



DRILL TAPPER

BIG DAISHOWA SEIKI CO LTD

CATALOG No. **EXi9**

**3 SECOND QUICK TOOL CHANGE
ONE HEAD FOR DRILLING & TAPPING
REDUCES DOWNTIME
ASSURES ACCURACY**



**ECONOMICAL TAPPING
WITH BIG DRILL TAPPER**

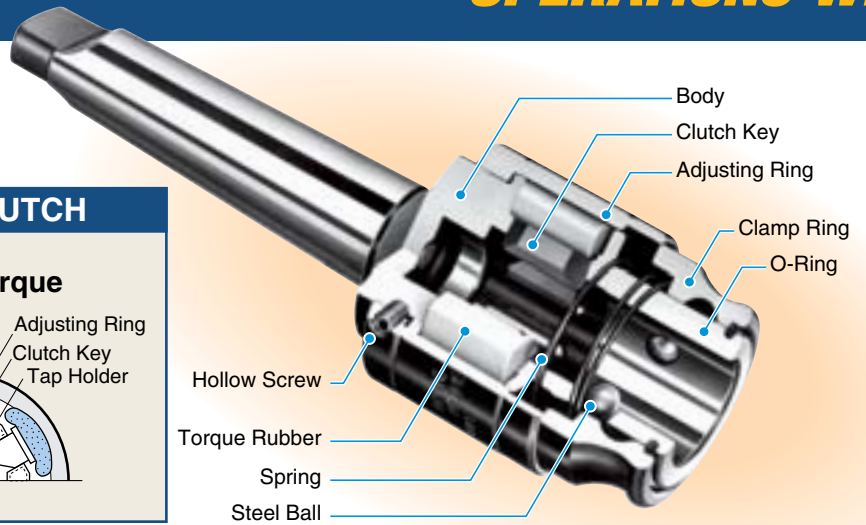
**THREE MODELS COVER
TAPPING RANGE FROM
No.8 to 2"**



FEATURES

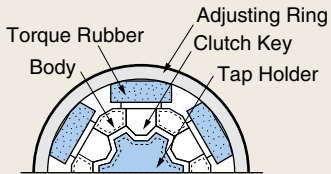
- Quick change holders allow fast changing of taps and drills only seconds.
- Automatic torque limiter built into each drill tapper.
- Adjustable torque control provides easy selection for the material to be tapped.
- Built-in safety clutch and exclusive tap holders assure safe tapping. There is no need to adjust torque for tapping blind or through holes.
- Stable tapping is assured by simple but efficient cross tapping prevention system.
- Excellent durability is achieved by utilizing the largest possible contact area, the finest quality material with hardness of HRC 63, and ground clutch keys. After long periods of use, the original torque can easily be restored by replacement of the clutch keys and torque rubbers.



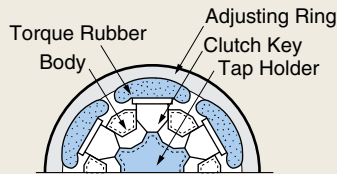


CONSTRUCTION OF SAFETY CLUTCH

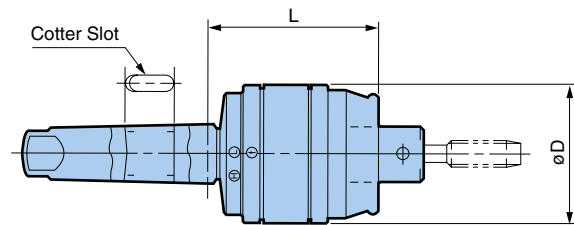
At normal torque



At over-torque



DRILL TAPPER HEAD



Model	Taper	Tapping Range		Drilling capacity	D	L	Weight (lbs)
		UNC	PT, PF				
DT24-2	MT2	No.8 - 1/2	1/8 - 1/4	.825	2.80	4.00	4.2
DT24-3	MT3	No.8 - 7/8	1/8 - 1/2	1.250			4.6
DT24-4	MT4						6.2
DT33-4	MT4	5/16 - 7/8	1/8 - 1	2.000	3.46	4.50	8.8
DT33-5ANSI	MT5						10.6
DT52-5ANSI	MT5	7/8 - 2	1/2 - 1 ³ / ₄	3.000	4.45	5.40	19.6

- MT2,3,4 Taper are without Cotter Slots.
- MT5 Taper is provided with ANSI Standard Cotter Slots.

