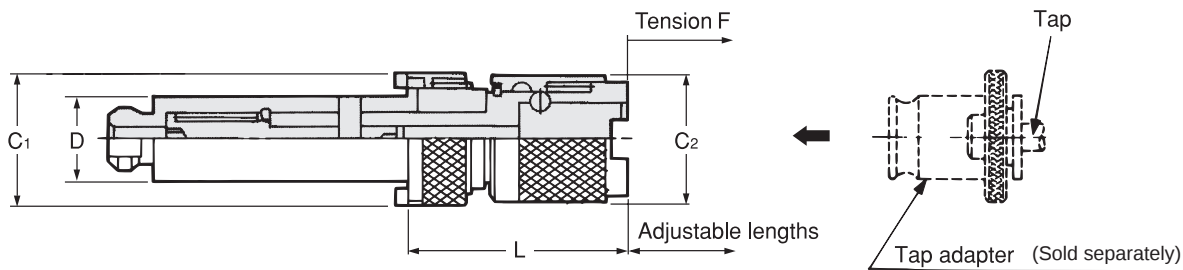


KD-NL

Quick Change Stub Tapper

- Designed for use on KD spindle.
- Spindle Feed: All kinds of feed styles. For spindle feed other than pitch feed, use KD-NL in a condition where the tension feature always works a little. In this case, the length adjustment should be retained less than half.



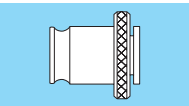
 For capable tap sizes, please refer to P.462-464 chart.

Code	Model	Tap Size	Adapter size	D	C2	C1	L	S MAX	F	kg
0830 00014008	KD 14 -NL008	M3 ~ M8 (M10)	0	14	23	19.5	45 + S	8	8-S	0.12
0830 00016010	KD 16 -NL010	U1/4 ~ U5/16 (U3/8)	0	16	23	26	43 + S	10	10-S	0.16
0830 00019110	KD 19 -NL110	M3 ~ M12 (M15) U1/4 ~ U7/16 (U9/16) Pipe(PT,PS,PF)1/8 ~ 1/4	1	19	32	28	41 + S	10	10-S	0.25
0830 00020110	KD 20 -NL110		1	20	32	28	41 + S	10	10-S	0.25
0830 00022110	KD 22 -NL110		1	22	32	32	41 + S	10	10-S	0.32
0830 00024110	KD 24 -NL110		1	24	32	32	41 + S	10	10-S	0.36
0830 00025115	KD 25 -NL115		1	25	32	36.2	41 + S	15	15-S	0.42
0830 00026115	KD 26 -NL115	M8 ~ M22 U3/8 ~ U7/8 Pipe(PT,PS,PF)1/8 ~ 1/2	1	26	32	36.2	41 + S	15	15-S	0.45
0830 00028215	KD 28 -NL215		2	28	50	36.2	56 + S	15	15-S	0.75
0830 00030215	KD 30 -NL215		2	30	50	38	56 + S	15	15-S	
0830 00032220	KD 32 -NL220		2	32	50	46	59 + S	20	20-S	
0830 00035220	KD 35 -NL220		2	35	50	46	59 + S	20	20-S	
0830 00036220	KD 36 -NL220		2	36	50	46	59 + S	20	20-S	1.15

1. Tap adapter is sold separately.
2. Finger collet assembly is sold separately.

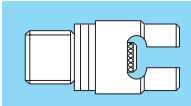
Tap Adapter

P. 458



Finger collet assembly

P. 438



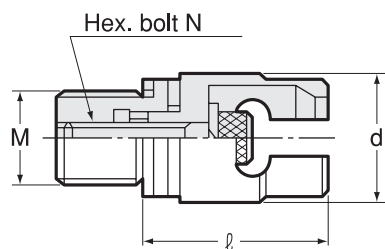
Ordering Example

KD28 - NL 006

| Length compensation (S Max)

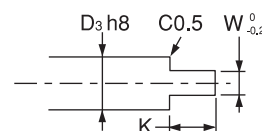
Adapter size

Finger collet assembly (Spindle parts)



Model	Holder	d	ℓ	M (P=1)	N
KDA -14	KD-14R2	14	27.3	M10	M5
KDA -16	KD-16	16	24.3	M12	M5
KDA -19	KD-19	19	29.3	M12	M5
KDA -20	KD-20	20	29.3	M12	M5
KDA -22	KD-22	22	27	M16	M6
KDA -24	KD-24	24	27	M16	M6
KDA -25	KD-25	25	29.5	M18	M8
KDA -26	KD-26	26	29.5	M18	M8
KDA -28	KD-28	28	29.5	M18	M8
KDA -30	KD-30	30	29.5	M18	M8
KDA -32	KD-32	32	30.5	M22	M8
KDA -35	KD-35	35	30.5	M22	M8
KDA -36	KD-36	36	30.5	M22	M8
KDA -48	KD-48	48	35.5	M22	M10

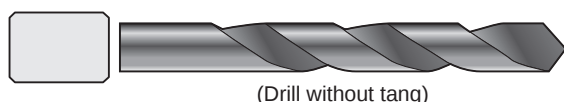
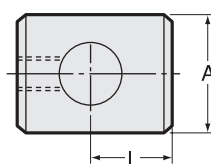
Tang



D3		W	K
Exceeding	Below		
3.1	5	2.4	5
5.1	6	3	6
6.1	9	4	8
9.1	12	5	8
12.1	16	6	10
16.1	22	8	12
22.1	32	12	12

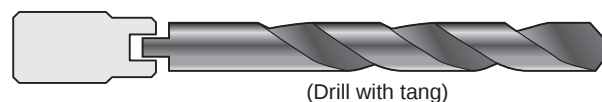
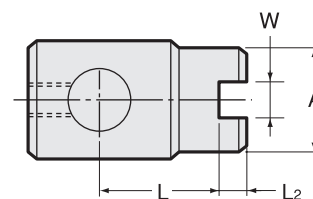
Preset driver
(For KD、KD-T)

