



# Quick Change Tapping Chucks Type KWFSL 60 ( M 30 to M 120 )

## Application :

For tapping operations with single pass and series taps on mechanically and numerically controlled radial drilling machines, drilling and milling machines.

## Features :

Quick change system with automatic locking of the adaptor in the chuck.

Adjustable length compensation acting on compression and expansion to compensate for differences between spindle feed and tap pitch.

Adjustable safety clutch with minimum torque after disengagement to protect against tap breakage.

Interchangeable shanks to allow the use of the chuck on different machines spindle configurations.

For lefthand threads on request.



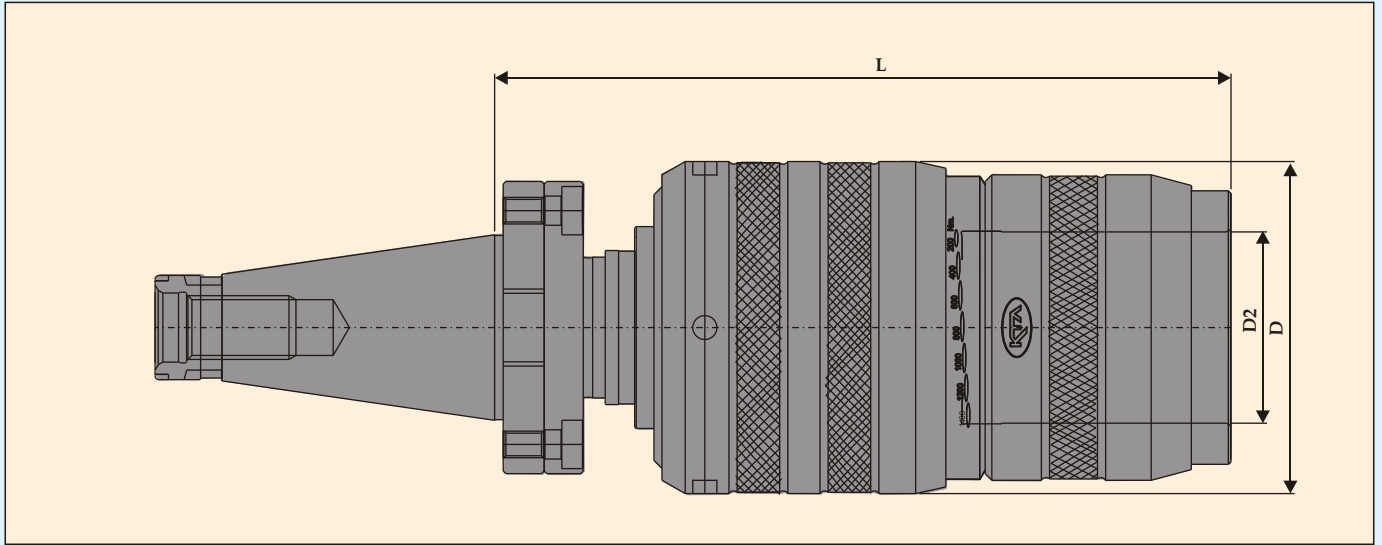
## **KTA Spindle Toolings**

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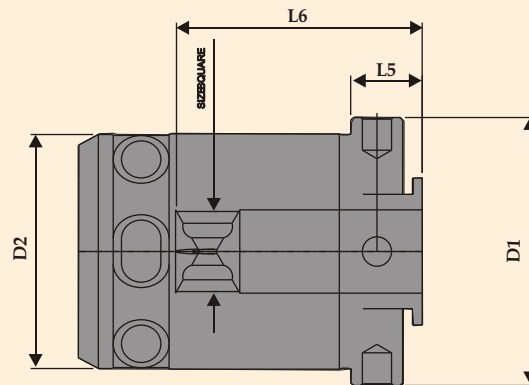
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## Quick Change Tapping Chuck (KWFSL 60)



