Quick-Change Tap Holders and Collets

Tired of Breaking Taps?

Our Tension-Compression tap holders automatically compensate for machine feed rates to improve results.

ANSI Clutch Drive & Rigid Tap Collets

Clutch drive stops spinning if tap reaches bottom of hole.

Rigid Tap Holders

Easy to use and reliable tap holders for general tapping applications.

We don't sell tools.
We sell tool life.

I personally guarantee your satisfaction with every Techniks product.

John A. Stagge
PRESIDENT

Quick-Change Tap Holders and Collets

CAT, BT Tension / Compression Tap Holders

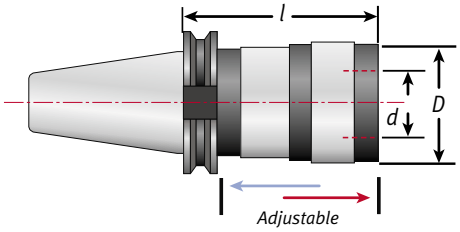
Techniks Quality Features

- *Adjustible tension helps start difficult taps*
- *Taper ground to AT3 accuracy or better*
- *Quick-Change Style*

ANSI Tap Collets pg. 158

Retention Knobs pg. 161

Tightening Stands pg. 168



CAT Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap Capacity	Compensation Tension	Compensation Compression
32400/40A	CAT 40 T/C Holder, Size 1	0.748"	1.5"	2.36"	1	0 – 9/16"	0.35"	0.35"
32400/50A	CAT 50 T/C Holder, Size 1	0.748"	1.5"	2.44"	1	0 – 9/16"	0.35"	0.35"
32600/40A	CAT 40 T/C Holder, Size 2	1.220"	2.17"	3.94"	2	5/16 – 7/8"	0.59"	0.59"
32600/50A	CAT 50 T/C Holder, Size 2	1.220"	2.17"	3.27"	2	5/16 – 7/8"	0.59"	0.59"
32800/40A	CAT 40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50A	CAT 50 T/C Holder, Size 3	1.890"	3.11"	5.24"	3	1/2 – 1 3/8"	0.94"	0.94"
32900/40A	CAT 40 T/C Holder, Size 4	2.362"	3.86"	6.06"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50A	CAT 50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

BT Tension / Compression Tap Holders

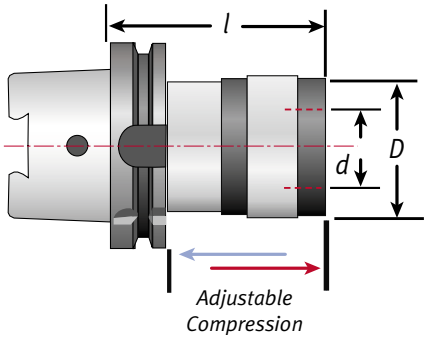
Part No.	Description	d	D	l	Size	Tap Capacity	Compensation Tension	Compensation Compression
32400/30BT	BT 30 T/C Holder, Size 1	0.748"	1.5"	2.48"	1	0 – 9/16"	0.35"	0.35"
32400/40BT	BT 40 T/C Holder, Size 1	0.748"	1.5"	2.68"	1	0 – 9/16"	0.35"	0.35"
32400/50BT	BT 50 T/C Holder, Size 1	0.748"	1.5"	3.15"	1	0 – 9/16"	0.35"	0.35"
32600/30BT	BT 30 T/C Holder, Size 2	1.220"	2.17"	3.78"	2	5/16 – 7/8"	0.59"	0.59"
32600/40BT	BT 40 T/C Holder, Size 2	1.220"	2.17"	3.66"	2	5/16 – 7/8"	0.59"	0.59"
32600/50BT	BT 50 T/C Holder, Size 2	1.220"	2.17"	4.02"	2	5/16 – 7/8"	0.59"	0.59"
32800/40BT	BT 40 T/C Holder, Size 3	1.890"	3.11"	5.43"	3	1/2 – 1-3/8"	0.94"	0.94"
32800/50BT	BT 50 T/C Holder, Size 3	1.890"	3.11"	5.31"	3	1/2 – 1-3/8"	0.94"	0.94"
32900/40BT	BT 40 T/C Holder, Size 4	2.362"	3.86"	6.18"	4	1-7/16 – 1-7/8"	1.02"	1.02"
32900/50BT	BT 50 T/C Holder, Size 4	2.362"	3.86"	5.79"	4	1-7/16 – 1-7/8"	1.02"	1.02"

Call (800) 597-3921 or (317) 803-8000 for fast, friendly answers to your questions.

