

M3 - M30

TAPPER **AUTO TAPPER SERIES**

DUAL CONTACT
BBT/BT
SHANK

AUTO TAPPER B

Simple and compact tapper with automatic depth control.

- Reduces variation of tap depth to $\pm 0.15\text{mm}$, making it ideal for pipe tapping and blind hole tapping.
- Best-selling auto tapper series with a simple structure and affordable prices.

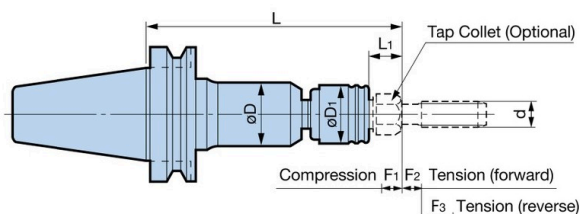

Automatic
depth control

A
TAPPER


● Model Description

BBT30 - **AUTO-B** **80** - **125**

- L dimension
- Tapping range
- AUTO TAPPER B
- BIG-PLUS BT No.



BIG-PLUS (BBT Shank) tools can be used on both BIG-PLUS spindles and conventional **BT** spindles.

BIG-PLUS BBT SHANK Model	Tapping range d	øD	øD ₁	L	L ₁	F ₁	F ₂	F ₃	Tap Collet	Weight (kg)
BBT30-AUTO-B 80-125	M 3 - M 8	30	25.5	125	17	5	5	10.5	TC 8-□	0.70
-AUTO-B120-150	M 3 - M12	35	32	150	30	6	6	12.5	TC12-□	0.86
BBT40-AUTO-B 80-130	M 3 - M 8	30	25.5	130	17	5	5	10.5	TC 8-□	1.4
-AUTO-B120-155	M 3 - M12	35	32	155	30	6	6	12.5	TC12-□	1.6
-AUTO-B200-185	M 7 - M20	48	44	185	25	6.5	6.5	13	TC20-□	2.3
-AUTO-B300-220	M20 - M30	58	55	220	38	7.5	7.5	14.5	TC30-□	3.2
BBT50-AUTO-B 80-140	M 3 - M 8	30	25.5	140	17	5	5	10.5	TC 8-□	4.2
-AUTO-B120-165	M 3 - M12	35	32	165	30	6	6	12.5	TC12-□	4.4
-AUTO-B200-195	M 7 - M20	48	44	195	25	6.5	6.5	13	TC20-□	5.1
-AUTO-B300-220	M20 - M30	58	55	220	38	7.5	7.5	14.5	TC30-□	6.0

1. Tap Collet is not included. TC Tap Collet is ordered separately.
2. Cannot be used in left-hand thread tapping.
3. Be sure to include the approach amount (distance between the tap tip and workpiece) when programming the starting point of tapping.
4. F₂ in the table is the tension amount until it reaches neutral. Be sure to perform test tapping when accurate tapping depth is required, as it may fluctuate slightly depending on the tap size and cutting conditions.

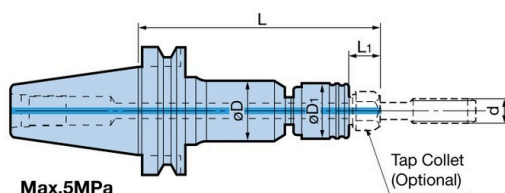
Tap Collets **A144**

[Center Through Type]

Automatic
depth control

Center through

Not BIG-PLUS (DUAL CONTACT) specification



BT SHANK Model	Tapping range d	øD	øD ₁	L	L ₁	Weight (kg)	Tap Collet
BT40-TTB120-155	M 3 - M12	35	32	155	30	1.6	TC12
-TTB200-185	M 7 - M20	48	44	185	25	2.3	TC20
-TTB300-220	M20 - M30	58	55	220	38	3.2	TC30
BT50-TTB120-165	M 3 - M12	35	32	165	30	4.4	TC12
-TTB200-195	M 7 - M20	48	44	195	25	5.1	TC20
-TTB300-220	M20 - M30	58	55	220	38	6.0	TC30

1. Tap Collet is not included.
2. Cannot be used in left-hand thread tapping.
3. When using the depth control, be sure to include the approach amount for programming.
4. Compression is 3mm for all models.
5. The tension is the same as for AUTO TAPPER B.
6. Please contact us if higher pressure coolant than 5MPa is required.

