



Tapping Catalog



Thank You For Your Interest In Fettes Manufacturing

Founded In The Industrial Heartland

For over 50 years, Fettes Manufacturing has produced, assembled, and delivered quality products from our primary plant facility located in Southeast Michigan, near metropolitan Detroit.

We Stand Behind Our Products

Fettes Manufacturing uses only the most premium grade materials in all of our manufacturing processes. We provide unconditionally guaranteed customer satisfaction on all products and orders.

Contact Us

For more information, please call 877-4FETTES, or visit us on the internet at www.fettesmfg.com.

Thank You

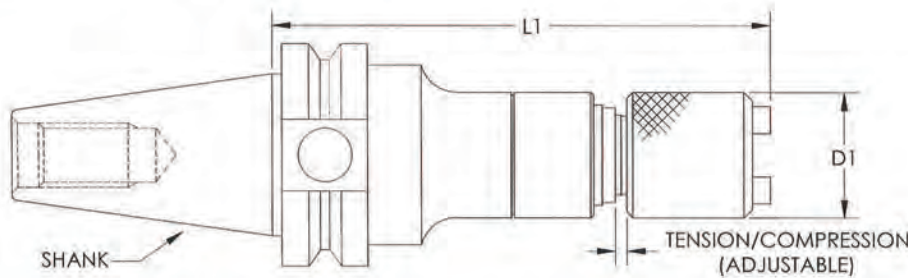
We appreciate your interest in our Company. We look forward to providing you with the highest quality of products and services.



Tap Holders

Integral Shank Tension/Compression Tap Holders

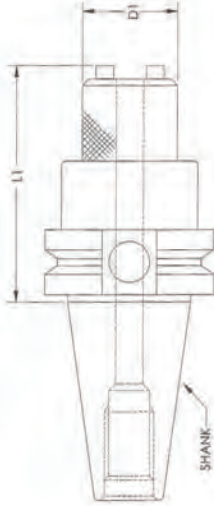
- Quick-change capability allows dull or broken taps to be replaced in seconds
- Unique ejector feature allows for adapter quick-change
- Compensates for machine feed and tap pitch variance
- Tension/Compression allows tap to be its own lead screw
- Ball bearing drive eliminates friction avoiding pushing or pulling of threads
- Tension/Compression adjustments made easily through the front of the tool using an allen wrench
- Will accept either lug drive or ball drive tap adapters



| ADAPTER SIZE | TAP SIZE RANGE | PART NUMBER | SHANK | D1 | L1 | TENSION | COMPRESSION |
|--------------|-----------------------------|---------------|---------|------|------|---------|-------------|
| #1 | 0 - 9/16 1/8 NPT | TAP1TC-BT30 | 30BT | 1.26 | 3.94 | 0.500 | 0.130 |
| | | TAP1TC-NMTB30 | 30NMTB | | 4.72 | | |
| | | TAP1TC-BT35 | 35BT | | 3.54 | | |
| | | TAP1TC-CAT40 | 40V | | 4.67 | | |
| | | TAP1TC-BT40 | 40BT | | 4.92 | | |
| | | TAP1TC-NMTB40 | 40NMTB | | 3.80 | | |
| | | TAP1TC-CAT45 | 45V | | 4.54 | | |
| | | TAP1TC-BT45 | 45BT | | 4.53 | | |
| | | TAP1TC-CAT50 | 50V | | 3.92 | | |
| | | TAP1TC-BT50 | 50BT | | 4.13 | | |
| | | TAP1TC-NMTB50 | 50NMTB | | 3.15 | | |
| #2 | 5/16 - 7/8 1/8 - 1/2 NPT | TAP2TC-CAT40 | 40V | 1.96 | 6.29 | 0.630 | 0.250 |
| | | TAP2TC-BT40 | 40BT | | 6.50 | | |
| | | TAP2TC-NMTB40 | 40 NMTB | | 5.50 | | |
| | | TAP2TC-CAT45 | 45V | | 6.17 | | |
| | | TAP2TC-BT45 | 45BT | | 6.30 | | |
| | | TAP2TC-CAT50 | 50V | | 5.54 | | |
| | | TAP2TC-BT50 | 50BT | | 5.51 | | |
| | | TAP2TC-NMTB50 | 50 NMTB | | 4.75 | | |
| #3 | 3/4 - 1 3/8 3/4, 1" NPT | TAP3TC-CAT45 | 45V | 2.91 | 9.06 | 0.880 | 0.500 |
| | | TAP3TC-BT45 | 45BT | | 9.25 | | |
| | | TAP3TC-CAT50 | 50V | | 8.50 | | |
| | | TAP3TC-BT50 | 50BT | | 8.86 | | |
| | | TAP3TC-NMTB50 | 50 NMTB | | 7.88 | | |

Integral Shank Rigid Tap Holders

- Quick-change capability allows dull or broken taps to be replaced in seconds
- Through-hole for coolant through spindle tapping
- Designed for machines with synchronized tapping capability
- Will accept either lug drive or ball drive tap adapters

