

Quick Change Drilling & Tapping Chucks

1) Quick Change Drilling & Tapping Chuck :

- QCDTC
- QCDA Series Adaptors

2) Quick Change Tapping Chuck :

- Quick Change Chuck Q Series
- CCSFL
- QSFL
- KWSFL 60 & KWE 60 Adaptors



Quick Change Drilling & Tapping Chuck

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Quick Change Drilling & Tapping Chuck (QCDTC)

▣ Features :

- With its Appropriate Quick Change Adaptors For Drilling, Counterboring, Reaming & Tapping Operations, is the ideal Quick change system. This system is capable to Perform Economically and with the Highest Accuracy, an Unlimited Number of Operations at a Single Clamping of the Component.
- The Adaptor Locks Automatically in the main body after the insertion, ejects Positively When Required, High Concentricity with no Axial and Radial Play, Extremely Short Movement when Changing the tools, Tool Change can be Effected Safely and Efficiently with the Spindle running up to 2000 r.p.m. or stationery. It can be used for Right Hand or Left Hand Rotations, for Horizontal or Vertical Applications.

▣ Vertical as well as Horizontal Applications :

- Drilling
- Counterboring
- Chamfering
- Reaming
- Tapping

▣ Best Suitable for :

- Drilling Machines
- Radial Drilling Machines
- Lathe Machines
- Tool Room Milling Machines

▣ Available In Size :

- QCDTC 2
- QCDTC 3
- QCDTC 4

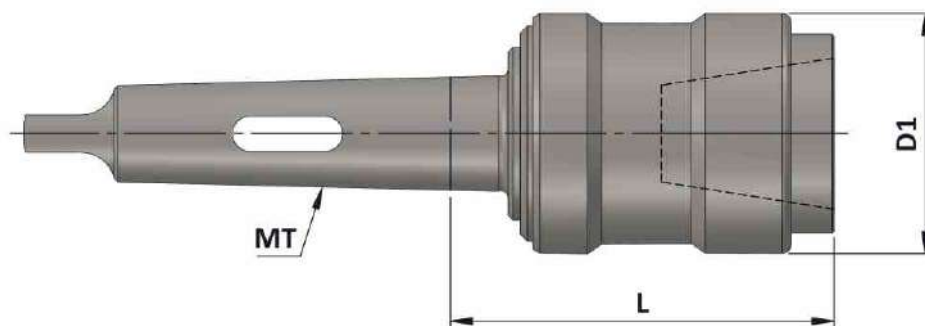




Quick Change Adaptor Applications

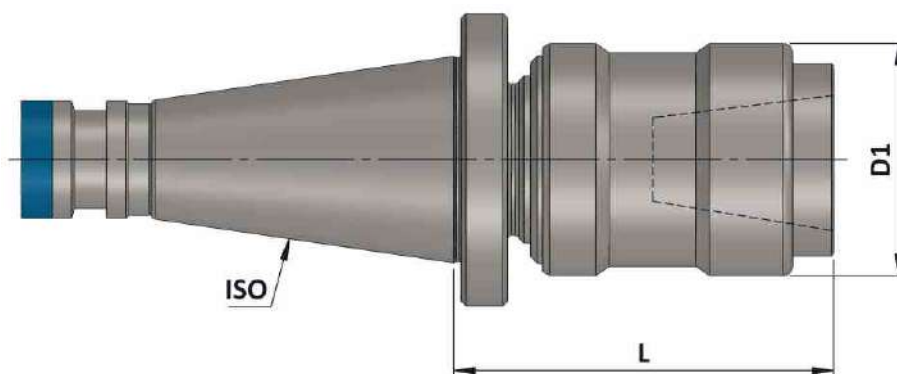
▣ Application :

- Adaptor Type **QCDA** : **Q**uick **C**hange **D**rill **A**daptor suitable for Morse Taper Drills.
- Adaptor Type **QCADA** : **Q**uick **C**hange **A**ddjustable **D**rill **A**daptor suitable for Morse Taper Drills for pre-setting off the machine, Should be used with adjustable adaptors TR28X2 or TR16X2.
- Adaptor Type **QCFRH** : **Q**uick **C**hange **F**loating **R**eamer **H**older suitable for Reamers, with self centering radial parallel float.
- Adaptor Type **QCCD/60** : **Q**uick **C**hange **C**enter **D**ead suitable for Toolroom work.
- Adaptor Type **QCCCA** : **Q**uick **C**hange **C**ollet **C**huck **A**daptor suitable for 'ER' Type Collets.
- Adaptor Type **QCDCA** : **Q**uick **C**hange **D**rill **C**huck **A**daptor suitable for keyless Drill Chucks.
- Adaptor Type **QCTAH../..** : **Q**uick **C**hange **T**ap **A**daptor **H**older suitable for tapping with KWES Tap Adaptors.