SYIC

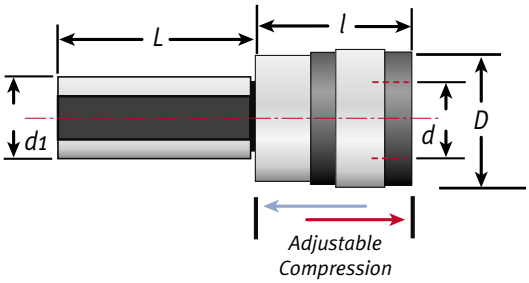
Techniks Quality Features

- *Adjustible tension helps start difficult taps*
- *Quick-Change Style*



HSK A Tension / Compression Tap Holders

Part No.	Description	d	D	l	Size	Tap Capacity	Compensation Tension	Compensation Compression
34400/H40A	HSK 40A T/C Holder, Size 1	0.748"	1.61"	3.14"	1	0 – 9/16"	0.295"	0.295"
34400/H50A	HSK 50A T/C Holder, Size 1	0.748"	1.61"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H63A	HSK 63A T/C Holder, Size 1	0.748"	1.61"	2.83"	1	0 – 9/16"	0.295"	0.295"
34400/H100A	HSK 100A T/C Holder, Size 1	0.748"	1.61"	3.14"	1	0 – 9/16"	0.295"	0.295"
34600/H50A	HSK 50A T/C Holder, Size 2	1.22"	2.36"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H63A	HSK 63A T/C Holder, Size 2	1.22"	2.36"	4.33"	2	5/16 – 7/8"	0.393"	0.393"
34600/H100A	HSK 100A T/C Holder, Size 2	1.22"	2.36"	3.94"	2	5/16 – 7/8"	0.393"	0.393"



Straight Shank Tapping Chucks

Part No.	Description	D1	D	l	L	Tap Capacity	Compensation Tension	Compensation Compression
32400/D25.4	1" shank T/C Holder, Size 1	1.00"	1.61"	1.76"	1.95"	0 – 9/16"	0.35"	0.35"
32600/D25.4	1" shank T/C Holder, Size 2	1.00"	2.36"	2.52"	2.00"	5/16 – 7/8"	0.59"	0.59"
32600/D38.1	1 1/2" shank T/C Holder, Size 2	1.50"	2.36"	2.52"	3.50"	5/16 – 7/8"	0.59"	0.59"
32800/D38.1	1 1/2" shank T/C Holder, Size 3	1.50"	3.38"	3.85"	3.50"	1/2 – 1 3/8"	0.94"	0.94"

CAT, BT Rigid Tap Holders

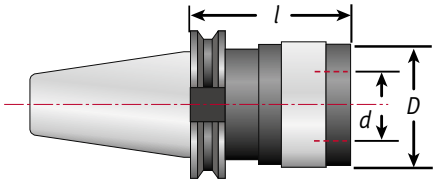
Techniks Quality Features

- *Taper ground to AT3 accuracy or better*
- *Quick-Change Style*

ANSI Tap Collets pg. 158

Retention Knobs pg. 161

Tightening Stands pg. 168



CAT Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/40A	CAT 40 Rigid Tap Holder, Size 1	2.32"	1.31"	0.748"	1	0 – 9/16"
21480/50A	CAT 50 Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 – 9/16"
21680/40A	CAT 40 Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 – 7/8"
21680/50A	CAT 50 Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 – 7/8"
21880/40A	CAT 40 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1 3/8"
21880/50A	CAT 50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 – 1-3/8"

