

*Designers & Manufacturers of Drilling & Tapping Solutions*

Some of the important features of the TRU-TAP™ as applied to use on CNC machines are:

- Instantaneous reverse without reversing machine motor.
- No tap overtravel . . . excellent for blind or shallow holes
- Program either using canned bore cycle or line-by-line for 2:1 reverse ratio.
- No need to under feed . . . program feed rates at 100%
- Balanced, heat treated gear reversing mechanism minimizes strain and wear.
- Bronze bushings at wear points, supporting the spindle from shank to chuck.
- Double row precision ball bearing for rigid shank support.
- Readily adapts to any machining center. Universal stop and spindle orientation assembly allows use in tool changers.
- Exclusive TRU-GRIP™ chuck assures tap accuracy.
- Sealed against coolant contamination
- Accurate depth repeatability within 1/3 turn
- Horizontal or vertical use without modifications.
- Right-or-left-hand available.
- High-speed . . . up to 3000 RPM.



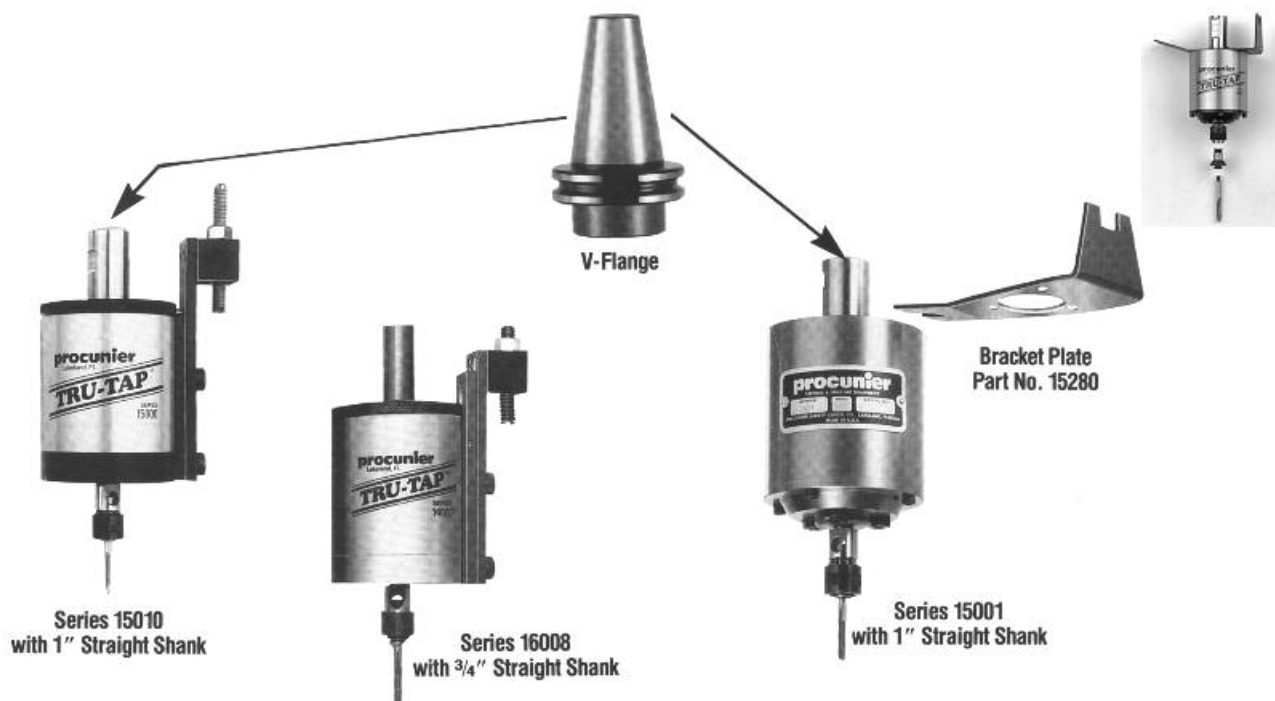
Also available in Quick Change

**Dimensions**

SERIES						
	15001	15008	15010	16001	16008	16010
A	1 <sup>19</sup> / <sub>32</sub> "	2 <sup>5</sup> / <sub>8</sub> "	2 <sup>5</sup> / <sub>8</sub> "	1 <sup>23</sup> / <sub>32</sub> "	2 <sup>25</sup> / <sub>32</sub> "	2 <sup>25</sup> / <sub>32</sub> "
B	1 <sup>19</sup> / <sub>32</sub> "	3 <sup>1</sup> / <sub>16</sub> "	3 <sup>1</sup> / <sub>16</sub> "	1 <sup>23</sup> / <sub>32</sub> "	3 <sup>3</sup> / <sub>16</sub> "	3 <sup>3</sup> / <sub>16</sub> "
C	1 <sup>19</sup> / <sub>32</sub> "	1 <sup>19</sup> / <sub>32</sub> "	1 <sup>19</sup> / <sub>32</sub> "	1 <sup>23</sup> / <sub>32</sub> "	1 <sup>23</sup> / <sub>32</sub> "	1 <sup>23</sup> / <sub>32</sub> "
D	7 <sup>3</sup> / <sub>16</sub> "	7 <sup>3</sup> / <sub>16</sub> "	7 <sup>3</sup> / <sub>16</sub> "	8 <sup>7</sup> / <sub>8</sub> "	8 <sup>7</sup> / <sub>8</sub> "	8 <sup>7</sup> / <sub>8</sub> "
E	3 <sup>7</sup> / <sub>8</sub> "	4 <sup>1</sup> / <sub>8</sub> "	4 <sup>1</sup> / <sub>8</sub> "	4 <sup>3</sup> / <sub>4</sub> "	5 <sup>1</sup> / <sub>16</sub> "	5 <sup>1</sup> / <sub>16</sub> "
F	1 <sup>5</sup> / <sub>16</sub> "	1 <sup>5</sup> / <sub>16</sub> "	1 <sup>5</sup> / <sub>16</sub> "	2 <sup>1</sup> / <sub>4</sub> "	1 <sup>1</sup> / <sub>4</sub> "	2 <sup>1</sup> / <sub>4</sub> "
G	3 <sup>4</sup> / <sub>4</sub> "	3 <sup>4</sup> / <sub>4</sub> "	3 <sup>4</sup> / <sub>4</sub> "	1"	1"	1"
H	1"	3 <sup>4</sup> / <sub>4</sub> "	1"	1"	3 <sup>4</sup> / <sub>4</sub> "	1"

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SERIES ORDER NUMBER	SHANK	TYPE STOP ROD	CAPACITY		MAX. SPEED	NET WEIGHT
			SOFT MAT'L	STEEL		
15001 / 15001 QC	1" STRAIGHT SHANK	BRACKET PLATE	#00-1/4" M2-M6	#00-#10 M2-M5	3000 RPM	3½ lbs.
15008 / 15008 QC	¾" STRAIGHT SHANK	SLIDE WITH ADJ. SCREW	#00-1/4" M2-M6	#00-#10 M2-M5	3000 RPM	4½ lbs.
15010 / 15010 QC	1" STRAIGHT SHANK	SLIDE WITH ADJ. SCREW	#00-1/4" M2-M6	#00-#10 M2-M5	3000 RPM	5 lbs.
16001 / 16001 QC	1" STRAIGHT SHANK	BRACKET PLATE	#8-1/2" M4-M12	#8-5/16" M4-M8	2500 RPM	5 lbs.
16008 / 16008 QC	¾" STRAIGHT SHANK	SLIDE WITH ADJ. SCREW	#8-1/2" M4-M12	#8-5/16" M4-M8	2500 RPM	6 lbs.
16010 / 16010 QC	1" STRAIGHT SHANK	SLIDE WITH ADJ. SCREW	#8-1/2" M4-M12	#8-5/16" M4-M8	2500 RPM	6½ lbs.



**Standard equipment supplied:**  
**Series 15000: Furnished with 2 wrenches.**  
**Series 16000: Furnished with 2 wrenches.**

**NOTE: Collets Not Included - Must be Ordered separately.**


## ACCESSORIES

### Collets

	Series	Range
	15000	Tap: 0 to 1/4" (M2 to M6)
	16000	Tap: #8 to 1/2" (M5 to M12)



### V-Flanges (Reduces overall projection)

	Series	Description	Net Weight
	15140	CAT 40, 1" Bore	1½ lbs.
	15150	CAT 50, 1" Bore	5½ lbs.