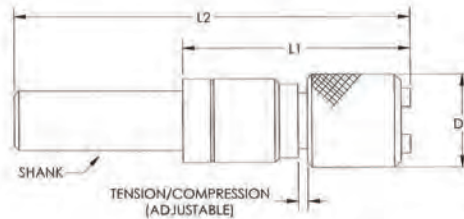


| ADAPTER SIZE | TAP SIZE RANGE | PART NUMBER | SHANK | D1 | L1 |
|--------------|-----------------------------|-------------|-------|-------|-------|
| #1 | 0 - 9/16 1/8 NPT | TAP1R-BT30 | 30BT | 1.260 | 1.970 |
| | | TAP1R-CAT40 | 40V | | 2.500 |
| | | TAP1R-BT40 | 40BT | | 2.360 |
| | | TAP1R-CAT50 | 50V | | 3.000 |
| | | TAP1R-BT50 | 50BT | | 3.150 |
| #2 | 5/16 - 7/8 1/8 - 1/2 NPT | TAP2R-BT30 | 30BT | 1.960 | 3.150 |
| | | TAP2R-CAT40 | 40V | | 3.00 |
| | | TAP2R-BT40 | 40BT | | 3.150 |
| | | TAP2R-CAT50 | 50V | | 3.00 |
| | | TAP2R-BT50 | 50BT | | 3.150 |
| #3 | 3/4 - 1 3/8 3/4, 1" NPT | TAP3R-CAT50 | 50V | 2.880 | 4.150 |
| | | TAP3R-BT50 | 50BT | | 4.920 |

Straight Shank Tension/Compression Tap Holders



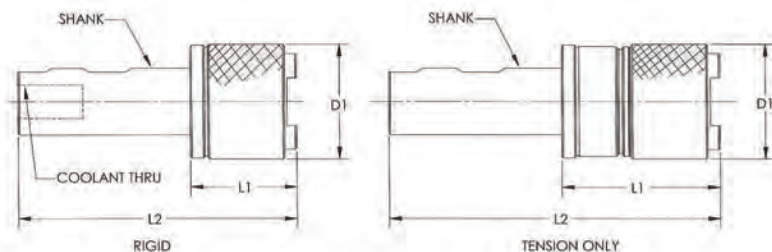
- Quick-change capability allows dull or broken taps to be replaced in seconds
- Unique ejector feature allows for adapter quick change
- Compensates for machine feed and tap pitch variance
- Tension/Compression allows tap to be its own lead screw
- Ball bearing drive eliminates friction avoiding pushing or pulling of threads
- Tension/Compression adjustments made easily through the front of the tool using an allen wrench
- Will accept either lug drive or ball drive tap adapters



| ADAPTER SIZE | TAP SIZE RANGE | PART NUMBER | SHANK | D1 | L1 | L2 | TENSION | COMPRESSION |
|--------------|-----------------------------|-------------|-------|-------|-------|--------|---------|-------------|
| #1 | 0 - 9/16 1/8 NPT | TAP1TC-S16 | 1.000 | 1.260 | 2.430 | 6.510 | 0.500 | 0.130 |
| #2 | 5/16 - 7/8 1/8 - 1/2 NPT | TAP2TC-S16 | 1.000 | 1.960 | 4.572 | 8.330 | 0.630 | 0.250 |
| | | TAP2TC-S20 | 1.250 | | | | | |
| #3 | 3/4 - 1 3/8 3/4, 1" NPT | TAP3TC-S20 | 1.250 | 2.910 | 6.590 | 11.550 | 0.880 | 0.500 |
| | | TAP3TC-S24 | 1.500 | | | | | |

Weldon Style Rigid and Tension Tap Holders

- Quick-change capability allows dull or broken taps to be replaced in seconds
- Rigid holder for use on machines with synchronized tapping capability
- Rigid holder designed for 500 psi coolant pressure using coolant through style tap adapters
- Tension holder compensates for machine feed and tap pitch variance
- Tension holder allows tap to be its own lead screw
- Will accept either lug drive or ball drive tap adapters
- Weldon flat on shank

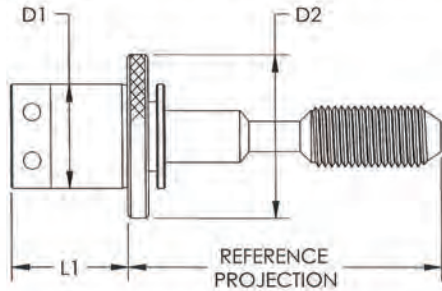


| ADAPTER SIZE | TAP SIZE RANGE | PART NUMBER | SHANK | D1 | L1 | L2 |
|--------------|-----------------------------|-------------|-------|-------|-------|-------|
| #1 | 0 - 9/16 1/8 NPT | TAP1R-W12 | .75" | 1.260 | 1.250 | 3.340 |
| | | TAP1T-W12 | | | 2.160 | 4.260 |
| #2 | 5/16 - 7/8 1/8 - 1/2 NPT | TAP2R-W16 | 1" | 1.960 | 2.090 | 5.060 |
| | | TAP2T-W16 | | | 3.190 | 6.485 |

