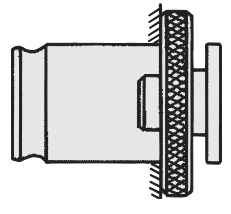


# QUICK CHANGE TAP ADAPTER

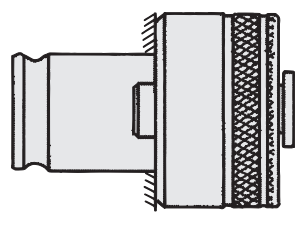
## Basic 4 Models

**WE**



**WE** Quick Change

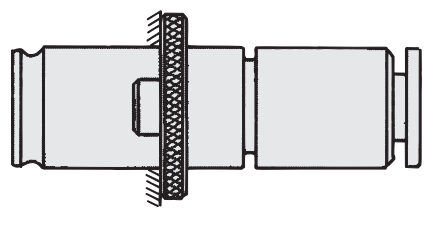
**WES · B**



**WE** Quick Change

**S** Safety Torque

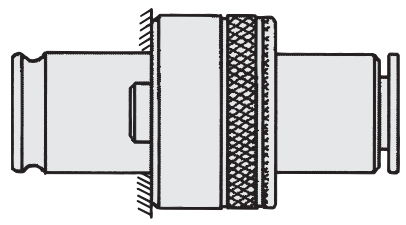
**WEN**



**WE** Quick Change

**N** Length Adjustment

**WESN · B**



**WE** Quick Change

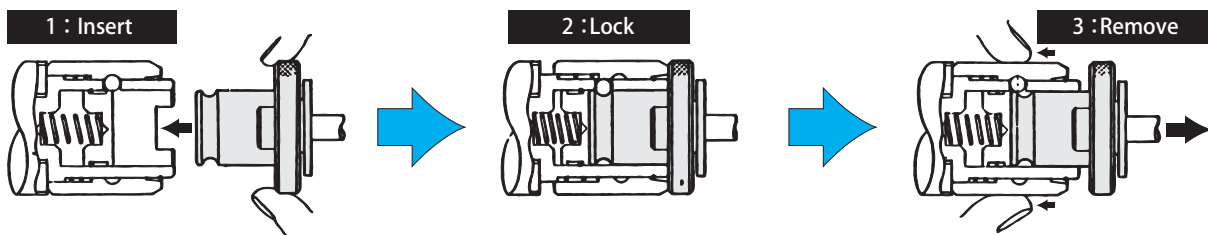
**S** Safety Torque

**N** Length Adjustment

In addition to the basic 4 models, wide variety of models (extended size, enlarged size, R type for short shank tap etc.) are available.

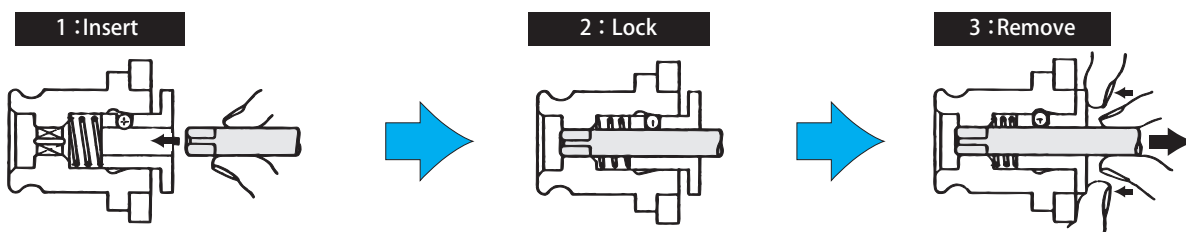
WE : Quick Change

Tapping chuck and tapping adapter



- 1 : Simply insert tap adapter into tapping chuck.
- 2 : Tapping chuck and tap adapter are connected firmly.
- 3 : Push down on operation sleeve of tapping chuck while removing tap adapter.

Tapping adapter and Tap

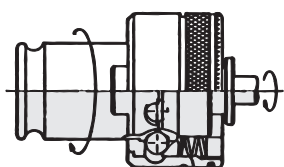


- 1 : Insert tap into bottom of tap adapter, and rotate tap manually to connect them firmly.
- 2 : Tap and adapter are connected firmly.
- 3 : Push down on ball bush while removing tap.