Oil Hole Tap Collets **A145**

Tap Collets **A144**
BIG **A142**

DUAL CONTACT
BBT/BT
SHANK

TAPPER

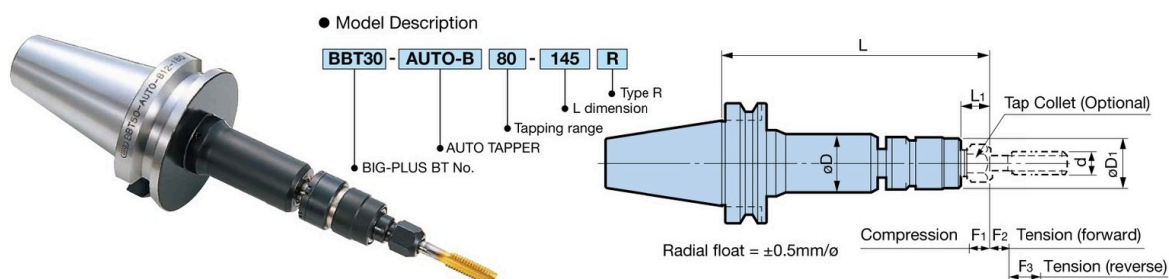
AUTO TAPPER SERIES

M3 - M20

A
TAPPER**AUTO TAPPER R**

Tapper with built-in radial float mechanism that absorbs misalignment with starting holes.

- Ideal for die-cast workpieces or those with separately processed starting holes.
- The radial float amount of $\pm 0.5\text{mm}$ not only prevents the tap from breaking due to misalignment, but also improves the thread accuracy.

Radial float
Automatic
depth controlBIG-PLUS (BBT Shank) tools can be used on both BIG-PLUS spindles and conventional **BT spindles**.

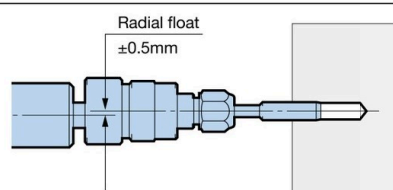
BIG-PLUS BBT SHANK Model	Tapping range d	φD	φD ₁	L	L ₁	F ₁	F ₂	F ₃	Tap Collet	Weight (kg)
BBT30-AUTO-B 80-145R	M3 - M 8	30	25.5	145	17	5	5	10.5	TC 8-□	0.8
-B120-170R	M3 - M12	35	32	170	30	6	6	12.5	TC12-□	1.0
BBT40-AUTO-B 80-150R	M3 - M 8	30	25.5	150	17	5	5	10.5	TC 8-□	1.5
-B120-175R	M3 - M12	35	32	175	30	6	6	12.5	TC12-□	1.8
-B200-205R	M7 - M20	48	44	205	25	6.5	6.5	13	TC20-□	2.5
BBT50-AUTO-B120-185R	M3 - M12	35	32	185	30	6	6	12.5	TC12-□	4.6
-B200-215R	M7 - M20	48	44	215	25	6.5	6.5	13	TC20-□	5.3

1. Tap Collet is not included.
2. Cannot be used in left-hand thread tapping.
3. When using the depth control, be sure to include the following approach amount for programming.

Tapper type	Approach amount
B 80-R	12mm
B120-R	13mm
B200-R	14mm

4. F₂ in the table is the tension amount until it reaches neutral.Tap Collets **A144****Secure radial float function**

The smooth radial float absorbs the misalignment when processing aluminum die-cast workpieces with existing starting holes or workpieces with separately processed starting holes, enabling stable tapping.

A143 **BIG**

TAPPER

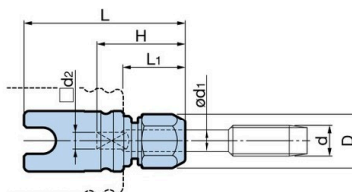
AUTO TAPPER SERIES

DUAL CONTACT
BBT/BT
SHANK

■ TAP COLLET TC (for Auto Tapper B / R Type and Synchronized Tap Holder STC Type)



