

Unlimited Possibilities...

For an entirely new perspective on tapping



Tapmatic Australian Stock List
Specialising in tapping for over 50 years, TAPMATIC produces the world's most complete state of the art program for the fastest, most accurate and cost efficient tapping on every machine and every application.

TAPMATIC
TAPPING HOLDERS

suttontools
world class cutting tools

Tool Holding Machine Reversal Attachments

suttontools

CNC Rigid Tapping - Synchroflex

- For the best rigid tapping results
- Holder designed for machines with rigid tapping
- Machine reversal required
- Increases tap life by 100% or more
- Improve thread quality
- Flexure design, acts like shock absorber

CNC Without Rigid Tapping - NSM

- Tension/compression tapping units for NC machining and turning centres
- Uses rubber-flex collets (only two required)
- ER Collect Chuck available on special request
- Provides greater thread accuracy and higher production rates
- Compact Design, for application where space is limited
- Releasable Hard Start, for accurate depth control

Size Ref.	Description	Size Capacity	Mount	Collet Series	Ref Code	Discount Group	Item #
FOR CNC RIGID TAPPING							
Tapping Attachments							Z100
SFT10	Synchroflex SFT10	M1-M6 #2-#10	25mm SS	ER11	43102511	Z1104	Z100 SFT10
SFT50	Synchroflex SFT50	M4-M12 #8-1/2	25mm SS	ER20	43502520	Z1104	Z100 SFT50
SFT75	Synchroflex SFT75	M4-M16 3/8 - 3/4	25mm SS	ER25	43752525	Z1104	Z100 SFT75
Collets - SFT10 (Round Drive)							Z110
0025	2-2.5mm	M1-1.8	-	ER11		Z1110	Z110 0025
0030	2.5-3mm	M2-2.6	-	ER11		Z1110	Z110 0030
0035	3-3.5mm	M3	-	ER11		Z1110	Z110 0035
0040	3.5-4mm	M3.5	-	ER11		Z1110	Z110 0040
0045	4-4.5mm	M4	-	ER11		Z1110	Z110 0045
0050	4.5-5mm	M4 JIS	-	ER11		Z1110	Z110 0050
0055	5-5.5mm	M5 JIS	-	ER11		Z1110	Z110 0055
0060	5.5-6mm	M5/M6 or M2-M6 Synchro	-	ER11		Z1110	Z110 0060
Collets - SFT50 (Square Drive)							Z111
0045	Ø 4.5mm	M4 DIN371	-	ER20		Z1110	Z111 0045
0050	Ø 5mm	ISO	-	ER20		Z1110	Z111 0050
0060	Ø 6mm	M5/M6 DIN371 or M2-M6 Synchro	-	ER20		Z1110	Z111 0060
0070	Ø 7mm	M10 DIN376	-	ER20		Z1110	Z111 0070
0080	Ø 8mm	M8 DIN371 or M8 Synchro	-	ER20		Z1110	Z111 0080
0090	Ø 9mm	M12 DIN376	-	ER20		Z1110	Z111 0090
0100	Ø 10mm	M10 DIN371 or M10 Synchro	-	ER20		Z1110	Z111 0100
Collets - SFT75 (Square Drive)							Z112
0045	Ø 4.5mm	M4 DIN371	-	ER25		Z1110	Z112 0045
0060	Ø 6mm	M5/M6 DIN371 or M2-M6 Synchro	-	ER25		Z1110	Z112 0060
0070	Ø 7mm	M10 DIN371	-	ER25		Z1110	Z112 0070
0080	Ø 8mm	M8 DIN371 or M8 Synchro	-	ER25		Z1110	Z112 0080
0090	Ø 9mm	M12 DIN376	-	ER25		Z1110	Z112 0090
0100	Ø 10mm	M10 DIN371 or M10 Synchro	-	ER25		Z1110	Z112 0100
0110	Ø 11mm	M14 DIN376	-	ER25		Z1110	Z112 0110
0120	Ø 12mm	M16 DIN376 or M12 Synchro	-	ER25		Z1110	Z112 0120
Accessories							Z130
3943	BT-40 Arbor W/25mm Bore	-	-	-	23943	Z1108	Z130 3943
3945	BT-50 Arbor W/25mm Bore	-	-	-	23945	Z1108	Z130 3945
BT40	Pull stud BT40	-	-	-		Z1108	Z135 BT40
BT50	Pull stud BT50	-	-	-		Z1108	Z135 BT50
FOR CNC WITHOUT RIGID TAPPING							
Tapping Attachments							Z102
NSM6	Tension & Compression Holder NSM6	M5-M18 #10-3/4	25mm SS	Rubberflex	35887	Z1104	Z102 NSM6
Collets - NSM6							Z117
0443	Rubberflex	3-7mm	-	J443	24300	Z1108	Z117 0443
0440	Rubberflex	5-12mm	-	J440	24100	Z1108	Z117 0440
0441	Rubberflex	8-16mm	-	J441	24000	Z1108	Z117 0441
0445	Rubberflex	10-14mm	-	J445	24500	Z1108	Z117 0445
Accessories							Z130
3943	BT-40 Arbor W/25mm Bore	-	-	-	23943	Z1108	Z130 3943
3945	BT-50 Arbor W/25mm Bore	-	-	-	23945	Z1108	Z130 3945
Accessories							Z135
BT40	Pull stud BT40	-	-	-		Z1108	Z135 BT40
BT50	Pull stud BT50	-	-	-		Z1108	Z135 BT50