QCDTC - With Morse Taper Shank (MT)

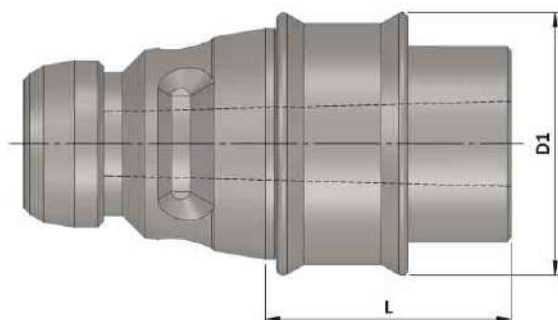
Item Name	Item Code	Suitable Adaptor	D1	L
MT 2 B QCDTC2	K11201230193	SIZE2	50	75
MT 3 B QCDTC2	K11202230193	SIZE2	50	75
MT 3 B QCDTC3	K11202231193	SIZE3	60	88
MT 4 B QCDTC3	K11213231193	SIZE3	60	89
MT 4 B QCDTC4	K11213232193	SIZE4	72	102
MT 5 B QCDTC4	K11215232193	SIZE4	72	102



QCDTC - With ISO Shank

Item Name	Item Code	Suitable Adaptor	D1	L
ISO40 QCDTC3	K11112231193	SIZE3	60	109
ISO40 QCDTC4	K11112232193	SIZE4	72	122
ISO50 QCDTC3	K11113231193	SIZE3	60	99
ISO50 QCDTC4	K11113232193	SIZE4	72	112

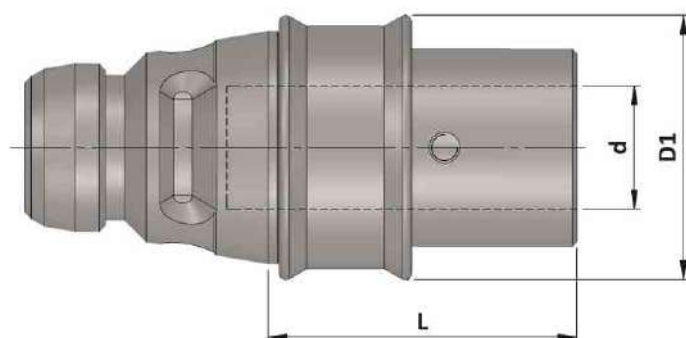
Note: All Dimensions are in mm



QCDA../MT..

Item Name	Item Code	Suitable Chuck	D1	L
QCDA2 MT 1	K11120237193	QCDTC2	42	18
QCDA2 MT 2	K11120140193	QCDTC2	42	30.5
QCDA3 MT 1	K11121237193	QCDTC3	50	20.5
QCDA3 MT 2	K11121140193	QCDTC3	50	20.5
QCDA3 MT 3	K11121113193	QCDTC3	50	38.5
QCDA4 MT 1	K11122237193	QCDTC4	60	33.5
QCDA4 MT 2	K11122140193	QCDTC4	60	33.5
QCDA4 MT 3	K11122113193	QCDTC4	60	33.5
QCDA4 MT 4	K11122114193	QCDTC4	60	56

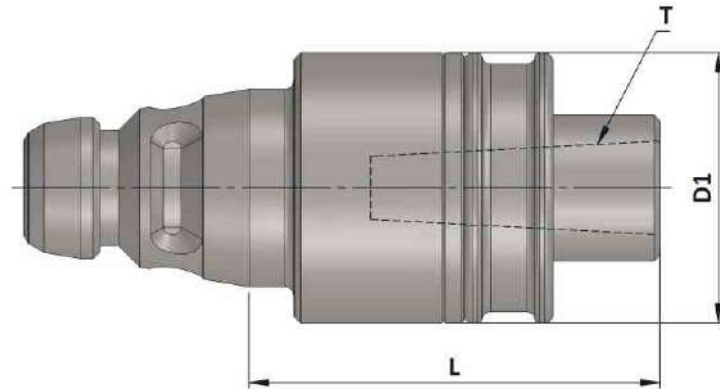
Quick Change Adjustable Drill Adaptor (QCADA../PB)



QCADA../PB

Item Name	Item Code	d	D1	L	Suitable Chuck
QCADA2 PB 16	K11120109193	16	42	32	QCDTC2
QCADA3 PB 28	K11121110193	28	50	70	QCDTC3
QCADA4 PB 28	K11122110193	28	60	70	QCDTC4

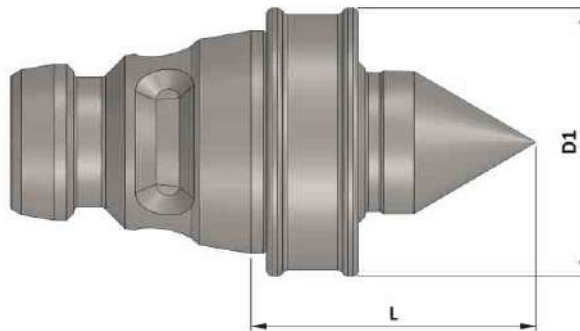
Note: All Dimensions are in mm



QCFRH../MT..