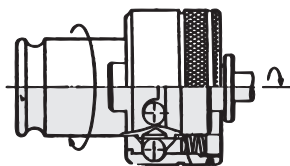
S : Safety torque

Safe torque device activates to prevent breakage tap when torque more than fixed amount is applied to tap. (Use with a tapper equipped with axial compensation mechanism.)

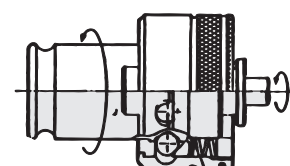
Normal operation (Normal machining)



Empty operation (Abnormal machining torque)

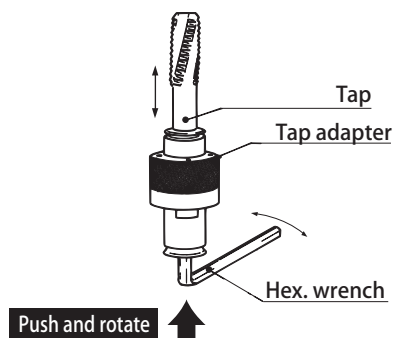


Reverse operation (Torque device doesn't move in the reverse direction)



When using left handed tap adapter, please specify.

N : Length adjustment



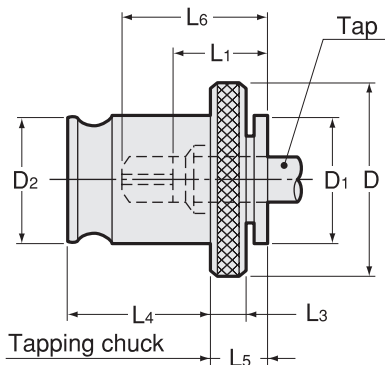
Insert hex. wrench into bottom of tap adapter and turn to adjust tool length.

Tap adapter with tool adjustment mechanism can be recommended for following conditions.

- 1.Tool adjustment with prestting gauge.
- 2.When tap length changes due to re-grinding.
- 3.When you do not want to use N/C machine tool compensation function.

# WE

## Quick Change Tap Adapter



### Applications

- For through hole, blind hole, right-hand thread and left-hand thread.

### Feature

- Quick Change
- ※ In case you are afraid of tap breakage, choose a WES ·B and a tapping chuck with safety torque clutch.

For capable tap sizes, please refer to P.462-464 chart.

| Code          | Model       | Tap Size  | Chuck size | D  | D1   | D2 | L1 | L3 | L4   | L5 | kg   |
|---------------|-------------|---|------------|----|------|----|----|----|------|----|------|
| 0210 0000 ※※※ | <b>WE0</b>  | M3 ~ M8 (M10)<br>U1/4 ~ U5/16 (U3/8)                              | 0          | 22 | 12.5 | 13 | 15 | 4  | 19.5 | 7  | 0.03 |
| 0210 0001 ※※※ | <b>WE1</b>  | M3 ~ M12 (M15)<br>U1/4 ~ U7/16 (U9/16)<br>Pipe(PT,PS,PF)1/8 ~ 1/4 | 1<br>32    | 30 | 19   | 19 | 17 | 4  | 21.5 | 7  | 0.06 |
| 0210 0004 ※※※ | <b>WE40</b> | M6 ~ M18<br>U1/4 ~ U3/4   | 40         | 40 | 25   | 26 | 30 | 5  | 32   | 13 | 0.12 |
| 0210 0002 ※※※ | <b>WE2</b>  | M8 ~ M22<br>U3/8 ~ U7/8   | 2          | 48 | 30   | 31 | 30 | 5  | 35   | 11 | 0.25 |
| 0210 0003 ※※※ | <b>WE3</b>  | M26 ~ M38<br>U1 ~ U1 3/8  | 3          | 70 | 47   | 48 | 44 | 6  | 55.5 | 14 | 0.8  |
| —             | <b>WE4</b>  | 7/8 ~ 1-3/4<br>M22 ~ M48  | 4          | 90 | 60   | 60 | 71 | 13 | 63   | 42 |      |

1. Tap sizes in brackets are for light tapping only.
2. Calculate tap projection length from L1 dimension.
3. L1 and L6 dimensions fluctuate with tap sizes. Always take into account ± 1.5mm allowance.
4. Refer to P.462 for tap shank dia. and square dimension.

