC2TA110090M140	RC2	3	M14	11.00	9.00	31.00	48.00	30.00	11.00
RC2TA120090M160	RC2	3	M16	12.00	9.00	31.00	48.00	30.00	11.00
RC2TA140110M180	RC2	3	M18	14.00	11.00	31.00	48.00	30.00	11.00
RC2TA160120M200	RC2	3	M20	16.00	12.00	31.00	48.00	30.00	11.00
RC2TA180145M220	RC2	3	M22 to M26	18.00	14.50	31.00	48.00	30.00	11.00
RC3TA110090M140	RC3	4	M14	11.00	9.00	48.00	70.00	44.00	14.00
RC3TA120090M160	RC3	4	M16	12.00	9.00	48.00	70.00	44.00	14.00
RC3TA140110M180	RC3	4	M18	14.00	11.00	48.00	70.00	44.00	14.00
RC3TA160120M200	RC3	4	M20	16.00	12.00	48.00	70.00	44.00	14.00
RC3TA180145M240	RC3	4	M22 to M26	18.00	14.50	48.00	70.00	44.00	14.00
RC3TA200160M300	RC3	4	M27	20.00	16.00	48.00	70.00	44.00	14.00
RC3TA220180M300	RC3	4	M30	22.00	18.00	48.00	70.00	44.00	14.00
RC3TA250200M360	RC3	4	M33	25.00	20.00	48.00	70.00	44.00	14.00
RC3TA280220M360	RC3	4	M36	28.00	22.00	48.00	70.00	44.00	14.00

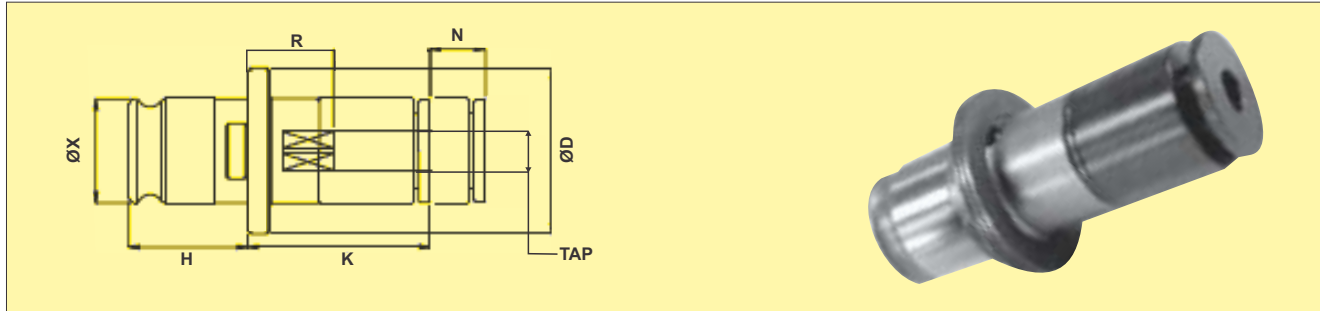
Note:

Tap Adaptor with coolant supply channel upon request

All details are subject to change without notice

Extension Type Quick Change Tap Adaptor

Without Overload Clutch for ISO 529/8283



- Rapid Change Style
- Solid positive drive
- For taps with ISO specifications - ISO 529/8283
- **Order Example:**
RCN1TA025021M

Catalogue No	Adaptor Type	Adaptor Size	Tap ISO 529/8283			ØD	H	K	N	R	ØX
			M	Ø	□						
RCN1TA025021M	RCN1	1	M3 to M12	2.5	2.1	30	21.5	33	10	16	19
RCN1TA028021M	RCN1	1		2.8	2.1	30	21.5	33	10	16	19
RCN1TA035027M	RCN1	1		3.5	2.7	30	21.5	33	10	16	19
RCN1TA040030M	RCN1	1		4.0	3.0	30	21.5	33	10	16	19
RCN1TA045034M	RCN1	1		4.5	3.4	30	21.5	33	10	16	19
RCN1TA060049M	RCN1	1		6.0	4.9	30	21.5	33	10	16	19
RCN1TA070055M	RCN1	1		7.0	5.5	30	21.5	33	10	16	19
RCN1TA080062M	RCN1	1		8.0	6.2	30	21.5	33	10	16	19
RCN1TA090070M	RCN1	1		9.0	7.0	30	21.5	33	10	16	19
RCN1TA100080M	RCN1	1		10	8.0	30	21.5	33	10	16	19
RCN1TA0110090M	RCN1	1		11	9.0	30	21.5	33	10	16	19
RCN2TA060049M	RCN2	2	M8 to M20	6.0	4.9	48	35	59	15	29	31
RCN2TA070055M	RCN2	2		7.0	5.5	48	35	59	15	29	31
RCN2TA080062M	RCN2	2		8.0	6.2	48	35	59	15	29	31
RCN2TA090070M	RCN2	2		9.0	7.0	48	35	59	15	29	31
RCN2TA100080M	RCN2	2		10	8.0	48	35	59	15	29	31
RCN2TA110090M	RCN2	2		11	9.0	48	35	59	15	29	31
RCN2TA120090M	RCN2	2		12	9.0	48	35	59	15	29	31
RCN2TA140110M	RCN2	2		14	11	48	35	59	15	29	31
RCN2TA160120M	RCN2	2		16	12	48	35	59	15	29	31
RCN2TA180145M	RCN2	2		18	14.5	48	35	59	15	29	31
RCN3TA110090M	RCN3	3	M14 to M33	11	9.0	70	55.5	82	25	38	48
RCN3TA120090M	RCN3	3		12	9.2	70	55.5	82	25	38	48
RCN3TA140110M	RCN3	3		14	11	70	55.5	82	25	38	48
RCN3TA160120M	RCN3	3		16	12	70	55.5	82	25	38	48
RCN3TA180145M	RCN3	3		18	14.5	70	55.5	82	25	38	48
RCN3TA200160M	RCN3	3		20	16	70	55.5	82	25	38	48
RCN3TA220180M	RCN3	3		22	18	70	55.5	82	25	38	48
RCN3TA250200M	RCN3	3		25	20	70	55.5	82	25	38	48
RCN3TA280220M	RCN3	3		28	22	70	55.5	82	25	38	48