Tap Adapters

Ball Drive Quick-Change Tap Adapters

- Ball drive eliminates rotational play or shifting between tap adapters and holder
- Quick-change capability allows dull or broken taps to be replaced in seconds
- Made from premium grade 4140 steel with case hardened precision ground bushings for extended wear and precision tapping
- Interchangeable with Bilz and other ball drive tap adapters



| FOR SIZE 1 HOLDERS | | | | | | |
|---------------------|-------------|----------|-------|-------|-------|----------------------|
| TAP RANGE | PART NUMBER | TAP SIZE | D1 | D2 | L1 | REFERENCE PROJECTION |
| 0 - 9/16 1/8 NPT | TAP-1B06 | 0-6 | 0.748 | 1.180 | 0.850 | 1.510 |
| | TAP-1B08 | 8 | | | | 1.570 |
| | TAP-1B10 | 10 | | | | 1.730 |
| | TAP-1B12 | 12 | | | | 1.790 |
| | TAP-1B250 | 1/4 | | | | 1.800 |
| | TAP-1B312 | 5/16 | | | | 1.950 |
| | TAP-1B375 | 3/8 | | | | 2.110 |
| | TAP-1B437 | 7/16 | | | | 2.360 |
| | TAP-1B500 | 1/2 | | | | 2.550 |
| | TAP-1B562 | 9/16 | | | | 2.790 |
| | TAP-1B125N | 1/8 NPT | | | | 1.360 |

| FOR SIZE 2 HOLDERS | | | | | | |
|-----------------------------|-------------|----------|-------|-------|-------|----------------------|
| TAP RANGE | PART NUMBER | TAP SIZE | D1 | D2 | L1 | REFERENCE PROJECTION |
| 5/16 - 7/8 1/8 - 1/2 NPT | TAP-2B312 | 5/16 | 1.220 | 1.880 | 1.380 | 1.990 |
| | TAP-2B375 | 3/8 | | | | 2.150 |
| | TAP-2B437 | 7/16 | | | | 2.400 |
| | TAP-2B500 | 1/2 | | | | 2.590 |
| | TAP-2B562 | 9/16 | | | | 2.790 |
| | TAP-2B625 | 5/8 | | | | 2.550 |
| | TAP-2B687 | 11/16 | | | | 2.710 |
| | TAP-2B750 | 3/4 | | | | 2.870 |
| | TAP-2B812 | 13/16 | | | | 3.100 |
| | TAP-2B875 | 7/8 | | | | 3.320 |
| | TAP-2B125N | 1/8 NPT | | | | 1.400 |
| | TAP-2B250N | 1/4 NPT | | | | 1.600 |
| | TAP-2B375N | 3/8 NPT | | | | 1.660 |
| | TAP-2B500N | 1/2 NPT | | | | 2.100 |

Ball Drive Quick-Change Tap Adapter (Cont'd.)

| FOR SIZE 3 HOLDERS | | | | | | |
|----------------------------|-------------|----------|-------|-------|-------|----------------------|
| TAP RANGE | PART NUMBER | TAP SIZE | D1 | D2 | L1 | REFERENCE PROJECTION |
| 3/4 - 1 3/8 3/4, 1" NPT | TAP-3B750 | 3/4 | 1.890 | 2.750 | 2.190 | 2.900 |
| | TAP-3B875 | 7/8 | | | | 3.230 |
| | TAP-3B937 | 15/16 | | | | 3.090 |
| | TAP-3B1000 | 1 | | | | 3.240 |
| | TAP-3B1125 | 1 1/8 | | | | 3.490 |
| | TAP-3B1250 | 1 1/4 | | | | 3.680 |
| | TAP-3B1375 | 1 3/8 | | | | 3.930 |
| | TAP-3B750N | 3/4 NPT | | | | 2.200 |
| | TAP-3B1000N | 1 NPT | | | | 2.580 |

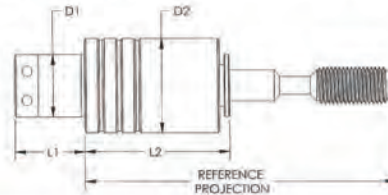
JIS Tap Adapters

| FOR SIZE 1 HOLDERS | | | | | | |
|--------------------|-----------------|----------|-------|-------|-------|---|
| TAP RANGE | PART NUMBER | TAP SIZE | D1 | D2 | L1 | REFERENCE PROJECTION |
| M1 TO M15 | TAP-1JIS-M1-2.6 | M1-2.6 | 0.748 | 1.180 | 0.850 | Projections may vary based on application |
| | TAP-1JIS-M3-3.5 | M3-3.5 | | | | |
| | TAP-1JIS-M4-4.5 | M4-4.5 | | | | |
| | TAP-1JIS-M5-5.5 | M5-5.5 | | | | |
| | TAP-1JIS-M6 | M6 | | | | |
| | TAP-1JIS-M7-8 | M7-8 | | | | |
| | TAP-1JIS-M9-10 | M9-10 | | | | |
| | TAP-1JIS-M11 | M11 | | | | |
| | TAP-1JIS-M12 | M12 | | | | |
| | TAP-1JIS-M13 | M13 | | | | |
| TAP-1JIS-M14-15 | M14-15 | | | | | |