Item Name	Item Code	Suitable Chuck	D1	L	Morse Taper (T)	Radial Parallel Float
QCFRH3 MT 3	K11123113193	QCDTC3	60	91	MT 3	1.5
QCFRH4 MT 4	K11124114193	QCDTC4	72	115	MT 4	1.5

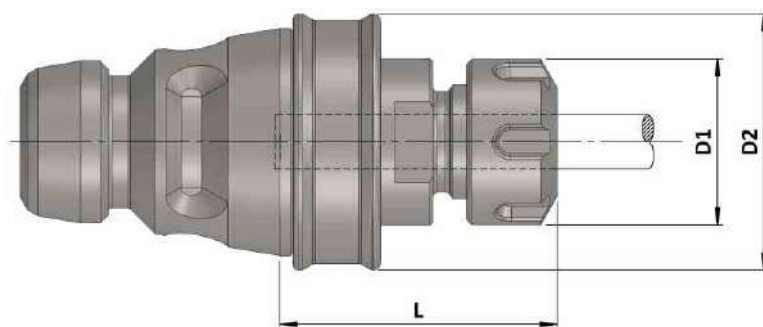
Quick Change Center Dead (QCCD/60 DEG)



QCCD../60 DEG

Item Name	Item Code	Suitable Chuck	D1	L
QCCD 2 /60 DEGREE	K11220255193	QCDTC2	42	46
QCCD 3 /60 DEGREE	K11221255193	QCDTC3	50	65
QCCD 4 /60 DEGREE	K11222255193	QCDTC4	60	78

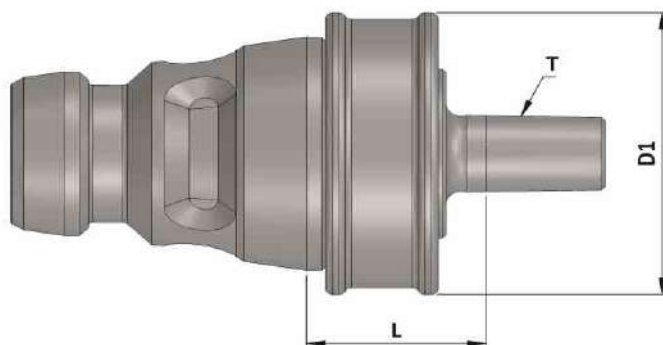
Note: All Dimensions are in mm



QCCCA../ER

Item Name	Item Code	Suitable Chuck	D1	D2	L
QCCCA2 ER 16	K11114238193	QCDTC2	32	42	42
QCCCA3 ER 16	K11115238193	QCDTC3	32	50	42
QCCCA3 ER 32	K11115239193	QCDTC3	50	50	51
QCCCA4 ER 32	K11116239193	QCDTC4	50	60	63
QCCCA4 ER 40	K11116240193	QCDTC4	63	60	63

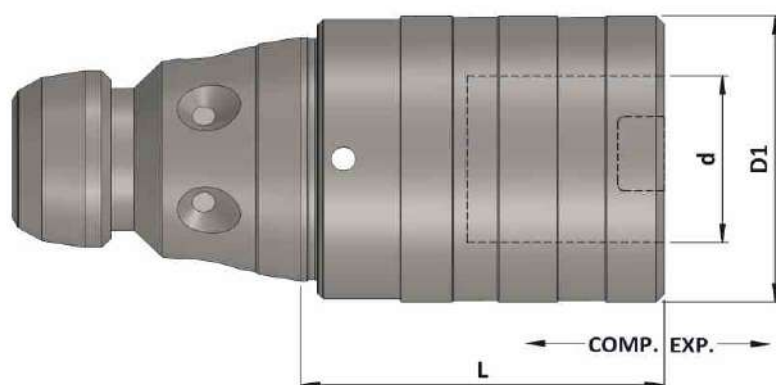
Quick Change Drill Chuck Adaptor (QCDCA../B)



QCDCA../B

Item Name	Item Code	Suitable Chuck	D1	T	L
QCDCA2/ B12	K11117107193	QCDTC2	42	B12	21.5
QCDCA3/ B16	K11118108193	QCDTC3	50	B16	26
QCDCA4/ B16	K11119108193	QCDTC4	60	B16	39

Note: All Dimensions are in mm



QCTAH../..

Item Name	Item Code	Capacity	Suitable Adaptor	Suitable Chuck	Comp.	Exp.	d	D1	L
QCTAH2 /1	K11125112193	M3 - M12	KWES1B	QCDTC2	7.5	7.5	19	36	42
QCTAH2 /2	K11125115193	M8 - M20	KWES2B	QCDTC2	12.5	12.5	31	53	72
QCTAH3 /1	K11126112193	M3 - M12	KWES1B	QCDTC3	7.5	7.5	19	36	42
QCTAH3 /2	K11126115193	M8 - M20	KWES2B	QCDTC3	12.5	12.5	31	53	66
QCTAH3 /3	K11126116193	M14 - M33	KWES3B	QCDTC3	20	20	48	78	126
QCTAH4 /1	K11127112193	M3 - M12	KWES1B	QCDTC4	7.5	7.5	19	36	42
QCTAH4 /2	K11127115193	M8 - M20	KWES2B	QCDTC4	12.5	12.5	31	53	66
QCTAH4 /3	K11127116193	M14 - M33	KWES3B	QCDTC4	20	20	48	78	121
QCTAH4 /4	K11127117193	M22 - M48	KWES4B	QCDTC4	22.5	22.5	60	96	135