Type1 without tang



(Drill without tang)

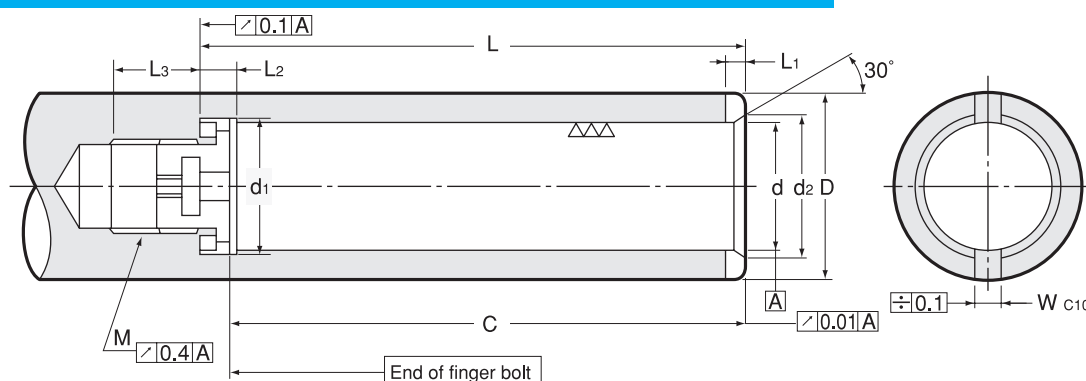
Type2 with tang



(Drill with tang)

Code	Model	Holder body	Type	W ^{+0.4} / _{+0.3}	A	L	L2
0802 02000071	KDS -007F	KDB-14R2	1	—	7	5	—
0802 02024071	-2.407F		2	2.4	7	5	4
0802 02003071	-307F		2	3	7	5	4
0802 02004071	-407F		2	4	7	5	4
0802 02000091	KDS -009F	KDB-16,19,20	1	—	9	7.5	—
0802 02024091	-2.409F		2	2.4	7	7.5	3
0802 02003091	-309F		2	3	9	5.5	3
0802 02004091	-409F		2	4	9	5.5	3
0802 02000121	KDS -012F	KDB-22,24	1	—	10	12.5	—
0802 02024121	-2.412F		2	2.4	10.8	12.5	4
0802 02003121	-312F		2	3	10.8	12.5	4
0802 02004121	-412F		2	4	10.8	9.5	4
0802 02005121	-512F	KDB-25,26,28,30	2	5	10.8	9.5	4
0802 02000161	KDS -016F		1	—	7	21	—
0802 02024161	-2.416F		2	2.4	12.5	21	3
0802 02003161	-316F		2	3	12.5	21	3
0802 02004161	-416F	KDB-32,35,36	2	4	12.5	19	3
0802 02005161	-516F		2	5	12.5	12	4
0802 02006161	-616F		2	6	16	7	5
0802 02000221	KDS -022F	KDB-32,35,36	1	—	19	14	—
0802 02024221	-2.422F		2	2.4	19	14	3
0802 02003221	-322F		2	3	19	14	3
0802 02004221	-422F		2	4	19	14	3
0802 02005221	-522F	KDB-48	2	5	19	11	3
0802 02006221	-622F		2	6	19	7	3
0802 02008221	-822F		2	8	19	7	3
0802 02000321	KDS -032F		1	—	29	12	—
0802 02008321	-832F	KDB-48	2	8	29	12	8
0802 02012321	-1232F		2	12	29	12	8

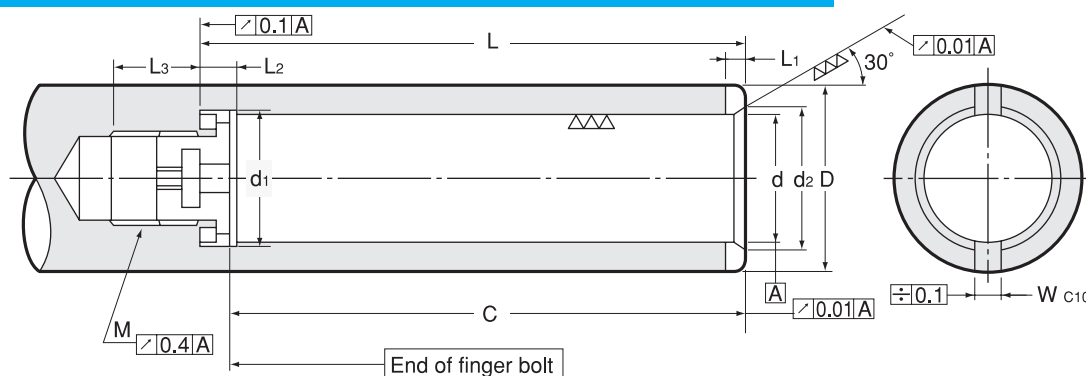
Dimension for KD spindle



1. C dimension shows length from end of finger bolt to end of spindle. (refer to P. 443)
2. Don't carburize thread (M) portion.

Size	d _{G6}	d ₂	D _{Min}	d ₁	L _{± 0.1}	L _{1^{+ 0.2 + 0.1}}	L ₂	L ₃	W _{C10}	M _{P=1}
14	14	15.5	20	14.4	68	3	5	15	8	10
16	16	17.5	25	16.4	72.5	3	5	15	8	12
19	19	20.5	28	19.4	82.5	3	5	15	9	12
20	20	21.5	28	20.4	82.5	3	5	15	9	12
22	22	23.5	32	22.4	89.5	3	5	15	10	16
24	24	25.5	32	24.4	89.5	3	5	15	10	16
25	25	26.5	35	25.4	105	3	8	20	10	18
26	26	27.5	35	26.4	105	3	8	20	10	18
28	28	29.5	38	28.4	105	3	8	20	10	18
30	30	31.5	40	30.4	105	3	8	20	10	18
32	32	33.5	42	32.4	123	3	8	20	10	22
35	35	36.5	45	35.4	123	3	8	20	10	22
36	36	37.5	45	36.4	123	3	8	20	10	22
48	48	49.5	65	48.4	145	4.5	8	20	11	22

Dimension for KD-T spindle



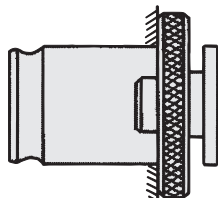
1. KD model can be used for KD-T spindle.
2. C dimension shows length from end of finger bolt to end of spindle. (refer to P. 443)
3. In case of heat treatment on the spindle, don't carburize thread (M) portion.
4. For 30° taper gauge information, please contact NT.