| FOR SIZE 2 HOLDERS | | | | | | |
|--------------------|--------------|----------|-------|-------|-------|---|
| TAP RANGE | PART NUMBER | TAP SIZE | D1 | D2 | L1 | REFERENCE PROJECTION |
| M12 TO M20 | TAP-2JIS-M12 | M12 | 1.220 | 1.880 | 1.380 | Projections may vary based on application |
| | TAP-2JIS-M14 | M14 | | | | |
| | TAP-2JIS-M16 | M16 | | | | |
| | TAP-2JIS-M18 | M18 | | | | |
| TAP-2JIS-M20 | M20 | | | | | |

Extended Range Tap Adapters

- Ball drive eliminates rotational play or shifting between tap adapter and holder
- Quick-change capability allows dull or broken taps to be replaced in seconds
- Made from premium grade 4140 steel with case hardened precision ground bushings for extended wear and precision tapping
- Interchangeable with Bilz and other ball drive tap adapters



| FOR SIZE 1 HOLDERS | | | | | | |
|--------------------|----------|-------|-------|-------|-------|-----------------|
| PART NUMBER | TAP SIZE | D1 | D2 | L1 | L2 | REF. PROJECTION |
| TAP-1ER625 | 5/8 | 0.748 | 1.180 | 0.850 | 2.190 | 4.240 |
| TAP-1ER687 | 11/16 | | | | | 4.390 |
| TAP-1ER750 | 3/4 | | | | | 4.550 |
| TAP-1ER875 | 7/8 | | | | | 4.930 |
| TAP-1ER250N | 1/4 NPT | | | | 1.450 | 2.630 |
| TAP-1ER375N | 3/8 NPT | | | | | 2.750 |
| TAP-1ER500N | 1/2 NPT | | | | | 3.320 |

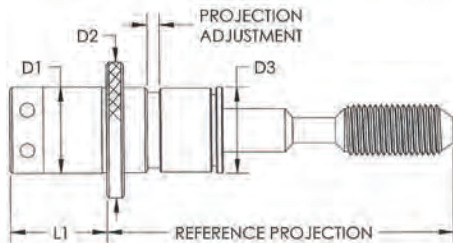
| FOR SIZE 2 HOLDERS | | | | | | |
|--------------------|----------------|-------|-------|-------|-------|-----------------|
| PART NUMBER | TAP SIZE | D1 | D2 | L1 | L2 | REF. PROJECTION |
| TAP-2ER937 | 15/16 | 1.220 | 1.880 | 1.380 | 3.170 | 5.540 |
| TAP-2ER1000 | 1 | | | | | 5.670 |
| TAP-2ER1062 | 1 1/16 | | | | | 5.600 |
| TAP-2ER1125 | 1 1/8 | | | | | 5.910 |
| TAP-2ER1250 | 1 3/16 & 1 1/4 | | | | | 5.790 |
| TAP-2ER1375 | 1 3/8 | | | | 7.760 | |
| TAP-2ER750N | 3/4 NPT | | | | 1.780 | 3.560 |
| TAP-2ER1000N | 1 NPT | 4.020 | | | | |

| FOR SIZE 3 HOLDERS | | | | | | |
|--------------------|----------------|-------|-------|-------|-------|-----------------|
| PART NUMBER | TAP SIZE | D1 | D2 | L1 | L2 | REF. PROJECTION |
| TAP-3ER1500 | 1 7/16 & 1 1/2 | 1.890 | 2.750 | 2.190 | 2.900 | 6.830 |
| TAP-3ER1625 | 1 5/8 | | | | | 7.460 |
| TAP-3ER1750 | 1 3/4 | | | | | 7.650 |
| TAP-3ER1875 | 1 7/8 | | | | | 7.960 |
| TAP-3ER2000 | 2 | | | | 8.150 | |
| TAP-3ER1250N | 1 1/4 NPT | | | | 1.650 | 4.250 |
| TAP-3ER1500N | 1 1/2 NPT | | | | | 4.500 |
| TAP-3ER2000N | 2 NPT | 2.900 | 4.750 | | | |

The Extended-Range Series can be used in applications where close center tapping of large taps presents a problem. The Extended-Range adapter permits large taps to be driven in a smaller holder thereby keeping diameters small.