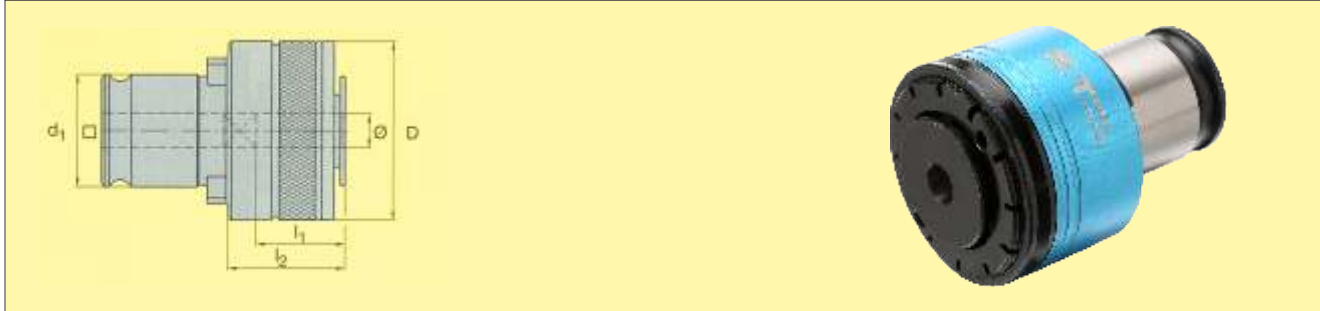
Note:

Also available for taps as per DIN 371/374/376

All details are subject to change without notice

Quick Change Tap Adaptor

With Overload clutch



- Quick change style
- For taps with ISO specifications - ISO 529/8283
- **Order Example:**
RS1TA028023M025