Size	d _{G6}	d _{2^{+ 0.02 - 0.08}}	D _{Min}	d ₁	L _{± 0.1}	L _{1^{+ 0.2 + 0.1}}	L ₂	L ₃	W _{C10}	M _{P=1}
14T	14	15.5	20	14.4	68	3	5	15	8	10
16T	16	17.5	25	16.4	72.5	3	5	15	8	12
19T	19	20.5	28	19.4	82.5	3	5	15	9	12
20T	20	21.5	28	20.4	82.5	3	5	15	9	12
22T	22	23.5	32	22.4	89.5	3	5	15	10	16
24T	24	25.5	32	24.4	89.5	3	5	15	10	16
25T	25	26.5	35	25.4	105	3	8	20	10	18
26T	26	27.5	35	26.4	105	3	8	20	10	18
28T	28	29.5	38	28.4	105	3	8	20	10	18
30T	30	31.5	40	30.4	105	3	8	20	10	18
32T	32	33.5	42	32.4	123	3	8	20	10	22
35T	35	36.5	45	35.4	123	3	8	20	10	22
36T	36	37.5	45	36.4	123	3	8	20	10	22
48T	48	49.5	65	48.4	145	4.5	8	20	11	22

QUICK CHANGE TAP ADAPTER

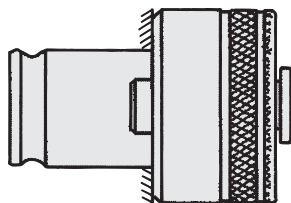
Basic 4 Models

WE



WE Quick Change

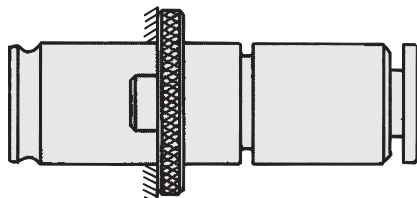
WES • B



WE Quick Change

S Safety Torque

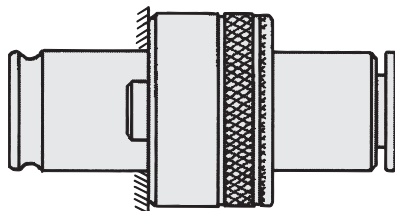
WEN



WE Quick Change

N Length Adjustment

WESN • B



WE Quick Change

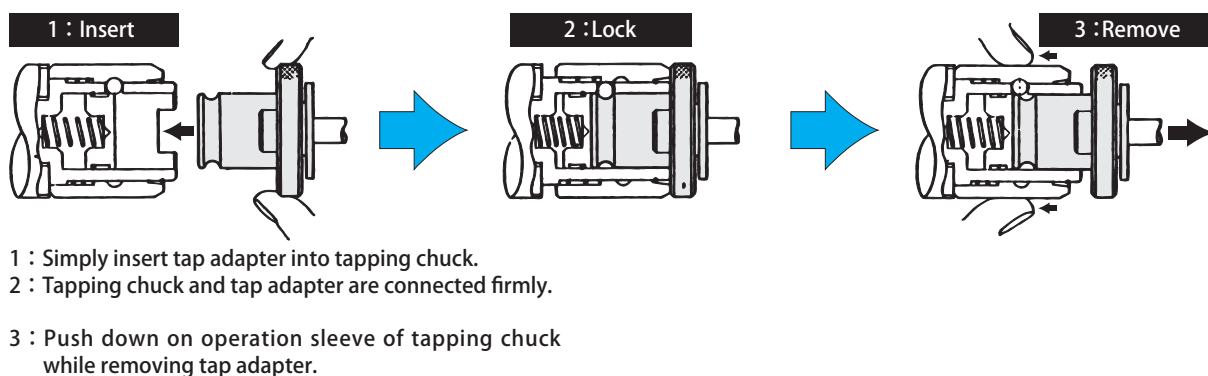
S Safety Torque

N Length Adjustment

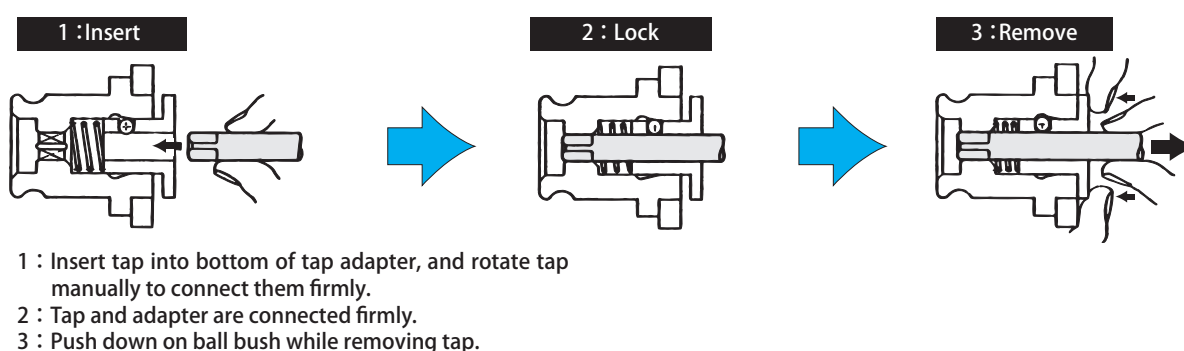
In addition to the basic 4 models, wide variety of models (extended size, enlarged size, R type for short shank tap etc.) are available.