Adjustable Length Tap Adapters

- Adjustable length tap adapters are used where accurate presetting of tap length is important
- Adjustment is made easy through the back of the adapter by rotating adjustment screw
- Extensions available to increase projection an additional 1 to 3 inches
- Extra length can eliminate the need for a pulley tap
- Ball drive eliminates rotational play or shifting between tap adapter and holder
- Quick-change capability allows dull or broken taps to be changed in seconds
- Made from premium grade 4140 steel with case hardened precision ground bushings for extended wear and precision tapping
- Interchangeable with Bilz and other ball drive tap adapters

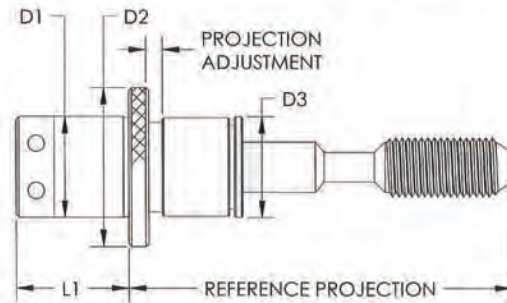


| FOR SIZE 1 HOLDERS | | | | | | |
|--------------------|----------|-------|-------|-------|-------|----------------------|
| PART NUMBER | TAP SIZE | L1 | D1 | D2 | D3 | REFERENCE PROJECTION |
| TAP-1AL06 | 0-6 | 0.850 | 0.748 | 1.180 | 0.750 | 2.52-2.91 |
| TAP-1AL08 | 8 | | | | | 2.59-2.98 |
| TAP-1AL10 | 10 | | | | | 2.84-3.23 |
| TAP-1AL12 | 12 | | | | | 2.81-3.20 |
| TAP-1AL250 | 1/4" | | | | | 2.90-3.29 |
| TAP-1AL312 | 5/16" | | | | | 2.97-3.36 |
| TAP-1AL375 | 3/8" | | | | | 3.13-3.52 |
| TAP-1AL437 | 7/16" | | | | | 3.38-3.77 |
| TAP-1AL500 | 1/2" | | | | | 3.57-3.96 |
| TAP-1AL562 | 9/16" | | | | | 3.72-4.11 |
| TAP-1AL125N | 1/8" NPT | | | | | 2.38-2.77 |

| FOR SIZE 2 HOLDERS | | | | | | |
|--------------------|----------|-------|-------|-------|-------|----------------------|
| PART NUMBER | TAP SIZE | L1 | D1 | D2 | D3 | REFERENCE PROJECTION |
| TAP-2AL562 | 9/16 | 1.380 | 1.220 | 1.880 | 1.180 | 4.670-5.260 |
| TAP-2AL625 | 5/8 | | | | | 4.390-4.980 |
| TAP-2AL687 | 11/16 | | | | | 4.550-5.140 |
| TAP-2AL750 | 3/4 | | | | | 4.700-5.290 |
| TAP-2AL812 | 13/16 | | | | | 4.920-5.510 |
| TAP-2AL875 | 7/8 | | | | | 5.080-5.670 |
| TAP-2AL125N | 1/8 NPT | | | | | 3.320-3.910 |
| TAP-2AL250N | 1/4 NPT | | | | | 3.490-4.080 |
| TAP-2AL375N | 3/8 NPT | | | | | 3.550-4.140 |
| TAP-2AL500N | 1/2 NPT | | | | | 3.990-4.580 |

Adjustable Length Reducing Tap Adapters

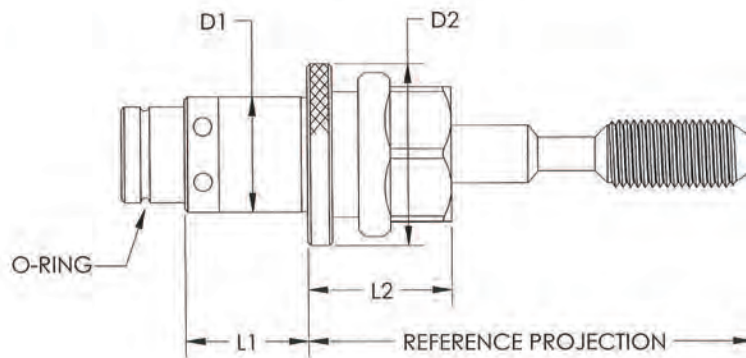
- Allows the use of taps generally used in a size 1 adapter, to be used in a size 2 adapter
- Adjustment is made easy through the back of the adapter by rotating adjustment screw
- Extensions available to increase projection an additional 1 to 3 inches
- Extra length can eliminate the need for a pulley cap
- Ball drive eliminates rotational play or shifting between tap adapter and holder
- Quick-change capability allows dull or broken taps to be changed in seconds
- Made from premium grade 4140 steel with case hardened precision ground bushings for extended wear and precision tapping
- Interchangeable with Bilz and other ball drive tap adapters



| FOR SIZE 2 HOLDERS | | | | | | |
|--------------------|----------|-------|-------|-------|------|----------------------|
| PART NUMBER | TAP SIZE | L1 | D1 | D2 | D3 | REFERENCE PROJECTION |
| TAP-2RA10 | 10 | 1.380 | 1.220 | 1.880 | .750 | 2.590 - 2.980 |
| TAP-2RA250 | 1/4 | | | | | 2.650 - 3.040 |
| TAP-2RA312 | 5/16 | | | | | 2.720 - 3.110 |
| TAP-2RA375 | 3/8 | | | | | 2.880 - 3.270 |
| TAP-2RA437 | 7/16 | | | | | 3.130 - 3.520 |
| TAP-2RA500 | 1/2 | | | | | 3.320 - 3.710 |