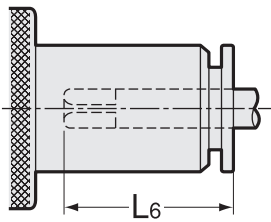
### Ordering Example

**WE1 M8J**  
Adapter size Tap size

BT  
 CAT  
 AHO  
 HSK-A/E/F/C  
 HSK-T  
 UTS  
 Specialized Machine  
 Related Equipment  
 Bush & Chamfering Drill  
 Sub Holder  
 Tapping Chuck  
 Tap Adapter  
 Adjustable Adapter  
 Endmill Chuck  
 Straight Drill Chuck  
 Floating Holder

## Tapping Capacity

Dimension L6



Symbol

⊙ : For JIS (old) Tap

● : For Coarse Thread Tap

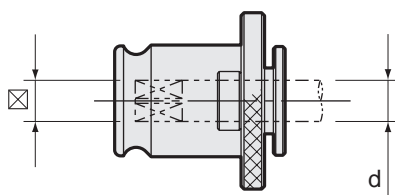
※ : For light machining on aluminum alloy and the like

**!** For capable tap sizes, please refer to P.462-464 chart.

### WESN · B、WES · B、WE

| Tap Dimension      |                |                   |                   |                  | WESN · B<br>WES · B WE 0 |      | WESN · B<br>WES · B WE 1 |      | WESN · B<br>WES · B WE 40 |      | WESN · B<br>WES · B WE 2 |      | WESN · B<br>WES · B WE 3 |      |
|--------------------|----------------|-------------------|-------------------|------------------|--------------------------|------|--------------------------|------|---------------------------|------|--------------------------|------|--------------------------|------|
| Metric Thread      | Unified Thread | Whit-worth Thread | Shank Dia. $\phi$ | Square $\square$ |                          | L6   |                          | L6   |                           | L6   |                          | L6   |                          | L6   |
| M3                 | NO5,NO6        |                   | 4                 | 3.2              | ⊙                        | 22   | ⊙                        | 23   |                           |      |                          |      |                          |      |
| M4 M4.5            | NO8            |                   | 5                 | 4                | ⊙                        | 22.5 | ⊙                        | 24.5 |                           |      |                          |      |                          |      |
| M5 M5.5            | NO10,NO12      |                   | 5.5               | 4.5              | ⊙                        | 22.5 | ⊙                        | 24.5 |                           |      |                          |      |                          |      |
| M6                 | U1/4           | W1/4              | 6                 | 4.5              | ⊙                        | 22   | ⊙                        | 24.5 | ⊙                         | 36.5 |                          |      |                          |      |
|                    | U5/16          | W5/16             | 6.1               | 5                | ⊙                        | 23   | ⊙                        | 25   | ⊙                         | 37.5 |                          |      |                          |      |
| M8 M7              |                |                   | 6.2               | 5                | ⊙                        | 23   | ⊙                        | 25.5 | ⊙                         | 37   | ⊙                        | 37   |                          |      |
| M10 M9             | U3/8           | W3/8              | 7                 | 5.5              | ※                        | 23.5 | ⊙                        | 25.5 | ⊙                         | 37   | ⊙                        | 37   |                          |      |
|                    | M11            | U7/16             | 8                 | 6                |                          |      | ⊙                        | 26.5 | ●                         | 38.5 | ●                        | 38.5 |                          |      |
| M12                |                |                   | 8.5               | 6.5              |                          |      | ⊙                        | 26.5 | ●                         | 38   | ●                        | 38   |                          |      |
|                    | U1/2           | W1/2              | 9                 | 7                |                          |      | ⊙                        | 27   | ⊙                         | 38.5 | ⊙                        | 38.5 |                          |      |
| M14 M15            | U9/16          | W9/16             | 10.5              | 8                |                          |      | ※                        | 28   | ●                         | 40   | ●                        | 40   |                          |      |
|                    | U5/8           | W5/8              | 12                | 9                |                          |      |                          |      | ⊙                         | 41.5 | ⊙                        | 41.5 |                          |      |
| M16                |                |                   | 12.5              | 10               |                          |      |                          |      | ●                         | 42   | ●                        | 42   |                          |      |
|                    | M17            |                   | 13                | 10               |                          |      |                          |      | ⊙                         | 42   | ⊙                        | 42   |                          |      |
| M18                | U3/4           | W3/4              | 14                | 11               |                          |      |                          |      | ⊙                         | 43.5 | ⊙                        | 43.5 |                          |      |
| M20                |                |                   | 15                | 12               |                          |      |                          |      |                           |      | ⊙                        | 44   |                          |      |
| M22                | U7/8           | W7/8              | 17                | 13               |                          |      |                          |      |                           |      | ⊙                        | 45   |                          |      |
| M27 M26            | U1             | W1                | 20                | 15               |                          |      |                          |      |                           |      |                          |      | ●                        | 62   |
|                    | M28            |                   | 21                | 17               |                          |      |                          |      |                           |      |                          |      | ●                        | 63.5 |
|                    | U1 1/8         | W1 1/8            | 22                | 17               |                          |      |                          |      |                           |      |                          |      | ●                        | 62.5 |
| M30                |                |                   | 23                | 17               |                          |      |                          |      |                           |      |                          |      | ●                        | 62   |
|                    | M32            | U1 1/4            | 24                | 19               |                          |      |                          |      |                           |      |                          |      | ●                        | 66   |
| M33                |                |                   | 25                | 19               |                          |      |                          |      |                           |      |                          |      | ●                        | 66   |
| M35 M34            | U1 3/8         | W1 3/8            | 26                | 21               |                          |      |                          |      |                           |      |                          |      | ●                        | 68   |
| M36 M38            |                |                   | 28                | 21               |                          |      |                          |      |                           |      |                          |      | ●                        | 67   |
| Pipe Tap Dimension |                |                   |                   |                  |                          |      |                          |      |                           |      |                          |      |                          |      |
| PT                 | PS             | PF                | $\phi$            | $\square$        |                          |      |                          |      |                           |      |                          |      |                          |      |
| 1/8                | 1/8            | 1/8               | 8                 | 6                |                          |      | ⊙                        | 26.5 |                           |      |                          |      |                          |      |
| 1/4                | 1/4            | 1/4               | 11                | 9                |                          |      | ⊙                        | 29   |                           |      |                          |      |                          |      |