WE : Quick Change

Tapping chuck and tapping adapter



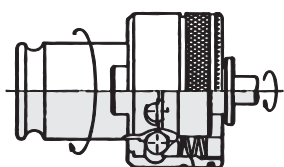
Tapping adapter and Tap



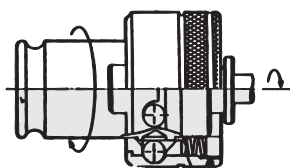
S : Safety torque

Safe torque device activates to prevent breakage tap when torque more than fixed amount is applied to tap. (Use with a taper equipped with axial compensation mechanism.)

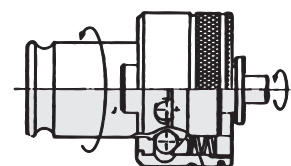
Normal operation (Normal machining)



Empty operation (Abnormal machining torque)

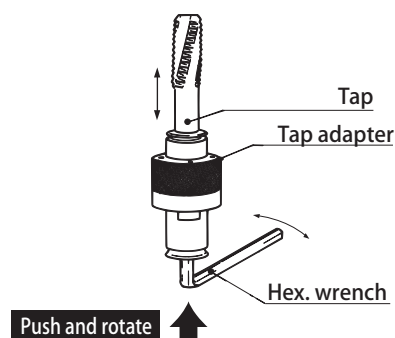


Reverse operation (Torque device doesn't move in the reverse direction)



When using left handed tap adapter, please specify.

N : Length adjustment

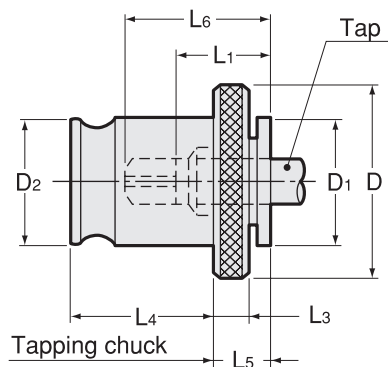


Insert hex. wrench into bottom of tap adapter and turn to adjust tool length.

Tap adapter with tool adjustment mechanism can be recommended for following conditions.

1. Tool adjustment with prestting gauge.
2. When tap length changes due to re-grinding.
3. When you do not want to use N/C machine tool compensation function.

Quick Change Tap Adapter



Applications

- For through hole, blind hole, right-hand thread and left-hand thread.

Feature

- Quick Change
- ※ In case you are afraid of tap breakage, choose a WES · B and a tapping chuck with safety torque clutch.

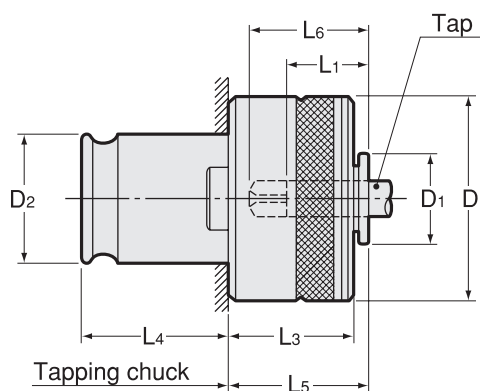
⚠ For capable tap sizes, please refer to P.462-464 chart.

Code	Model	Tap Size	Chuck size	D	D1	D2	L1	L3	L4	L5	kg
0210 00000 ※※※	WE0	M3 ~ M8 (M10) U1/4 ~ U5/16 (U3/8)	0	22	12.5	13	15	4	19.5	7	0.03
0210 00001 ※※※	WE1	M3 ~ M12 (M15) U1/4 ~ U7/16 (U9/16) Pipe(PT,PS,PF)1/8 ~ 1/4	1 32	30	19	19	17	4	21.5	7	0.06
0210 00040 ※※※	WE40	M6 ~ M18 U1/4 ~ U3/4	40	40	25	26	30	5	32	13	0.12
0210 00002 ※※※	WE2	M8 ~ M22 U3/8 ~ U7/8	2	48	30	31	30	5	35	11	0.25
0210 00003 ※※※	WE3	M26 ~ M38 U1 ~ U1 3/8	3	70	47	48	44	6	55.5	14	0.8
—	WE4	7/8 ~ 1-3/4 M22 ~ M48	4	90	60	60	71	13	63	42	

1. Tap sizes in brackets are for light tapping only.
2. Calculate tap projection length from L1 dimension.
3. L1 and L6 dimensions fluctuate with tap sizes. Always take into account $\pm 1.5\text{mm}$ allowance.
4. Refer to P.462 for tap shank dia. and square dimension.

Ordering Example

WE1 **M8J**
Adapter size Tap size



Applications

- For right-hand thread only. Through hole and blind hole.

Feature

- Quick Change
- Safety torque clutch actuates to prevent tap breakage when an excessive torque is applied to tap. In this case, a tapping chuck with compression device should be used together.

For capable tap sizes, please refer to P.462-464 chart.