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**High Speed-Lightweight-Extra Sensitive**

- Balanced, heat treated gear reversing mechanism minimizes strain and wear.
- Reverses at twice forward speed to increase productivity 33% and avoid tap jamming.
- Aluminum housing provides extra strength and rigidity with minimum weight.
- Bronze bushings at wear points, supporting the spindle from shank to chuck.
- Extremely sensitive friction clutch engages conical surfaces of drive and reverse shells with smooth, "cushioned" action, allowing sensitive operator feel. Assures automatic tap protection.
- Double row precision ball bearing for rigid shank support.

Precision-built from shank to chuck for accurate, sensitive, high-production tapping – with automatic tap protection!

No matter how you judge tapping equipment, you'll find that Proconier Style E tapping heads are the best for less. They are quality built, precision engineered units designed to give you thread-perfect tapping at high speeds. Special heat-treated gears maintain smooth, clock-like performance on job after job, month after month.

Proconier Style E tapping heads embody many features which have been perfected and proven in over 40 years of production experience. They are particularly outstanding in giving you high operating efficiency, minimum maintenance, longer tool life and less tap breakage.

**Here's why you need cover clamps**

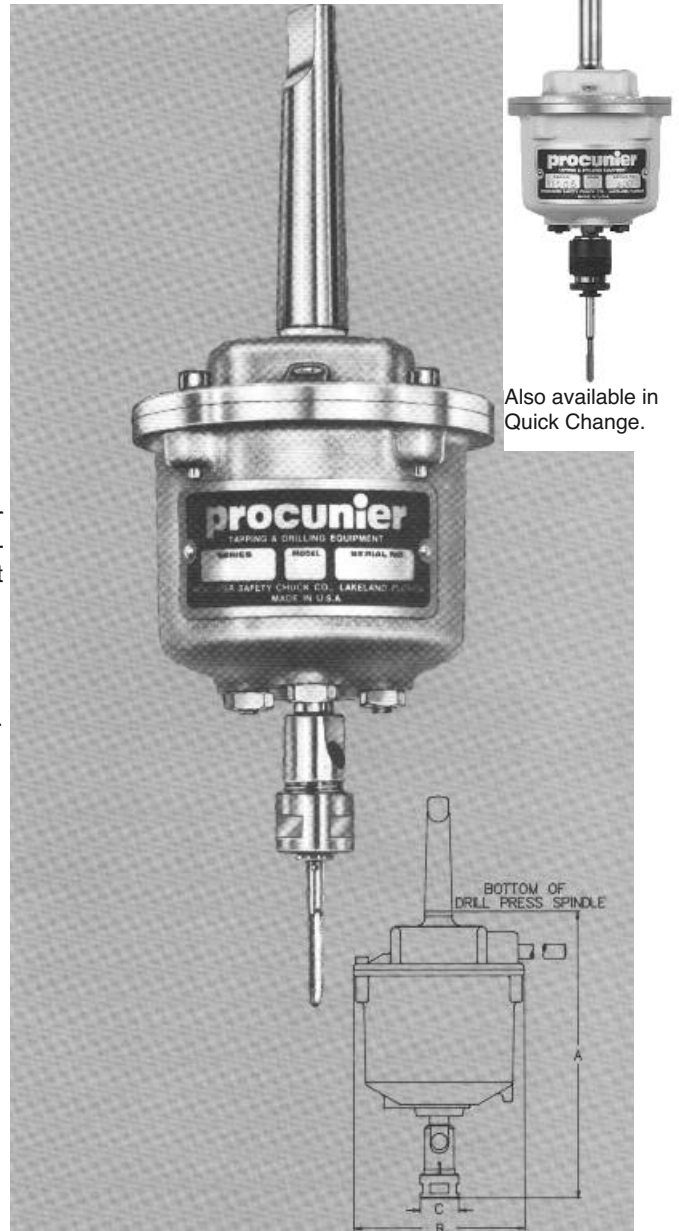
Cover clamps combine the gauged accuracy you want with extra tap protection and longer tap life. It's all because they give your attachment greater rigidity – even at high tapping speeds.

Series	Style	Collet Series	Standard Equipment
11000	1-E	51800 or 58800	2 wrenches
12000	2-E	52800 or 59800	2 wrenches
13000	3-E	53800	2 wrenches

**NOTE: Collets Not Included - Must be Ordered separately.**

Tapping heads can be used in HORIZONTAL position with slight change in oiling system. Do not use in INVERTED position. Factory can easily alter any model for LEFT HAND tapping.

Series Order Number 57550.



Also available in Quick Change.

**DIMENSIONS**

SERIES	STYLE	"A"	"B"	"C"
11000	1-E	5½"	3½"	¾"
12000	2-E	7½"	47/16"	1"
13000	3-E	8½"	5½"	1½"

**SPECIFICATIONS**

SERIES	STYLE	SHANK	CAPACITY					MAX. SPEED	SHIP WEIGHT
			SOFT MATERIAL			STEEL			
			INCH	M.M.	PIPE	INCH	M.M.		
11000	1-E	½"-1-2-3 mt	0-¼"	M2-M6	—	0-#10	M2-M4	3000	4 lbs.
12000	2-E	½"-1-2-3 mt	#6-½"	M4-M12	⅙"	#6-5/16"	M4-M8	2000	8 lbs.
13000	3-E	¾"-2-3-4 mt	#10-¾"	M6-M18	¼"	#10-½"	M6-M12	1000	15 lbs.

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\*SPECIAL UNIT—UPON ORDERING, SPECIFY MAKE OF DRILL PRESS, QUILL DIAMETER, SPINDLE TAPER AND LENGTH.

Models Without Cover Clamps					
Shank	Complete Unit Order Numbers				
	Series 11000 Style 1-E	Series 12000 Style 2-E	Series 13000 Style 3-E		
½" SS	11006/11006 QC	12006/12006 QC	—		
¾" SS	—	—	13006		
1 M.T.	11001/11001QC	12001/12001QC	—		
2 M.T.	11002/11002QC	12002/12002QC	13002		
3 M.T.	11003/11003QC	12003/12003QC	13003		
4 M.T.	—	—	13004		

Models With Cover Clamps					
Drill Press	Quill Dia.	Taper	Complete Unit Order Numbers		
			Series 11000 Style 1-E	Series 12000 Style 2-E	Series 13000 Style 3-E
ALLEN No. 2	2.250	2A Jac	11053	12053	13053
ATLAS 15"	1.812	33 Jac	11035	12035	13035
BOICE CRANE 15"	1.850	33 Jac	11036	12036	13036
BUFFALO 15"	1.750	33 Jac	11037	12037	13037
18"	2.375	2 M.T.	11063	12063	13063
18"	2.375	3 M.T.	11099 *	12084	13084
BURGMASER 1D 2B		¾-16	11054	12054	—
		¾-16	11055	12055	—
CINCINNATI 16"	1.850	33 Jac	11036	12036	13036
18"	2.375	2 M.T.	11063	12063	13063
18"	2.375	3 M.T.	11099 *	12084	13084
CLAUSING 15"	1.988	33 Jac	11038	12038	13038
15"	1.988	2 M.T.	11064	12064	13064
20"	2.489	3 M.T.	11099 *	12085	13085
CRAFTSMAN	1.625	33 Jac	11039	12039	13039
	1.812	33 Jac	11035	12035	13035
	1.875	33 Jac	11041	12041	13041
DUMORE 24 & 28	1.750	2A Jac	11042	12042	13042
60	1.625	2A Jac	11044	12044	13044
91	2.000	33 Jac	11048	12048	13048
DURO 18"	2.500	2 M.T.	11071	12071	13071
18"	2.500	3 M.T.	11099 *	12091	13091
EDLUND No. 2B	2.861	2 M.T.	11065	12065	13065
3B	3.125	3 M.T.	11099 *	12099 *	13099 *
HYPNEUMAT 200	1.625	2A Jac	11044	12044	13044
350	1.750	2A Jac	11045	12045	13045
JET 13R	1.812	6A Jac	11061	12061	13061
LELAND- 1LMS	2.438	2A Jac	11046	12046	13046
GIFFORD 2LMS	2.875	2 M.T.	11067	12067	13067
POWERMATIC 15"	2.187	33 Jac	11047	12047	13047
15"	2.187	2 M.T.	11068	12068	13068
20"	2.750	2 M.T.	11099 *	12072	13072
20"	2.750	3 M.T.	11099 *	12088	13088
ROCKWELL/ DELTA 14"	1.750	33 Jac	11037	12037	13037
15"	2.000	33 Jac	11048	12048	13048
17"	2.250	33 Jac	11049	12049	13049
17"	2.250	2 M.T.	11069	12069	13069
20"	2.375	2 M.T.	11063	12063	13063
20"	2.375	3 M.T.	11099 *	12084	13084
SOUTH BEND 14"	1.750	6A Jac	11050	12050	13050
STANDARD MACHINE	2.125	2A Jac	11051	12051	13051
UNIMATIC MACHINE	2.250	2A Jac	11052	12052	13052
WALKER-TURNER 15"	1.812	33 Jac	11035	12035	13035
15"	1.812	2 M.T.	11070	12070	13070
17"	2.250	2 M.T.	11069	12069	13069
17"	2.250	3 M.T.	11099 *	12090	13090
20"	2.375	2 M.T.	11063	12063	13063
20"	2.375	3 M.T.	11099 *	12084	13084
WILTON 15"	2.000	33 Jac	11048	12048	13048