## Tapping Capacity



### ANSI

Unit : Inch

| Type                           | Chuck size | Tap size | φ d Tap Shank | ☒ Drive Square |
|--------------------------------|------------|----------|---------------|----------------|
| WE0<br>WES0B<br>WEN0<br>WESN0B | 0          | #0-6     | 0.141         | 0.110          |
|                                |            | #8       | 0.168         | 0.131          |
|                                |            | #10      | 0.194         | 0.152          |
|                                |            | #12      | 0.220         | 0.165          |
|                                |            | 1/4      | 0.255         | 0.191          |
| WE1<br>WES1B<br>WEN1<br>WESN1B | 1          | 5/16     | 0.318         | 0.238          |
|                                |            | #0-6     | 0.141         | 0.110          |
|                                |            | #8       | 0.168         | 0.131          |
|                                |            | #10      | 0.194         | 0.152          |
|                                |            | #12      | 0.220         | 0.165          |
|                                |            | 1/4      | 0.255         | 0.191          |
|                                |            | 5/16     | 0.318         | 0.238          |
|                                |            | 3/8      | 0.381         | 0.286          |
|                                |            | 7/16     | 0.323         | 0.242          |
|                                |            | 1/2      | 0.367         | 0.275          |
| WE2<br>WES2B<br>WEN2<br>WESN2B | 2          | 1/8SPT   | 0.313         | 0.234          |
|                                |            | 1/8LPT   | 0.437         | 0.328          |
|                                |            | 5/16     | 0.318         | 0.238          |
|                                |            | 3/8      | 0.381         | 0.286          |
|                                |            | 7/16     | 0.323         | 0.242          |
|                                |            | 1/2      | 0.367         | 0.275          |
|                                |            | 9/16     | 0.429         | 0.322          |
|                                |            | 5/8      | 0.480         | 0.360          |
|                                |            | 11/16    | 0.542         | 0.406          |
|                                |            | 3/4      | 0.590         | 0.442          |
| WE3<br>WES3B<br>WEN3<br>WESN3B | 3          | 13/16    | 0.652         | 0.489          |
|                                |            | 7/8      | 0.697         | 0.523          |
|                                |            | 15/16    | 0.760         | 0.570          |
|                                |            | 1        | 0.800         | 0.600          |
|                                |            | 1-1/8    | 0.896         | 0.672          |
|                                |            | 1-1/4    | 1.021         | 0.766          |
|                                |            | 1-3/8    | 1.108         | 0.831          |
| WE4<br>WES4B                   | 4          | 1/2PT    | 0.687         | 0.515          |
|                                |            | 3/4PT    | 0.906         | 0.679          |
|                                |            | 1PT      | 1.125         | 0.843          |
|                                |            | 7/8      | 0.697         | 0.523          |
|                                |            | 15/16    | 0.760         | 0.570          |
|                                |            | 1        | 0.800         | 0.600          |
|                                |            | 1-1/8    | 0.896         | 0.672          |
| 1-1/4                          | 1.021      | 0.766    |               |                |
| 1-3/8                          | 1.108      | 0.831    |               |                |
| 1-1/2                          | 1.233      | 0.925    |               |                |
| 1-3/4                          | 1.430      | 1.072    |               |                |

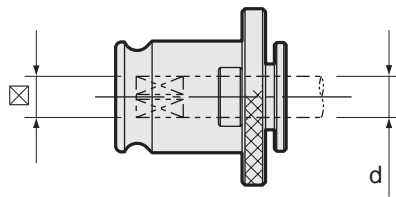
### ISO

Unit : Metric

| Type                           | Chuck size | Tap size                           | φ d Tap Shank | ☒ Drive Square |
|--------------------------------|------------|------------------------------------|---------------|----------------|
| WE0<br>WES0B<br>WEN0<br>WESN0B | 0          | Please contact NT USA for details. |               |                |
| WE1<br>WES1B<br>WEN1<br>WESN1B | 1          | M3-1                               | 2.24          | 1.8            |