BT Rigid Tap Holders

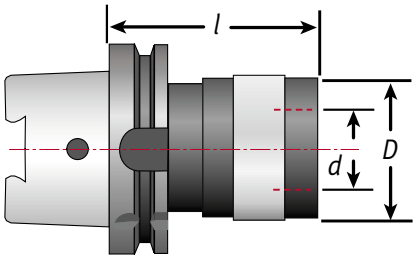
Part No.	Description	l	D	d	Size	Tap Capacity
21480/30BT	BT 30 Rigid Tap Holder, Size 1	2.80"	1.31"	0.748"	1	0 - 9/16"
21480/40BT	BT 40 Rigid Tap Holder, Size 1	2.63"	1.31"	0.748"	1	0 - 9/16"
21480/50BT	BT 50 Rigid Tap Holder, Size 1	3.07"	1.31"	0.748"	1	0 - 9/16"
21680/30BT	BT 30 Rigid Tap Holder, Size 2	3.70"	1.97"	1.22"	2	5/16 - 7/8"
21680/40BT	BT 40 Rigid Tap Holder, Size 2	3.54"	1.97"	1.22"	2	5/16 - 7/8"
21680/50BT	BT 50 Rigid Tap Holder, Size 2	3.97"	1.97"	1.22"	2	5/16 - 7/8"
21880/40BT	BT 40 Rigid Tap Holder, Size 3	4.61"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/50BT	BT 50 Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"

Distributors - Call to register for our Distributors Webstore for full online access.

SYIC

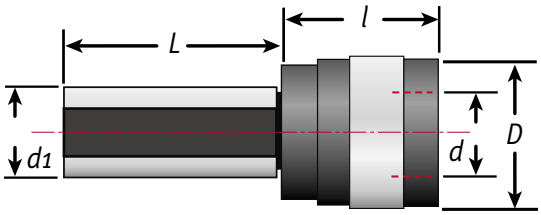
Techniks Quality Features

- *Quick-Change Style*



HSK Rigid Tap Holders

Part No.	Description	l	D	d	Size	Tap Capacity
21480/H50A	HSK 50A Rigid Tap Holder, Size 1	2.30"	1.31"	0.748"	1	0 - 9/16"
21480/H63A	HSK 63A Rigid Tap Holder, Size 1	2.32"	1.31"	0.748"	1	0 - 9/16"
21480/H100A	HSK 100A Rigid Tap Holder, Size 1	2.95"	1.31"	0.748"	1	0 - 9/16"
21680/H50A	HSK 50A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H63A	HSK 63A Rigid Tap Holder, Size 2	3.23"	1.97"	1.22"	2	5/16 - 7/8"
21680/H100A	HSK 100A Rigid Tap Holder, Size 2	3.86"	1.97"	1.22"	2	5/16 - 7/8"
21880/H63A	HSK 63A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"
21880/H100A	HSK 100A Rigid Tap Holder, Size 3	4.80"	2.83"	1.89"	3	1/2 - 1 3/8"



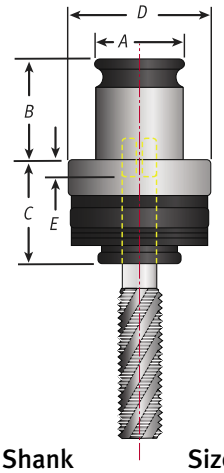
Straight Shank Rigid Tap Holders

Part No.	Description	d1	L	l	D	d	Tap Capacity
21480/D25.4	1" shank, Rigid Tap Holder, Size 1	1.00"	1.95"	1.60"	1.61"	.748"	0 – 9/16"
21680/D25.4	1" shank, Rigid Tap Holder, Size 2	1.00"	2.00"	2.50"	2.36"	1.22"	3/8 – 7/8"
21880/D38.1	1 1/2" shank, Rigid Tap Holder, Size 3	1.50"	3.50"	3.44"	3.38"	1.89"	1/2 – 1 3/8"

ANSI Clutch Drive Tap Collet Features

- *Prevents broken taps*
- *Automatically stops spinning when bottom is reached*
- *Change worn taps in seconds*

Note: Metric tap collets available on request. Please verify shank diameter when ordering metric tap collets.