Accessories



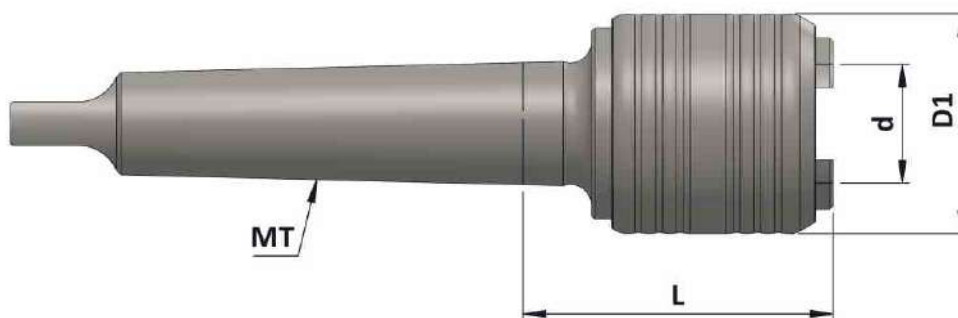
For Tap Adaptor KWES..B & KWESK..B
Ref. Page No. 267-288



For Tap Adaptor
Reduction Socket KWRE
Ref. Page No. 289

☞ For Tap Shank Dimension & Recommended Torque Values Ref. Page No. 290-292

Note: All Dimensions are in mm



Q (Morse Taper)

(No Compression & No Expansion)

Item Name	Item Code	Capacity	Suitable Adaptor	d	D1	L
MT 2 B Q 3-12	K11201241223	M3 - M12	KWE1	19	32	40
MT 3 B Q 3-12	K11202241223	M3 - M12	KWE1	19	32	40
MT 2 B Q 8-20	K11201241225	M8 - M20	KWE2	31	50	61
MT 3 B Q 8-20	K11202241225	M8 - M20	KWE2	31	50	61

Accessories



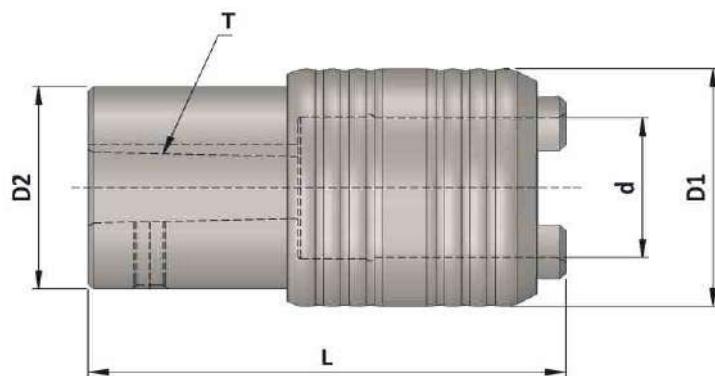
For Tap Adaptor KWE & KWEK
Ref. Page No. 253-266



For Tap Adaptor
Reduction Socket KWRE
Ref. Page No. 289

☞ For Tap Shank Dimension & Recommended Torque Values Ref. Page No. 290-292

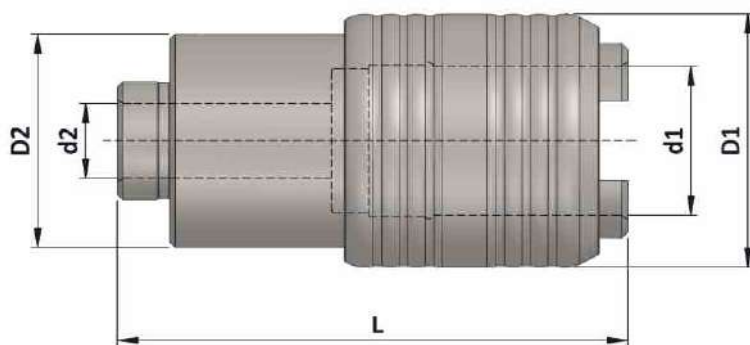
Note: All Dimensions are in mm



Q (Short Internal Tapper)

(No Compression & No Expansion)

Item Name	Item Code	Capacity	Suitable Adaptor	d	D1	D2	T	L
INTERNAL B12 Q 3-12	K11245266193	M3 - M12	KWES1B / KWE1	19	32	27.9	B12	59
INTERNAL B16 Q 8-20	K11246241225	M8 - M20	KWES2B / KWE2	31	50	44.8	B16	80
INTERNAL B18 Q 8-20	K11247241225	M8 - M20	KWES2B / KWE2	31	50	44.8	B18	88



Q (Internal Dia.)