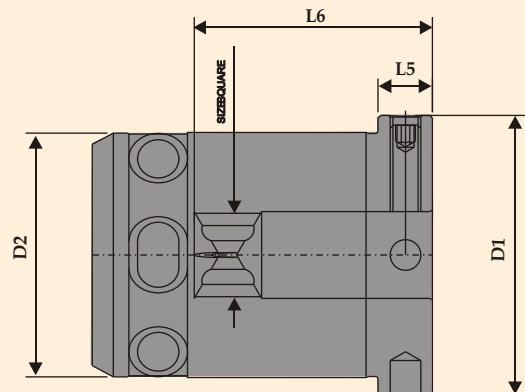
## Adaptor Type KWE 60

Adaptor Type KWE 60



## Adaptor Type KWEK 60

Adaptor Type KWEK 60  
with extended range  
tap clamped by grub screw



## Quick Change Tapping Chuck (KWFSL 60)

| Chuck Designation<br>Size   Locat | For Taps         | Torque | Suitable Adaptors | Length Comp. |        | L   | D dia. | D2 dia. | Approx. weight Kgs |
|-----------------------------------|------------------|--------|-------------------|--------------|--------|-----|--------|---------|--------------------|
|                                   |                  |        |                   | Compr.       | Expan. |     |        |         |                    |
| KWFSL 60 / SK 50                  | M 30 - M 68 x 6  | 1400   | KWE 60            | 20           | 20     | 275 | 125    | 72      | 16                 |
| KWFSL 60 / SK 60                  | M 30 - M 120 x 4 |        | KWEK 60           |              |        | 277 |        |         | 18                 |

| Chuck Designation<br>Size   Locat | For Taps         | Torque | Suitable Adaptors | Length Comp. |        | L   | D dia. | D2 dia. | Approx. weight Kgs |
|-----------------------------------|------------------|--------|-------------------|--------------|--------|-----|--------|---------|--------------------|
|                                   |                  |        |                   | Compr.       | Expan. |     |        |         |                    |
| KWFSL 60 / MK 5                   | M 30 - M 68 x 6  | 1400   | KWE 60            | 20           | 20     | 280 | 125    | 72      | 16                 |
| KWFSL 60 / MK 6                   | M 30 - M 120 x 4 |        | KWEK 60           |              |        | 282 |        |         | 18                 |

| Adaptor Designation<br>Size | For Taps    |           | D1<br>Dia. | D2<br>Dia. | L5 | L6 | Approx. weight<br>Kgs |
|-----------------------------|-------------|-----------|------------|------------|----|----|-----------------------|
|                             | Thread Dia  | Shank Dia |            |            |    |    |                       |
| KWE 60                      | M 30 - M 48 | 22 - 36   | 82         | 72         | 25 | 78 | 2,5                   |

| Adaptor Designation<br>Size | For Taps         |           | D1<br>Dia. | D2<br>Dia. | L5 | L6 | Approx. weight<br>Kgs |
|-----------------------------|------------------|-----------|------------|------------|----|----|-----------------------|
|                             | Thread Dia       | Shank Dia |            |            |    |    |                       |
| KWEK 60                     | M 48 - M 68 x 6  | > 36 - 56 | 82         | 72         | 16 | 88 | 1,5                   |
|                             | M 48 - M 120 x 4 |           |            |            |    |    |                       |



## Quick Change Tapping Chucks (KWFSL 60)

KTA's KWFSL 60 TAPPING CHUCKS are used to tap large internal threads during the manufacture of machines, engines, turbines, nuclear reactors, components etc.

To tap these large threads, single pass as well as series taps are used. Whether single pass or series taps are used depends mainly on diameter, pitch, tolerance and surface finish of the thread and the material to be tapped.

KTA's KWFSL 60 TAPPING CHUCKS fulfills all requirements for tapping threads economically and within tolerances whether single pass or series taps are used.

With these chucks and adaptors various working methods are possible.

Tapping with single pass taps:

The thread will be finished in a single operation.

Difference between machine feed and thread pitch are compensated by the length compensation.

Tapping with series taps :

When tapping with series taps it is not always possible to exactly introduce the second tap into the pre-cut thread by machine. Even chucks with length compensation cannot guarantee safe results. The safest method is, to introduce the second tap by hand into the pre-cut thread and have the chuck to finish-cut the thread.

The use of chuck KWFSL 60 simplifies this method. The adaptor with the tap screwed into the pre-cut thread is automatically engaged in the chuck when the spindle moves forward and the thread is then cut. Differences between machine feed and tap pitch are compensated by the length compensation.

**DEALER :-**

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