|                                |            | M3.5, M2                           | 2.5           | 2.0            |
|                                |            | M2.5, M2.2                         | 2.8           | 2.24           |
|                                |            | M4-1, M3-2                         | 3.15          | 2.5            |
|                                |            | M4.5, M3.5                         | 3.55          | 2.8            |
|                                |            | M5-1, M4-2                         | 4.0           | 3.15           |
|                                |            | M6-1                               | 4.5           | 3.55           |
|                                |            | M5-2                               | 5.0           | 4.0            |
|                                |            | M5-3                               | 5.6           | 4.5            |
|                                |            | M8-1, M6-2                         | 6.3           | 5.0            |
|                                |            | M7                                 | 7.1           | 5.6            |
|                                |            | M11, M10-1, M8-2                   | 8.0           | 6.3            |
|                                |            | M12, M9                            | 9.0           | 7.1            |
|                                |            | M10-2                              | 10.0          | 8.0            |
| WE2<br>WES2B<br>WEN2<br>WESN2B | 2          | M14                                | 11.2          | 9.0            |
|                                |            | M5-1, M4-2                         | 4.0           | 3.15           |
|                                |            | M6-1                               | 4.5           | 3.55           |
|                                |            | M5-2                               | 5.0           | 4.0            |
|                                |            | M5-3                               | 5.6           | 4.5            |
|                                |            | M8-1, M6-2                         | 6.3           | 5.0            |
|                                |            | M7                                 | 7.1           | 5.6            |
|                                |            | M11, M10-1, M8-2                   | 8.0           | 6.3            |
|                                |            | M12, M9                            | 9.0           | 7.1            |
|                                |            | M10-2                              | 10.0          | 8.0            |
|                                |            | M14                                | 11.2          | 9.0            |
|                                |            | M16                                | 12.5          | 10.0           |
|                                |            | M20, M18                           | 14.0          | 11.2           |
|                                |            | M22                                | 16.0          | 12.5           |
| WE3<br>WES3B<br>WEN3<br>WESN3B | 3          | M12, M9                            | 9.0           | 7.1            |
|                                |            | M10-2                              | 10.0          | 8.0            |
|                                |            | M14                                | 11.2          | 9.0            |
|                                |            | M16                                | 12.5          | 10.0           |
|                                |            | M20, M18                           | 14.0          | 11.2           |
|                                |            | M22                                | 16.0          | 12.5           |
|                                |            | M30, M27                           | 20.0          | 16.0           |
|                                |            | M33-1                              | 22.4          | 18.0           |
| WE4<br>WES4B                   | 4          | M36, M33-2                         | 25.0          | 20.0           |
|                                |            | M42, M39                           | 28.0          | 22.4           |
|                                |            | M22                                | 16.0          | 12.5           |
|                                |            | M24                                | 18.0          | 14.0           |
|                                |            | M30, M27                           | 20.0          | 16.0           |
|                                |            | M33-1                              | 22.4          | 18.0           |