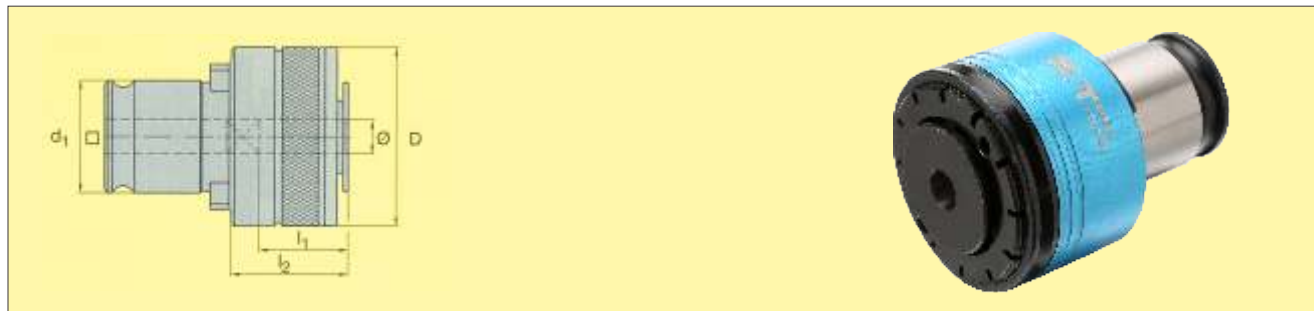
Catalogue No	Adaptor Type	Adaptor Size	Tap ISO 529/8283			d ₁	D	l ₁	l ₂
			M	Ø	□				
RS1TA028023M025	RS1	1	M2.5	2.80	2.24	19.00	32.50	17.00	25.00
RS1TA032025M030	RS1	1	M3	3.15	2.50	19.00	32.50	17.00	25.00
RS1TA036028M035	RS1	1	M3.5	3.55	2.80	19.00	32.50	17.00	25.00
RS1TA040032M040	RS1	1	M4	4.00	3.15	19.00	32.50	17.00	25.00
RS1TA045036M045	RS1	1	M4.5	4.50	3.55	19.00	32.50	17.00	25.00
RS1TA050040M050	RS1	1	M5	5.00	4.00	19.00	32.50	17.00	25.00
RS1TA056045M060	RS1	1	12 UNC/UNF	5.60	4.50	19.00	32.50	17.00	25.00
RS1TA063050M060	RS1	1	M6	6.30	5.00	19.00	32.50	17.00	25.00
RS1TA071056M070	RS1	1	M7	7.10	5.60	19.00	32.50	17.00	25.00
RS1TA080063M080	RS1	1	M8	8.00	6.30	19.00	32.50	17.00	25.00
RS1TA080063M110	RS1	1	M11	8.00	6.30	19.00	32.50	17.00	25.00
RS1TA090071M090	RS1	1	M9	9.00	7.10	19.00	32.50	17.00	25.00
RS1TA090071M120	RS1	1	M12	9.00	7.10	19.00	32.50	17.00	25.00
RS1TA100080M100	RS1	1	M10	10.00	8.00	19.00	32.50	17.00	25.00
RS2TA063050M060	RS2	3	M6	6.30	5.00	31.00	50.50	30.00	34.00
RS2TA071056M070	RS2	3	M7	7.10	5.60	31.00	50.50	30.00	34.00
RS2TA080063M080	RS2	3	M8	8.00	6.30	31.00	50.50	30.00	34.00
RS2TA080063MBSP	RS2	3	1/8" BSP	8.00	6.30	31.00	50.50	30.00	34.00
RS2TA080063M110	RS2	3	M11	8.00	6.30	31.00	50.50	30.00	34.00
RS2TA090071M090	RS2	3	M9	9.00	7.10	31.00	50.50	30.00	34.00
RS2TA090071M120	RS2	3	M12	9.00	7.10	31.00	50.50	30.00	34.00
RS2TA100080M100	RS2	3	M10	10.00	8.00	31.00	50.50	30.00	34.00
RS2TA100080MBSP	RS2	3	1/4" BSP	10.00	8.00	31.00	50.50	30.00	34.00
RS2TA112090M140	RS2	3	M14	11.20	9.00	31.00	50.50	30.00	34.00
RS2TA125100M160	RS2	3	M16	12.50	10.00	31.00	50.50	30.00	34.00
RS2TA125100MBSP	RS2	3	3/8" BSP	12.50	10.00	31.00	50.50	30.00	34.00
RS2TA140112M180	RS2	3	M18	14.00	11.20	31.00	50.50	30.00	34.00
RS2TA140112M200	RS2	3	M20	14.00	11.20	31.00	50.50	30.00	34.00
RS2TA160125M220	RS2	3	M22	16.00	12.50	31.00	50.50	30.00	34.00
RS2TA160125MBSP	RS2	3	1/2" BSP	16.00	12.50	31.00	50.50	30.00	34.00
RS2TA180140M240	RS2	3	M24	18.00	14.00	31.00	50.50	30.00	34.00
RS2TA180140MBSP	RS2	3	5/8" BSP	18.00	14.00	31.00	50.50	30.00	34.00
RS3TA112090M140	RS3	4	M14	11.20	9.00	48.00	72.00	44.00	45.00
RS3TA125100M160	RS3	4	M16	12.50	10.00	48.00	72.00	44.00	45.00
RS3TA125100MBSP	RS3	4	3/8" BSP	12.50	10.00	48.00	72.00	44.00	45.00
RS3TA140112M180	RS3	4	M18	14.00	11.20	48.00	72.00	44.00	45.00
RS3TA140112M200	RS3	4	M20	14.00	11.20	48.00	72.00	44.00	45.00
RS3TA160125M220	RS3	4	M22	16.00	12.50	48.00	72.00	44.00	45.00
RS3TA160125MBSP	RS3	4	1/2" BSP	16.00	12.50	48.00	72.00	44.00	45.00
RS3TA180140M240	RS3	4	M24	18.00	14.00	48.00	72.00	44.00	45.00
RS3TA180140MBSP	RS3	4	5/8" BSP	18.00	14.00	48.00	72.00	44.00	45.00
RS3TA200160M270	RS3	4	M27	20.00	16.00	48.00	72.00	44.00	45.00
RS3TA200160M300	RS3	4	M30	20.00	16.00	48.00	72.00	44.00	45.00
RS3TA200160MBSP	RS3	4	3/4" BSP	20.00	16.00	48.00	72.00	44.00	45.00
RS3TA220180MBSP	RS3	4	7/8" BSP	22.00	18.00	48.00	72.00	44.00	45.00
RS3TA224180M330	RS3	4	M33	22.40	18.00	48.00	72.00	44.00	45.00
RS3TA250200M360	RS3	4	M36	25.00	20.00	48.00	72.00	44.00	45.00

Note:

Tap Adaptor with coolant supply channel upon request

Quick Change Tap Adaptor

With Overload clutch



- Quick change style
- For taps with DIN specifications - DIN 371/374/376
- **Order Example:**
RS1TA025021M010