ER25 Collet (Sq. Drive)



BT-40 Arbor



Rubberflex Collet



Other machine interfaces & accessories to all your tapping needs are also available, for more information please contact our special sales dept on 1800 035 010

www.sutton.com.au

Tool Holding Self Reversing Attachments



CNC High Production - RDT

- Self-Reversing Holder for CNC machines
- Machine reversal NOT required, less wear and tear on machine spindle
- Designed for applications, where high volume of threads are required
- Constant speed tapping
- Bore cycle (G85) used in CNC program, instead of Tapping cycle (G84)

NOTE: 2 different size stop arms available for RDT50, must check for machine centre distance, & order best suited.

Manual Machines - Rx

- For manually operated drilling and milling machines
- 1.75 x 1 increased reverse speed
- New durable, rugged design
- Self-feed ensures gauge perfect threads
- New heavy duty ball clutch
- Re-entry cushion eliminates cross threading
- Pre-selective torque drive prevents tap breakage

Size Ref.	Description	Size Capacity	Mount	Collet Series	Ref Code	Discount Group	Item #
FOR CNC HIGH PRODUCTION							
Tapping Attachments							
							Z103
RDT25	Self Reversing RDT25	M2.5-M6 #4-1/4	25mm SS	ER11	39252511	Z1102	Z103 RDT25
RDT50	Self Reversing RDT50	M4-M12 #10-1/2	25mm SS	ER16	39502516	Z1102	Z103 RDT50
							Z110
Collets - RDT25 (Round Drive)							
0025	2-2.5mm	M1-1.8	-	ER11		Z1110	Z110 0025
0030	2.5-3mm	M2-2.6	-	ER11		Z1110	Z110 0030
0035	3-3.5mm	M3	-	ER11		Z1110	Z110 0035
0040	3.5-4mm	M3.5	-	ER11		Z1110	Z110 0040
0045	4-4.5mm	M4	-	ER11		Z1110	Z110 0045
0050	4.5-5mm	M4 JIS	-	ER11		Z1110	Z110 0050
0055	5-5.5mm	M5 JIS	-	ER11		Z1110	Z110 0055
0060	5.5-6mm	M5/M6	-	ER11		Z1110	Z110 0060
							Z114
Collets - RDT50 (Square Drive)							
0045	Ø 4.5mm	M4 DIN371	-	ER16		Z1110	Z114 0045
0050	Ø 5mm	ISO	-	ER16		Z1110	Z114 0050
0060	Ø 6mm	M5/M6 DIN371	-	ER16		Z1110	Z114 0060
0070	Ø 7mm	M10 DIN376	-	ER16		Z1110	Z114 0070
							Z130
Accessories							
3943	BT-40 Arbor W/25mm Bore	-	-	-	23943	Z1108	Z130 3943
3945	BT-50 Arbor W/25mm Bore	-	-	-	23945	Z1108	Z130 3945
							Z135
BT40	Pull stud BT40	-	-	-		Z1108	Z135 BT40
BT50	Pull stud BT50	-	-	-		Z1108	Z135 BT50
							Z132
2565	65mm Stop Arm RDT25	-	-	ER11	392565	Z1102	Z132 2565
							Z133
5065	65mm Stop Arm RDT50	-	-	ER16	395065	Z1102	Z133 5065
5080	80mm Stop Arm RDT50	-	-	ER16	395080	Z1102	Z133 5080
TOOL HOLDING MANUAL MACHINES							
Tapping Attachments (Discount Group Z1106)							
							Z104
RX30	Self Reversing Rx30	M1.4-M6 #0-1/4	25mm SS	W#6 JT	013006	Z1106	Z104 RX30
RX50	Self Reversing Rx50	M3-M12 #6-1/2	25mm SS	W#6 JT	015006	Z1106	Z104 RX50
RX70	Self Reversing Rx70	M5-M18 #10-3/4	25mm SS	W#3 JT	017003	Z1106	Z104 RX70
							Z115
Collets - Rx30 (Discount Group Z1108)							
0116	Rubberflex	3-5mm	-	J116	21600	Z1108	Z115 0116
0117	Rubberflex	5-6.5mm	-	J117	21700	Z1108	Z115 0117
							Z116
Collets - Rx50							
0421	Rubberflex	3.5-6.5mm	-	J421	22100	Z1108	Z116 0421
0420	Rubberflex	5-8mm	-	J420	22000	Z1108	Z116 0420
							Z117
Collets - Rx70							
0443	Rubberflex	3-7mm	-	J443	24300	Z1108	Z117 0443
0440	Rubberflex	5-12mm	-	J440	24100	Z1108	Z117 0440
0441	Rubberflex	8-16mm	-	J441	24000	Z1108	Z117 0441
0445	Rubberflex	10-14mm	-	J445	24500	Z1108	Z117 0445
							Z131
Accessories (Discount Group Z1108)							
0203	#2MT X Arbor			#3 JT	20203	Z1108	Z131 0203
0206	#2MT X Arbor			#6 JT	20206	Z1108	Z131 0206
0303	#3MT X Arbor			#3 JT	20303	Z1108	Z131 0303
0306	#3MT X Arbor			#6 JT	20306	Z1108	Z131 0306
0403	#4MT X Arbor			#3 JT	20403	Z1108	Z131 0403
							Z134
0099	Quill Clamp	1-1/2 to 2-3/8	-	-	29099	Z1108	Z134 0099
0991	Quill Clamp	2-3/8 to 4-1/2	-	-	290991	Z1108	Z134 0991