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**Rugged-Heavy Duty**

- 17 tooth spline drive for full power.
- Aluminum housing provides extra strength and rigidity with minimum weight.
- Double row ball bearings give smoother, more accurate operation and long, dependable service life.
- Double cone friction clutch allows operator "Feel".
- Hardened, helical gears with 2:1 reverse avoids tap jamming and increases production.
- Bronze bushings at wear points supporting spindle from shank to chuck.

Here's the unit that's designed for the especially difficult big-hole tapping jobs. Rugged and tough, but smooth and easy to operate, it's considered by many "the only way" to handle large size tapping jobs with precision and efficiency. Operators are amazed at the sensitivity of this heavy-duty unit that allows them to do more in less time without downtime or fatigue slowing production.

Users prefer the cover clamp style because it eliminates the weight hanging from the drill press spindle and bearings . . . provides increased rigidity.

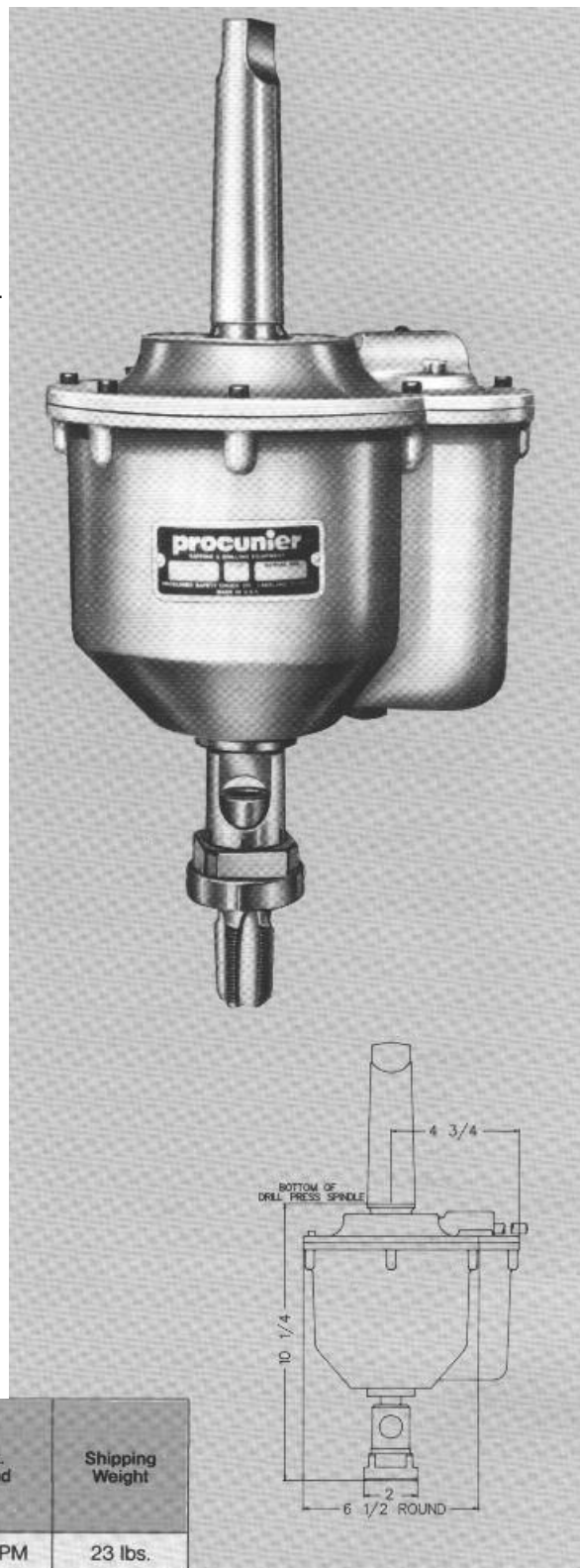
The Tap King combines the best of proven experience with today's best ideas. The design incorporates every mechanical advancement and improved manufacturing technique developed at Procunier during the past 50 years.

**STANDARD EQUIPMENT**

No. 4F furnished with 2 wrenches.

For LEFT HAND operation the unit must be modified. Series Order Number 57550

**Note: Collets Not Included. Must Be Ordered Separately.**



**SPECIFICATIONS**

Capacity					Max. Speed	Shipping Weight
Mild Steel		Soft Material				
Inch	M.M.	Inches	M.M.	Pipe Tap		
¼"-1"	M7-M22	¼" to 1½"	M7-M28	⅝"-¾"	800 RPM	23 lbs.

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Models Without Cover Clamps	
Shank	Series 14000 Style 4-F
¾" S.S.	14006
2 M.T.	14002
3 M.T.	14003
4 M.T.	14004
5 M.T.	14005



Models With Cover Clamps			
Drill Press	Quill Dia.	Taper	Series 14000 Style 4-F
ALLEN #2	2.875	2 M.T.	14099*
AVEY 2BMA 2BMA	3.500 3.500	2 M.T. 3 M.T.	14099* 14099*
BUFFALO 18" 18"	2.375 2.375	2 M.T. 3 M.T.	14063 14087
CINCINNATI 18" 18"	2.375 2.375	2 M.T. 3 M.T.	14063 14087
CLAUSING 15" 20"	1.988 2.489	2 M.T. 3 M.T.	14064 14085
DURO 18" 18"	2.500 2.500	2 M.T. 3 M.T.	14071 14091
EDLUND 2B 3B 3B	2.861 2.861 3.125	2 M.T. 3 M.T. 3 M.T.	14065 14099* 14099*
JET 14M	2.050	2 M.T.	14066
LELAND-GIFFORD 2LMS 3LMS	2.875 2.875	2 M.T. 3 M.T.	14067 14099*
POWERMATIC 15" 20" 20"	2.187 2.750 2.750	2 M.T. 2 M.T. 3 M.T.	14068 14072 14088
ROCKWELL/DELTA 17" 20" 20"	2.250 2.375 2.375	2 M.T. 2 M.T. 3 M.T.	14069 14070 14084
WALKER-TURNER 17" 17" 20" 20"	2.250 2.250 2.375 2.375	2 M.T. 3 M.T. 2 M.T. 3 M.T.	14069 14090 14070 14084

\*SPECIAL UNIT—UPON ORDERING, SPECIFY MAKE OF DRILL PRESS, QUILL DIAMETER, SPINDLE TAPER AND LENGTH.

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Lead Screw Tapping, the most advanced method yet devised!

- Finger tip trigger arm gives superior sensitivity.
- Built-in stop gives uniform depth within 1/3 turn.
- Reverses at twice forward speed. Idles in neutral.
- Lead screw assembly changes in seconds to vary pitch.
- Balanced, hardened gear train for long, dependable service life

The lead screw principle provides benefits no other system can even promise. It offers unmatched accuracy, precision control and eliminates rejects and gauging procedures. No other method can match it for speed, sensitivity and productivity.