Catalogue No	Adaptor Type	Adaptor Size	Tap DIN 371/374/376			d ₁	D	l ₁	l ₂
			M	Ø	□				
RS1TA025021M010	RS1	1	M1	2.50	2.10	19.00	32.50	17.00	25.00
RS1TA025021M030	RS1	1	M3	2.50	2.10	19.00	32.50	17.00	25.00
RS1TA028021M020	RS1	1	M2	2.80	2.10	19.00	32.50	17.00	25.00
RS1TA028021M040	RS1	1	M3	2.80	2.10	19.00	32.50	17.00	25.00
RS1TA035027M030	RS1	1	M3	3.50	2.70	19.00	32.50	17.00	25.00
RS1TA035027M050	RS1	1	M5	3.50	2.70	19.00	32.50	17.00	25.00
RS1TA040030M035	RS1	1	M3.5	4.00	3.00	19.00	32.50	17.00	25.00
RS1TA045034M040	RS1	1	M4	4.50	3.40	19.00	32.50	17.00	25.00
RS1TA045034M060	RS1	1	M6	4.50	3.40	19.00	32.50	17.00	25.00
RS1TA060049M050	RS1	1	M5	6.00	4.90	19.00	32.50	17.00	25.00
RS1TA060049M060	RS1	1	M6	6.00	4.90	19.00	32.50	17.00	25.00
RS1TA060049M080	RS1	1	M8	6.00	4.90	19.00	32.50	17.00	25.00
RS1TA070055M100	RS1	1	M10	7.00	5.50	19.00	32.50	17.00	25.00
RS1TA080062M080	RS1	1	M8	8.00	6.20	19.00	32.50	17.00	25.00
RS1TA090070M120	RS1	1	M12	9.00	7.00	19.00	32.50	17.00	25.00
RS1TA100080M100	RS1	1	M10	10.00	8.00	19.00	32.50	17.00	25.00
RS1TA110090M140	RS1	1	M14	11.00	9.00	19.00	32.50	17.00	25.00
RS2TA060049M050	RS2	3	M5	6.00	4.90	31.00	50.50	30.00	34.00
RS2TA060049M060	RS2	3	M6	6.00	4.90	31.00	50.50	30.00	34.00
RS2TA060049M080	RS2	3	M8	6.00	4.90	31.00	50.50	30.00	34.00
RS2TA070055M100	RS2	3	M10	7.00	5.50	31.00	50.50	30.00	34.00
RS2TA080062M080	RS2	3	M8	8.00	6.20	31.00	50.50	30.00	34.00
RS2TA090070M120	RS2	3	M12	9.00	7.00	31.00	50.50	30.00	34.00
RS2TA100080M100	RS2	3	M10	10.00	8.00	31.00	50.50	30.00	34.00
RS2TA110090M140	RS2	3	M14	11.00	9.00	31.00	50.50	30.00	34.00
RS2TA120090M160	RS2	3	M16	12.00	9.00	31.00	50.50	30.00	34.00
RS2TA140110M180	RS2	3	M18	14.00	11.00	31.00	50.50	30.00	34.00
RS2TA160120M200	RS2	3	M20	16.00	12.00	31.00	50.50	30.00	34.00
RS2TA180145M220	RS2	3	M22	18.00	14.50	31.00	50.50	30.00	34.00
RS2TA180145M240	RS2	3	M24	18.00	14.50	31.00	50.50	30.00	34.00
RS3TA110090M140	RS3	4	M14	11.00	9.00	48.00	72.00	44.00	45.00
RS3TA120090M160	RS3	4	M16	12.00	9.00	48.00	72.00	44.00	45.00
RS3TA140110M180	RS3	4	M18	14.00	11.00	48.00	72.00	44.00	45.00
RS3TA160120M200	RS3	4	M20	16.00	12.00	48.00	72.00	44.00	45.00
RS3TA180145M220	RS3	4	M22	18.00	14.50	48.00	72.00	44.00	45.00
RS3TA180145M240	RS3	4	M24	18.00	14.50	48.00	72.00	44.00	45.00
RS3TA200160M270	RS3	4	M27	20.00	16.00	48.00	72.00	44.00	45.00
RS3TA220180M300	RS3	4	M30	22.00	18.00	48.00	72.00	44.00	45.00
RS3TA250200M330	RS3	4	M33	25.00	20.00	48.00	72.00	44.00	45.00
RS3TA280220M360	RS3	4	M36	28.00	22.00	48.00	72.00	44.00	45.00

Note:

Tap Adaptor with coolant supply channel upon request

All details are subject to change without notice

Extension Type Quick Change Tap Adaptor

With Overload Clutch for ISO 529/8283



- Quick change style
- For taps with ISO specifications - ISO 529/8283
- **Order Example:**
RSN1TA028023M025

