



# 'CCSFL' TAPPING ATTACHMENT (Non - Reversible)

**CC** : Collet Chuck  
**S** : Safety Clutch  
**F** : Float Radial Parallel  
**L** : Length Compensation

## APPLICATIONS:

For Tapping operations on reversible drilling & Tapping Machines & Turning Machines.

## FEATURES :

- Wide range of Collet head for clamping of the taps.
- Adjustable safety torque clutch for prevention of tap breakages.
- Radial Parallel float to compensate for misalignment between hole & Tap.
- Length compensation acting on compression & expansion which compensates machine feed & Tap pitch.

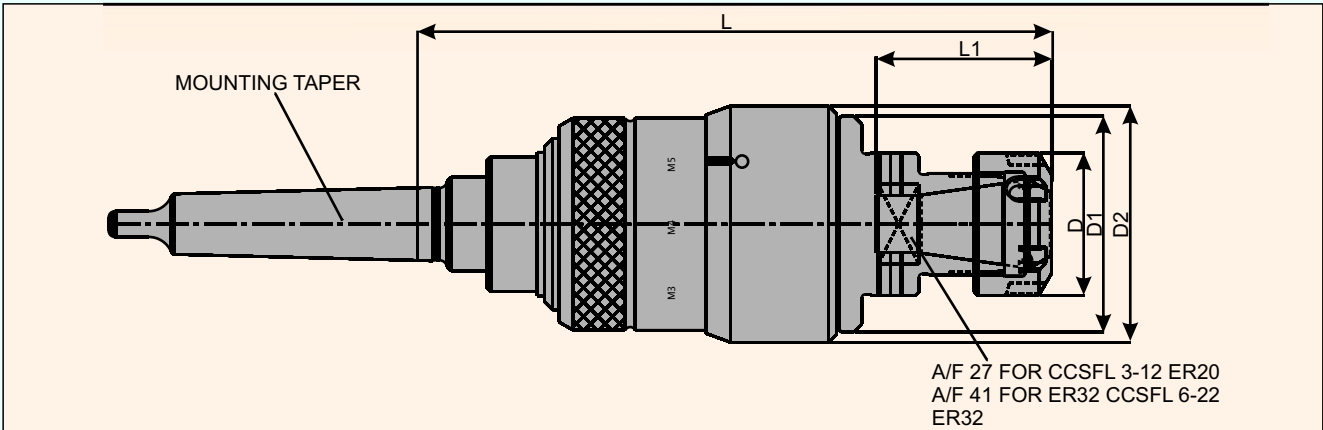


## **KTA Spindle Toolings**

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Chuck Designation Size / Location	For Taps	Suitable Collet	Length Comp.		Float	D dia.	D1 dia	D2 dia	L	L1	Approx. Weight Kg.
			Compr.	Expan.							
CCSFL 12 - MT 2	M 3 - M 12	ER20	10	20	1.0	35	50	58	150	43	1.5
CCSFL 12 - MT 3											
CCSFL 22 - MT 3											
CCSFL 22 - MT 4	M 6 - M 22	ER32	10	20	1.5	50	76	83	191	53	4.0
CCSFL 22 - MT 5									193		4.5

Ordering Example :-  
KTA CCSFL - 12 / MT 2 = Qty. - 2 Nos.  
KTA CCSFL - 22 / MT 3 = Qty. - 2 Nos.

‘CCSFL’ is a simple to use & operator friendly tapping Attachment.

‘CCSFL’ 12 is equipped with ER20 collet Head, where ER20 collets are used . The maximum capacity of the collet is 13mm. This can be used up to M16 fine pitch.

‘CCSFL’ 22 is equipped with ER32 collet Head, where ER32 collets are used. The maximum capacity of the collet is 20mm. This can be used up to M30 fine pitch.