Each lead screw tapper has its own built-in stroke which eliminates drill press feeds. The tap is fed gently and automatically into the work producing the same precisely tapped part time after time without variation.

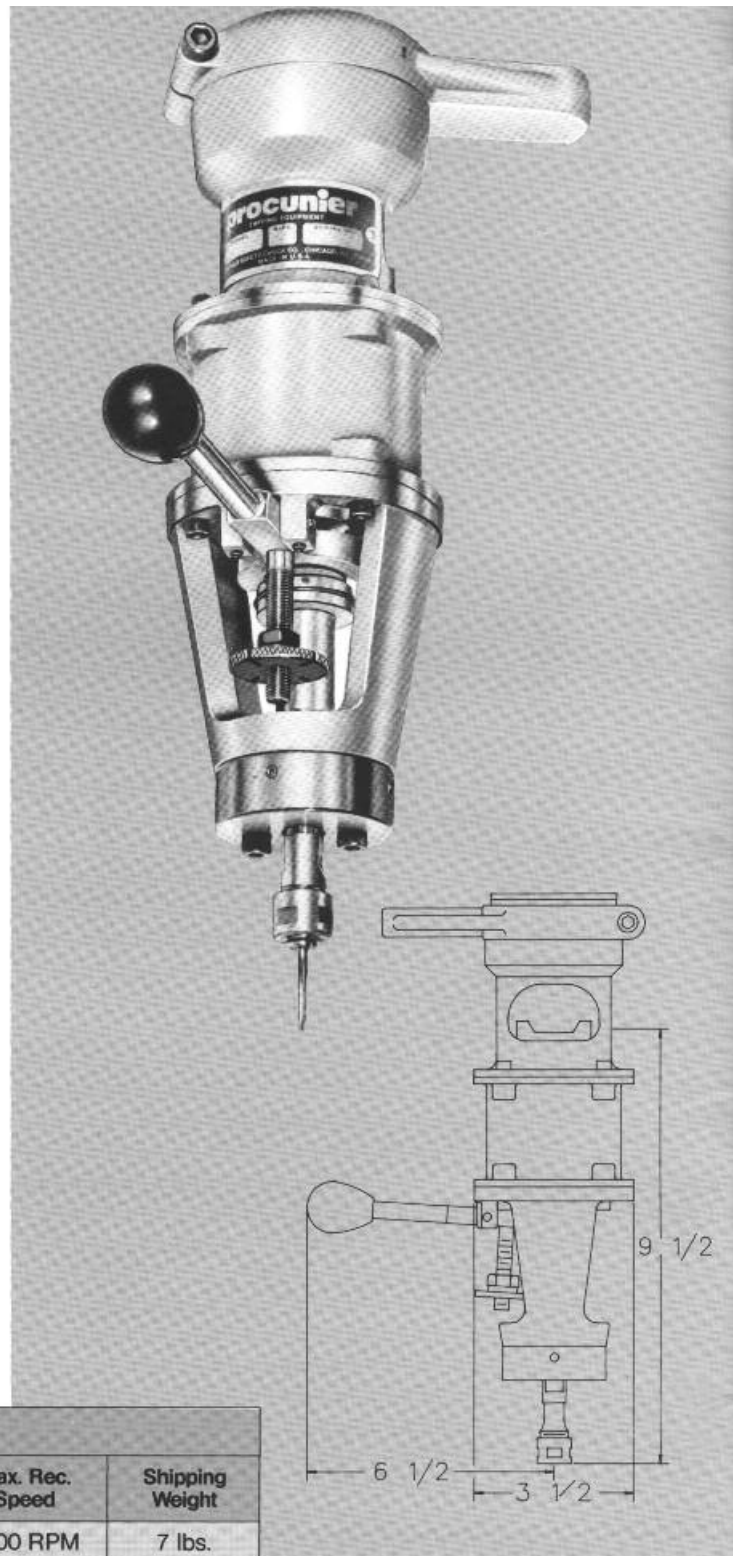
The new Style L Tapper operates with fingertip pressure on the trigger lever, engaging a friction clutch. More pressure on the trigger results in more torque at the tap, giving the sensitive feel small taps require with complete operator control on pitches from 32 to 127 threads per inch.

**STANDARD EQUIPMENT**

No. 1L furnished with wrenches.

For LEFT HAND operation the unit must be modified. Series Order Number 57550. (Use left hand Lead Screw.)

**Note: Collets & Lead Screw assembly Not Included. Must Be Ordered Separately.**



**SPECIFICATIONS**

Capacity					
Inch	M.M.	Stroke, Max.	Pitch	Max. Rec. Speed	Shipping Weight
00 -#8	M1-M4	1 1/8"	32 to 127	2000 RPM	7 lbs.

Note: Larger capacity model #3LS 5/16T Max. Available P.O.A.

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Drill Press	Quill	Taper	Series 20000 Style 1-L
ALLEN No. 2	2.250	2A Jac	20053
ATLAS 15"	1.812	33 Jac	20035
BOICE CRANE 15"	1.850	33 Jac	20036
BUFFALO 15" 18"	1.750 2.375	33 Jac 2 M.T.	20037 20063
CINCINNATI 16" 18"	1.850 2.375	33 Jac 2 M.T.	20036 20063
CLAUSING 15" 15"	1.988 1.988	33 Jac 2 M.T.	20038 20064
CRAFTSMAN	1.625 1.812 1.875	33 Jac 33 Jac 33 Jac	20039 20035 20041
DURO 18"	2.500	2 M.T.	20071
EDLUND No. 2B	2.861	2 M.T.	20065
JET No. 13R	1.812	6A Jac	20061
LELAND-GIFFORD 1LMS 2LMS	2.438 2.875	2A Jac 2 M.T.	20046 20067
POWERMATIC 15" 15"	2.187 2.187	33 Jac 2 M.T.	20047 20068
ROCKWELL/DELTA 14" 15" 17" 17" 20"	1.750 2.000 2.250 2.250 2.375	33 Jac 33 Jac 33 Jac 2 M.T. 2 M.T.	20037 20048 20049 20069 20063
SOUTH BEND 14"	1.750	6A Jac	20050
STANDARD MACHINE	2.125	2A Jac	20051
WALKER-TURNER 15" 15" 17" 20"	1.812 1.812 2.250 2.375	33 Jac 2 M.T. 2 M.T. 2 M.T.	20035 20070 20069 20063
WILTON 15"	2.000	33 Jac	20048



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## Style AL Lead Screw Tappers Series 21000 and 23000

- Precise operation every time.
- Electrically controlled, air operated.
- Built-in stop gives uniform depth within 1/3 turn.
- Friction clutch gives smooth, cushioned action and tap protection
- Precision thread ground lead screws are changed in seconds.

These lead screw tappers are completely automatic. The lead screw head has its own built-in stroke which eliminates drill press feeds. To operate, merely depress the push button which sets the tap in motion for a complete cycle. Or, use the convenient foot pedal which also sets the unit in operation but has the advantage of freeing both hands.

