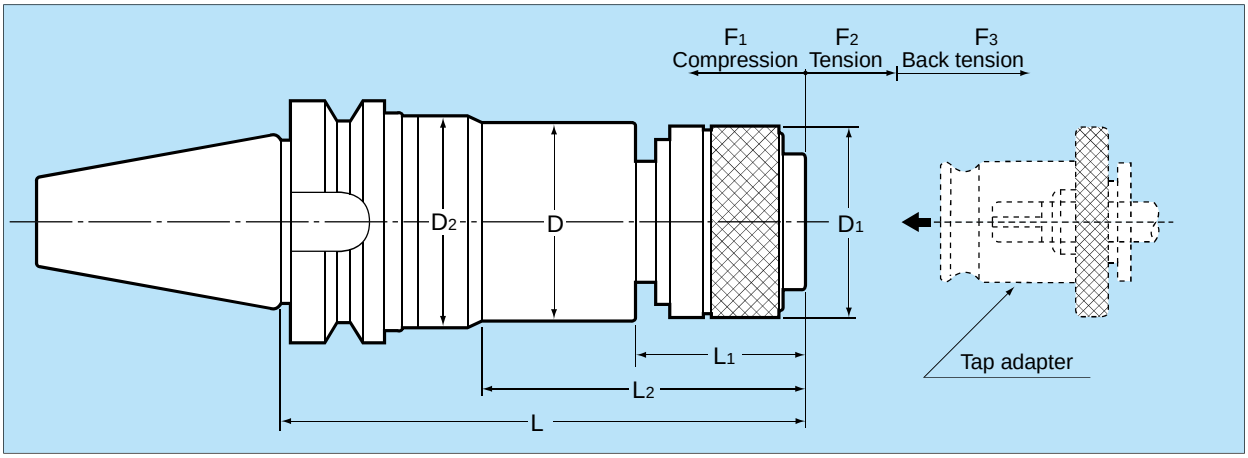
Tap Holders
TP3B （Auto Depth Control）



Model		Tapping capacity	Adapter size	L	L1	L2	D	D1	D2	Axial compensation F1	Axial compensation F2	F3
BT30	-TP3B-1-113	M3 – M12(M15) U1/4 – U7/16 (U9/16) Pipe(PT,PS,PF) 1/8 – 1/4	1	4.449	1.181	2.421	1.339	1.26	1.535		0.157	0.315
BT40	-TP3B-1-113											
	-TP3B-2-135	M8 – M22 U3/8 – U7/8 Pipe(PT,PS,PF) 1/8 – 1/2	2	5.315	1.752	3.406	2.047	1.969	2.205		0.197	0.433
BT50	-TP3B-1-128	M3 – M12(M15) U1/4 – U7/16 (U9/16) Pipe(PT,PS,PF) 1/8 – 1/4	1	5.039	1.181	2.421	1.339	1.26	1.535	0.020	0.157	0.315
	-TP3B-2-150	M8 – M22 U3/8 – U7/8 Pipe(PT,PS,PF) 1/8 – 1/2	2	5.906	1.752	3.406	2.047	1.969	2.205		0.197	0.433
	-TP3B-3-181	M16 – M38 U5/8 – U3/8 Pipe(PT,PS,PF) 1/4 – $1^{1}/_{8}$	3	7.126	2.579	4.685	2.992	2.835	3.150		0.236	0.472

1. Tap sizes in brackets are for light tapping only.
2. Tap sizes are based on old JIS standard.
3. Tap adapter with safety torque clutch cannot be used.
4. Tap adapter is sold separately.(P131 - 134)

Ordering Example　BT40-TP3B-1-113

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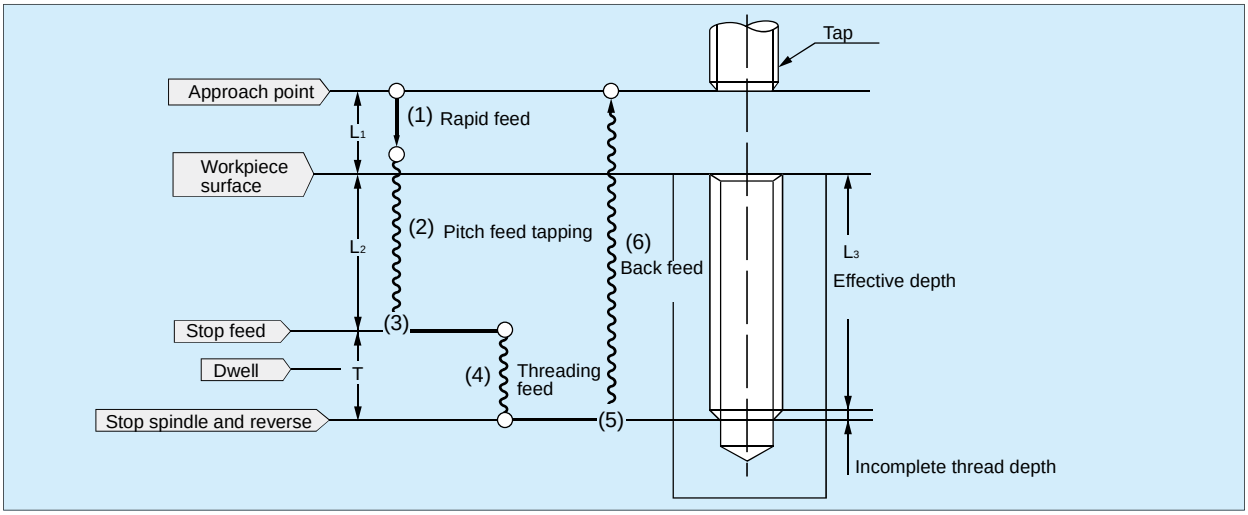
How to use

In case auto depth control is used: (Blind holes, tapered screws etc.)

(1) Rapid feed from approach point
(2) Tapping by pitch
(3) Stop feed
(4) Spindle rotation more than tap self-feed (Dwell)
(5) Stop spindle and reverse
(6) Back feed



Approach L_1 = 13mm or more

Cutting depth L_2 =
Effective thread depth L_3+Incomplete thread length - Tension F_2

$$\text{Dwell time (sec.)} = \frac{\text{Tension } F_2}{\text{Tap pitch} \times \text{Rotation } (\text{min}^{-1})} \times 60$$

In case auto depth control is not used (through hole), use TP3B as a conventional tapping chuck.

(1) Rapid feed from approach point
(2) Tapping by pitch
(3) Stop spindle and reverse
(4) Back feed
(5) Quick return