Collet Set

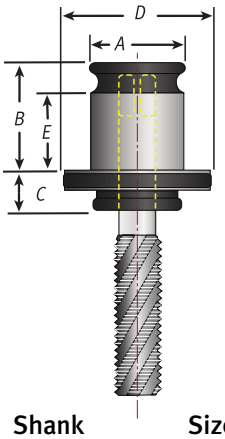
Part No.	Description
48/13-SET	Size 3, 12 piece set – 1/2" thru 1 5/16"

Dimensions	A	B	C	D	E
Size 1	.75"	.85"	.98"	1.26"	.31"
Size 2	1.22"	1.38"	1.34"	1.97"	.16"
Size 3	1.89"	2.19"	1.77"	2.83"	.04"

ANSI Clutch Drive Tap Collets

ANSI	Metric Tap With ANSI Shank	Shank	Size 0	Size 1	Size 2	Size 3
0-6"	M1.6-M3.5	0.141"	13/0 - 4036	19/1 - 4036		
8, 5/32"	M4	0.168"	13/0 - 4041	19/1 - 4041		
10, 3/16"	M4.5, M5	0.194"	13/0 - 4048	19/1 - 4048		
12, 7/32"		0.220"	13/0 - 4054	19/1 - 4054		
1/4"	M6, M6.3	0.255"	13/0 - 4063	19/1 - 4063		
5/16"	M7, M8	0.318"		19/1 - 4079	31/2 - 4079	
3/8"	M10	0.381"		19/1 - 4095	31/2 - 4095	
7/16"	M11	0.323"		19/1 - 4111	31/2 - 4111	
1/2"	M12, M12.5	0.367"		19/1 - 4127	31/2 - 4127	48/3 - 4127
9/16"	M14	0.429"		19/1 - 4142	31/2 - 4142	48/3 - 4142
5/8"	M16	0.480"			31/2 - 4158	48/3 - 4158
11/16"	M18	0.542"			31/2 - 4174	48/3 - 4174
3/4"		0.590"			31/2 - 4190	48/3 - 4190
13/16"	M20	0.652"			31/2 - 4206	48/3 - 4206
7/8"	M22	0.697"			31/2 - 4222	48/3 - 4222
15/16"	M24	0.760"				48/3 - 4238
1"	M25	0.800"				48/3 - 4254
1 1/8, 1 1/16"	M27	0.896"				48/3 - 4286
1 1/4, 1 3/16"	M30	1.021"				48/3 - 4317
1 3/8, 1 5/16"	M33	1.108"				48/3 - 4349
1/8" NPT		0.437"		19/1 - 4097		
1/4" NPT		0.562"			31/2 - 4131C	
3/8" NPT		0.700"			31/2 - 4166C	48/3 - 4166C
1/2" NPT					31/2 - 4209C	48/3 - 4209C
3/4" NPT						48/3 - 4264C
1" NPT						48/3 - 4332C

Need it FAST? We offer Same Day Shipping until 5:00 pm E.S.T.



ANSI Rigid Tap Collet Features

- *Change worn taps in seconds*
- *Quick-Change Style*

Dimensions	A	B	C	D	E
Size 1	.75"	.85"	.28"	1.18"	.39"
Size 2	1.22"	1.38"	.43"	1.81"	.75"
Size 3	1.89"	2.19"	.55"	2.68"	1.18"
Size 4	2.36"	2.48"	1.65"	3.27"	1.14"