(No Compression & No Expansion)

Item Name	Item Code	Capacity	Suitable Adaptor	d1	d2	D1	D2	L
INTERNAL DIA 16 Q 8-20	K11233241225	M8 - M20	KWES2B / KWE2	31	16	50	44.8	86.5
INTERNAL DIA 25 Q 8-20	K11243241225	M8 - M20	KWES2B / KWE2	31	25	50	44.8	103
INTERNAL DIA 25 Q 14-33	K11243241226	M14 - M33	KWES3B / KWE3	48	25	72	67.4	124.5
INTERNAL DIA 35 Q 22-48	K11258241265	M22 - M48	KWES4B / KWE4	60	35	92	84	139

☞ For Necessary Accessories Selection Please Go Through Page No. 186

Note: All Dimensions are in mm



'CCSFL' Tapping Attachment (Non Reversible)

CC : Collet Chuck
S : Safety Clutch
F : Float Radial Parallel
L : Length Compensation

▣ Applications :

For Tapping Operations on Reversible Drilling & Tapping Machines & Turning Machines.

▣ Features :

- ER 20 & ER 32 collet heads for holding wide range of taps.
- Adjustable safety torque clutch for prevention of tap breakages.
- Self Centering Radial Parallel float to compensate for misalignment between the tap & hole to be tapped.
- Length compensation acting on compression & expansion which compensates & expansion which compensates machine feed & Tap pitch.





'CCSFL' Tapping Attachment (Non - Reversible)

'CCSFL' is a simple to use & operator friendly tapping Attachment.

'CCSFL' 3-12 is equipped with ER 20 Collet Head, where ER 20 collets are used. The maximum capacity of the collet is 13mm. This can be used up to M16 fine pitch.

'CCSFL' 8-20 is equipped with ER32 collet Head, where ER32 collets are used. The maximum capacity of the collet is 20mm. This can be used up to M30 fine pitch.

SAFETY BALL CLUTCH :

There is a safety clutch mechanism which is suitable within its range of Tapping. The safety clutch disengages when the present torque is exceeded. After disengagement there is almost no Torque on the Tap & thus the clutch suffers practically no wear. Due to this Tap breakage is prevented. Blind holes can be bottom- tapped under full rotation of the spindle, reversal of the spindle re-engages the clutch and the tap is automatically

FLOAT RADIAL PARALLEL :

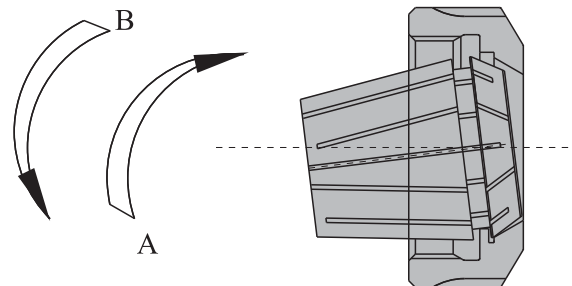
The ball operated floating device guarantees threads to correct tolerances. In case of misalignment, protects the tap against side thrust. It comes again into center automatically after every tapping operation . The radial Parallel float is 1.0mm & 1.50 mm respectively.

LENGTH COMPENSATION :

The length compensation is Ball Cage operated and hence the axial movement is very smooth. Even at the extreme Torque, the free axial movement prevents damage to thread flanks. When the feed rate & tap pitch do not match, i.e during hand feed, this helps for cutting small threads on heavy machines.

The collet must always be inserted into the nut before setting the tool into the collet. The collet is fitted inside the nut by applying slight pressure A. It is removed by applying B to the collet.

Never tighten the chuck without a correct size tool shank being present in the collet. Failure to observe this guideline can result in collet breakage.



CCSFL Tapping Chuck Set With Collet & Spanner



CCSFL - With Morse Taper Shank (MT)

Item Name	Item Code	Capacity	Suitable Collet	Comp.	Exp.	Radial Parallel Float	D1	D2	D3	L1	L2
MT2B CCSFL 3-12	K11227103223	M3 - M12	ER 20	10	20	1	35	50	58	150	43
MT3B CCSFL 3-12	K11228103223	M3 - M12	ER 20	10	20	1	35	50	58	150	43
MT2B CCSFL NO.06 - 1/2"	K11227103227	06 - 1/2"	ER 20	10	20	1	35	50	58	150	43
MT3B CCSFL NO.06 - 1/2"	K11228103227	06 - 1/2"	ER 20	10	20	1	35	50	58	150	43
MT3B CCSFL 8 - 20	K11228103224	M8 - M20	ER 32	10	20	1.5	50	76	83	191	53
MT4B CCSFL 8 - 20	K11213103224	M8 - M20	ER 32	10	20	1.5	50	76	83	192	53
MT5B CCSFL 8 - 20	K11215103224	M8 - M20	ER 32	10	20	1.5	50	76	83	193	53
MT3B CCSFL 1/4" - 3/4"	K11228103228	1/4" - 3/4"	ER 32	10	20	1.5	50	76	83	191	53
MT4B CCSFL 1/4" - 3/4"	K11213103228	1/4" - 3/4"	ER 32	10	20	1.5	50	76	83	192	53
MT5B CCSFL 1/4" - 3/4"	K11215103228	1/4" - 3/4"	ER 32	10	20	1.5	50	76	83	193	53

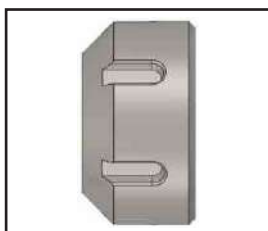
Accessories



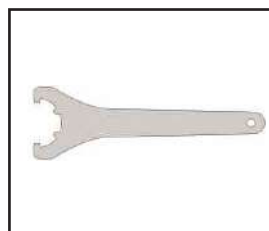
For Collet ER (DIN 6499)
Ref. Page No. 229-235