- BT
- CAT
- AHO
- HSK-A/E/F/C
- HSK-T
- UTS
- Specialized Machine
- Related Equipment
- Bush & Chamfering Drill
- Sub Holder
- Tapping Chuck
- Tap Adapter
- Adjustable Adapter
- Endmill Chuck
- Straight Drill Chuck
- Floating Holder

## Tapping Capacity



### DIN

Unit : Metric

| Type                           | Chuck size | Tap size   | φ d Tap Shank | Drive Square |
|--------------------------------|------------|------------|---------------|--------------|
| WE0<br>WES0B<br>WENO<br>WESN0B | 0          | M3, M5     | 3.5           | 2.7          |
|                                |            | M4, M6     | 4.5           | 3.4          |
|                                |            | M5, M6, M8 | 6.0           | 4.9          |
|                                |            | M10        | 7.0           | 5.5          |
|                                |            | M8, M10    | 8.0           | 6.2          |
| WE1<br>WES1B<br>WEN1<br>WESN1B | 1          | M3, M5     | 3.5           | 2.7          |
|                                |            | M3.5       | 4.0           | 3.0          |
|                                |            | M4, M6     | 4.5           | 3.4          |
|                                |            | M5, M6, M8 | 6.0           | 4.9          |
|                                |            | M10        | 7.0           | 5.5          |
|                                |            | M8, M10    | 8.0           | 6.2          |
|                                |            | M12        | 9.0           | 7.0          |
| WE2<br>WES2B<br>WEN2<br>WESN2B | 2          | M10        | 10.0          | 8.0          |
|                                |            | M14        | 11.0          | 9.0          |
|                                |            | M16        | 12.0          | 9.0          |
|                                |            | M18        | 14.0          | 11.0         |
|                                |            | M20        | 16.0          | 12.0         |
|                                |            | M22, M24   | 18.0          | 14.5         |
|                                |            | M12        | 9.0           | 7.0          |
|                                |            | M10        | 10.0          | 8.0          |
|                                |            | M14        | 11.0          | 9.0          |
|                                |            | M16        | 12.0          | 9.0          |
|                                |            | M18        | 14.0          | 11.0         |
| WE3<br>WES3B<br>WEN3<br>WESN3B | 3          | M20        | 16.0          | 12.0         |
|                                |            | M22, M24   | 18.0          | 14.5         |
|                                |            | M27, M30   | 20.0          | 16.0         |
|                                |            | M33, M36   | 22.0          | 18.0         |
|                                |            | M36        | 25.0          | 20.0         |
|                                |            | M22, M24   | 18.0          | 14.5         |
| WE4<br>WES4B                   | 4          | M27, M30   | 20.0          | 16.0         |
|                                |            | M30        | 22.0          | 18.0         |
|                                |            | M33, M36   | 25.0          | 20.0         |
|                                |            | M36        | 28.0          | 22.0         |
|                                |            | M39, M42   | 32.0          | 24.0         |
|                                |            | M45, M48   | 36.0          | 29.0         |