Code	Model	Tap Size	Chuck size	D	D1	D2	L1	L3	L4	L5	kg
0210 06000 ※※※	WES0B	M3 ~ M8 (M10) U1/4 ~ U5/16 (U3/8)	0	23	12.5	13	15	20	19.5	21	0.06
0210 06001 ※※※	WES1B	M3 ~ M12 (M15) U1/4 ~ U7/16 (U9/16) Pipe(PT,PS,PF)1/8 ~ 1/4	1 32	32	19	19	17	25	21.5	25	0.15
0210 06040 ※※※	WES40B	M6 ~ M18 U1/4 ~ U3/4	40	40	25	26	30	27	32	30	0.3
0210 06002 ※※※	WES2B	M8 ~ M22 U3/8 ~ U7/8	2	50	30	31	30	31	35	33	0.6
0210 06003 ※※※	WES3B	M26 ~ M38 U1 ~ U1 3/8	3	72	47	48	44	41	55.5	45	1.5
—	WES4B	7/8 ~ 1-3/4 M22 ~ M48	4	95	60	60	71	61	63	68	

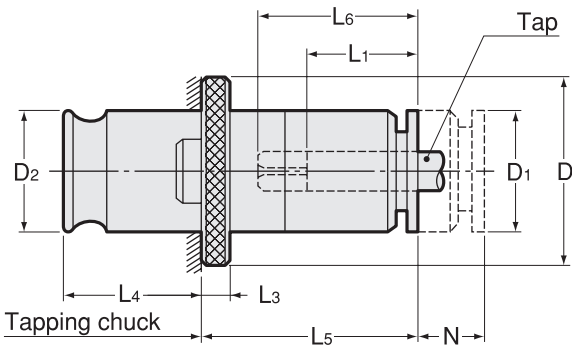
1. Tap sizes in brackets are for light tapping only.
2. Calculate tap projection length from L1 dimension.
3. Tapping chuck with compression device should be used together.
4. Specify PT, PS or PF when using a pipe tap, as each of them has various safety torque value.
5. L1 and L6 dimensions fluctuate with tap sizes. Always take into account $\pm 1.5\text{mm}$ allowance.
6. Refer to P.462 for tap shank dia. and square dimension.

Ordering Example

WES1B M8J
Adapter size Tap size

WEN

Quick Change Tap Adapter



Applications

- For through hole, blind hole, right-hand thread and left-hand thread.

Feature

- Quick Change
- Length adjustment facilitates your depth control of re-ground tap.

 For capable tap sizes, please refer to P.462-464 chart.

Code	Type	Tap Size	Chuck Size	N	D	D1	D2	L1	L3	L4	L5
—	WEN0	M3 ~ M8(M10) U1/4 ~ U5/16 (U3/8)	0	8	22	13	13	15	4	19.5	29
—	WEN1	#0-12, 1/4 - 1/2 M3-M12	1	10	30	19	19	17	4	21.5	34
—	WEN2	5/16 - 7/8 M8-M20	2	15	48	30	31	30	5	35	60
—	WEN3	13/16 - 1-3/8 M14-M33	3	25	70	48	48	44	6	55.5	83

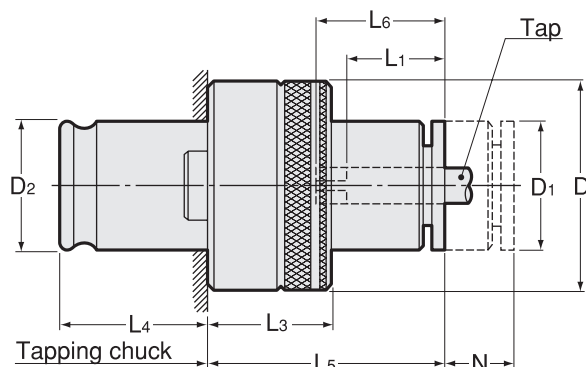
1. Tap sizes in brackets are for light tapping only.
2. Calculate tap projection length from L1 dimension.
3. L1 and L6 dimensions fluctuate with tap sizes. Always take into account ± 1.5mm allowance.
4. Refer to P.462 for tap shank dia. and square dimension.

Ordering Example

WEN1 **M11**
 Adapter size Tap size

WESN · B

Quick Change Tap Adapter



Applications

- For right-hand thread only. Through hole and blind hole.

Feature

- Quick Change
- Safety torque clutch actuates to prevent tap breakage when an excessive torque is applied to tap. In this case, a tapping chuck with compression device should be used together.
- Length Adjustment facilitates your depth control of re-ground tap.

 For capable tap sizes, please refer to P.462-464 chart.

Code	Model	Tap Size	Chuck size	N Adjustable length	D	D1	D2	L1	L3	L4	L5	kg
0210 06100 ※※※	WESN0B	M3 ~ M8 (M10) U1/4 ~ U5/16 (U3/8)	0	8	23	13	13	15	20	19.5	28	0.1
0210 06101 ※※※	WESN1B	M3 ~ M12 (M15) U1/4 ~ U7/16 (U9/16) Pipe(PT,PS,PF)1/8 ~ 1/4	$\frac{1}{32}$	10	32	19	19	17	25	21.5	33	0.2
0210 06140 ※※※	WESN40B	M6 ~ M18 U1/4 ~ U3/4	40	15	40	25	26	30	27	32	53	0.4
0210 06102 ※※※	WESN2B	M8 ~ M22 U3/8 ~ U7/8	2	15	50	30	31	30	31	35	59	0.7
0210 06103 ※※※	WESN3B	M26 ~ M38 U1 ~ U1 3/8	3	25	72	48	48	44	41	55.5	82.5	2.1

1. Tap sizes in brackets are for light tapping only.
2. Calculate tap projection length from L1 dimension.
3. Tapping chuck with compression device should be used together.
4. Specify PT, PS or PF when using a pipe tap, as each of them has various safety torque value.
5. L1 and L6 dimensions fluctuate with tap sizes. Always take into account $\pm 1.5\text{mm}$ allowance.
6. Refer to P.462 for tap shank dia. and square dimension.

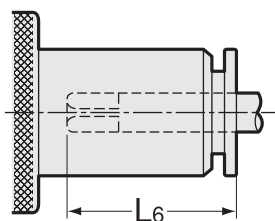
Ordering Example

WESN2B M12J

Adapter size Tap size

Tapping Capacity

Dimension L6



Symbol

○ : For JIS (old) Tap

● : For Coarse Thread Tap

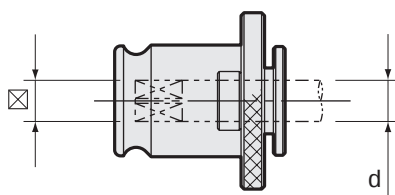
※ : For light machining on aluminum alloy and the like

⚠ For capable tap sizes, please refer to P.462-464 chart.

