

# TENSION & COMPRESSION & QUICK CHANGE TAP CHUCKS



## FEATURES

- Tension & compression
- ER collet or quick change system
- Adapters with fixed drive or torque control
- Axial length compensation

## BENEFITS

- Higher quality threads
- Reduced risk of tap breakages
- Reduced risk of oversized threads
- Better tool life
- Ideal for high end workpieces

## Tension & Compression, Quick Change or ER Type Tap Chucks

Quick change tap chucks PRICE the fastest tool changes and one of the most reliable clamping systems for conventional or CNC machine tapping. With a wide range of adapters, taps can be clamped from M2-M48

The YG-1 TER tap chuck system PRICEs tension and compression axial length compensation with the use of ER collets.

# CONTENTS

BT MAS BT40, BT50.....P1080	DIN 2080 & PSC ISO40/50, PSC40/50/63/80/100.....P1083	TAPPING ER COLLET SETS ER-MD Series .....P1084
DIN 69871 SK40, SK50.....P1081	WELDON .....P1084	QUICK CHANGE TAP ADAPTERS Fixed & Clutch Drive.....P1085
HSK-A HSK50-A, HSK63-A, HSK100-A.....P1082	MORSE TAPER MT 2 - 4 .....P1084	TAPPING ER COLLETS ER-MD Series .....P1085

## BENEFITS OF TENSION & COMPRESSION TAP CHUCKS

The axial length compensation prevents oversized threads and helps prevent tap breakage from over travel, e.g. when the tap hits the bottom of the hole. Tension and compression tap chucks are also ideal for high-end tapping applications in modern CNC machine tools, where the workpiece is of high value, or where difficult materials require high torque loads.

The chucks PRICE extra safety mechanisms compared to other chucks, such as ER Collet chucks, these make issues such as taps slipping impossible.

## TENSION & COMPRESSION QUICK CHANGE TAP CHUCKS



- Axial length compensation (tension & compression)
- Quick change system
- Adapters available in 3 sizes for different thread sizes
- Adapters available in fixed drive or clutch type
- Taps or adapters cannot slip in chuck
- Taps can be changed quickly whilst on the machine



## QUICK CHANGE TAP ADAPTERS - WITH TORQUE CONTROL OR FIXED DRIVE

SQUARE DRIVE prevents the tap from slipping in the adapter



DRIVE KEYS prevent the adapter from slipping in the chuck



WITH TORQUE CONTROL

- Adjustable torque control
- Ideal for materials with high tensile strength or that are difficult to tap
- Helps prevent broken taps, especially in smaller diameters
- Improved thread quality
- Recommended for high value workpieces



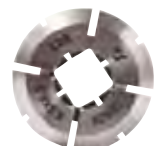
FIXED DRIVE

- No torque control
- Ideal for materials that are easier to tap
- Low cost
- Recommended for lower value workpieces

## TENSION & COMPRESSION TER (ER) TAP CHUCK



- Axial length compensation (tension & compression)
- ER collet system
- Collets can be readily interchanged with solid ER collet chucks.
- Available in ER16 or ER32



**TENSION & COMPRESSION TAP CHUCKS BT MAS**

Tension & Compression Tap Chucks - Quick Change or ER System



**QUICK CHANGE TAP CHUCK**

- ▶ Quick change system - use with quick change tap adapters P986X
- ▶ With axial length compensation
- ▶ BT MAS taper



Taper	Adapter Size	Adapter	Tap Shank Range	Tap Size Range	Tension / Compression Range	ORDER CODE	PRICE
BT40	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	BT40-ATP312	▲
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	BT40-ATP822	▲
	3	IBC3 / IBS3	11 - 36	M14 - M48	+/-24	BT40H138GR3DC	▲
BT50	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	BT50-ATP312	▲
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	BT50-ATP822	▲
	3	IBC3 / IBS3	11 - 36	M14 - M48	+/-24	BT50H135GR3DC	▲

**ER COLLET TAP CHUCK**

- ▶ ER output - use with ER-MD style collets
- ▶ With axial length compensation
- ▶ BT MAS taper