Catalogue No	Adaptor Type	Adaptor Size	Tap ISO 529/8283			ØD	H	K	N	R	ØX
			M	Ø	□						
RSN1TA028023M025	RSN1	1	M2.5	2.80	2.24	32.5	21.5	33	10	17	19
RSN1TA032025M030	RSN1	1	M3	3.15	2.50	32.5	21.5	33	10	17	19
RSN1TA032025M040	RSN1	1	M4	3.15	2.50	32.5	21.5	33	10	17	19
RSN1TA036028M035	RSN1	1	M3.5	3.55	2.80	32.5	21.5	33	10	17	19
RSN1TA036028M045	RSN1	1	M4.5	3.55	2.80	32.5	21.5	33	10	17	19
RSN1TA040032M040	RSN1	1	M4	4.00	3.15	32.5	21.5	33	10	17	19
RSN1TA045036M045	RSN1	1	M4.5	4.50	3.55	32.5	21.5	33	10	17	19
RSN1TA045036M060	RSN1	1	M6	4.50	3.55	32.5	21.5	33	10	17	19
RSN1TA050040M050	RSN1	1	M5	5.00	4.00	32.5	21.5	33	10	17	19
RSN1TA063050M060	RSN1	1	M6	6.30	5.00	32.5	21.5	33	10	17	19
RSN1TA063050M080	RSN1	1	M8	6.30	5.00	32.5	21.5	33	10	17	19
RSN1TA071056M070	RSN1	1	M7	7.10	5.60	32.5	21.5	33	10	17	19
RSN1TA080063M080	RSN1	1	M8	8.00	6.30	32.5	21.5	33	10	17	19
RSN1TA080063M110	RSN1	1	M11	8.00	6.30	32.5	21.5	33	10	17	19
RSN1TA090071M090	RSN1	1	M9	9.00	7.10	32.5	21.5	33	10	17	19
RSN1TA090071M120	RSN1	1	M12	9.00	7.10	32.5	21.5	33	10	17	19
RSN1TA100080M100	RSN1	1	M10	10.00	8.00	32.5	21.5	33	10	17	19
RSN2TA063050M060	RSN2	3	M6	6.30	5.00	50.5	35	59	15	30	31
RSN2TA063050M080	RSN2	3	M8	6.30	5.00	50.5	35	59	15	30	31
RSN2TA071056M070	RSN2	3	M7	7.10	5.60	50.5	35	59	15	30	31
RSN2TA080063M080	RSN2	3	M8	8.00	6.30	50.5	35	59	15	30	31
RSN2TA080063M100	RSN2	3	M10	8.00	6.30	50.5	35	59	15	30	31
RSN2TA080063M110	RSN2	3	M11	8.00	6.30	50.5	35	59	15	30	31
RSN2TA090071M090	RSN2	3	M9	9.00	7.10	50.5	35	59	15	30	31
RSN2TA090071M120	RSN2	3	M12	9.00	7.10	50.5	35	59	15	30	31
RSN2TA100080M100	RSN2	3	M10	10.00	8.00	50.5	35	59	15	30	31
RSN2TA112090M140	RSN2	3	M14	11.20	9.00	50.5	35	59	15	30	31
RSN2TA125100M160	RSN2	3	M16	12.50	10.00	50.5	35	59	15	30	31
RSN2TA140112M180	RSN2	3	M18	14.00	11.20	50.5	35	59	15	30	31
RSN2TA140112M200	RSN2	3	M20	14.00	11.20	50.5	35	59	15	30	31
RSN2TA160125M220	RSN2	3	M22	16.00	12.50	50.5	35	59	15	30	31
RSN2TA180140M240	RSN2	3	M24	18.00	14.00	50.5	35	59	15	30	31
RSN3TA112090M140	RSN3	4	M14	11.20	9.00	72	55.5	82	25	44	48
RSN3TA125100M160	RSN3	4	M16	12.50	10.00	72	55.5	82	25	44	48
RSN3TA140112M180	RSN3	4	M18	14.00	11.20	72	55.5	82	25	44	48
RSN3TA140112M200	RSN3	4	M20	14.00	11.20	72	55.5	82	25	44	48
RSN3TA160125M220	RSN3	4	M22	16.00	12.50	72	55.5	82	25	44	48
RSN3TA180140M240	RSN3	4	M24	18.00	14.00	72	55.5	82	25	44	48
RSN3TA200160M270	RSN3	4	M27	20.00	16.00	72	55.5	82	25	44	48
RSN3TA200160M300	RSN3	4	M30	20.00	16.00	72	55.5	82	25	44	48
RSN3TA224180M330	RSN3	4	M33	22.40	18.00	72	55.5	82	25	44	48
RSN3TA250200M360	RSN3	4	M36	25.00	20.00	72	55.5	82	25	44	48
RSN3TA250200M330	RSN3	4	M33	25.00	20.00	72	55.5	82	25	44	48

Note:

Also available for taps as per DIN 371/374/376

All details are subject to change without notice

Introduction for Setting Torque for Clutch Type Adaptors

Adaptor with Clutch Type

Torque Wrench

Adjustable Wrench

Setscrew
Wrench for
Adaptors Size 3-4

Setting Shank

Reduction

Setting Shank

Adjustable
Pin Wrench

Adaptors Type

RC
RS

Adaptors Type

RC
RS

Screw Driver For
Adaptors Size 0-1
Size 2-7

Setting Socket

Setting Socket

Torque Adjustment Unit

Recommended Torque Values

For Safety Clutch adjustment

Tap Information - Metric (ISO 529)