ANSI Rigid Tap Collets

ANSI	Metric Tap With ANSI Shank	Shank	Size 1	Size 2	Size 3	Size 4
0-6"	M1.6-M3.5	0.141"	19/11-4036			
8, 5/32"	M4	0.168"	19/11-4041			
10, 3/16"	M4.5, M5	0.194"	19/11-4048			
12, 7/32"		0.220"	19/11-4054			
1/4"	M6, M6.3	0.255"	19/11-4063			
5/16"	M7, M8	0.318"	19/11-4079	31/12-4079		
3/8"	M10	0.381"	19/11-4095	31/12-4095		
7/16"	M11	0.323"	19/11-4111	31/12-4111		
1/2"	M12, M12.5	0.367"	19/11-4127	31/12-4127	48/13-4127	
9/16"	M14	0.429"	19/11-4142	31/12-4142	48/13-4142	
5/8"	M16	0.480"		31/12-4158	48/13-4158	
11/16"	M18	0.542"		31/12-4174	48/13-4174	
3/4"		0.590"		31/12-4190C	48/13-4190	
13/16"	M20	0.652"		31/12-4206C	48/13-4206	
7/8"	M22	0.697"		31/12-4222C	48/13-4222	
15/16"	M24	0.760"			48/13-4238	
1"	M25	0.800"			48/13-4254	
1 1/8, 1 1/16"	M27	0.896"			48/13-4286	
1 1/4, 1 3/16"	M30	1.021"			48/13-4317	
1 3/8, 1 5/16"	M33	1.108"			48/13-4349	
1 1/2, 1 7/16"	M36	1.233"				60/14-4381C
1 5/8"	M39	1.305"				60/14-4412C
1 3/4"	M42	1.430"				60/14-4444C
1 7/8"		1.520"				60/14-4476C
1/8" NPT		0.437"	19/11-4097			
1/4" NPT		0.562"		31/12-4131C		
3/8" NPT		0.700"		31/12-4166C	48/13-4166C	
1/2" NPT				31/12-4209C	48/13-4209C	
3/4" NPT					48/13-4264C	
1" NPT					48/13-4332C	

Tools cut smoother, faster, & safer when you tighten collets, nuts, and retention knobs to correct specifications.

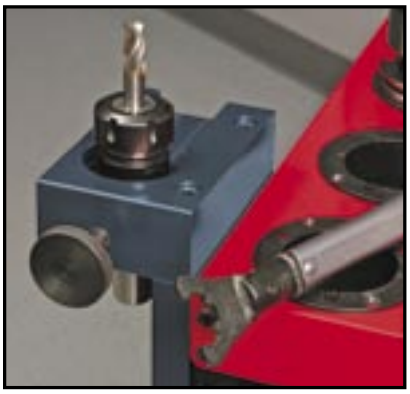
Recommended Collet & Retention Knob Tightening Torque

Collet	Nut Type	Collets I.D. OVER 1/16" (2mm)	Collets I.D. UNDER 1/16" (2mm)	Order Torque Wrench Adapter
ER 16	slotted	42 ft/lbs	30 ft/lbs	04580-16
ER 16	hex	42 ft/lbs	30 ft/lbs	04601-16
ER 20	slotted	59 ft/lbs	24 ft/lbs	04580-20
ER 20	hex	59 ft/lbs	24 ft/lbs	04602-20
ER 25	slotted	77 ft/lbs	77 ft/lbs	04503-25
ER 25	mini nut	25 ft/lbs	25 ft/lbs	04587
ER 32	slotted	100 ft/lbs	100 ft/lbs	04604-32
ER 40	slotted	130 ft/lbs	130 ft/lbs	04605-40
SYOZ 25	hook	90 ft/lbs	90 ft/lbs	03690-25
TG 75	hook	90 ft/lbs	90 ft/lbs	04018-TWA
TG 100	hook	90 ft/lbs	90 ft/lbs	03690-25

DIRECTIONS

1. Snap collet into nut.
2. Insert cutter into collet. Collets without counter bore require shank to extend to the bottom of the collet.
3. Hand tighten collet nut assembly into tool holder.
4. Insert tool holder assembly into tightening fixture and secure it.
5. Tighten collet nut to recommended torque using a torque wrench and adapter.

Retention Knobs	Wrench Flats	Drive	Torque	Order Socket
BT 30 Taper	0.535"	1/4"	36 ft/lbs	PSS-30BT
ISO 30 Taper	0.535"	3/8"	36 ft/lbs	PSS-30ISO
Any 40 Taper	0.750"	3/8"	76 ft/lbs	PSS-40
BT 50 Taper	1.187"	1/2"	99 ft/lbs	PSS-50
CAT 50 Taper	1.250"	1/2"	99 ft/lbs	PSSC-50



Use a tightening fixture and torque wrench to make sure tools are properly tightened. Incorrect torque can cause cracked collets, poor cutting performance, and possibly cause tools to come loose during operation, causing a very dangerous work environment.