- Model Description
- TC 8 - M2**
- Tap size
 - Body size
 - Tap Collet



● TC Mate
Convenient for
attaching and
removing Tap Collets

TC Mate **H4**



TAPPER

Model	Tapping range d			ød ₁	□d ₂	H	L	L ₁	D	Weight (kg)	Tapper					
	Metric	Unify	Pipe													
TC 8-M 2	M2 - M2,6	No.3,No.4	—	3	2.5	21	40.5	17	16	0.05	STC8					
-M 3	M 3	No.5,No.6		4	3.2	23										
-M 4	M 4	No.8		5	4	27			19		AUTO-B80 AUTO-B80-R STC8 ATB8					
-M 5	M 5	No.10,No.12		5.5	4.5	29										
-M 6 U1/4	M 6	U1/4		6		30										
-U5/16	—	U5/16		6.1												
-M 8	M 7,M 8	—		6.2												
TC12-M 3	M 3	No.5,No.6	—	4	3.2	24	55	30	22	0.1	AUTO-B120 AUTO-B120-F TTB120 STC12 ATB12 ATS12R					
-M 4	M 4	No.8		5	4	29										
-M 5	M 5	No.10,No.12		5.5	4.5											
-M 6 U1/4	M 6	U1/4		6		30										
-U5/16	—	U5/16		6.1												
-M 8	M 7,M 8	—		6.2												
-M10 U3/8	M 9,M10	U3/8		7	5.5	31										
-U7/16 P1/8	—	U7/16	P1/8	8	6											
-M12	M12	—	—	8.5	6.5											
-U1/2	—	U1/2	—	9	7	32	63	25	22	0.2	AUTO-B200 AUTO-B200-F TTB200 STC20 ATB20 ATS20R					
TC20-M 8	M 7,M 8	—	—	6.2	5	33										
-M10 U3/8	M 9,M10	U3/8	—	7	5.5											
-U7/16 P1/8	—	U7/16	P1/8	8	6											
-M12	M12	—	—	8.5	6.5	34			31							
-U1/2	—	U1/2	—	9	7	35										
-M14 U9/16	M14	U9/16	—	10.5	8	36										
-P1/4	—	—	P1/4	11	9	31										
-U5/8	—	U5/8	—	12		37										
-M16	M16	—	—	12.5	10	38										
-M18 U3/4	M18	U3/4	—	14	11	39										
-P3/8	—	—	P3/8	14	11	34										
-M20	M20	—	—	15	12	40										
TC30-M20	M20	—	—	15	12	40						83	38	41	0.5	AUTO-B300 TTB300 STC30
-M22 U7/8	M22	U7/8	—	17	13	41										
-P1/2	—	—	P1/2	18	14	42										
-M24 P5/8	M24	—	P5/8	19	15	43										
-M27 U1	M27	U1	—	20												
-U1 1/8	—	U1 1/8	—	22	17	45										
-M30 P3/4	M30	—	P3/4	23												
-P1	—	—	P1	26			21									

Model symbol description

M = Metric Thread
U = Unify Thread
P = Pipe Thread

BIG A144

DUAL CONTACT
BBT/BT
SHANK

TAPPER

AUTO TAPPER SERIES

A

TAPPER

■ OIL HOLE TAP COLLET TC (For Center Through AUTO TAPPER B Type,
SYNCHRONIZED TAP HOLDER STC Type)

- Oil Hole Tap Collet that can feed coolant without waste.



● Model Description

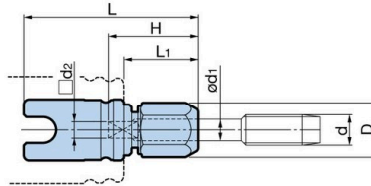
TC 8 - O M6

● Tap size

● Through Tool

● Body size

● Tap Collet



● TC Mate
Convenient for
attaching and
removing Tap Collets

TC Mate H4



Model	Tapping range d			ød ₁	□d ₂	H	L	L ₁	D	Weight (kg)	Tapper
	Metric	Unify	Pipe								
TC 8-OM 6 OU1/4	M 6	U1/4	—	6	4.5	34	45.5	22	19	0.05	STC8
-OM 8	M 7,M 8	—		6.2	5	35					
TC12-OM 6 OU1/4	M 6	U1/4	—	6	4.5	34	60	35	22	0.1	TTB120 STC12
-OM 8	M 7,M 8	—		6.2	5	35					
-OM10 OU3/8	M 9,M10	U3/8	7	5.5	36						
-OU7/16 OP1/8	—	U7/16	P1/8	8		6					
-OM12	M12	—	—	8.5	6.5						
-OU1/2	—	U1/2		9	7	37					
TC20-OM 8	M 7,M 8	—	—	6.2	5	38	68	30	22	0.2	TTB200 STC20
-OM10 OU3/8	M 9,M10	U3/8		7	5.5						
-OU7/16 OP1/8	—	U7/16	P1/8	8	6	39					
-OM12	M12	—	—	8.5	6.5						
-OU1/2	—	U1/2		9	7	40					
-OM14 OU9/16	M14	U9/16	P1/4	10.5	8	41					
-OP1/4	—	—		11	9	36					
-OU5/8		U5/8	12	42							
-OM16	M16	—	—	12.5	10	43					
-OM18 OU3/4	M18	U3/4		14	11	44					
-OP3/8	—	—	P3/8	—	—	39					
-OM20	M20	—	—	15	12	45					
TC30-OM20	M20	—	—	15	12	45	88	42	41	0.5	TTB300 STC30
-OM22 OU7/8	M22	U7/8		17	13	46					
-OP1/2	—	—	P1/2	18	14	47					
-OM24	M24		—	19	15	48					
-OM27 OU1	M27	U1		20		17					
-OU1 1/8	—	U1 1/8	22								
-OM30 OP3/4	M30	—	P3/4	23							