Tap Size	Ø	□	Torque	Tap Size	Ø	□	Torque
M2	2.5	2.0	.3 Nm	M8	8.0	6.3	8 Nm
M3.5	2.5	2.0	.8 Nm	M10	8.0	6.3	16 Nm
M2.2	2.8	2.24	.35 Nm	M11	8.0	6.3	18 Nm
M2.5	2.8	2.24	.4 Nm	M9	9.0	7.1	12 Nm
M3	3.15	2.5	.5 Nm	M12	9.0	7.1	22 Nm
M4	3.15	2.5	1.2 Nm	M10	10.0	7.1	16 Nm
M3.5	3.55	2.8	.8 Nm	M14	11.2	8.0	36 Nm
M4.5	3.55	2.8	1.6 Nm	M16	12.5	9.0	40 Nm
M4	4.0	3.15	1.2 Nm	M18	14.0	10.0	63 Nm
M5	4.0	3.15	2 Nm	M20	14.0	11.2	70 Nm
M4.5	4.5	3.55	1.6 Nm	M22	16.0	11.2	80 Nm
M6	4.5	3.55	4 Nm	M24	18.0	14.0	125 Nm
M5	5.0	4.0	2 Nm	M30	20.0	16.0	220 Nm
M7	5.6	4.5	6 Nm	M33	22.4	18.0	240 Nm
M6	6.3	5.0	4 Nm	M33	25.0	20.0	240 Nm
M8	6.3	5.0	8 Nm	M36	25.0	20.0	280 Nm
M7	7.1	5.6	6 Nm	M39	28.0	22.4	320 Nm
M10	7.1	5.6	16 Nm	M42	28.0	22.4	420 Nm

Tap Information - Metric (JIS)

Tap Size	Ø	□	Torque	Tap Size	Ø	□	Torque
M2	3.0	2.5	.6 Nm	M17	13.0	10	67 Nm
M3	4.0	3.2	1 Nm	M18	14.0	11	80 Nm
M4	5.0	4	2.3 Nm	M20	15.0	12	88 Nm
M5	5.5	4.5	3.6 Nm	M22	17.0	13	98 Nm
M6	6.0	4.5	5.9 Nm	M24, M25	19.0	15	132 Nm
M7, M8	6.2	5	11.8 Nm	M26, M27	20.0	15	157 Nm
M9, M10	7.0	5.5	21.6 Nm	M28	21	17	175 Nm
M11	8.0	6	25 Nm	M30	23	17	225 Nm
M12	8.5	6.5	31.4 Nm	M32	24	19	235 Nm
M13	9.5	7	39 Nm	M33	25	19	245 Nm
M14, M15	10.5	8	46 Nm	M34, M35	26	21	265 Nm
M16	12.5	10	51 Nm	M36, M38	28	21	304 Nm

TORQUE VALUES REFER TO THE PRESET TORQUE VALUE FOR TORQUE CONTROL TAP COLLETS. THE VALUES ARE SUITABLE FOR MATERIAL WITH A TENSILE STRENGTH OF UP TO 1,000 N/MM2

Recommended Torque Values

For Safety Clutch adjustment

Tap Information - Inch (ANSI)

Tap Size	Ø	□	Torque	Tap Size	Ø	□	Torque
#0	.141"	.110"	.043 ft-lbs	15/16	.760"	.570"	3.047 ft-lbs
#2	.141"	.110"	.043 ft-lbs	1	.800"	.600"	3.976 ft-lbs
#4	.141"	.110"	.043 ft-lbs	1-1/8	.896"	.672"	5.512 ft-lbs
#6	.141"	.110"	.043 ft-lbs	1-1/4	1.021"	.766"	6.378 ft-lbs
#8	.168"	.131"	.067 ft-lbs	1-3/8	1.108"	.831"	8.110 ft-lbs
#10	.194"	.152"	.087 ft-lbs	1-1/2	1.233"	.925"	8.701 ft-lbs
#12	.220"	.165"	.114 ft-lbs	1-5/8	1.305"	.979"	9.335 ft-lbs
1/4	.255"	.191"	.173 ft-lbs	1-3/4	1.430"	1.072"	10.015 ft-lbs
5/16	.318"	.238"	.287 ft-lbs	1-7/8	1.519"	1.139"	10.745 ft-lbs
3/8	.381"	.286"	.464 ft-lbs	1/8SS	.3125"	.234"	.275 ft-lbs
7/16	.323"	.242"	.669 ft-lbs	1/8LS	.4375"	.328"	1.130 ft-lbs
1/2	.387"	.275"	.984 ft-lbs	3/8SS	.275"	.206"	.453 ft-lbs
9/16	.429"	.322"	1.141 ft-lbs	1/4 NPT	.5625"	.421"	.433 ft-lbs
5/8	.480"	.360"	1.449 ft-lbs	3/8 NPT	.700"	.515"	.551 ft-lbs
11/16	.542"	.406"	1.732 ft-lbs	1/2 NPT	.6875"	.531"	1.275 ft-lbs
3/4	.590"	.442"	2.087 ft-lbs	3/4 NPT	.906"	.679"	1.653 ft-lbs
13/16	.652"	.489"	2.264 ft-lbs	1 NPT	1.125"	.843"	3.189 ft-lbs
7/8	.697"	.523"	2.901 ft-lbs				