For Tap Collet ER-G
Ref. Page No. 236-240



For ER Nut
Ref. Page No. 217 & 218



For ER Spanner
Ref. Page No. 215-216



For Sealing Disc
Ref. Page No. 219-226

Note: All Dimensions are in mm



Quick Change Tapping Attachment QSFL (Non Reversible)

Q : Quick Change (Tap Adaptor)

S : Safety Clutch

F : Float Radial Parallel

L : Length Compensation

▣ **Application :**

For Tapping operation on Drilling, Tapping and Radial Drilling Machines. For Horizontal application on Lathes.

▣ **Features :**

- Quick Change Tapping Attachment to be used with Quick Change Tap Adaptor KWE1 / KWE2.
- Adjustable Safety Clutch Prevents Tap Breakages.
- Length compensation acting on compression and expansion to compensate between the tap pitch and machine or hand feed.
- Self - centering Radial Parallel float to compensate misalignment between the tap and hole to be tapped.





‘QSFL’ Tapping Attachment (Non Reversible)

‘QSFL’ is a simple to use & operator friendly tapping Attachment.

‘QSFL’ 3-12 is equipped with Quick Change Tap Adaptor Head, Where KWE1 Tap Adaptors are used. This Attachment can be used up to M16 fine pitch.

‘QSFL’ 8-20 is equipped with Quick Change Tap Adaptor Head, Where KWE2 Tap Adaptors are used. This Attachment can be used up to M30 fine pitch.

SAFETY BALL CLUTCH :

There is a safety clutch mechanism which is suitable within its range of Tapping. The safety clutch disengages when the present torque is exceeded. After disengagement there is almost no Torque on the Tap & thus the clutch suffers practically no wear. Due to this Tap breakage is prevented. Blind holes can be bottom- tapped under full rotation of the spindle, reversal of the spindle re-engages the clutch and the tap is automatically .

FLOAT RADIAL PARALLEL :

The ball operated floating device guarantees threads to correct tolerances. In case of misalignment, protects the tap against side thrust. It comes again into center automatically after every tapping operation . The radial Parallel float is 1.0mm & 1.50 mm respectively.

LENGTH COMPENSATION :

The length compensation is Ball Cage operated and hence the axial movement is very smooth. Even at the extreme Torque, the free axial movement prevents damage to thread flanks. When the feed rate & tap pitch do not match, i.e during hand feed, this helps for cutting small threads on heavy machines.



QSFL With Morse Taper Shank (MT)

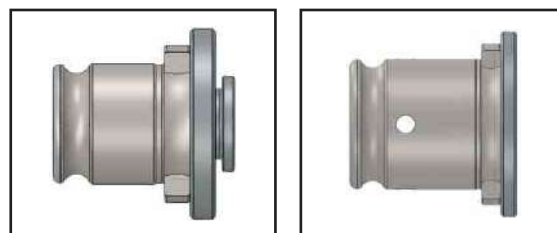
Item Name	Item Code	Capacity	Suitable Adaptor	Comp.	Exp.	Radial Parallel Float	d	D1	D2	L
MT2B QSFL 3 - 12	K11201104223	M3 - M12	KWE1	10	20	1	19	32	58	142
MT3B QSFL 3 - 12	K11202104223	M3 - M12	KWE1	10	20	1	19	32	58	142
MT2B QSFL NO.06 - 1/2"	K11227104245	06 - 1/2"	KWE1	10	20	1	19	32	58	142
MT3B QSFL NO.06 - 1/2"	K11228104245	06 - 1/2"	KWE1	10	20	1	19	32	58	142
MT3B QSFL 8 - 20	K11202104225	M8 - M20	KWE2	10	20	1.5	31	50	83	190
MT4B QSFL 8 - 20	K11225104225	M8 - M20	KWE2	10	20	1.5	31	50	83	191
MT5B QSFL 8 - 20	K11226104225	M8 - M20	KWE2	10	20	1.5	31	50	83	192
MT3B QSFL 1/4" - 3/4"	K11202104244	1/4" - 3/4"	KWE2	10	20	1.5	31	50	83	190
MT4B QSFL 1/4" - 3/4"	K11213104244	1/4" - 3/4"	KWE2	10	20	1.5	31	50	83	191
MT5B QSFL 1/4" - 3/4"	K11226104244	1/4" - 3/4"	KWE2	10	20	1.5	31	50	83	192



QSFL With Short Internal taper

Item Name	Item Code	Capacity	Suitable Adaptor	Comp.	Exp.	Radial Parallel Float	d	D1	D2	T	L
B16 QSFL 3-12	K11218104223	M3 - M12	KWE1	10	20	1	19	32	58	B16	155
J2 QSFL 3-12	K11106104223	M3 - M12	KWE1	10	20	1	19	32	58	J2	155
J6 QSFL 3-12	K11107104223	M3 - M12	KWE1	10	20	1	19	32	58	J6	155

Accessories



For Tap Adaptor KWE & KWEK
Ref. Page No. 253-258 & 263-264

☞ For Tap Shank Dimension & Recommended Torque Values Ref. Page No. 290-292

Note: All Dimensions are in mm



Quick Change Tapping Chuck

KWFSL 60 (M 30 To M 120)

▣ **Application :**

This Heavy Duty Tapping Attachment can be used on Drilling, Radial Drilling & Milling Machines Single Tap or Series Taps also can be used.