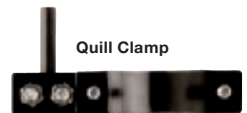
ER25 Collet (Sq. Drive)



BT-40 Arbor



Quill Clamp



#3 JT Arbor



Rubberflex Collet

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Tapmatic SynchroFlex with unique Double Flexure

Unlike other “synchronous” tap drivers that use soft plastic components or Belleville washers similar as above, to cushion the taps’ entry into the hole, Tapmatic SynchroFlex utilizes a patented (computer generated, precisely machined, special steel alloy) Double Flexure between the mount and the chuck.

It compensates both axially and radially for the unavoidable discrepancies between the machine’s programmed RPM, feed and traverse and the exact thread pitch and precise hole location.

The Tapmatic SynchroFlex is dependable and predictable. You can expect long life performance under all working conditions. What’s more, you’ll make significant savings when it comes to tap costs.

The Tapmatic SynchroFlex is available now from Sutton Tools. We also stock other models in the Tapmatic range, for both manual and automated tapping applications.

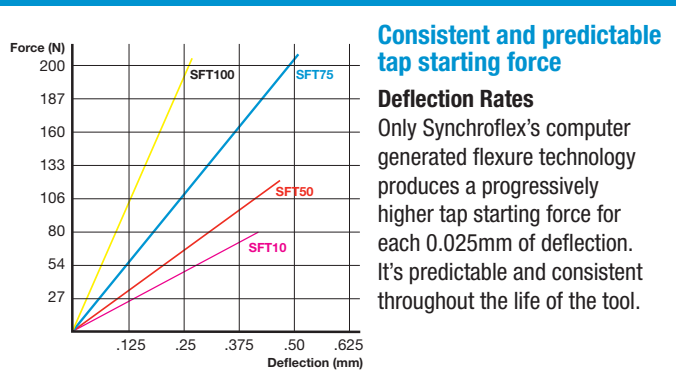


Synchroflex Proven Results

Independent tests in real world applications confirm Synchroflex is unmatched in performance

- Tap life increased by 100% or more
- Thread quality improved
- Increased production due to less tap breakage
- Less down time
- Reduced costs. The most economical rigid tapping

Synchroflex exerts lower thrust and torque forces than any other tap holder on the market. In any given material the lower the thrust and torque forces on the tap, the longer the tap life.

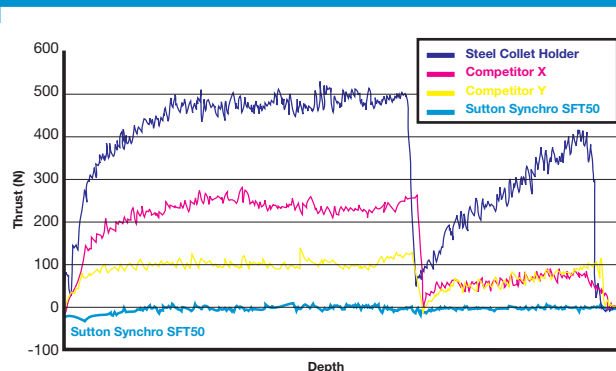


Test One (Thrust): 10 holes, M6 R45AI, 2 flute tap, 3x Dia deep in AL7075 at 1000 RPM

Holder Type	Average Thrust (N)	Average Down Cut Thrust (N) Entering Hole	Average Reverse Thrust (N) Exiting Hole
Steel Collet Holder (Rigid)	1008	1379	930
Competitor X	681	879	445
Competitor Y	320	425	266
Tapmatic Synchroflex	-12	-29	-31

Test Two (Torque): 10 holes, M6 R45AI, 2 flute tap, 3x Dia deep in AL7075 at 2000 RPM

Holder Type	Average Torque (Ncm)	Average Down Cut Torque (Ncm) Entering Hole	Average Reverse Torque (Ncm) Exiting Hole
Steel Collet Holder (Rigid)	481	631	-387
Competitor X	593	639	-354
Competitor Y	542	730	-392
Tapmatic Synchroflex	268	371	-190



Graph illustrates the final hole tapped by each tap driver.