**SAFETY BALL CLUTCH :**

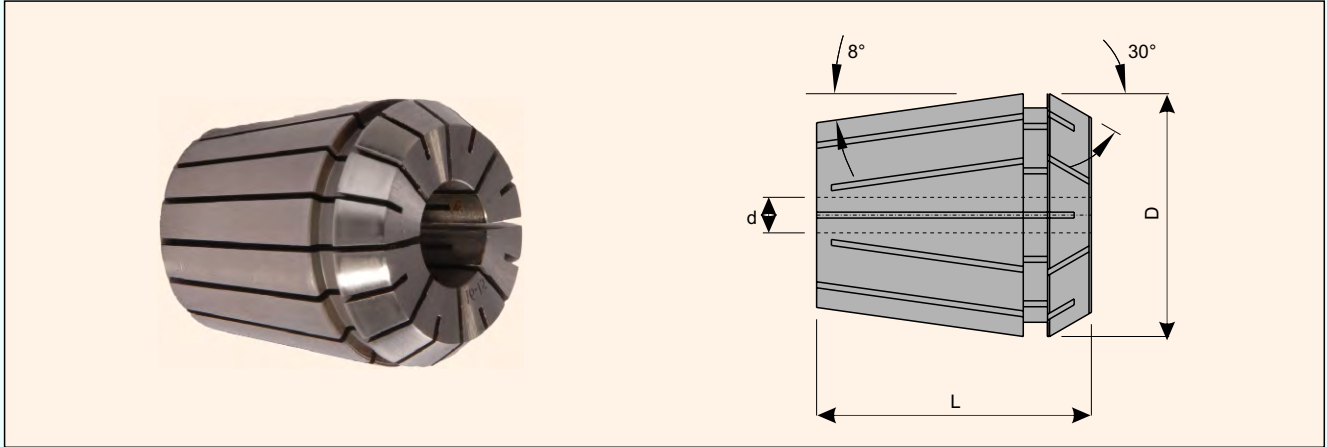
There is a safety clutch mechanism which is suitable within its range of Tapping. The safety clutch disengages when the present torque is exceeded. After disengagement there is almost no Torque on the Tap & thus the clutch suffers practically no wear. Due to this Tap breakage is prevented. Blind holes can be bottom- tapped under full rotation of the spindle, reversal of the spindle re-engages the clutch and the tap is automatically withdrawn.

**FLOAT RADIAL PARALLEL :**

The ball operated floating device guarantees threads to correct tolerances. In case of misalignment, protects the tap against side thrust. It comes again into center automatically after every tapping operation . The radial Parallel float is 1.0mm & 1.50 mm respectively.

