

**With  
Axial Float  
& Torque  
Control**



# Reversible Tapping Attachments

Also available Non-Reversible Tapping Attachment for lathes, radial drills & all machines with reversible motors.



**SAI TRUMAN ENTERPRISES**

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## 'TACO' Patented reversible tapping attachment with robust construction offer following advantages :

- Usable on every vertical drilling machine or machines with rotating non-reversing spindles.
- Right or left hand tapping without modification.
- Complete protection against tap breakage ensured by an ultra-sensitive and smooth operating ball-clutch.
- Forward and reverse ball drive design transmits rotational power to the tap and disengages smoothly and silently.
- Axial float ensures smooth tapping and better thread profile.
- Cushioned drive eliminates the possibility of cross threadings during roughing and finishing taps and ensures gauge perfect thread.
- A planetary gear reversing mechanism transmits smooth positive reverse to the tap retraction and it retracts 75% more faster than it enters.
- Accurate depth control by means of its accurate neutral mechanism.
- Batch quantities or mass production of tapping can be achieved accurately by this attachment.
- Having versatile application in every machine shop, it dispenses with laborious hand tapping and use of expensive machines.
- Not suitable for radial drilling machines.



### Collet for HR Model

Collet and adjustable left and right nuts to adopt all tap sizes, within an attachment's rated capacity.



### Tap Adaptor for HRF Model

• The Spindle of the attachment has quick change device.  
 • Simple insertion of the tap shank into adaptor is sufficient for chucking. No tools required for rapid tap change in the adaptor. • For each tap with varying shank dimensions a different QA adaptor is required.

Model	Capacity mm	Collet ( Tap Shank $\varnothing$ mm )		Tap Adaptor Model	Shank ( Female )	Standard Arbor
		Standard	Optional			
HR 1	1.4 - 7	S161 (2.5-4.5) S171 (4.5-6.5)	S151 (1-2.5)	—	JT 33	JT 33/MT 1 or JT 33/MT 2
HRF 1	(1/16" - 1/4")	—	—	QA-0		
HR 2	3 - 12	S212 (3.5-6.5) S222 (6.5-10)	S232 (2-4.5)	—	5/8"-16 UN	5/8"-16 UN/MT 2 or 5/8"-16 UN/MT 3
HRF 2	(1/8" - 1/2")	—	—	QA-1		
HR 3	8 - 20	S413 (4.5-10) S453 (10-16)	S433 (2.8-7)	—	M20 P2.5	M 20/MT 3 or M 20/MT4
HRF 3	(5/16" - 3/4")	—	—	QA-40		
HR 4	14 - 30	S613 (9-16) S623 (16-23)	—	—	M20 P2.5	M 20/MT 4 or M 20/MT 5
HRF 4	(9/16" - 1 1/8")	—	—	QA-3		



**New  
Improved  
Friction Clutch  
with Smooth  
Reversal**



## **Reversible Tapping Attachments**

Usable on every vertical drilling machine with rotating non-reversing spindles.

**ONLY SUITABLE FOR PILLAR TYPE DRILLING MACHINE**





# Reversible Tapping Attachments



## Model TCN

- Having versatile application in every machine shop, it dispenses with labourious hand tapping and use of expensive machines.
- Batch quantities or mass production of tapping can be achieved accurately by this attachment.
- Right or left hand tapping without modification.
- Automatic reverse mechanism and rapid backout, with inbuilt planetary gear drive.
- Self-centering chuck to hold Tap True.
- Improved adjustable friction-clutch to avoid Tap breakage.
- Not suitable for radial drilling machine.

Model	TCN 1	TCNF 1	TCN 2	TCNF 2	TCN 3	TCNF 3	TCN 4	TCNF 4	TCN 5	TCNF 5
Capacity	3-10 1/8" - 3/8"		6-16 1/4" - 5/8"		8-18 5/16" - 3/4"		10-24 3/8" - 1"		14-30 9/16" - 1 1/8"	
Shank Morse Taper	1 or 2		2 or 3		3		3 or 4		4	
Suitable Tap Adaptor for TCNF	-	QA-1*	-	QA-40*	-	QA-40*	-	QA-3*	-	QA-3*

\* While placing order inform morse Taper shank size

## Tap Adaptor for TCNF Model

The Spindle of the attachment has quick change device. Simple insertion of the tap shank into adaptor is sufficient for chucking. No tools required for rapid tap change in the adaptor. Inform shank dia and square size of the Tap as different \* QA adaptor is required for each Tap.



## Die Holders Model DH

Tapping attachment can easily be converted in to efficient threading attachment by inserting Die-Holder in its chuck.



## Model TCNR

Non-Reversible Tapping Attachments are also available without reversing mechanism but with adjustable friction clutch & Self Center chuck. TCNR are available in five Models, covering tapping capacity from 3mm to 30mm equivalent to model TCN.

Model	CAPACITY	MAX. THREAD LENGTH	O.D. OF ROUND DIE	USE WITH MODEL TCN / TCNR	SHANK Ø x SQUARE
DH-1	M3-M7 1/8" - 1/4"	35 mm	13/16" OD	TCN-1	10 x 8
DH-1	M3-M7 1/8" - 1/4"	35 mm	1" OD	TCN-1	10 x 8
DH-2	M6-M10 1/4" - 3/8"	38 mm	1" OD	TCN-2	12.50 x 10
DH-3	M6-M14 1/4" - 9/16"	40 mm	1-5/16" OD	TCN-3	14 x 11.20
DH-4	M10-M18 3/8" - 3/4"	40 mm	1-1/2" OD	TCN-3 upto M14 & TCN-4 & TCN-5	14 x 11.20

Authorised Dealer



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