Tap Information - Metric (DIN 371/376)

Tap Size	Ø	□	Torque	Tap Size	Ø	□	Torque
M1.4, M1.8	2.5	2.1	.3 Nm	M11	8.0	6.2	18 Nm
M3	2.5	2.1	.5 Nm	M12	9.0	7.0	22 Nm
M2	2.8	2.1	.3 Nm	M10	10.0	8.0	16 Nm
M2.2	2.8	2.1	.35 Nm	M14	11.0	9.0	36 Nm
M2.5	2.8	2.1	.4 Nm	M16	12.0	9.0	40 Nm
M4	2.8	2.1	1.2 Nm	M16	14.0	11.0	40 Nm
M3	3.5	2.7	.5 Nm	M18	14.0	11.0	63 Nm
M5	3.5	2.7	2 Nm	M20	16.0	12.0	70 Nm
M3.5	4.0	3.0	.8 Nm	M22	18.0	14.5	80 Nm
M4	4.5	3.4	1.2 Nm	M24	18.0	14.5	125 Nm
M6	4.5	3.4	4 Nm	M27	20.0	16.0	140 Nm
M5	6.0	4.9	2 Nm	M30	22.0	18.0	220 Nm
M6	6.0	4.9	4 Nm	M33	25.0	20.0	240 Nm
M8	6.0	4.9	8 Nm	M36	25.0	20.0	280 Nm
M10	7.0	5.5	16 Nm	M36	28.0	22.0	280 Nm
M8	8.0	6.2	8 Nm				

TORQUE VALUES REFER TO THE PRESET TORQUE VALUE FOR TORQUE CONTROL TAP COLLETS. THE VALUES ARE SUITABLE FOR MATERIAL WITH A TENSILE STRENGTH OF UP TO 1,000 N/MM2

Tap Shank Dimensions

Tap Shank Dimensions ISO 529 - 1975

Dimension Dia. x Square	Metric		UNC		UNF		BSW		BSF		BA	
		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged		Shank dia. enlarged
3.15 x 2.5	M4	M3	-	No. 4-40	-	No. 4-40	-	-	-	-	No. 3	No. 6
3.55 x 2.8	M4.5	M3.5	No. 10-24	No. 6-32	No. 10-32	No. 6-40	3/16"-24	-	3/16"-32	-	No. 2	No. 4
4 x 3.15	M5	M4	No. 12-24	-	No. 12-28	-	-	-	7/32"-28	-	No. 1	-
4.5 x 3.55	M6	-	1/4"-20	No. 8-32	1/4"-28	No. 3-36	1/4"-20	-	1/4"-28	-	No. 0	No. 3
5 x 4	-	M5	-	No. 10-24	-	No. 10-32	-	3/16"-24	-	3/16"-32	-	No. 2
5.6 x 4.5	-	-	-	No. 12-24	-	No. 12-28	-	-	9/32"-26	7/32"-28	-	No. 1
6.3 x 5	M8	M6	5/16"-18	1/4"-20	5/16"-24	1/4"-28	5/16"-18	1/4"-20	5/16"-22	1/4"-26	-	No. 0
7.1 x 5.6	-	-	3/8"-16	-	3/8"-24	-	3/8"-16	-	3/8"-20	9/32"-36	-	-
8 x 6.3	M10	M8	7/16"-14	5/16"-18	7/16"-20	-	7/16"-14	5/16"-18	7/16"-18	5/16"-22	-	-
9 x 7.1	M12	-	1/2"-13	-	1/2"-20	-	1/2"-12	-	1/2"-12	-	-	-
10 x 8	-	M10	-	3/8"-16	-	3/8"-21	-	3/8"-16	-	3/8"-20	-	-
11.2 x 9	M14	-	3/16"-12	-	9/16"-18	-	9/16"-12	-	9/16"-16	-	-	-
12.5 x 10	M16	-	5/8"-11	-	3/8"-18	-	3/8"-11	-	3/8"-14	-	-	-
14 x 11.2	M18	-	3/4"-10	-	3/4"-16	-	11/16"-11	-	11/16"-14	-	-	-
	M20	-	-	-	-	-	3/4"-10	-	3/4"-12	-	-	-
16 x 12.5	M22	-	7/8"-9	-	7/8"-14	-	7/8"-9	-	7/8"-11	-	-	-
18 x 14	M24	-	1"-8	-	1"-12	-	1"-8	-	1"-10	-	-	-
20 x 16	M27	-	1 1/8"-7	-	1 1/8"-12	-	1 1/8"-7	-	1 1/8"-9	-	-	-
	M30	-	-	-	-	-	-	-	-	-	-	-
22.5 x 18	M33	-	1 3/4"-4	-	1 3/4"-12	-	1 3/4"-7	-	1 3/4"-9	-	-	-
25 x 20	M36	-	1 3/8"-6	-	1 3/8"-12	-	-	-	1 3/8"-8	-	-	-
28 x 22.4	M49	-	1 3/8"-6	-	1 3/8"-12	-	1 3/8"-6	-	1 3/8"-8	-	-	-
	M42	-	-	-	-	-	-	-	1 3/8"-8	-	-	-
31.5 x 25	M45	-	1 3/4"-5	-	-	-	1 3/4"-5	-	1 3/4"-7	-	-	-
	M48	-	-	-	-	-	-	-	-	-	-	-