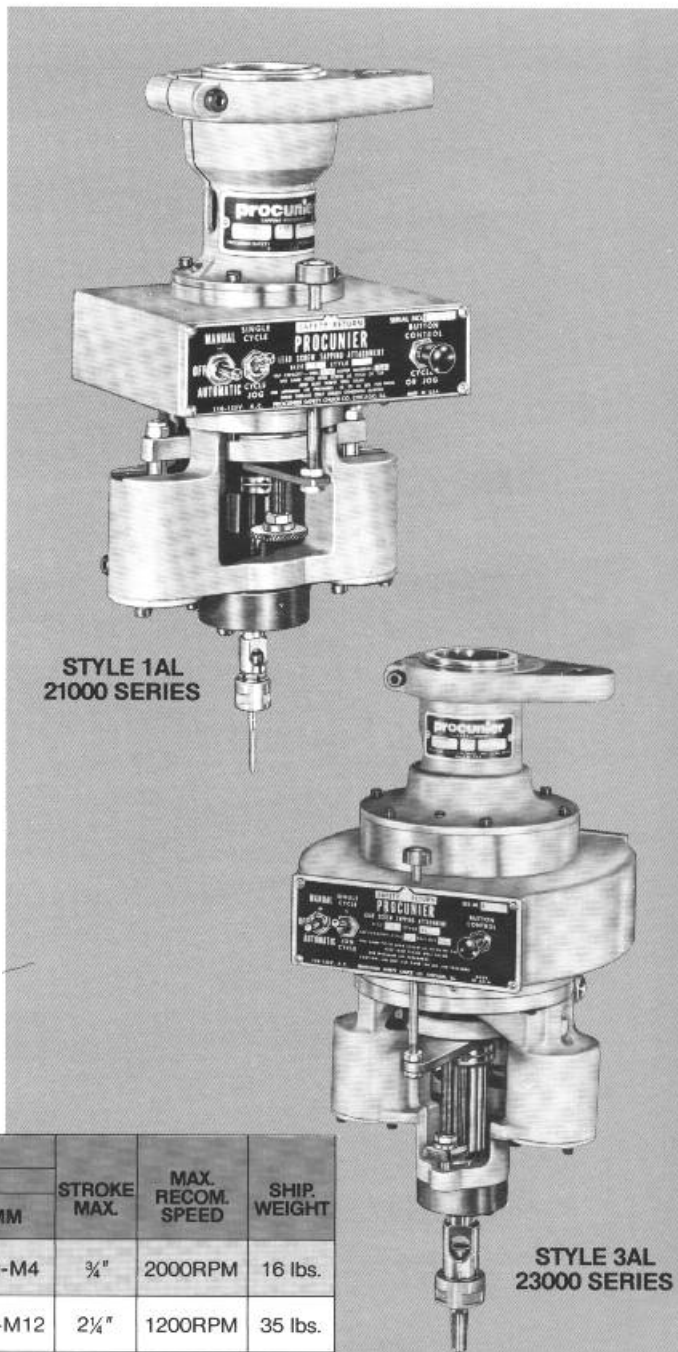
When the start button is depressed, the electrically controlled air pressure is released engaging the sensitive friction clutch. The tap, being completely controlled by the lead screw, is fed gently and automatically into the work. The result is continuous and repetitive uniformity and precision that never varies. And, it does not take a skilled operator to produce perfect pieces. If you can push a button, you're a tapping expert!

The lead screw will eliminate parts spoilage and stripped threads, reduce inspection, cut fixture costs, repeat depth accuracy within 1/3 turn of pitch, provide automatic tap protection . . . and more

### STANDARD EQUIPMENT

Nos. 1AL & 3AL are supplied with grounded power line cord, air line with fittings, foot switch with the grounded cord and plug, wrenches, quill clamping cover and drive adaptor as required. Series 21000 uses #1 (51800 series), and series 23000 uses #3 (53800 series).

**Note: Collets & Lead Screw Assembly Not Included. Must be Ordered Separately.**



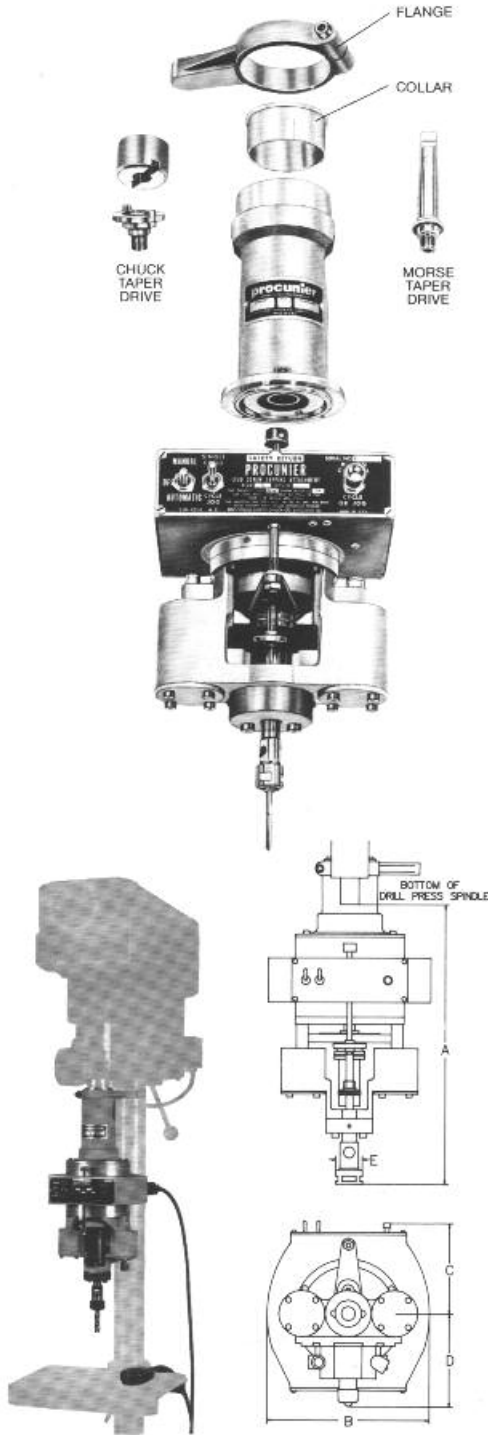
SERIES	STYLE	CAPACITY					STROKE MAX.	MAX. RECOM. SPEED	SHIP. WEIGHT
		SOFT MATERIAL			STEEL				
		INCH	MM	PIPE	INCH	MM			
21000	1-AL	#0-¼"	M2-M6	—	#0-¾"	M2-M4	¾"	2000RPM	16 lbs.
23000	3-AL	#10-¾"	M5-M18	¼"-*¾"	#10-½"	M5-M12	2¼"	1200RPM	35 lbs.

\*For 3/8" Pipe tap use #3-AL4TG lead screw assembly (24000 Series) and use #4 collets (54000 Series)

For LEFT HAND operation the unit must be modified. Series Order Number 57550. (Use left hand Lead Screw.) Not for use in inverted position.

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**Style AL Lead Screw Tappers Series 21000 and 23000**



DRILL PRESS	QUILL DIA.	TAPER	SERIES 21000 STYLE 1AL	SERIES 23000 STYLE 3AL
ALLEN #2	2.250	2A JAC	21053	23053
ATLAS 15"	1.812	33JAC	21035	23035
BOICE CRANE 15"	1.850	33JAC	21036	23036
BUFFALO 15"	1.750	33JAC	21037	23037
18"	2.375	2MT	21063	23063
18"	2.375	3MT	21099 *	23084
CINCINNATI 16"	1.850	33JAC	21036	23036
18"	2.375	2MT	21063	23063
18"	2.375	3MT	21099 *	23084
CLAUSING 15"	1.988	33JAC	21038	23038
15"	1.988	2MT	21064	23064
20"	2.489	3MT	21099 *	23085
CRAFTSMAN	1.625	33JAC	21039	23039
	1.812	33JAC	21035	23035
	1.875	33JAC	21041	23041
DURO 18"	2.500	2MT	21071	23071
18"	2.500	3MT	21099 *	23091
EDLUND 2B	2.861	2MT	21065	23065
3B	3.125	3MT	21099 *	23099*
JET 13R	1.812	6A JAC	21061	23061
14M	2.050	2MT	21099 *	23066
LELAND GIFFORD 1-LMS	2.438	2A JAC	21046	23046
2-LMS	2.875	2MT	21067	23067
POWERMATIC 15"	2.187	33JAC	21047	23047
15"	2.187	2MT	21068	23068
20"	2.750	2MT	21099 *	23072
20"	2.750	3MT	21099 *	23088
ROCKWELL/DELTA 14"	1.750	33JAC	21037	23037
15"	2.000	33JAC	21048	23048
17"	2.250	33JAC	21049	23049
17"	2.250	2MT	21069	23069
20"	2.375	2MT	21063	23063
20"	2.375	3MT	21099 *	23084
SOUTH BEND 14"	1.750	6A JAC	21050	23050
STANDARD MACHINE	2.125	2A JAC	21051	23051
WALKER TURNER 15"	1.812	33JAC	21035	23035
15"	1.812	2MT	21070	23070
17"	2.250	2MT	21069	23069
17"	2.250	3MT	21099 *	23090
20"	2.375	2MT	21063	23063
20"	2.375	3MT	21099 *	23084
WILTON 15"	2.000	33JAC	21048	23048

\*SPECIAL UNIT—UPON ORDERING, SPECIFY MAKE OF DRILL PRESS, QUILL DIAMETER, SPINDLE TAPER AND LENGTH. SEE PAGE 29.