### JIS

Unit : Metric

| Type                           | Chuck size | Tap size | φ d Tap Shank | Drive Square |
|--------------------------------|------------|----------|---------------|--------------|
| WE0<br>WES0B<br>WENO<br>WESN0B | 0          | M3       | 4.0           | 3.2          |
|                                |            | M4, M4.5 | 5.0           | 4.0          |
|                                |            | M5, M5.5 | 5.5           | 4.5          |
|                                |            | M6       | 6.0           | 4.5          |
|                                |            | M7, M8   | 6.2           | 5.0          |
|                                |            | M9, M10  | 7.0           | 5.5          |
| WE1<br>WES1B<br>WEN1<br>WESN1B | 1          | M11      | 8.0           | 6.0          |
|                                |            | M3       | 4.0           | 3.2          |
|                                |            | M4, M4.5 | 5.0           | 4.0          |
|                                |            | M5, M5.5 | 5.5           | 4.5          |
|                                |            | M6       | 6.0           | 4.5          |
|                                |            | M7, M8   | 6.2           | 5.0          |
|                                |            | M9, M10  | 7.0           | 5.5          |
|                                |            | M11      | 8.0           | 6.0          |
|                                |            | M12      | 8.5           | 6.5          |
|                                |            | M13      | 9.5           | 7.0          |
| WE2<br>WES2B<br>WEN2<br>WESN2B | 2          | M14, M15 | 10.5          | 8.0          |
|                                |            | M6       | 6.0           | 4.5          |
|                                |            | M7, M8   | 6.2           | 5.0          |
|                                |            | M9, M10  | 7.0           | 5.5          |
|                                |            | M11      | 8.0           | 6.0          |
|                                |            | M12      | 8.5           | 6.5          |
|                                |            | M13      | 9.5           | 7.0          |
|                                |            | M14, M15 | 10.5          | 8.0          |
|                                |            | M16      | 12.5          | 10.0         |
|                                |            | M17      | 13.0          | 10.0         |
|                                |            | M18      | 14.0          | 11.0         |
|                                |            | M20      | 15.0          | 12.0         |
|                                |            | M22      | 17.0          | 13.0         |
| WE3<br>WES3B<br>WEN3<br>WESN3B | 3          | M14, M15 | 10.5          | 8.0          |
|                                |            | M16      | 12.5          | 10.0         |
|                                |            | M17      | 13.0          | 10.0         |
|                                |            | M18      | 14.0          | 11.0         |
|                                |            | M20      | 15.0          | 12.0         |
|                                |            | M22      | 17.0          | 13.0         |
|                                |            | M24, M25 | 19.0          | 15.0         |
|                                |            | M26, M27 | 20.0          | 15.0         |
|                                |            | M28      | 21.0          | 17.0         |
|                                |            | M30      | 23.0          | 17.0         |
| WE4<br>WES4B                   | 4          | M32      | 24.0          | 19.0         |
|                                |            | M33      | 25.0          | 19.0         |
|                                |            | M34, M35 | 26.0          | 21.0         |
|                                |            | M36, M38 | 28.0          | 21.0         |
|                                |            | M22      | 17.0          | 13.0         |
|                                |            | M24, M25 | 19.0          | 15.0         |
|                                |            | M26, M27 | 20.0          | 15.0         |
|                                |            | M28      | 21.0          | 17.0         |
|                                |            | M30      | 23.0          | 17.0         |
|                                |            | M32      | 24.0          | 19.0         |
|                                |            | M33      | 25.0          | 19.0         |
|                                |            | M34, M35 | 26.0          | 21.0         |
|                                |            | M36, M38 | 28.0          | 21.0         |
|                                |            | M39, M40 | 30.0          | 23.0         |
| M42                            | 32.0       | 26.0     |               |              |
| M45                            | 35.0       | 26.0     |               |              |
| M48                            | 38.0       | 29.0     |               |              |