▣ **Features :**

- Quick change system with automatic locking of the adaptor in the chuck.
- Length compensation acting on compression and expansion to compensate for differences between spindle feed and tap pitch.
- Adjustable safety clutch with minimum torque after disengagement to protect against tap breakage.
- Interchangeable shanks to allow the use of the chuck on different machines spindle configurations.

▣ **Capacity :**

- M 30 To M 68 x 6 Standard Pitch
M 30 To M 120 x 4 Fine Pitch





Quick Change Tapping Chucks (KWFSL 60)

KTA's KWFSL 60 TAPPING CHUCKS are used to tap large internal threads during the manufacture of machines, engines, turbines, nuclear reactors, components etc.

To tap these large threads, single pass as well as series taps are used. Whether single pass or series taps are used depends mainly on diameter, pitch, tolerance and surface finish of the thread and the material to be tapped.

KTA's KWFSL 60 TAPPING CHUCKS fulfills all requirements for tapping threads economically and within tolerances whether single pass or series taps are used.

With these chucks and adaptors various working methods are possible.

Tapping with single pass taps:

The thread will be finished in a single operation.

Difference between machine feed and thread pitch are compensated by the length compensation.

Tapping with series taps:

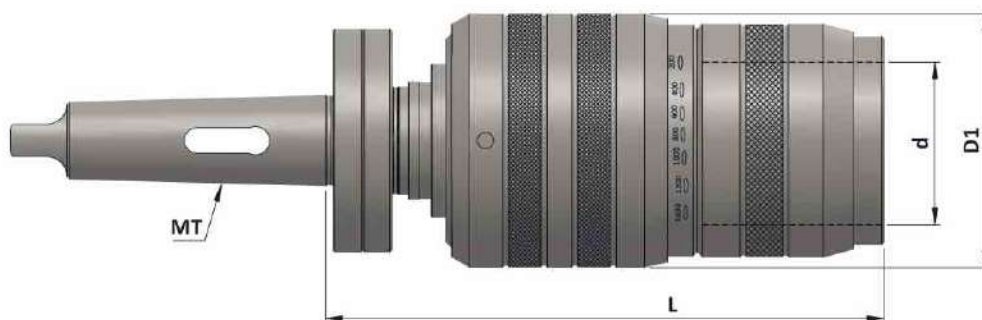
When tapping with series taps it is not always possible to exactly introduce the second tap into the pre-cut thread by machine. Even chucks with length compensation cannot guarantee safe results. The safest method is, to introduce the second tap by hand into the pre-cut thread and have the chuck to finish-cut the thread.

The use of chuck **KWFSL 60** simplifies this method. The adaptor with the tap screwed into the pre-cut thread is automatically engaged in the chuck when the spindle moves forward and the thread is then cut. Differences between machine feed and tap pitch are compensated by the length compensation.

KWFSL 60 Capacity :

M 30 To M 68 x 6 Standard Pitch

M 30 To M 120 x 4 Fine Pitch



KWFSL 60/MT

Item Name	Item Code	Morse Taper	Capacity	Torque Nm.	Suitable Adaptor	Comp.	Exp.	d	D1	L
MT5B KWFSL60 -	K11215101193	MT5B	M30 - M68 x 6 M30 - M120 x 4	200 - 1400	KWE60/ KWEK60	20	20	72	125	280



KWFSL 60/ISO 50 (DIN 2080)

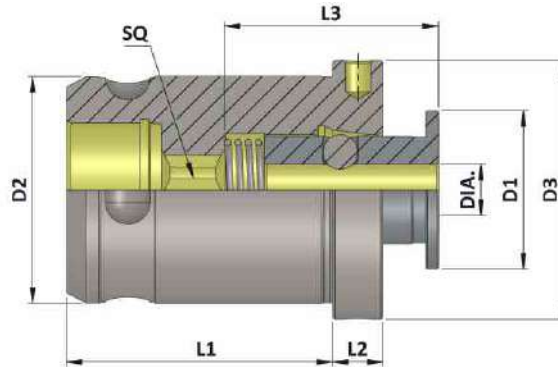
Item Name	Item Code	ISO	Capacity	Torque Nm.	Suitable Adaptor	Comp.	Exp.	d	D1	L
ISO50 KWFSL60	K11105101193	50	M30 - M68 x 6 M30 - M120 x 4	200 - 1400	KWE60/ KWEK60	20	20	72	125	275