WESN · B、WES · B、WE

Tap Dimension					WESN · B WES · B WE 0		WESN · B WES · B WE 1		WESN · B WES · B WE 40		WESN · B WES · B WE 2		WESN · B WES · B WE 3	
Metric Thread	Unified Thread	Whit-worth Thread	Shank Dia. Φ	Square □	L6		L6		L6		L6		L6	
M3	NO5,NO6		4	3.2	○	22	○	23						
M4 M4.5	NO8		5	4	○	22.5	○	24.5						
M5 M5.5	NO10,NO12		5.5	4.5	○	22.5	○	24.5						
M6	U1/4	W1/4	6	4.5	○	22	○	24.5	○	36.5				
	U5/16	W5/16	6.1	5	○	23	○	25	○	37.5				
M8 M7			6.2	5	○	23	○	25.5	○	37	○	37		
M10 M9	U3/8	W3/8	7	5.5	※	23.5	○	25.5	○	37	○	37		
M11	U7/16	W7/16	8	6			○	26.5	●	38.5	●	38.5		
M12			8.5	6.5			○	26.5	●	38	●	38		
	U1/2	W1/2	9	7			○	27	○	38.5	○	38.5		
M14 M15	U9/16	W9/16	10.5	8			※	28	●	40	●	40		
	U5/8	W5/8	12	9					○	41.5	○	41.5		
M16			12.5	10					●	42	●	42		
M17			13	10					○	42	○	42		
M18	U3/4	W3/4	14	11					○	43.5	○	43.5		
M20			15	12							○	44		
M22	U7/8	W7/8	17	13							○	45		
M27 M26	U1	W1	20	15									●	62
M28			21	17									●	63.5
	U1 1/8	W1 1/8	22	17									●	62.5
M30			23	17									●	62
M32	U1 1/4	W1 1/4	24	19									●	66
M33			25	19									●	66
M35 M34	U1 3/8	W1 3/8	26	21									●	68
M36 M38			28	21									●	67
Pipe Tap Dimension														
PT	PS	PF	φ	□										
1/8	1/8	1/8	8	6			○	26.5						
1/4	1/4	1/4	11	9			○	29						

Tapping Capacity



ANSI

Unit : Inch

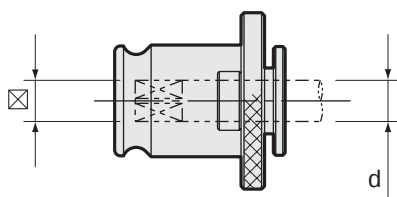
Type	Chuck size	Tap size	φ d Tap Shank	□ Drive Square
WE0 WES0B WEN0 WESN0B	0	#0-6	0.141	0.110
		#8	0.168	0.131
		#10	0.194	0.152
		#12	0.220	0.165
		1/4	0.255	0.191
WE1 WES1B WEN1 WESN1B	1	5/16	0.318	0.238
		#0-6	0.141	0.110
		#8	0.168	0.131
		#10	0.194	0.152
		#12	0.220	0.165
		1/4	0.255	0.191
		5/16	0.318	0.238
		3/8	0.381	0.286
		7/16	0.323	0.242
		1/2	0.367	0.275
WE2 WES2B WEN2 WESN2B	2	1/8SPT	0.313	0.234
		1/8LPT	0.437	0.328
		5/16	0.318	0.238
		3/8	0.381	0.286
		7/16	0.323	0.242
		1/2	0.367	0.275
		9/16	0.429	0.322
		5/8	0.480	0.360
		11/16	0.542	0.406
		3/4	0.590	0.442
WE3 WES3B WEN3 WESN3B	3	13/16	0.652	0.489
		7/8	0.697	0.523
		15/16	0.760	0.570
		1	0.800	0.600
		1-1/8	0.896	0.672
		1-1/4	1.021	0.766
		1-3/8	1.108	0.831
		1/2PT	0.687	0.515
WE4 WES4B	4	3/4PT	0.906	0.679
		1PT	1.125	0.843
		7/8	0.697	0.523
		15/16	0.760	0.570
		1	0.800	0.600
		1-1/8	0.896	0.672
		1-1/4	1.021	0.766
		1-3/8	1.108	0.831

ISO

Unit : Metric

Type	Chuck size	Tap size	φ d Tap Shank	□ Drive Square
WE0 WES0B WEN0 WESN0B	0	Please contact NT USA for details.		
WE1 WES1B WEN1 WESN1B	1	M3-1	2.24	1.8
		M3.5, M2	2.5	2.0
		M2.5, M2.2	2.8	2.24
		M4-1, M3-2	3.15	2.5
		M4.5, M3.5	3.55	2.8
		M5-1, M4-2	4.0	3.15
		M6-1	4.5	3.55
		M5-2	5.0	4.0
		M5-3	5.6	4.5
		M8-1, M6-2	6.3	5.0
		M7	7.1	5.6
		M11, M10-1, M8-2	8.0	6.3
		M12, M9	9.0	7.1
		M10-2	10.0	8.0
WE2 WES2B WEN2 WESN2B	2	M14	11.2	9.0
		M5-1, M4-2	4.0	3.15
		M6-1	4.5	3.55
		M5-2	5.0	4.0
		M5-3	5.6	4.5
		M8-1, M6-2	6.3	5.0
		M7	7.1	5.6
		M11, M10-1, M8-2	8.0	6.3
		M12, M9	9.0	7.1
		M10-2	10.0	8.0
		M14	11.2	9.0
		M16	12.5	10.0
		M20, M18	14.0	11.2
		M22	16.0	12.5
WE3 WES3B WEN3 WESN3B	3	M24	18.0	14.0
		M12, M9	9.0	7.1
		M10-2	10.0	8.0
		M14	11.2	9.0
		M16	12.5	10.0
		M20, M18	14.0	11.2
		M22	16.0	12.5
		M24	18.0	14.0
WE4 WES4B	4	M30, M27	20.0	16.0
		M33-1	22.4	18.0
		M36, M33-2	25.0	20.0
		M42, M39	28.0	22.4
		M22	16.0	12.5
		M24	18.0	14.0