Taper	ER	Nut Dia.	Gauge Length	Tap Shank Range	Tap Size Range	Nut Type	ORDER CODE	PRICE
BT40	ER16MD	28	100	3.5 - 8	M3 - M8	Hex	BT40-TER16-100	▲
	ER16MD	28	150	3.5 - 8	M3 - M8	Hex	BT40-TER16-150	▲
	ER32MD	50	110	3.5 - 16	M3 - M20	Std	BT40-TER32-110	▲
	ER32MD	50	150	3.5 - 16	M3 - M20	Std	BT40-TER32-150	▲
BT50	ER16MD	28	115	3.5 - 8	M3 - M8	Hex	BT50-TER16-115	▲
	ER16MD	25	150	3.5 - 8	M3 - M8	Hex	BT50-TER16-150	▲
	ER32MD	50	120	3.5 - 16	M3 - M20	Std	BT50-TER32-120	▲
	ER32MD	50	150	3.5 - 16	M3 - M20	Std	BT50-TER32-150	▲

▲ UK stock - Generally x-stock for next day delivery ▼ European stock - Generally 2-3 days delivery (please check for lead times)

**COMBO TAPS - HSS 5% COBALT**



THE ECONOMICAL MACHINE TAP SERIES FOR GENERAL TAPPING OF ALL MATERIALS

- ▶ Exceptional reliability tapping steels, stainless steel, cast iron, copper, brass and aluminium
- ▶ Available in bright, nitrided or TiN coated
- ▶ Patented geometry



See Page 762

**TENSION & COMPRESSION TAP CHUCKS DIN 69871**



Tension & Compression Tap Chucks - Quick Change or ER System

**QUICK CHANGE TAP CHUCK**

- ▶ Quick change system - use with quick change tap adapters P986X
- ▶ With axial length compensation
- ▶ DIN 69871



Taper	Adapter Size	Adapter	Tap Shank Range	Tap Size Range	Tension / Compression Range	ORDER CODE	PRICE
SK40	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	SK40-ATP312	▲
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	SK40-ATP822	▲
	3	IBC3 / IBS3	11 - 36	M14 - M48	+/-24	SK40H138GR3DC	▲
SK50	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	SK50-ATP312	▲
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	SK50-ATP822	▲
	3	IBC3 / IBS3	11 - 36	M14 - M48	+/-24	SK50H133GR3.DC	▲

**ER COLLET TAP CHUCK**

- ▶ ER output - use with ER-MD style collets
- ▶ With axial length compensation
- ▶ DIN 69871



Taper	ER	Nut Dia.	Gauge Length	Tap Shank Range	Tap Size Range	Nut Type	ORDER CODE	PRICE
SK40	ER16MD	28	100	3.5 - 8	M3 - M8	Hex	SK40-TER16-100	▲
	ER16MD	28	150	3.5 - 8	M3 - M8	Hex	SK40-TER16-150	▲
	ER32MD	50	110	3.5 - 16	M3 - M20	Std	SK40-TER32-130	▲
	ER32MD	50	150	3.5 - 16	M3 - M20	Std	SK40-TER32-150	▲
SK50	ER16MD	28	115	3.5 - 8	M3 - M8	Hex	SK50-TER16-115	▲
	ER16MD	25	150	3.5 - 8	M3 - M8	Hex	SK50-TER16-150	▲
	ER32MD	50	120	3.5 - 16	M3 - M20	Std	SK50-TER32-120	▲
	ER32MD	50	150	3.5 - 16	M3 - M20	Std	SK50-TER32-150	▲

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**INOX SERIES PERFORMANCE MACHINE TAPS**



HIGH PERFORMANCE MACHINE TAPS FOR TAPPING STAINLESS STEEL, DUPLEX & SOFT STEELS

- ▶ BLUE ring series
- ▶ Special inox taper prevents taps breaking in stainless steel machining
- ▶ Made from powder steel or vanadium cobalt compound for extreme tool life and high speed tapping
- ▶ Available with through coolant design
- ▶ Made in Italy by UFS



See Page 820





## TENSION & COMPRESSION TAP CHUCKS HSK-A

Tension & Compression Tap Chucks - Quick Change

### QUICK CHANGE TAP CHUCK HSK-A

- ▶ Quick change system - use with quick change tap adapters P986X
- ▶ With axial length compensation
- ▶ HSK-A taper