Tap Shank Dimensions DIN

Dimension Dia. x Square	DIN 352	DIN 353	DIN 357	DIN 354	DIN 356	DIN 2182	DIN 2183
3.5 x 2.7	M3	-	M3	M5	M5	1/8"	-
4 x 3	M4	-	M3.5	-	-	-	-
4.5 x 3.4	M4	-	M4	M6	M6	5/32"	1/4"
	M5	-	M5	-	-	7/32"	-
6 x 4.9	M6	-	M6	-	-	-	-
	M8	-	-	M8	M8	-	-
7 x 5.5	M10	G 1/8"	-	M10	M10	1/4"	3/8"
8 x 6.2	-	-	M8	-	-	5/16"	7/16"
9 x 7	M12	-	-	M12	M12	3/8"	1/2"
10 x 8	-	-	M10	-	-	-	-
11 x 9	M14	G 1/4"	-	M14	M14	-	9/16"
12 x 9	M16	G 3/8"	-	M16	M16	-	5/8"
14 x 11	M18	-	-	M18	M18	-	11/16"
16 x 12	M20	G 1/2"	-	M20	M20	-	13/16"
18 x 14.5	M22	G 5/8"	-	M22	M22	-	7/8"
	M24	-	-	M24	M24	-	15/16"
20 x 16	M27	G 3/4"	-	M27	M27	-	1"
22 x 18	M30	G 7/8"	-	M30	M30	-	1 1/8"
25 x 20	M33	G 1"	-	M33	M33	-	1 1/4"
28 x 22	M36	G 1 1/8"	-	M36	M36	-	1 3/8"
32 x 24	M39	G 1 1/8"	-	M39	M39	-	1 1/2"
	M42	-	-	M42	M42	-	1 5/8"
	M45	G 1 3/8"	-	M45	M45	-	1 3/4"
36 x 29	M48	G 1 3/4"	-	M48	M48	-	1 7/8"
	-	G 2"	-	-	-	-	-

Tap Shank Dimensions			ANSI (US Standards)			Tap Shank Dimensions (JIS Standards)		
Dimension in Inch, Dia. x Square	Metric Conversion	Tap Size	Dimension in Inch, Dia. x Square	Metric Conversion	Tap Size	Dimension in mm, Dia. x Square		Tap Size
0.141	0.110	3.35 2.80 1/8" No. 6	0.590	0.642	14.99 11.23 3/4"	4.0	3.0	M3 & M3.5
0.165	0.121	4.27 3.35 5/32" No. 8	0.652	0.689	16.57 12.43 M20	5.0	4.0	M4 & M4.5
0.194	0.152	4.93 3.87 3/16" No. 10	0.688	0.715	17.47 14.09 1/2" Ps	5.5	4.5	M5
0.220	0.165	5.55 4.20 No. 12	0.697	0.723	17.71 13.29 7/16"	6.0	4.5	M6
0.250	0.191	6.48 4.86 1/4" No. 14	0.700	0.731	17.78 14.49 3/8" Ps	6.2	5.0	M7 & M8
0.312	0.234	7.94 5.95 1/16" Ps 1/8" Ps	0.760	0.770	19.31 14.48 M24	7.0	5.5	M9 & M10
0.375	0.278	8.93 6.05 3/16" 3/8"	0.800	0.800	20.32 15.24 1"	8.0	6.2	M11
0.524	0.242	8.21 6.35 5/16" 7/16"	0.896	0.672	22.76 17.07 1 1/8"	8.5	6.5	M12
0.567	0.275	9.34 6.99 1/2"	0.906	0.629	23.02 17.25 3/4" Ps	10.5	8.0	M14
0.581	0.286	9.68 7.27 3/8"	1.021	0.766	25.94 19.46 1 1/2"	12.5	10.0	M16
0.429	0.322	10.90 8.18 9/16"	1.108	0.833	28.15 21.11 1 3/8"	14.0	11.0	M18
0.436	0.328	11.12 8.54 1/8" Ps	1.125	0.843	28.58 21.42 1" Ps	15.0	12.0	M20
0.480	0.360	12.20 9.45 5/8"	1.203	0.925	31.32 23.50 1 1/2"	17.0	13.0	M22
0.512	0.406	13.77 10.31 1 1/16"	1.132	0.984	31.54 25.00 1 5/8" Ps	19.0	15.0	M24
0.563	0.421	14.28 10.70 1/4" Ps	1.430	1.072	36.33 27.25 1 3/4"	20.0	15.0	M27
						23.0	23.17	M30

Birla - Machining Center Tooling



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AT3 Class machining centers

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