STANDARD SETS



⚠ Not Include Drill Chuck

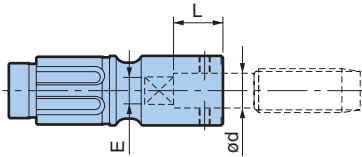
Set Model	Taper	Head	HOLDERS
SDT24-2 ANSI	MT2	DT24-2	T24-No.10, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, J24-6
SDT24-3 ANSI	MT3	DT24-3	T24-1/4, 5/16, 3/8, 1/2, 5/8, 3/4, 7/8
SDT24-4 ANSI	MT4	DT24-4	J24-6, D24-MT2
SDT33-4 ANSI	MT4	DT33-4	T33-3/8, 1/2, 5/8, 3/4, 7/8, 1, 1.1/4
SDT33-5 ANSI	MT5	DT33-5ANSI	J33-6, D33-MT3

- Sets do not include Drill Chuck.
- MT5 Taper is provided with ANSI Standard Cotter Slots.

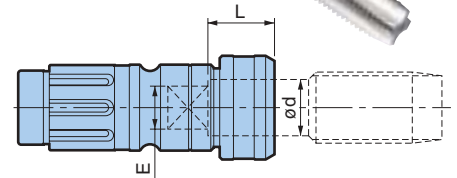
SYSTEM FOR DRILLING AND TAPPING-TWO ONE HEAD!

STANDARD TAP HOLDER

for DT24 · DT33
Side Lock System



for DT52
Collet Chuck System



for DT24	
Model	L
T24-NO.8	0.748
T24-NO.10	
T24-NO.12	
T24-AU1/4	
T24-AU5/16	
T24-AU3/8	
T24-AU7/16	0.866
T24-AU1/2	
T24-AU9/16	
T24-AU5/8	
T24-AU11/16	
T24-AU3/4	
T24-AU13/16	0.748
T24-AU7/8	
T24-AU15/16	
T24-AP1/8	
T24-AP1/4	
T24-AP3/8	
T24-AP1/2	

for DT33	
Model	L
T33-AU5/16	0.748
T33-AU3/8	
T33-AU7/16	
T33-AU1/2	
T33-AU9/16	
T33-AU5/8	
T33-AU11/16	0.866
T33-AU3/4	
T33-AU13/16	
T33-AU7/8	
T33-AU15/16	
T33-AU1	
T33-AU1.1/8	0.748
T33-AU1.1/4	
T33-AP1/8	
T33-AP1/4	
T33-AP3/8	
T33-AP1/2	
T33-AP3/4	
T33-AP1	

for DT52	
Model	L
T52-AU7/8	1.063
T52-AU15/16	
T52-AU1	
T52-AU1.1/8	1.260
T52-AU1.1/4	
T52-AU1.3/8	
T52-AU1.1/2	1.378
T52-AU1.5/8	
T52-AU1.3/4	
T52-AU1.7/8	1.575
T52-AU2	
T52-AP3/8	0.906
T52-AP1/2	
T52-AP3/4	0.984
T52-AP1	0.827
T52-AP1.1/4	0.984
T52-AP1.1/2	1.102

* Floating Tap Holders see next page.