Model symbol description

M = Metric Thread

U = Unify Thread

P = Pipe Thread

AUTO TAPPER SERIES

TAPPER

DUAL CONTACT

BBT/BT
SHANK

AUTO TAPPER E M3 - M36

Smoother axial float function and built-in torque limiter.

- Ideal for machining center tapping cycles.

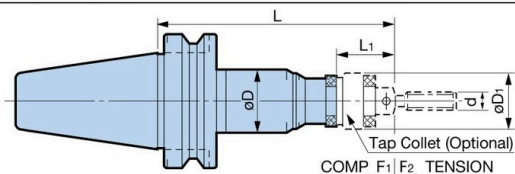


Model Description

BBT40 - AUTO-E 12 - 165
 L dimension
 Tapping range
 AUTO TAPPER E
 BIG-PLUS BT No.

Original one-way torque limiter

If the torque limiter is activated with the tap in reverse, tap breakage may occur, which is very dangerous. The **BIG** AUTO TAPPER series uses a unique one-way torque limiter that does not work while in reverse, allowing safe tapping.



BIG-PLUS (BBT Shank) tools can be used on both BIG-PLUS spindles and conventional BT spindles.

BIG-PLUS BBT SHANK Model	Tapping range d	øD	øD ₁	L	L ₁	F ₁	F ₂	Tap Collet	Weight (kg)
BBT40-AUTO-E12-165	M 3 - M12	46	38.5	165	40	15	20	TCE12-□	1.8
-AUTO-E24-195	M 9 - M24	64	58.5	195	55	15	20	TCE24-□	3.4
BBT50-AUTO-E12-165	M 3 - M12	46	38.5	165	40	15	20	TCE12-□	4.2
-195				195					4.8
-AUTO-E24-195	M 9 - M24	64	58.5	195	55	15	20	TCE24-□	5.7
-240				240					6.5
-AUTO-E36-255	M20 - M36	94	78.5	255	65	20	20	TCE36-□	11.0

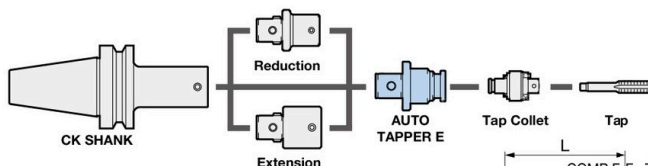
1. Tap collet must be ordered separately.
2. Torque limiter is built into the Tap Collet.
3. The torque limiter of the Tap Collet is set for high-carbon steel upon delivery.
4. As the reverse torque is set to 3x, it cannot be used for the left-hand thread.

Tap Collets **A147**



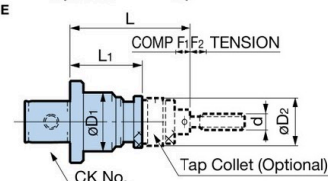
[CK AUTO TAPPER E] M3 - M24

- Combination with a long type CK Shank is convenient when long taper is required.



Model Description

CK6 - ATE 12
 Tapping range
 AUTO TAPPER E
 CK No.



Model	Tapping range d	CK No.	øD ₁	øD ₂	L	L ₁	F ₁	F ₂	Weight (kg)	Tap Collet
CK6-ATE12	M3 - M12	CK6	47	38.5	90	50	5	10	0.9	TCE12-□
CK6-ATE24	M9 - M24		64	58.5	135	80	7	15	1.8	TCE24-□

1. Tap collet must be ordered separately.
2. Torque limiter is built into the Tap Collet.
3. The torque limiter of the Tap Collet is set for high-carbon steel upon delivery.
4. As the reverse torque is set to 3x, it cannot be used for the left-hand thread.