Coolant Through Tap Adapters

- Ball drive eliminates rotational play or shifting between tap adapter and holder
- Supplied with O-ring, collet nut and positive drive (order collets separately)
- This adapter is to be used with rigid holder only
- Maximum pressure 500 psi
- Interchangeable with Bilz and most other ball drive tap adapters
- Coolant through for complex tapping operations

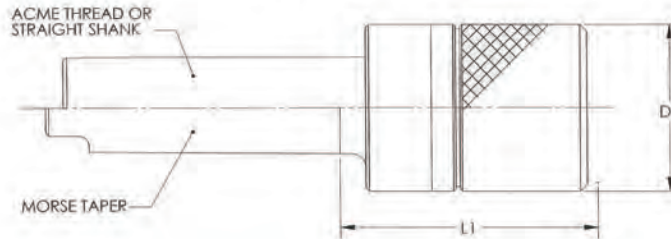


| FOR SIZE 1 HOLDERS | | | | | | |
|--------------------|----------|-------|-------|-------|-------|----------------------|
| PART NUMBER | TAP SIZE | D1 | D2 | L1 | L2 | REFERENCE PROJECTION |
| TAP-1CT250 | 1/4 | 0.748 | 1.180 | 0.850 | 1.060 | 2.22 |
| TAP-1CT312 | 5/16 | | | | | 2.30 |
| TAP-1CT375 | 3/8 | | | | | 2.52 |
| TAP-1CT437 | 7/16 | | | | | 2.74 |
| TAP-1CT500 | 1/2 | | | | | 2.96 |

| FOR SIZE 2 HOLDERS | | | | | | |
|--------------------|----------|-------|-------|-------|-------|----------------------|
| PART NUMBER | TAP SIZE | D1 | D2 | L1 | L2 | REFERENCE PROJECTION |
| TAP-1CT562 | 9/16 | 1.220 | 1.880 | 1.380 | 1.400 | 3.12 |
| TAP-1CT625 | 5/8 | | | | | 3.35 |
| TAP-1CT687 | 11/16 | | | | | 3.44 |
| TAP-1CT750 | 3/4 | | | | | 3.66 |
| TAP-1CT812 | 13/16 | | | | | 3.63 |
| TAP-1CT875 | 7/8 | | | | | 3.85 |

Specialty Shank Tap Holders

- Quick-change capability allows dull or broken taps to be replaced in seconds
- Ball bearing drive eliminates friction avoiding pushing or pulling of threads
- Will accept either lug drive or ball drive tap adapters

