

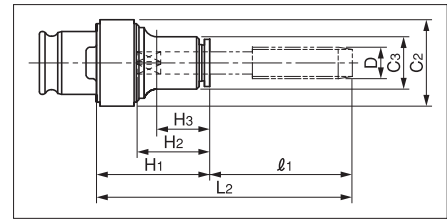
MODEL TC

◎SA 시리즈 탭퍼(RA/SA-III/SA-II/SA-VI)에 공통의TC 콜렛

- 탭의 신속한 교환 ● 4종류의 길이 선택 가능(32~168 mm)
- ※ 초경 탭은 파지력이 저하해 빠지기 쉬워집니다.
- 토크 리미터 장착으로 탭 파손을 방지 ● 탭 각부의 회전력에 의한 토크 변속
- 탭의 신속한 교환으로 원활한 툴 포지셔닝
- 탭 사이즈별로 적정 토크를 설정하여 작업시간 단축
- 토크 리미터는 볼 클러치 메커니즘을 채용, 작동은 매끄럽고 안전성과 내구성을 확보
- 선택할 수 있는 4종류의 설정 토크 사양(표준, 옐로우, 레드, 롤)
- 오버 사이즈 콜렛(P02 참조)에는 “레드” 또는 “롤”의 설정 토크 사양은 없습니다.

◎TC collets can be combined with SA-series tappers (RA/SA-III/SA-II/SA-VI)

- Quick-change of taps
- Available in 4 different lengths (32~168 mm)
- ※ Cemented carbide taps decrease clamping force and tend to pull out of the tap collet.
- A torque limiter is equipped to avoid tap breakage
- Reliable torque transmission by driving the square portion of the tap
- Stable tool positioning on quick changing of taps
- Suitable torques have already been set for each tap size in order to save time.
- The torque limiter adopts a ball clutch mechanism for smooth operation and maintains safety as well as high durability.
- Your choice of 4 setup torques (Standard, Yellow, Red and Roll)
- Oversized collets (cf. P02) do not include “Red” or “Roll” setup torque.



nominal name	Optional setup torques of torque limiter			
	Standard	Yellow	Red	Roll
use	general cutting	light cutting	heavy cutting	thread forming
printed mark	(Blank)	YELLOW	RED	ROLL
work materials	carbon steels (SC) Cr-Mo steel (SCM) ductile cast iron (FCD) gray cast iron (FC) etc.	aluminum alloy die castings brass castings plastics etc.	stainless steels (SUS) tool steels etc.	carbon steels (SC) Cr-Mo steel (SCM) aluminum alloy die castings etc.
setup torque	about twice as much as cutting torque of 0.45% carbon steels	about 20% lower than standard torque	about 30% higher than standard torque	about 60% higher than standard torque

model	tap size D		pipe thread	H1	H3	C2	C3	weight (kg)
	metric thread	unified thread						
TC 206	M 2 ~ M 8	U No.2 ~ U 5/16		32.0	20.0	21	15	0.07
	M 3 ~ M 12	U No.5 ~ U 1/2	P 1/8	43.5	20.5	33	20	0.19
TC 412	M 14 ~ M 16	U 9/16 ~ U 5/8	P 1/4 ~ P 3/8	49.5	33.0	33	27	0.23
	M 8 ~ M 22	U 3/8 ~ U 7/8		65.0	38.0	50	32	0.61
TC 1022	M 24 ~ M 27	U 1		68.0	42.5	50	36	0.65
			P 1/8	59.0	20.5	50	20	0.52
			P 1/4 ~ P 3/8	59.0	25.5	50	27	0.56
			P 1/2 ~ P 5/8	62.0	38.5	50	36	0.63
TC 2035	M 18 ~ M 36	U 3/4 ~ U 13/8		85.0	50.0	70	46	1.72
			P 3/8 ~ P 1	71.0	36.0	70	46	1.66
	M 27 ~ M 28	U 1 ~ U 1 1/8		85.0	47.0	87	64	3.42
	M 30 ~ M 52	U 1 1/4 ~ U 2		100.0	62.0	87	64	3.50
TC 3050	M 56	U 2 1/4		105.0	69.5	87	68	3.57
			P 3/4 ~ P 1 3/4	85.0	47.0	87	64	3.59
	M 50 ~ M 90	U 2 ~ U 3 1/2		130.0	81.0	116	86	7.99
	M 100	U 4		130.0	84.5	116	90	7.64
TC 206 L+30	M 2 ~ M 8	U No.2 ~ U 5/16	P 1 5/8 ~ P 3	113.0	64.0	116	86	7.64
	M 2 ~ M 8	U No.2 ~ U 5/16		62.0	50.0	21	15	0.08
	M 2 ~ M 8	U No.2 ~ U 5/16		92.0	80.0	21	15	0.11
	M 3 ~ M 8	U No.5 ~ U 5/16		103.5	75.0	33	16	0.24
TC 412 L+60	M 10 ~ M 12	U 3/8 ~ U 1/2	P 1/8	103.5	80.0	33	20	0.26
	M 14 ~ M 16	U 9/16 ~ U 5/8		109.5	93.0	33	27	0.40
			P 1/4 ~ P 3/8	109.5	93.0	33	27	0.40
				143.5	115.0	33	16	0.26
TC 412 L+100	M 10 ~ M 12	U 3/8 ~ U 1/2	P 1/8	143.5	120.0	33	20	0.31
	M 14 ~ M 16	U 9/16 ~ U 5/8		149.5	133.0	33	27	0.53
			P 1/4 ~ P 3/8	149.5	133.0	33	27	0.53
				125.0	86.5	50	20	0.70
TC 1022 L+60	M 14 ~ M 16	U 9/16 ~ U 5/8		125.0	91.5	50	27	0.80
	M 18 ~ M 22	U 3/4 ~ U 7/8		125.0	98.0	50	32	0.85
	M 24 ~ M 27	U 1		128.0	104.5	50	36	0.90
			P 1/8	119.0	80.5	50	20	0.62
			P 1/4 ~ P 3/8	119.0	85.5	50	27	0.76
			P 1/2 ~ P 5/8	122.0	98.5	50	36	0.86
TC 1022 L+100			P 3/4	125.0	102.0	50	40	1.06
	M 8 ~ M 12	U 3/8 ~ U 1/2		165.0	126.5	50	20	0.85
	M 14 ~ M 16	U 9/16 ~ U 5/8		165.0	131.5	50	27	0.90
	M 18 ~ M 22	U 3/4 ~ U 7/8		165.0	138.5	50	32	1.00
	M 24 ~ M 27	U 1		168.0	144.5	50	36	1.05
			P 1/8	159.0	120.5	50	20	0.66
TC 2035 L+60			P 1/4 ~ P 3/8	159.0	125.5	50	27	0.86
			P 1/2 ~ P 5/8	162.0	138.5	50	36	1.03
			P 3/4	165.0	142.0	50	40	1.28
	M 18 ~ M 22	U 3/4 ~ U 7/8		145.0	97.0	70	32	1.45
TC 2035 L+60	M 24 ~ M 27	U 1		145.0	101.5	70	36	1.65
	M 28 ~ M 36	U 1 1/8 ~ U 1 3/8		145.0	110.0	70	46	1.90
			P 3/8 ~ P 1	131.0	96.0	70	46	2.30



※TC2035 이상의 관용나사용 콜렛은 고정나사방식이 사용됩니다.
 ※TC collets for pipe thread (≧TC2035) are used in the setscrew manner.