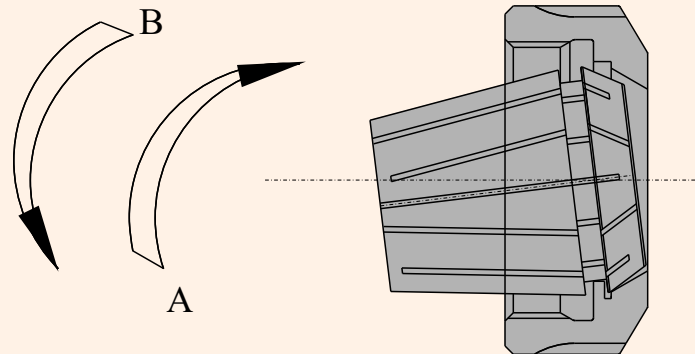
**LENGTH COMPENSATION :**

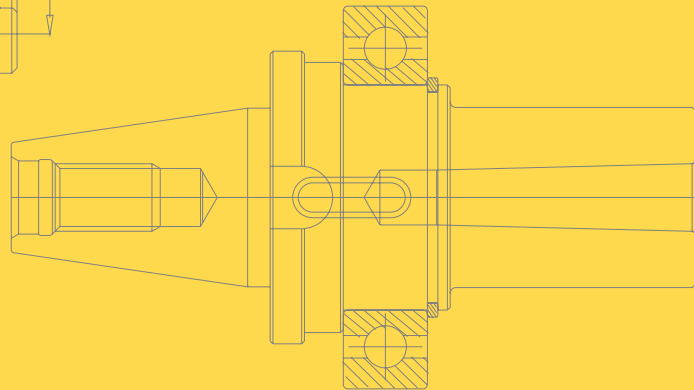
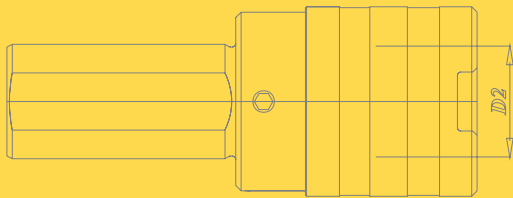
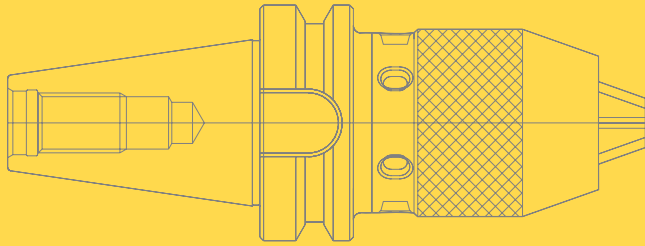
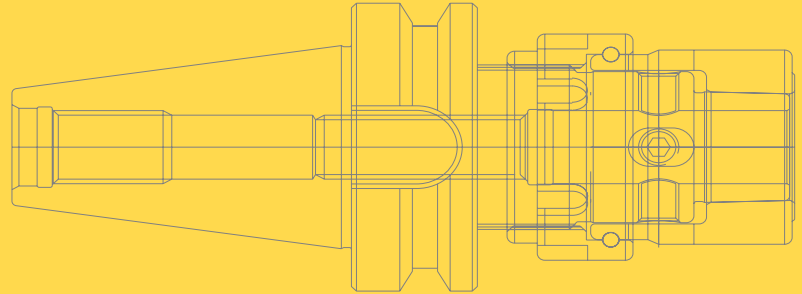
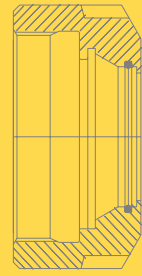
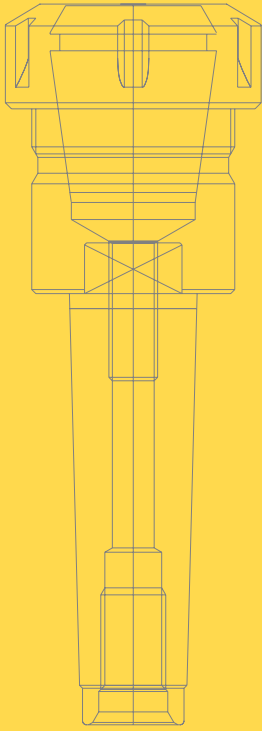
The length compensation is Ball Cage operated and hence the axial movement is very smooth. Even at the extreme Torque, the free axial movement prevents damage to thread flanks. When the feed rate & tap pitch do not match, i.e during hand feed, this helps for cutting small threads on heavy machines.



Collet Designation	Bore Range 'd'			Clamping Capacity per set		Each Collet collapse by mm	D mm	L Mm
	From mm	To	in steps mm	From mm	To mm			
ER20	1.0	13	1.0	1.0	13.0	1.0	21.0	31.0
ER32	2.0	20	1.0	2.0	20.0	1.0	33.0	40.0

The collet must always be inserted into the nut before setting the tool into the collet. The collet is fitted inside the nut by applying slight pressure A. It is removed by applying B to the collet. Never tighten the chuck without a correct size tool shank being present in the collet. Failure to observe this guideline can result in collet breakage.





**DEALERS:**