DIMENSIONS						
SERIES	STYLE	A	B	C	D	E
21000	1AL	9½	6¼	3¾	3 <sup>7</sup> / <sub>16</sub>	¾
23000	3AL	14½	8¾	4¾	5 <sup>5</sup> / <sub>16</sub>	1¾

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## Lead Screw Assemblies

Includes one-piece hardened and ground lead screw with THRU-GRIP tap holder, split lead screw nut, cap and wiper oiler. Entire unit is quickly replaced by merely removing pin in drive collar and 2 screws in Lead Screw cap. Fully adjustable for wear. Choose pitch, right – or left-hand thread and model from table below. All Proconier tappers use Style AL lead screw assemblies except when the 1-AL (21000 Series) is used with model 22MD (30000 Series) then the Style MB lead screw assemblies (30400 Series) must be used.

### Order Numbers for Lead Screw Assemblies

PITCH	1-AL—½" Dia.		22-MB—½" Dia.		3-AL—¾" Dia.		3-AL—4TG—¾" Dia.	
	R.H.	L.H.	R.H.	L.H.	R.H.	L.H.	R.H.	L.H.
127	21401	21402						
120	21403	21404						
113	21405	21406						
110	21407	21408						
102	21409	21410						
100	21411	21412						
96	21413	21414						
90	21415	21416						
80	21419	21420	30419	30420				
72	21421	21422	30421	30422				
64	21425	21426	30425	30426	23425	23426		
60	21427	21428	30427	30428	23427	23428		
56	21429	21430	30429	30430	23429	23430		
48	21435	21436	30435	30436	23435	23436		
44	21437	21438	30437	30438	23437	23438		
40	21439	21440	30439	30440	23439	23440		
36	21443	21444	30443	30444	23443	23444		
32	21445	21446	30445	30446	23445	23446	24445	24446
28	21449	21450	30449	30450	23449	23450	24449	24450
27	21451	21452			23451	23452	24451	24452
26	21453	21454	30453	30454	23453	23454		
24	21455	21456	30455	30456	23455	23456	24455	24456
20	21459	21460	30459	30460	23459	23460	24459	24460
18	21463	21464	30463	30464	23463	23464	24463	24464
16	21465	21466	30465	30466	23465	23466	24465	24466
14					23467	23468	24467	24468
13					23469	23470	24469	24470
12					23471	23472	24471	24472
11½					23473	23474	24473	24474
11					23475	23476	24475	24476
10					23477	23478	24477	24478
5					23487	23488	24487	24488

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AL Style



MB Style

PITCH	1-AL—½" Dia.		22-MB—½" Dia.		3-AL—¾" Dia.		3-AL—4TG—¾" Dia.	
	R.H.	L.H.	R.H.	L.H.	R.H.	L.H.	R.H.	L.H.
.25mm	21505	21506	30505	30506				
.30mm	21507	21508	30507	30508				
.35mm	21509	21510	30509	30510				
.40mm	21511	21512	30511	30512	23511	23512		
.43mm	21513	21514	30513	30514	23513	23514		
.45mm	21515	21516	30515	30516	23515	23516		
.50mm	21517	21518	30517	30518	23517	23518		
.53mm	21519	21520	30519	30520	23519	23520		
.60mm	21521	21522	30521	30522	23521	23522		
.66mm	21523	21524	30523	30524	23523	23524		
.70mm	21525	21526	30525	30526	23525	23526		
.73mm	21527	21528	30527	30528	23527	23528		
.75mm	21529	21530	30529	30530	23529	23530		
.80mm	21531	21532	30531	30532	23531	23532		
.81mm	21533	21534	30533	30534	23533	23534		
1.00mm	21535	21536	30535	30536	23535	23536	24535	24536
1.20mm	21537	21538	30537	30538	23537	23538	24537	24538
1.25mm	21539	21540	30539	30540	23539	23540	24539	24540
1.40mm					23541	23542	24541	24542
1.50mm					23543	23544	24543	24544
1.60mm					23545	23546	24545	24546
1.70mm					23547	23548	24547	24548
1.75mm					23549	23550	24549	24550
2.00mm					23551	23552	24551	24552
2.50mm					23553	23554	24553	24554

Note: Left hand lead screws may only be used with tappers which are modified for L.H. use.  
Other lead screws available upon request. Contact factory.

*Designers & Manufacturers of Drilling & Tapping Solutions*

Now, within seconds, you can convert your single spindle tapping attachment or unit into a multiple spindle tapping machine to tap 2, 3, or 4 holes with the same effort it normally takes to tap a single hole!

**MD 2, 3 and 4-spindle single eccentric gear-driven models feature:**

- Fully adjustable spindle centers:  
2-spindle: 1" min. (1" – 4" bolt circle)  
3-spindle: 1 1/8" min. (1 1/2" – 4 1/2" bolt circle)  
4-spindle: 1 1/16" min. (1 1/2" – 4 1/2" bolt circle)
- Mounts directly to Size 3 Lead Screw Unit for gauge-perfect tapping.
- Hardened gearing . . . ball and needle bearing construction.
- Hex and tang drivers . . . no keys or pins.

Special features include 1:1 or 1:2 input-to-output speed gear ratio. (NOTE: Must use lead screw assembly with one-half the pitch of the tap with 1:2 ratio units, or twice the pitch for metric taps.) Our innovative adapter guide assembly is supplied with Models 23MD, 33MD and 43MD to add even greater versatility and allow the unit to rotate a full 360° to align with hole patterns on a horizontal, vertical or diagonal plane.

**STANDARD EQUIPMENT**

Styles 23MD, 33MD and 43MD are furnished with an adapter guide assemblies.

Order Numbers for Style MD Attachments  
(Spindle assemblies or collets not included)

STYLE	NO. OF SPINDLES	GEAR RATIO	
		1:1	1:2*
23MD	2	30033	30034
33MD	3	31033	31034
43MD	4	32033	32034

\*Must use lead screw assembly with one-half the pitch of tap, or metric twice the pitch.



**Adapter Guide Assembly**

Used with Models 23MD, 33MD and 43MD to provide tapping flexibility. Assembly includes guide rods, cylinder guide housings and adapter ring for mounting on 3-AL lead screw tappers.

Order #30266

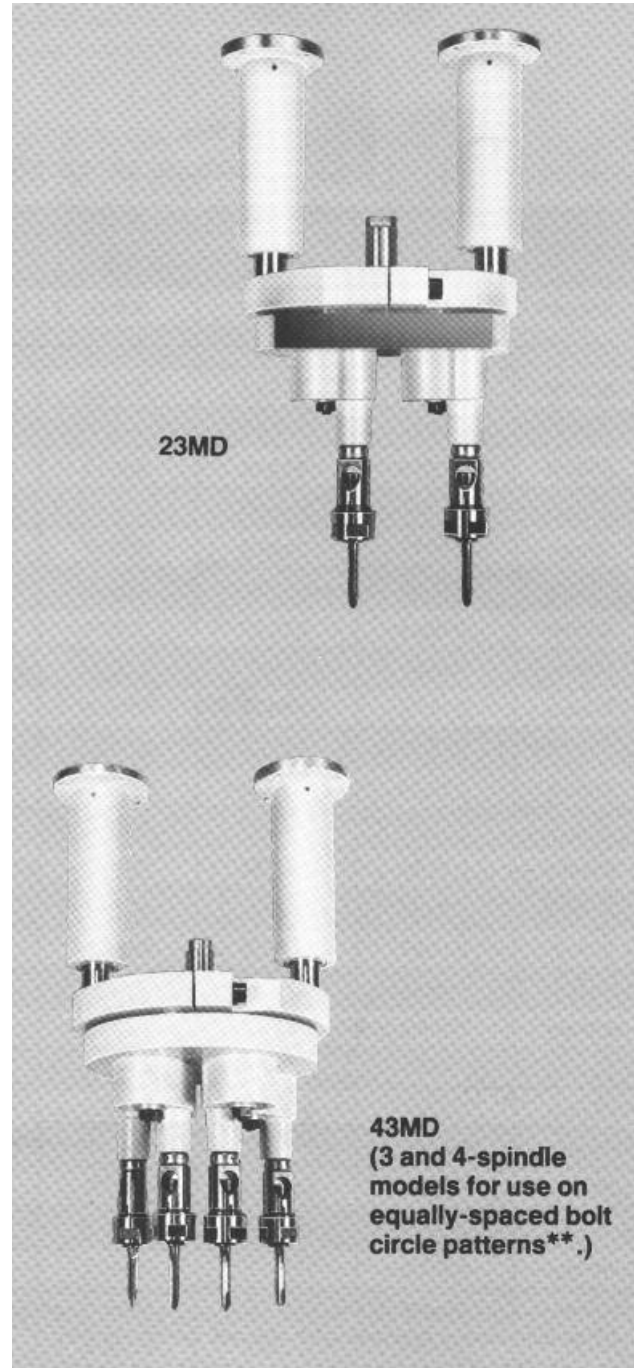


**Fixed Spindle Adapter**

Converts adjustable spindle assemblies to a fixed position.