Reference Table

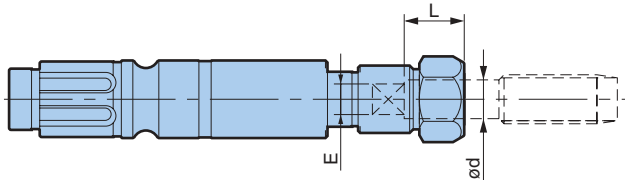
Unified and American National Thread									ANPT, NPT and NPTP		
SIZE	ød	E	SIZE	ød	E	SIZE	ød	E	SIZE	ød	E
NO.8	0.168	0.131	AU9/16	0.429	0.322	AU1.1/8	0.896	0.672	AP1/8	0.438	0.328
NO.10	0.194	0.152	AU5/8	0.480	0.360	AU1.1/4	1.021	0.766	AP1/4	0.563	0.421
NO.12	0.220	0.165	AU11/16	0.542	0.406	AU1.3/8	1.108	0.831	AP3/8	0.700	0.531
AU1/4	0.255	0.191	AU3/4	0.590	0.442	AU1.1/2	1.233	0.925	AP1/2	0.688	0.515
AU5/16	0.318	0.238	AU13/16	0.652	0.482	AU1.5/8	1.305	0.979	AP3/4	0.906	0.679
AU3/8	0.381	0.286	AU7/8	0.697	0.523	AU1.3/4	1.430	1.072	AP1	1.125	0.843
AU7/16	0.323	0.242	AU15/16	0.760	0.570	AU1.7/8	1.519	1.139	AP1.1/4	1.313	0.984
AU1/2	0.367	0.275	AU1	0.800	0.600	AU2	1.644	1.233	AP1.1/2	1.500	1.125

ød=Diameter of shank E=Size of square

FLOATING TAP HOLDER



Unique floating mechanism system automatically adjusts the difference between the spindle feed of the tap.

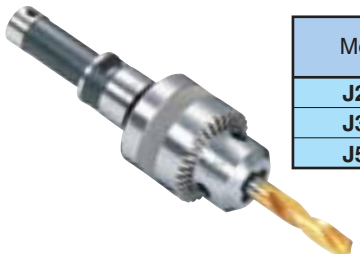


for DT24		Compression=0.59" Tension=0.59"
Model	L	
T24-NO.8FT	0.866	
T24-NO.10FT		
T24-NO.12FT		
T24-AU1/4FT		
T24-AU5/16FT		
T24-AU3/8FT		
T24-AU7/16FT		
T24-AU1/2FT	0.984	
T24-AU9/16FT		
T24-AU5/8FT		
T24-AU11/16FT		
T24-AU3/4FT		
T24-AU13/16FT	1.063	
T24-AU7/8FT		
T24-AU15/16FT		
T24-AP1/8FT	0.866	
T24-AP1/4FT	0.709	
T24-AP3/8FT	0.748	
T24-AP1/2FT	0.984	

for DT33		Compression=0.59" Tension=0.59"
Model	L	
T33-AU5/16FT	0.866	
T33-AU3/8FT		
T33-AU7/16FT		
T33-AU1/2FT		
T33-AU9/16FT		
T33-AU5/8FT	0.984	
T33-AU11/16FT		
T33-AU3/4FT		
T33-AU13/16FT		
T33-AU7/8FT	1.063	
T33-AU15/16FT		
T33-AU1FT		
T33-AU1.1/8FT	0.866	
T33-AU1.1/4FT		
T33-AP1/8FT	0.709	
T33-AP1/4FT	0.748	
T33-AP3/8FT	0.984	
T33-AP1/2FT	1.063	
T33-AP3/4FT		
T33-AP1FT		

for DT52		Compression=0.59" Tension=0.79"
Model	L	
T52-AU7/8FT	1.063	
T52-AU15/16FT		
T52-AU1FT		
T52-AU1.1/8FT	1.260	
T52-AU1.1/4FT		
T52-AU1.1/2FT	1.378	
T52-AU1.5/8FT		
T52-AU1.3/4FT		
T52-AU1.7/8FT	1.535	
T52-AU2FT		
T52-AP3/8FT	0.984	
T52-AP1/2FT		
T52-AP3/4FT		
T52-AP1FT	1.378	
T52-AP1.1/4FT		
T52-AP1.1/2FT		

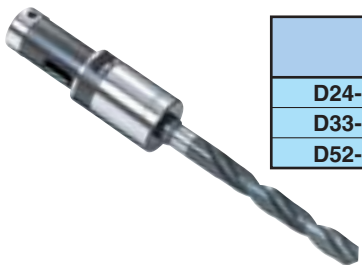
DRILL CHUCK ADAPTER



Model	Head
J24-6	DT24
J33-6	DT33
J52-6	DT52

Drill Chuck is not included
JACOBS Taper JT6

MORSE TAPER ADAPTER



Model	Head
D24-MT1, MT2, MT3	DT24
D33-MT1, MT2, MT3, MT4	DT33
D52-MT2, MT3, MT4, MT5	DT52

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