P1085



Taper	Adapter Size	Adapter	Tap Shank Range	Tap Size Range	Tension / Compression Range	ORDER CODE	PRICE
HSK50A	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	HSK50-TCC-1	▼
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	HSK50-TCC-2	▼
HSK63A	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	HSK63-TCC-1	▲
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	HSK63-TCC-2	▲
HSK100A	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	HSK100-TCC-1	▲
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	HSK100-TCC-2	▲

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### COOLANT TUBES & KEYS HSK-A

- ▶ For through coolant supply on HSK tool holders (sold separately)



	HSK50-A	HSK63-A	HSK100-A
COOLANT TUBE	950APR01	963APR01	910APR01
COOLANT TUBE KEY	950CHVAR	963CHVAR	910CHVAR

## HR SERIES HIGH STRENGTH MACHINE TAPS



HIGH PERFORMANCE MACHINE TAPS FOR HIGH STRENGTH ALLOY STEELS AND HARDENED STEELS (<HRc52)

- ▶ RED ring HR series
- ▶ Special strong flute design prevents taps breaking in hard materials
- ▶ Made from powder steel compound with cobalt and vanadium content for extreme tool life
- ▶ Available with through coolant design
- ▶ Made in Italy by UFS



See Page 808





## TENSION & COMPRESSION TAP CHUCKS DIN 2080 & PSC

Tension & Compression Tap Chucks - Quick Change

### QUICK CHANGE TAP CHUCK DIN2080

- ▶ Quick change system - use with quick change tap adapters P986X
- ▶ With axial length compensation
- ▶ DIN 2080



P1085



Taper	Adapter Size	Adapter	Tap Shank Range	Tap Size Range	Tension / Compression Range	ORDER CODE	PRICE
ISO40	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	ISO40-H52GR1DC ▲	
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	ISO40-H77GR2DC ▲	
ISO50	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	ISO50-H79GR2DC ▲	

### QUICK CHANGE TAP CHUCK PSC

- ▶ Quick change system - use with quick change tap adapters P986X
- ▶ With axial length compensation
- ▶ PSC polygon shank
- ▶ Compatible with Capto



CAPTO  
COMPATIBLE

P1085



Taper	Adapter Size	Adapter	Tap Shank Range	Tap Size Range	Tension / Compression Range	ORDER CODE	PRICE
PSC40	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	18.620.040.12 ▼	
PSC50	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	18.620.050.12 ▼	
PSC63	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	18.620.063.12 ▼	
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	18.620.063.20 ▼	
	3	IBC3 / IBS3	11 - 36	M14 - M48	+/-24	18.620.063.33 ▼	
PSC80	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	18.620.080.12 ▼	
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	18.620.080.20 ▼	
	3	IBC3 / IBS3	11 - 36	M14 - M48	+/-24	18.620.080.33 ▼	
PSC100	1	IBC1 / IBS1	2.8 - 12	M2 - M16	+/-9	18.620.100.12 ▼	
	2	IBC2 / IBS2	6 - 18	M4.5 - M24	+/-15	18.620.100.20 ▼	
	3	IBC3 / IBS3	11 - 36	M14 - M48	+/-24	18.620.100.33 ▼	

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## MACHINE TAPS Al-Cu-Fe YELLOW RING SERIES



HIGH PERFORMANCE MACHINE TAPS FOR ALUMINIUM, COPPER, BRASS & PLASTIC MACHINING

- ▶ Special interrupted flute design prevents flute clogging and damaged threads in soft long chipping materials
- ▶ Polished flutes prevent chips sticking to the tap
- ▶ Spiral flute taps with 45° helix for fast chip evacuation
- ▶ Made in Italy by UFS



See Page 860





## TENSION & COMPRESSION TAP CHUCKS WELDON & MORSE TAPER

Tension & Compression Tap Chucks - Quick Change

### QUICK CHANGE TAP CHUCK WELDON

- ▶ Quick change system - use with quick change tap adapters opposite
- ▶ With axial length compensation
- ▶ Weldon shank - ideal for lathes or for clamping in side lock arbor for milling machines