Provides greater strength and rigidity. (Special optional accessory)

Order #30299





23MD

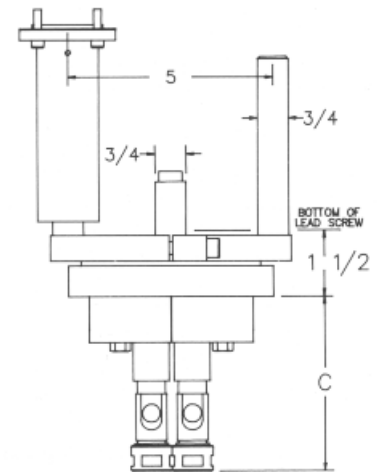
43MD  
(3 and 4-spindle models for use on equally-spaced bolt circle patterns\*\*.)

*Designers & Manufacturers of Drilling & Tapping Solutions*

Quality engineered spindles incorporate complete bearing construction with hardened spindles. Available in stationary, adjustable and compensating designs. Complete assemblies include precision needle bearings for accuracy, thrust bearings for load, spindle complete with lock nut and wrenches if required, strong hex drive gear with tension adjusting nut, and positive single nut lock housing.

	ORDER NUMBER	MODELS	TYPE	USE WITH COLLET SERIES	TAPPING CAPACITY	"C" LENGTH	NET WEIGHT
		30405	2DS	#2 Collet Stationary	52600 52800	#0-3/8"	4 1/8"
2 DS	30406	5DS	#5 Collet Stationary	55600 55800	#0-3/8"	4 7/16"	3/4 lb.
	30407	5DA	#5 Collet Adjustable depth 7/8" Adj.	55600 55800	#0-3/8"	6 3/4" Max.	3/4 lb.
5 DA	30408	5DC	#5 Collet Compression 1/2" Pitch Compensation	55800	#0-3/8"	6 1/2"	3/4 lb.
	30409	5DT	#5 Collet Tension 1/2" Pitch Compensation	55800	#0-3/8"	5 11/16"	3/4 lb.

**NOTE: Quick-Change spindle assemblies are now available. Contact the factory for details.**



**SPECIFICATIONS**

Model No.	Use With Tapper Style	Bolt Circle Centers	CAPACITY				Max. Speed RPM	Ship. Wgt.
			SOFT MATERIAL		STEEL			
			Thread Cutting	Thread Forming	Thread Cutting	Thread Forming		
23 MD	3-AL	1"-4"	#4-3/8"	#4-5/16"	#4-5/16"	#4-1/4"	1200	9 lbs.
33 MD	3-AL	1 1/2"-4 1/2"	#4-5/16"	#4-5/16"	#4-1/4"	#4-#12	1200	10 lbs.
43 MD	3-AL	1 1/2"-4 1/2"	#4-1/4"	#4-1/4"	#4-#12	#4-#12	1200	10 lbs.

Designers & Manufacturers of Drilling & Tapping Solutions

- Tap up to 17 holes at once
- Minimum spindle centers = 1/2" collet or 3/8" bored type.
- 6" or 8" round work area
- Converts from 1:1 to 1:2 gear ratio in the field.
- Ball bearing construction, hardened gears and solid hex drivers give dependable, heavy-duty service.
- Aluminum head for minimum weight. Sturdy base with dual guide rods and balance springs.

### STANDARD EQUIPMENT

Styles 37-MJ, 37-MK, 37-MP and 37-MQ furnished with base assembly (shown below), wrenches and unbored TEMPLATE.

Spindles with U-joints and collets not included as standard equipment.

### SPECIFICATIONS

STYLE	MAX. REC. SPEED	SHIPPING WEIGHT
37-MJ	2200 RPM	38 lbs.
37-MK	2200 RPM	42 lbs.
37-MP	2200 RPM	41 lbs.
37-MQ	2200 RPM	45 lbs.

**CAPACITY**—Maximum 3/8" tap per driver depending on spindle assembly selected.

### Order Numbers for Style 37-MJ, 37-MK, 37-MP and 37-MQ Attachments

STYLE	WORK AREA	NO. OF DRIVERS	GEAR RATIO	WITH BASE ASSEMBLY ORDER NO.	LESS BASE ASSEMBLY ORDER NO.
37-MJ	6" dia.	7	1:1	33005	33009
37-MJ	6" dia.	6	1:2	33006	33010
37-MK	8" dia.	9	1:1	34005	34009
37-MK	8" dia.	8	1:2	34006	34010
37-MP	6" dia.	10	1:1	39005	39009
37-MQ	8" dia.	17	1:1	40005	40009



**Base Assembly** – MJ, MK, MP and MQ include base, bosses, guide rods, balance springs and adapter bar. Series order Number 33510 Weight – 23 lbs.



### TEM-PLATE

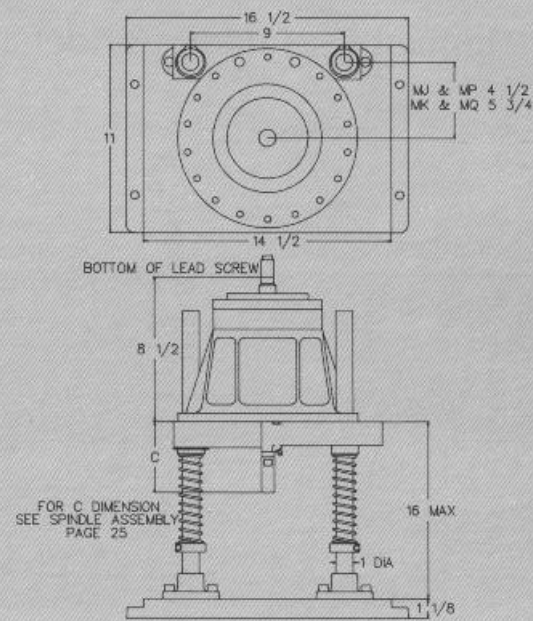
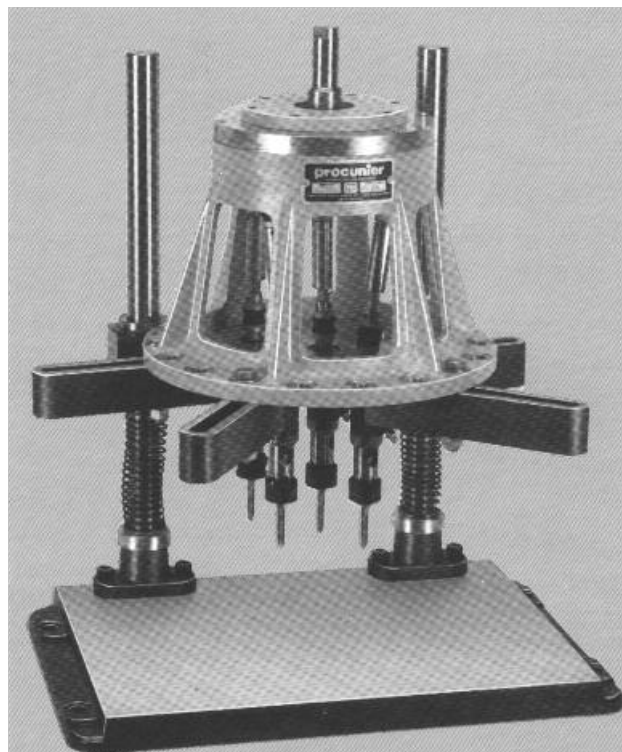
The exclusive Proconier TEM-PLATE assures positive location of spindle assemblies allowing ease of repeat set-ups. Plates are easily interchanged to different hole patterns.

