

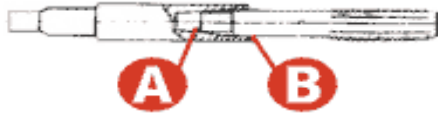
Self-Locking

TAP EXTENSION

A way to solve your long tapping problems with an extension that offers all the benefits of a long tap but at the cost associated with a standard tap.

The secret of the Tap Extensions' unique self-locking design is a precision machined EDM cavity that receives the end of a standard tap.

The bottom part of the cavity, **(A)**, is a tapered square with a wall angle of less than one degree, which receives the square section of the tap and grips it so securely that a thin drift is needed to separate the tap and the extension.



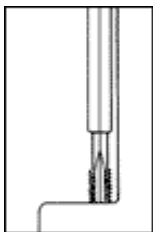
The cylindrical part of the tap shank fits tightly into a similar cavity in the extension, **(B)**,

providing resistance to bending. Each extension is designed for a specific tap size, and the tapered square and round socket conform to the size standards of leading tap manufacturers.

**NO SET SCREWS
NO COLLETS
NEEDED**



Why It's Different

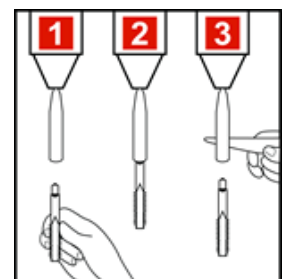


Minimum Diameters For Close Quarter Tapping

Because the Tap Extension has no set screws or collars which extend shaft diameter, and because each extension is sized for a particular tap size, it offers unique capabilities in allowing the user to tap close to the edge or shoulder of the workpiece. With the Tap Extension, as opposed to collar types, the distance from centerline to the edge of the workpiece can be as little as one half the diameter of the extension size.

Quick Change

To set up or to change a tap, the operator inserts the proper size tap and seats it firmly until there is no play between the two tools. **(1)** That's all there is to it! No set screws to set, no collets to locate and install, no collars to tighten. The operator then proceeds to tap the hole. This process seats the tap so firmly in the tapered socket that it requires a thin drift to separate the two, and trues the tap. **(2)** To replace a tap when it dulls or breaks, the operator simply inserts a thin drift into the slot in the end of the extension and pries the tap loose. **(3)**

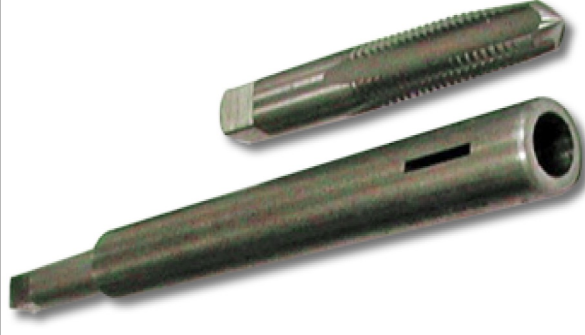


See reverse side of sheet for Machine & Pipe extension size charts

No. 101 Extension for MACHINE TAPPING

PART NUMBERS

Standard TAP SIZE	Maximum Extension DIAMETER	Maximum TAP SHANK Accepted	Maximum TAP SQUARE Accepted	Length of SMALL SHANK of Extension	Diameter of SMALL SHANK of Extension	Square SHANK of Extension	2" Length	4" Length	6" Length	8" Length
	A	B	C	D	E	F				
0-6	.250	.141	.110		.191	.191	1012	1014	1016	1018
8	.250	.168	.131		.191	.191	1022	1024	1026	1028
10	.250	.194	.152		.191	.191	1032	1034	1036	1038
12	.312	.220	.165	1.5	.220	.165		1044	1046	1048
1/4	.375	.255	.191	1.5	.255	.191		1054	1056	1058
5/16	.437	.318	.238	1.5	.318	.238		1064	1066	1068
3/8	.500	.381	.286	1.5	.381	.286		1074	1076	1078
7/16	.500	.323	.242	1.5	.323	.242		1084	1086	1088
1/2	.500	.367	.275	1.5	.367	.275		1094	1096	1098
9/16	.625	.429	.322	1.5	.429	.322		1104	1106	1108
5/8	.625	.480	.360	1.5	.480	.360		1114	1116	1118
11/16	.625	.542	.406	1.5	.541	.406		1124	1126	1128
3/4	.750	.590	.442	1.5	.590	.442		1134	1136	1138
13/16	.875	.652	.489	1.5	.652	.489		1144	1146	1148
7/8	.875	.697	.523	1.5	.697	.523		1154	1156	1158
15/16	.875	.760	.570	1.5	.760	.570		1164	1166	1168
1	1.000	.800	.600	1.5	.800	.600		1174	1176	1178
1-1/8	1.125	.896	.672	1.5	.896	.672		1184	1186	1188
1-1/4	1.250	1.021	.766	1.5	1.021	.766		1194	1196	1198



*MINIMUM SIZES ARE PUBLISHED MAXIMUMS LESS THE FOLLOWING

TAP SIZE	MINIMUM TAP SHANK	TAP SIZE	MINIMUM TAP SQUARE
0-#12	-.004	0-3/4"	-.004
1/4-1"	-.005	7/8-1"	-.006



No. 102 Extension for PIPE TAPPING

PART NUMBERS

Standard TAP SIZE	Maximum Extension DIAMETER	Maximum TAP SHANK Accepted	Maximum TAP SQUARE Accepted	Length of SMALL SHANK of Extension	Diameter of SMALL SHANK of Extension	4" Length	6" Length	8" Length
	A	B	C	D	E			
1/16	.437	.312	.234	1.5	.312	2014	2016	2018
1/8	.625	.437	.328	1.5	.437	2024	2026	2028
1/4	.750	.562	.421	1.5	.562	2034	2036	2038
3/8	.875	.700	.531	1.5	.700	2044	2046	2048
1/2	.875	.687	.515	1.5	.687	2054	2056	2058
3/4	1.125	.906	.679	1.5	.906	2064	2066	2068
1"	1.312	1.125	.843	1.5	1.125	2074	2076	2078
1-1/4	1.500	1.3125	.984	1.5	1.3125	2094	2096	2098
1-1/2	1.750	1.500	1.125	1.5	1.500	3014	3016	3018

call for a quote on special sizes

*MINIMUM SIZES ARE PUBLISHED MAXIMUMS LESS THE FOLLOWING

TAP SIZE	MINIMUM TAP SHANK	TAP SIZE	MINIMUM TAP SQUARE
1/16	-.002	1/16-1/8	-.004
1/8-1/2	-.007	1/4-3/4	-.006
3/4-1"	-.009	1"+	-.008