Tapping Capacity



DIN

Unit : Metric

Type	Chuck size	Tap size	φ d Tap Shank	Drive Square
WE0 WES0B WEN0 WESN0B	0	M3, M5	3.5	2.7
		M4, M6	4.5	3.4
		M5, M6, M8	6.0	4.9
		M10	7.0	5.5
		M8, M10	8.0	6.2
WE1 WES1B WEN1 WESN1B	1	M3, M5	3.5	2.7
		M3.5	4.0	3.0
		M4, M6	4.5	3.4
		M5, M6, M8	6.0	4.9
		M10	7.0	5.5
		M8, M10	8.0	6.2
		M12	9.0	7.0
WE2 WES2B WEN2 WESN2B	2	M10	10.0	8.0
		M14	11.0	9.0
		M16	12.0	9.0
		M18	14.0	11.0
		M20	16.0	12.0
		M22, M24	18.0	14.5
		M12	9.0	7.0
		M10	10.0	8.0
		M14	11.0	9.0
		M16	12.0	9.0
		M18	14.0	11.0
WE3 WES3B WEN3 WESN3B	3	M20	16.0	12.0
		M22, M24	18.0	14.5
		M27, M30	20.0	16.0
		M33, M36	22.0	18.0
		M36	25.0	20.0
WE4 WES4B	4	M22, M24	18.0	14.5
		M27, M30	20.0	16.0
		M30	22.0	18.0
		M33, M36	25.0	20.0
		M36	28.0	22.0
		M39, M42	32.0	24.0
		M45, M48	36.0	29.0

JIS

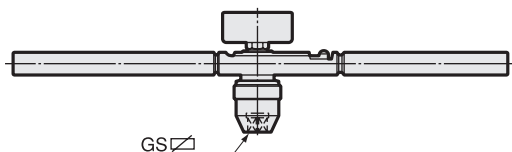
Unit : Metric

Type	Chuck size	Tap size	φ d Tap Shank	Drive Square
WE0 WES0B WEN0 WESN0B	0	M3	4.0	3.2
		M4, M4.5	5.0	4.0
		M5, M5.5	5.5	4.5
		M6	6.0	4.5
		M7, M8	6.2	5.0
		M9, M10	7.0	5.5
		M11	8.0	6.0
WE1 WES1B WEN1 WESN1B	1	M3	4.0	3.2
		M4, M4.5	5.0	4.0
		M5, M5.5	5.5	4.5
		M6	6.0	4.5
		M7, M8	6.2	5.0
		M9, M10	7.0	5.5
		M11	8.0	6.0
		M12	8.5	6.5
		M13	9.5	7.0
		M14, M15	10.5	8.0
WE2 WES2B WEN2 WESN2B	2	M6	6.0	4.5
		M7, M8	6.2	5.0
		M9, M10	7.0	5.5
		M11	8.0	6.0
		M12	8.5	6.5
		M13	9.5	7.0
		M14, M15	10.5	8.0
		M16	12.5	10.0
		M17	13.0	10.0
		M18	14.0	11.0
		M20	15.0	12.0
		M22	17.0	13.0
WE3 WES3B WEN3 WESN3B	3	M14, M15	10.5	8.0
		M16	12.5	10.0
		M17	13.0	10.0
		M18	14.0	11.0
		M20	15.0	12.0
		M22	17.0	13.0
		M24, M25	19.0	15.0
		M26, M27	20.0	15.0
		M28	21.0	17.0
		M30	23.0	17.0
		M32	24.0	19.0
		M33	25.0	19.0
		M34, M35	26.0	21.0
		M36, M38	28.0	21.0
WE4 WES4B	4	M22	17.0	13.0
		M24, M25	19.0	15.0
		M26, M27	20.0	15.0
		M28	21.0	17.0
		M30	23.0	17.0
		M32	24.0	19.0
		M33	25.0	19.0
		M34, M35	26.0	21.0
		M36, M38	28.0	21.0
		M39, M40	30.0	23.0
		M42	32.0	26.0
		M45	35.0	26.0
		M48	38.0	29.0

Torque Setting

Torque Wrench (for right thread)

G type

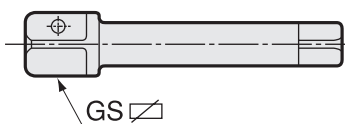


Oil pressure torque wrench with N-m, divisions.

Code	Model	Adapter size	(N-m)	GS
0150 09000000	G0	0	15	13
0150 09000001	G1	0.1	30	13
0150 09000002	G2	2.40	120	13
0150 09000003	G3	3	300	13
0150 09000004	GE4-RD4	4	1,000	25

Setting Shank

GS type



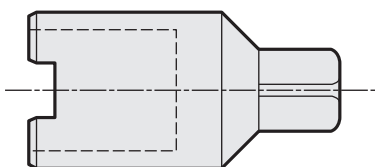
Code	Model	GS	Tapsize
0210 091100 ※※	GS13-M ※※	13	M3 ~ M38
0210 091110 ※※	GS25-M ※※	25	M22 ~ M48

1.Tap size will be inserted in " ※※ ".

2.Square head of setting shank fit into square part of torque wrench.

Setting Socket

GW type

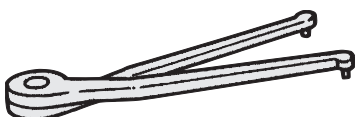


Code	Model	Adapter size
0210 09200000	GW0	0
0210 09200001	GW1	1
0210 09200040	GW40	40
0210 09200002	GW2	2
0210 09200003	GW3	3
0210 09200004	GW4	4

Fix square part of setting socket on vise, and then insert tap adapter into it for torque setting.