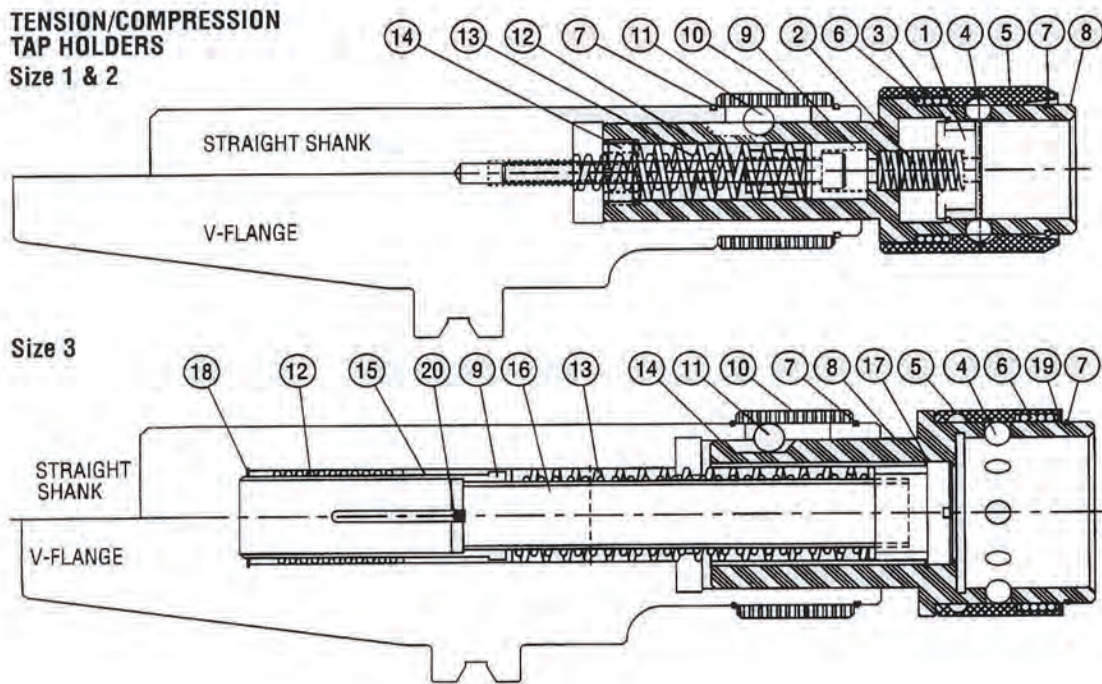


| FOR SIZE 1 ADAPTERS | | | | | | | | | | |
|---------------------|------------------------|---------------------|--------------|---------------------|-------|---------------------|-------|----------------|-------|-------|
| PART NUMBER | HOLDER STYLE | TAP SIZE RANGE | RADIAL FLOAT | SHANK | D1 | L1 | | | | |
| TAP1RF-MT2 | RADIAL FLOAT | 0 - 9/16 1/8 NPT | 0.070 | #2 MORSE TAPER | 1.260 | 2.610 | | | | |
| TAP1RF-A12 | | | | 3/4-12 ACME | | | | | | |
| TAP1RF-A14 | | | | 7/8-12 ACME | | | | | | |
| TAP1RF-A17 | | | | 1 1/16-12 ACME | | | | | | |
| TAP1RF-S16 | | | | 1" STRT SHANK | | | | | | |
| TAP1TC-A16 | TENSION COMPRESSION | | | 0 - 9/16 1/8 NPT | 0.070 | 1-12 ACME | 1.260 | 2.840 | | |
| TAP1TC-A17 | | | | | | 1 1/16-12 ACME | | | | |
| TAP1R-A12 | RIGID | | | | | 0 - 9/16 1/8 NPT | 0.070 | 3/4-12 ACME | 1.260 | 2.750 |
| TAP1R-A16 | | | | | | | | 1-12 ACME | | |
| TAP1R-A17 | | | | | | | | 1 1/16-12 ACME | | |
| TAP1R-A17 | | 1 1/16-12 ACME | | | | | | | | |

| FOR SIZE 2 ADAPTERS | | | | | | | | | | |
|---------------------|------------------------|--------------------------------|--------------|--------------------------------|-------|--------------------------------|-------|----------------|-------|-------|
| PART NUMBER | HOLDER STYLE | TAP SIZE RANGE | RADIAL FLOAT | SHANK | D1 | L1 | | | | |
| TAP2RF-MT3 | RADIAL FLOAT | 5/16 - 7/8 1/8 - 1/2 NPT | 0.095 | #3 MORSE TAPER | 1.960 | 3.610 | | | | |
| TAP2RF-A17 | | | | 1 1/16-12 ACME | | | | | | |
| TAP2RF-A22 | | | | 1 3/8-12 ACME | | | | | | |
| TAP2RF-S16 | | | | 1" STRT SHANK | | | | | | |
| TAP2TC-A16 | TENSION COMPRESSION | | | 5/16 - 7/8 1/8 - 1/2 NPT | 0.095 | 1-12 ACME | 1.960 | 4.740 | | |
| TAP2TC-A17 | | | | | | 1 1/16-12 ACME | | | | |
| TAP2TC-A22 | | | | | | 1 3/8-12 ACME | | | | |
| TAP2R-A16 | RIGID | | | | | 5/16 - 7/8 1/8 - 1/2 NPT | 0.095 | 1-12 ACME | 1.960 | 4.500 |
| TAP2R-A17 | | | | | | | | 1 1/16-12 ACME | | |
| TAP2R-A17 | | | | | | | | 1 1/16-12 ACME | | |
| TAP2R-A22 | | 1 3/8-12 ACME | | | | | | | | |

| FOR SIZE 3 ADAPTERS | | | | | | |
|---------------------|--------------|------------------------------|--------------|----------------|-------|-------|
| PART NUMBER | HOLDER STYLE | TAP SIZE RANGE | RADIAL FLOAT | SHANK | D1 | L1 |
| TAP-3MT4 | RADIAL FLOAT | 3/4-1 3/8 3/4 , 1" NPT | 0.150 | #4 MORSE TAPER | 2.910 | 5.180 |

CNC Tapping Replacement Components



| DETAIL NUMBER | DESCRIPTION | SIZE 1 | SIZE 2 | SIZE 3 | QTY. |
|---------------|--------------------------------|--------------|--------------|------------------|------|
| 1 | Pressure Plug | TC31-01 | TC32-01 | *** | 1 |
| 2 | Pressure Plug Spring | PT-1006 | PT-1007 | *** | 1 |
| 3 | Pressure Plug Retaining Spring | LR.039X.840 | LR.047X1.280 | *** | 1 |
| 4 | Adaptor Drive Balls | 4.5MM GR.25 | 6.5MM GR.25 | 9.0MM GR.25 | 6 |
| 5 | Unlocking Shell | 81-006 | 82-006 | 83-006 | 1 |
| 6 | Unlocking Shell Spring | PT-1008 | PT-1009 | PT-1010 | 1 |
| 7 | Shell Retaining Spring | LR.039X1.006 | LR.059X1.600 | LR.071X2.400 | 3 |
| 8 | Tap Adaptor Carrier | TC31-02 | TC32-02 | TC33-02 | 1 |
| 9 | Spring Bushing | TC31-03 | TC32-03 | TC33-03 | 1 |
| 10 | Ball Cage | TC31-04 | TC32-04 | TC33-04 | 1 |
| 11 | T&C Compensating Balls | 5.5MM GR.25 | 8.5MM GR.25 | 12.0MM GR.25 | 3 |
| 12 | Tension Spring | PT-1011 | PT-1011 | 1327-01 | 1 |
| 13 | Compression Spring | B11-65/ALT | B11-65/ALT | PT-1012 | 2 |
| 14 | Carrier Retaining Screw | TC31-05 | TC32-05 | TC33-05 | 1 |
| 15 | T&C Adjustment Nut | *** | *** | TC33-06 | 1 |
| 16 | T&C Adjustment Screw | *** | *** | TC3-06 | 1 |
| 17 | TRU ARC Ring | *** | *** | N5000-131 | 1 |
| 18 | Tension Spring Snap Ring | *** | *** | WSM-50 | 1 |
| 19 | Unlocking Spring Seat | *** | *** | TC3-014 | 1 |
| 20 | Roll Pin | *** | *** | 1/8 X 3/4 TYPE A | 1 |