P1085



Shank Diameter	Adapter Size	Adapter	Tap Shank Range	Tap Size Range	Tension / Compression Range	ORDER CODE	PRICE
20	1	IBC1 / IBS1	2.8-12	M2-M16	+/-9	M3-M12CIL.D20GR1	▲
25	1	IBC1 / IBS1	2.8-12	M2-M16	+/-9	M3-M12CIL.D25GR1	▲
	2	IBC2 / IBS2	6-18	M4.5-M24	+/-15	M6-M20CIL.D25GR2	▲
32	1	IBC1 / IBS1	2.8-12	M2-M16	+/-9	M3-M12CIL.D32GR1	▲
	2	IBC2 / IBS2	6-18	M4.5-M24	+/-15	M6-M20CIL.D32GR2	▲
	3	IBC3 / IBS3	11-36	M14-M48	+/-24	M14-M33CIL.D32GR3	▲
40	1	IBC1 / IBS1	2.8-12	M2-M16	+/-9	M3-M12CIL.D40GR1	▲
	2	IBC2 / IBS2	6-18	M4.5-M24	+/-15	M6-M20CIL.D40GR2	▲
	3	IBC3 / IBS3	11-36	M14-M48	+/-24	M14-M33CIL.D40GR3	▲

### QUICK CHANGE TAP CHUCK MORSE TAPER

- ▶ Quick change system - use with quick change tap adapters opposite
- ▶ With axial length compensation
- ▶ Morse taper shank



P1085



Taper	Adapter Size	Adapter	Tap Shank Range	Tap Size Range	Tension / Compression Range	ORDER CODE	PRICE
MT2	1	IBC1 / IBS1	2.8-12	M2-M16	+/-9	M3-M12CM2BGR1	▲
MT3	1	IBC1 / IBS1	2.8-12	M2-M16	+/-9	M3-M12CM3BGR1	▲
MT3	2	IBC2 / IBS2	6-18	M4.5-M24	+/-15	M6-M20CM3BGR2	▲
MT4	2	IBC2 / IBS2	6-18	M4.5-M24	+/-15	M6-M20CM4BGR2	▲

▲ UK stock - Generally x-stock for next day delivery    ▼ European stock - Generally 2-3 days delivery (please check for lead times)



**TAP CHUCK ADAPTERS & COLLETS**

For Quick Change or ER System

**QUICK CHANGE TAP ADAPTERS**

- ▶ Clutch type (with torque control)
- ▶ Fixed drive (no torque control)

**Fixed Drive**



**Clutch Drive**



Adaptor Size	Tap Shank	Tap Square	Fixed Drive		Clutch Drive	
			ORDER CODE	PRICE	ORDER CODE	PRICE
1	2.8	2.1	IBC1-2.8X2.1	▲ £22.32	IBS1-2.8X2.1	▲
	3.5	2.7	IBC1-3.5X2.7	▲ £22.32	IBS1-3.5X2.7	▲
	4	3	-	-	-	-
	4.5	3.4	IBC1-4.5X3.4	▲ £22.32	IBS1-4.5X3.4	▲
	5.5	4.3	-	-	IBS1-5.5X4.3	▲
	6.3	5	IBC1-6.3X5	▲ £22.32	-	-
	6	4.9	IBC1-6X4.9	▲ £22.32	IBS1-6X4.9	▲
	7	5.5	IBC1-7X5.5	▲ £22.32	IBS1-7X5.5	▲
	8	6.2	IBC1-8X6.2	▲ £22.32	IBS1-8X6.2	▲
	9	7	IBC1-9X7	▲ £22.32	IBS1-9X7	▲
	10	8	IBC1-10X8	▲ £22.32	IBS1-10X8	▲
11	9	IBC1-11X9	▲ £22.32	-	-	
2	6	4.9	IBC2-6X4.9	▲ £28.27	IBS2-6X4.9	▲
	7	5.5	IBC2-7X5.5	▲ £28.27	IBS2-7X5.5	▲
	8	6.2	IBC2-8X6.2	▲ £28.27	IBS2-8X6.2	▲
	9	7	IBC2-9X7	▲ £28.27	IBS2-9X7	▲
	10	8	IBC2-10X8	▲ £28.27	IBS2-10X8	▲
	11	9	IBC2-11X9	▲ £28.27	IBS2-11X9	▲
	12	9	IBC2-12X9	▲ £28.27	IBS2-12X9	▲
	14	11	IBC2-14X11	▲ £28.27	IBS2-14X11	▲
3	16	12	IBC2-16X12	▲ £28.27	IBS2-16X12	▲
	18	14.5	IBC2-18X14.5	▲ £28.27	IBS2-18X14.5	▲
	11	9	IBC3-11X9	▲ £53.09	IBS3-11X9	▲
	12	9	IBC3-12X9	▲ £53.09	IBS3-12X9	▲
	14	11	IBC3-14X11	▲ £53.09	IBS3-14X11	▲
	16	12	IBC3-16X12	▲ £53.09	IBS3-16X12	▲
	18	14.5	IBC3-18X14.5	▲ £53.09	IBS3-18X14.5	▲
	20	16	IBC3-20X16	▲ £53.09	IBS3-20X16	▲
22	18	IBC3-22X18	▲ £53.09	IBS3-22X18	▲	
25	20	IBC3-25X20	▲ £53.09	IBS3-25X20	▲	
28	22	IBC3-28X22	▲ £53.09	IBS3-28X22	▼	
32	24	IBC3-32X24	▲ £88.48	-	-	
36	29	IBC3-36X29	▲ £88.48	-	-	