Note: All Dimensions are in mm



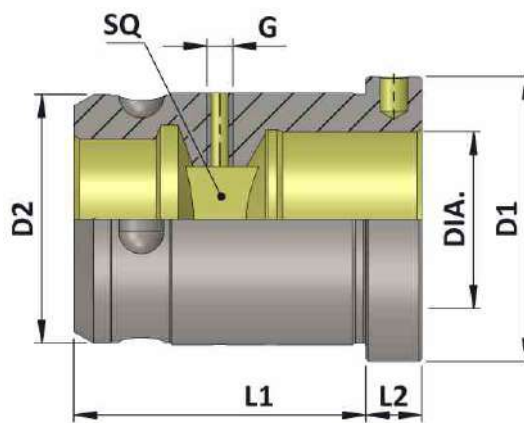
Quick Change Tap Adaptor (KWE 60 & KWEK 60)

Technical information



Technical Information (KWE 60)

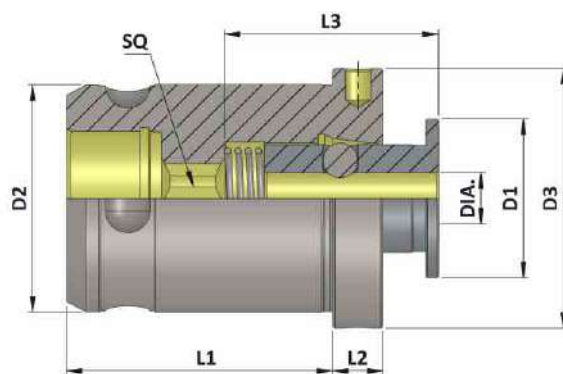
Item Name	Capacity	Shank Dia.	Suitable Chuck Size	D1	D2	D3	L1	L2	L3
KWE 60	M30 - M48	22 - 36	60	50	72	82	84	16	60



Technical Information (KWEK 60)

Item Name	Capacity	Shank Dia.	Suitable Chuck Size	D1	D2	L1	L2
KWEK 60	M48 - M68 x 6 M48 - M120 x 4	> 36 - 56	60	82	72	84	16

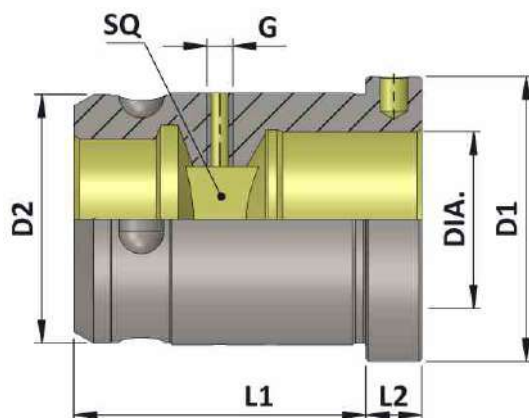
Note: All Dimensions are in mm



KWE 60 Tap Adaptor

Item Name	Item Code	DIA	Square
KWE60 DIA 22.00 SQ 18.00	K11198155193	22.00	18.00
KWE60 DIA 22.40 SQ 18.00	K11198135193	22.40	18.00
KWE60 DIA 23.00 SQ 17.00	K11198180193	23.00	17.00
KWE60 DIA 24.00 SQ 19.00	K11198181193	24.00	19.00
KWE60 DIA 25.00 SQ 19.00	K11198186193	25.00	19.00
KWE60 DIA 25.00 SQ 20.00	K11198136193	25.00	20.00
KWE60 DIA 26.00 SQ 21.00	K11198182193	26.00	21.00
KWE60 DIA 28.00 SQ 21.00	K11198187193	28.00	21.00
KWE60 DIA 28.00 SQ 22.00	K11198156193	28.00	22.00
KWE60 DIA 28.00 SQ 22.40	K11198137193	28.00	22.40
KWE60 DIA 30.00 SQ 23.00	K11198183193	30.00	23.00
KWE60 DIA 31.50 SQ 25.00	K11198138193	31.50	25.00
KWE60 DIA 32.00 SQ 24.00	K11198157193	32.00	24.00
KWE60 DIA 32.00 SQ 26.00	K11198184193	32.00	26.00
KWE60 DIA 35.00 SQ 26.00	K11198185193	35.00	26.00
KWE60 DIA 35.50 SQ 28.00	K11199139193	35.50	28.00
KWE60 DIA 36.00 SQ 29.00	K11198158193	36.00	29.00

Note: All Dimensions are in mm



KWEK 60 Tap Adaptor

Item Name	Item Code	Dia.	Square
KWEK60 DIA 38.00 SQ 29.00	K11199188193	38.00	29.00
KWEK60 DIA 40.00 SQ 31.50	K11199220193	40.00	31.50
KWEK60 DIA 40.00 SQ 32.00	K11199160193	40.00	32.00
KWEK60 DIA 45.00 SQ 35.00	K11199161193	45.00	35.00
KWEK60 DIA 45.00 SQ 35.50	K11199242193	45.00	35.50
KWEK60 DIA 50.00 SQ 39.00	K11199245193	50.00	39.00
KWEK60 DIA 50.00 SQ 40.00	K11199243193	50.00	40.00
KWEK60 DIA 56.00 SQ 44.00	K11199246193	56.00	44.00
KWEK60 DIA 56.00 SQ 45.00	K11199244193	56.00	45.00

Note: All Dimensions are in mm