Adjustable Pin Wrench

GWA type



Code	Model	Pin diameter	Adapter size
0150 09300000	GWA0	2	0
0150 09300001	GWA1	2.5	1
0150 09300040	GWA40	3	2、3、40
0150 09300004	GWA4	6	4

Rotate sled ring of tap adapter by pin wrench for torque adjustment.

BT

CAT

AHO

HSK-A/E/F/C

HSK-T

UTS

Specialized Machine

Related Equipment

Bush & Chamfering Drill

Sub Holder

Tapping Chuck

Tap Adapter

Adjustable Adapter

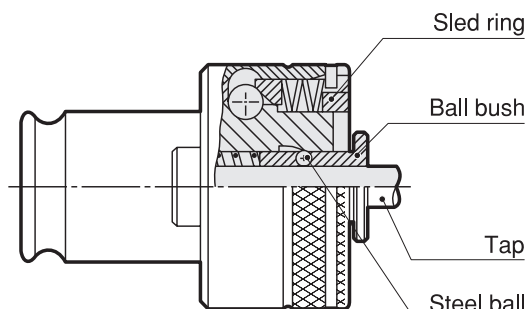
Endmill Chuck

Straight Drill Chuck

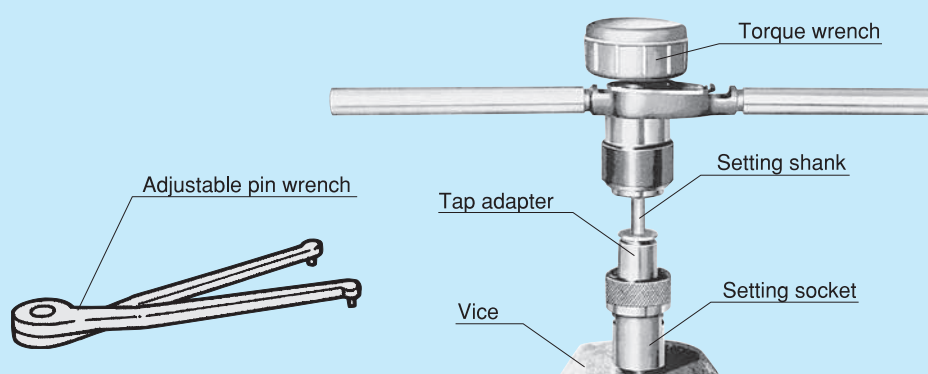
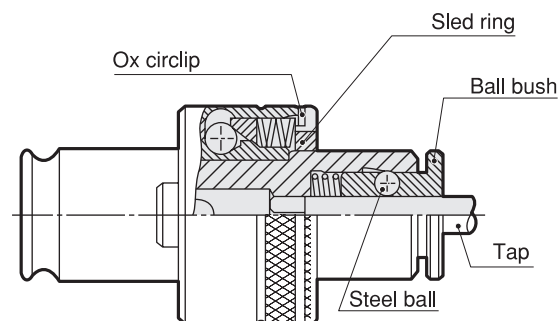
Floating Holder

Torque setting

Tap adapter type WES • B



Tap adapter type WESN • B



Torque setting by special tool

- 1) Fix square part of setting socket by using vise.
- 2) Insert tap adapter into the setting socket.
- 3) Insert the setting shank into the tap adapter.
- 4) Insert square part of torque wrench into head part of setting shank.
- 5) Check current torque.
- 6) When changing torque, remove horn part of ox circlip.
- 7) Insert adjustable pin wrench into pin hole of sled ring.
- 8) Rotate sled ring clockwise when increase torque or counterclockwise when decrease torque.
- 9) Check torque again after setting torque.
- 10) After setting the torque, return horn part of ox circlip to original position to fix sled ring.

Torque setting without special tool

- 1) Remove horn part of ox circlip.
- 2) Insert adjustable pin wrench into pin hole of sled ring.
- 3) Rotate sled ring clockwise when increase torque or counterclockwise when decrease torque. Sled ring rotation must be 45 ~ 90°
- 4) After setting the torque, return horn part of ox circlip to original position to fix sled ring.

Guidelines for Torque Value

Metric Tap		Inch Tap		PT Tap		PS and PF Taps	
Tap Size	Torque (N-m)	Tap Size	Torque (N-m)	Tap Size	Torque (N-m)	Tap Size	Torque (N-m)
M3	1.0	1/8"	2.0	1/8"	26.0	1/8"	8.0
M4	2.3	1/4"	8.0	1/4"	35.0	1/4"	26.0
M5	3.7	5/16"	14.0	3/8"	47.0	3/8"	32.0
M6	6.0	3/8"	22.0	1/2"	100.0	1/2"	65.0
M7	7.5	7/16"	32.0	3/4"	120.0	3/4"	90.0
M8	12.0	1/2"	45.0	1"	240.0	1"	160.0
M9	14.0	9/16"	52.0	1 1/4"	270.0	1 1/4"	200.0
M10	22.0	5/8"	65.0	1 3/8"	300.0	1 3/8"	220.0
M11	26.0			1 1/2"	310.0	1 1/2"	240.0
M12	32.0	3/4"	90.0				
M14	47.0						
M16	52.0	7/8"	120.0				
M18	82.0						
M20	90.0	1"	160.0				
M22	100.0	1 1/8"	220.0				
M24	135.0	1 1/4"	250.0				
M27	160.0	1 3/8"	325.0				
M30	230.0	1 1/2"	360.0				
M33	250.0	1 5/8"	580.0				
M36	310.0	1 3/4"	630.0				
M39	325.0	1 7/8"	750.0				
M40 (細)	210.0	2"	800.0				
M42	420.0						
M45	480.0						
M48	630.0						
M50 (細)	260.0						

BT

CAT

AHO

HSK-A/E/F/C

HSK-T

UTS

Specialized Machine

Related Equipment

Bush & Chamfering Drill

Sub Holder

Tapping Chuck

Tap Adapter

Adjustable Adapter

Endmill Chuck

Straight Drill Chuck

Floating Holder