**TAPPING ER COLLETS ER-MD SERIES**

- ▶ Square drive prevents tap from slipping in ER collet
- ▶ Nominal diameter clamping only



ER	Shank Ø	Square	ORDER CODE	PRICE
ER16	3.5	2.7	ER16MD03.5	▲
	4	3	ER16MD04	▲
	4.5	3.4	ER16MD04.5	▲
	5	4	ER16MD05	▲
	5.5	4.3	ER16MD05.5	▲
	6	4.9	ER16MD06	▲
	7	5.5	ER16MD07	▲
	8	6.2	ER16MD08	▲
ER20	3.5	2.7	ER20MD03.5	▲
	4	3	ER20MD04	▲
	4.5	3.4	ER20MD04.5	▲
	5	4	ER20MD05	▲
	5.5	4.3	ER20MD05.5	▲
	6	4.9	ER20MD06	▲
	7	5.5	ER20MD07	▲
	8	6.2	ER20MD08	▲
ER25	9	7	ER20MD09	▲
	10	8	ER20MD10	▲
	3.5	2.7	ER25MD03.5	▲
	4	3	ER25MD04	▲
	4.5	3.4	ER25MD04.5	▲
	5	4	ER25MD05	▲
	5.5	4.3	ER25MD05.5	▲
	6	4.9	ER25MD06	▲
	7	5.5	ER25MD07	▲
	8	6.2	ER25MD08	▲
	9	7	ER25MD09	▲
	10	8	ER25MD10	▲
ER32	11	9	ER25MD11	▲
	12	9	ER25MD12	▲
	3.5	2.7	ER32MD03.5	▲
	4	3	ER32MD04	▲
	4.5	3.4	ER32MD04.5	▲
	5	4	ER32MD05	▲
	5.5	4.3	ER32MD05.5	▲
	6	4.9	ER32MD06	▲
	7	5.5	ER32MD07	▲
	8	6.2	ER32MD08	▲
	9	7	ER32MD09	▲
	10	8	ER32MD10	▲
	11	9	ER32MD11	▲
	12	9	ER32MD12	▲
ER40	14	11	ER32MD14	▲
	6	4.9	ER40MD06	▲
	7	5.5	ER40MD07	▲
	8	6.2	ER40MD08	▲
	9	7	ER40MD09	▲
	10	8	ER40MD10	▲
	11	9	ER40MD11	▲
	12	9	ER40MD12	▲
	14	11	ER40MD14	▲
	16	12	ER40MD16	▲
	18	14.5	ER40MD18	▲
20	16	ER40MD20	▲	

**TAPPING ER COLLET SETS ER-MD SERIES**

- ▶ Square drive prevents tap from slipping
- ▶ Recommended for use with all Synchro Tap Chucks for maximum reliability



ER	No of Collets	Sizes Included	ORDER CODE	PRICE
ER16	4	3.5, 4.5, 6, 7	ER16MD-4PCS	▲
ER20	7	3.5, 4.5, 6, 7, 8, 9, 10	ER20MD-7PCS	▲
ER25	9	3.5, 4.5, 6, 7, 8, 9, 10, 11, 12	ER25MD-9PCS	▲
ER32	10	4.5, 6, 7, 8, 9, 10, 11, 12, 14, 16	ER32MD-10PCS	▲
ER40	11	6, 7, 8, 9, 10, 11, 12, 14, 16, 18, 20	ER40MD-11PCS	▼

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