Tap Reference Guide

| TAPS FOR STANDARD ADAPTERS | | | | | | | | |
|--|------|------|--|------|------|--|--------|------|
| SIZE 1 ADAPTERS PAGE # 5 USE HOLDER SIZE 1 | | | SIZE 2 ADAPTERS PAGE # 5 USE HOLDER SIZE 2 | | | SIZE 3 ADAPTERS PAGE # 6 USE HOLDER SIZE 3 | | |
| TAP SIZE | SHK. | SQ. | TAP SIZE | SHK. | SQ. | TAP SIZE | SHK. | Sq. |
| 0-6 | .141 | .110 | 5/8 | .480 | .360 | 3/4 | .590 | .442 |
| 8 | .168 | .131 | 11/16 | .542 | .406 | 7/8 | .697 | .523 |
| 10 | .194 | .152 | 3/4 | .590 | .442 | 15/16 | .760 | .570 |
| 12 | .220 | .165 | 13/16 | .652 | .489 | 1 | .800 | .600 |
| 1/4 | .255 | .191 | 7/8 | .697 | .523 | 1 1/16 | .896 | .672 |
| 5/16 | .318 | .238 | 1/4 NPT | .563 | .421 | 1 1/8 | .896 | .672 |
| 3/8 | .381 | .286 | 3/8 NPT | .700 | .531 | 1 3/16 | 1.021 | .766 |
| 7/16 | .323 | .242 | 1/2 NPT | .688 | .515 | 1 1/4 | 1.021 | .766 |
| 1/2 | .367 | .275 | | | | 1 5/16 | 1.108 | .831 |
| 9/16 | .429 | .322 | | | | 1 3/8 | 1.108 | .831 |
| 1/8 R.S. | .438 | .328 | | | | 3/4 NPT | .906 | .679 |
| 1/8 S.S. | .313 | .234 | | | | 1 NPT | 1.1251 | .843 |
| 1/16 NPT | 3.13 | .234 | | | | | | |

| TAPS FOR EXTENDED RANGE ADAPTERS | | | | | | | | |
|--|------|------|--|-------|------|--|-------|-------|
| SIZE 1 ADAPTERS PAGE # 7 USE HOLDER SIZE 1 | | | SIZE 2 ADAPTERS PAGE # 7 USE HOLDER SIZE 2 | | | SIZE 3 ADAPTERS PAGE # 7 USE HOLDER SIZE 3 | | |
| TAP SIZE | SHK. | SQ. | TAP SIZE | SHK. | SQ. | TAP SIZE | SHK. | Sq. |
| 5/8 | .480 | .360 | 15/16 | .760 | .570 | 1 7/16 | 1.233 | .925 |
| 11/16 | .542 | .406 | 1 | .800 | .600 | 1 1/2 | 1.233 | .925 |
| 3/4 | .590 | .442 | 1 1/16 | .896 | .672 | 1 5/8 | 1.305 | .979 |
| 13/16 | .652 | .489 | 1 1/8 | .896 | .672 | 1 3/4 | 1.430 | 1.072 |
| 7/8 | .697 | .523 | 1 3/16 | 1.021 | .766 | 1 7/8 | 1.519 | 1.139 |
| 1/4 | .563 | .421 | 1 1/4 | 1.021 | .766 | 2 | 1.644 | 1.233 |
| 3/8 | .700 | .531 | 1 5/16 | 1.108 | .831 | 2 1/8 | 1.769 | 1.327 |
| 1/2 | .688 | .515 | 1 3/8 | 1.108 | .831 | 2 1/4 | 1.894 | 1.420 |
| | | | 3/4 | .906 | .679 | 2 3/8 | 2.019 | 1.514 |
| | | | | | | 2 1/2 | 2.100 | 1.575 |
| | | | | | | 1 1/4 | 1.313 | .984 |
| | | | | | | 1 1/2 | 1.500 | 1.125 |
| | | | | | | 2 | 1.875 | 1.406 |



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