Tap Collets **A147**

Shanks **A77**

BIG A146

DUAL CONTACT
BBT/BT
SHANK

TAPPER

AUTO TAPPER SERIES

A

TAPPER

■ TAP COLLET TCE (for Auto Tapper E)



Standard type

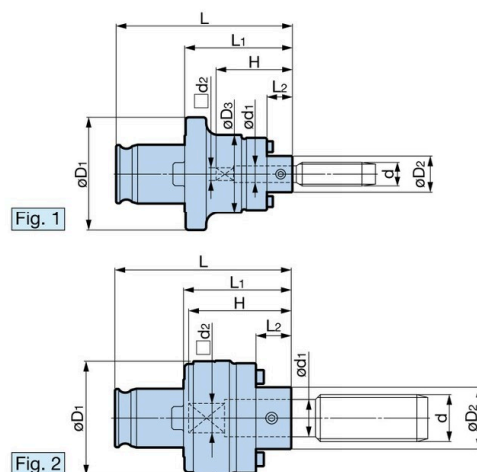
Long type
(L₂ is 50mm longer than
the standard type.)

● Model Description

TCE12 - M3

● Tap size

● Tap Collet model

※ Models with (L) are the long type. L₂ is 50mm longer than the standard type. Example: TCE12-M3L

Model	Fig.	Tapping range d			ød ₁	□d ₂	H	L		L ₁		L ₂		øD ₁	øD ₂	øD ₃	Weight (kg)		Tapper
		Metric	Unify	Pipe				Standard	Long	Standard	Long	Standard	Long				Standard	Long	
TCE12-M 3(L)	1	M 3	No.5, No.6	—	4	3.2	23	62	112	40	90	10	60	38	13	26	0.2	0.25	AUTO-E12 ATE12
-M 4(L)		M 4	No.8		5	4	29												
-M 5(L)		M 5	No.10, No.12		5.5	4.5	32												
-M 6 U1/4(L)		M 6	U1/4		6														
-U5/16	2	—	U5/16	P1/8	6.1	5	33	90	140	55	105	13	63	38.5	19	—	0.3	0.4	AUTO-E24 ATE24
-M 8(L)		M 7, M 8	—		6.2														
-M10 U3/8(L)		M 9, M10	U3/8		7	5.5	35												
-U7/16		—	U7/16		8	6	36												
-P1/8		—	—		8.5	6.5	36												
-M12(L)		M12	—		9	7	37												
-U1/2		—	U1/2		9	7	37												
TCE24-M10 U3/8(L)		M 9, M10	U3/8		7	5.5	38												
-U7/16	1	—	U7/16	P1/8	8	6	39	90	140	55	105	13	63	58	19	40	0.7	0.8	AUTO-E24 ATE24
-P1/8		—	—		8.5	6.5	39												
-M12(L)		M12	—		9	7	40												
-U1/2		—	U1/2		9	7	40												
-M14 U9/16(L)	2	M14	U9/16	P1/4	10.5	8	41	90	140	55	105	18	68	58.5	32	—	0.9	1.0	AUTO-E24 ATE24
-P1/4		—	—		11	9	31												
-U5/8		—	U5/8		12		42												
-M16(L)		M16	—		12.5	10	43												
-M18 U3/4(L)		M18	U3/4		14	11	44												
-P3/8		—	—		15	12	45												
-M20(L)		M20	—		17	13	51												
-M22 U7/8(L)		M22	U7/8		17	13	51												
-P1/2	1	—	—	P1/2	18	14	42	116	—	65	—	18	78	32	60	1.8	—	—	AUTO-E36
-M24(L)		M24	—		19	15	53												
TCE36-M20		M20	—		15	12	48												
-M22 U7/8		M22	U7/8		17	13	49												
-P1/2	2	—	—	P3/4	18	14	42	116	—	65	—	21	78.5	45	—	2.0	—	—	AUTO-E36
-M24		M24	—		19	15	51												
-M27 U1		M27	U1		20		58												
-U1 1/8		—	U1 1/8		22		60												
-M30		M30	—		23	17													
-P3/4		—	—		24		47												
-U1 1/4		—	U1 1/4		24	19	47												
-P7/8		—	—		25		62												
-M33	1	M33	—	P1	25		62	116	—	65	—	21	78.5	45	—	2.0	—	—	AUTO-E36
-U1 3/8		—	U1 3/8		26		69												
-P1		—	—		26		69												
-M36		M36	—		28		69												
-P1 1/8		—	—	P1 1/8	28		52												

A147 **BIG**