\*PROCUNIER will custom position and bore these TEM-PLATES.



### Special Bar Assembly

Cartridge type spindles do not require a TEM-PLATE. They are designed to use 1 1/2" – thick bars bored to hold cartridge type spindles. These bars are special and individually quoted. Series Order Number 33499.



*Designers & Manufacturers of Drilling & Tapping Solutions*

- Tap up to 17 holes
- Minimum spindle centers = 1/2" collet or 3/8" bored type.
- 4" x 10" or 5" x 12" rectangular work area.
- Available with 1:1 to 1:2 gear ratio.
- Ball bearing construction, hardened gears and solid hex drivers give dependable, heavy-duty service.
- Aluminum head for minimum weight. Sturdy base with dual guide rods and balance springs.

**STANDARD EQUIPMENT**

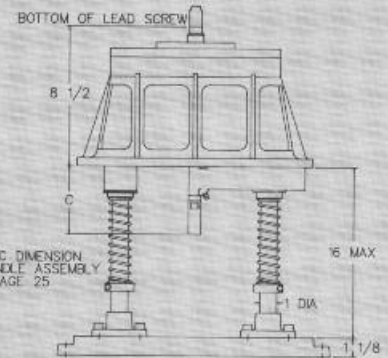
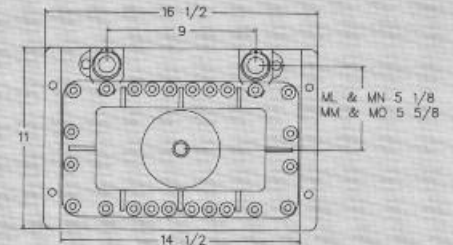
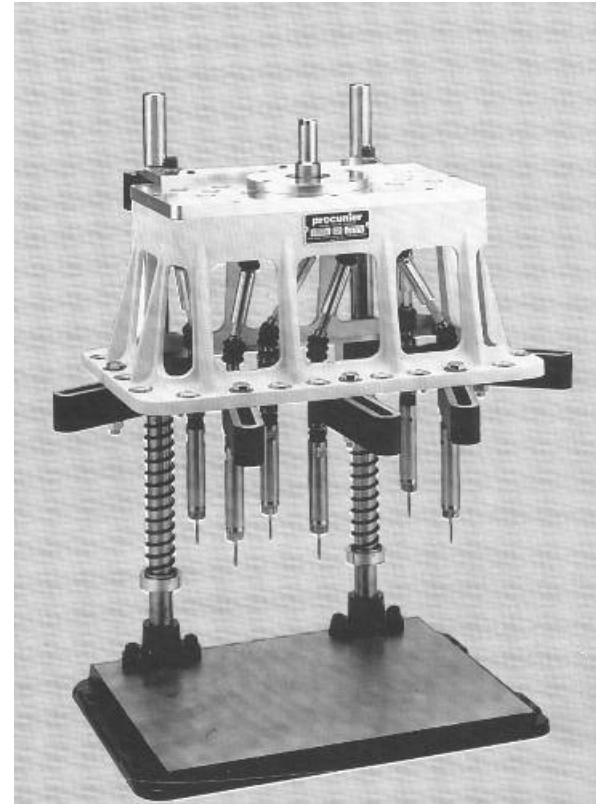
Styles 37-ML, 37-MM, 37-MN and 37-MO furnished with base assembly (shown below), wrenches and unbored TEM-PLATE.

STYLE	MAX. REC. SPEED	SHIPPING WEIGHT
37-ML	2000 RPM	49 lbs.
37-MM	2000 RPM	54 lbs.
37-MN	2000 RPM	52 lbs.
37-MO	2000 RPM	57 lbs.

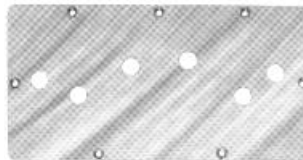
**CAPACITY**—maximum 3/8" tap per driver depending on spindle assembly selected.

**Order Numbers For Style 37-ML, 37-MM, 37-MN & 37-MO Attachments**

STYLE	WORK AREA	NO. OF DRIVERS	GEAR RATIO	WITH BASE ASSY. ORDER NO.	LESS BASE ASSY. ORDER NO.
37-ML	4" x 10"	9	1:1	35005	35009
37-ML	4" x 10"	8	1:2	35006	35010
37-MM	5" x 12"	13	1:1	36005	36009
37-MM	5" x 12"	12	1:2	36006	36010
37-MN	4" x 10"	13	1:1	37005	37009
37-MO	5" x 12"	17	1:1	38005	38009



**Base Assembly – ML, MM, MN and MO** include base, bosses, guide rods, balance springs and adapter bar.  
Series Order Number 35510 ML, MN  
Series Order Number 36510 MM, MO



**TEM-PLATE**

The exclusive Proconier TEM-PLATE assures positive location of spindle assemblies allowing ease of repeat set-ups. Plates are easily inter-changed to different hole patterns.

\*PROCUNIER will custom position and bore these TEM-PLATES.  
Order Number 57540.

Fits Style	Order Number
37-ML & 37-MN	35261*
37-MM & 37-MO	36261*



**Special Bar Assembly**

Cartridge type spindles do not require a TEM-PLATE. They are designed to use 1 1/4" thick bars bored to hold cartridge type spindles. These bars are special and individually quoted.  
Series Order Number 33499.



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**#0 & #5 COLLET**

**Tap Collets  
Order Numbers for Drill Collets**



**#1, #2, #3, #4 COLLET**

**NOTE: On MM Taps, check round and square dimensions for proper Collet selection.**

TAP SIZE	TAP DIMENSIONS		#0 PRO #1 ROC 7/16" HEX	#1 PRO 3/8" O.D.	#2 PRO 1/2" O.D.	#3 3/4" O.D.	#4 1" O.D.	#2 ROC #5 PRO 5/8" HEX	#1 MT TAP DRIVER	#0 Quick Change	#0 Quick Change
	ROUND	SQUARE									
2.3mm	.092	.079	50801	51801							
2.5mm	.099	.079	50802	51802							
2.8mm	.110	.079	50803	51803							
2.8 ISO	.110	.088	50804	51804							
3.0mm	.118	.095	50805	51805							
3.15 ISO	.124	.098	50806	51806							
3.2mm	.126	.095	50807	51807							
1/8" W	.128	.105	50808	51808							
3.4mm	.134	.106	50809	51809							
3.5mm	.138	.106	50810	51810							
#0-6	.141	.110	50811	51811*	52811			55811	56811	58811	59811
#4BA	.144	.116	50812	51812	52812			55812			
3.8mm	.150	.118	50813	51813	52813			55813			
4.0mm	.158	.118	50814	51814	52814			55814			
4.0 ISO	.158	.124	50815	51815	52815			55815			
5/32" W	.160	.125	50816	51816	52816			55816			
4.2mm	.165	.134	50817	51817	52817			55817			
#8	.168	.131	50818	51818*	52818*	53818		55818	56818	58818	59811
4.5mm	.177	.134	50819	51819	52819	53819		55819			
4.5 ISO	.177	.140	50820	51820	52820	53820		55820			
4.6mm	.181	.150	50821	51821	52821	53821		55821			
1/4" Nut	.185	.139	50822	51822	52822	53822		55822			
3/16" W	.189	.149	50823	51823	52823	53823		55823			
#10	.194	.152	50824	51824*	52824*	53824		55824	56824	58824	59824
5.0mm	.197	.150	50825	51825	52825	53825		55825			
5.0 ISO	.197	.158	50826	51826	52826	53826		55826			
3/16" SB	.201	.151	50827	51827	52827	53827		55827			
5.5mm	.217	.169	50828	51828	52828	53828		55828			
#12	.220	.165	50829	51829	52829	53829		55829	56829	58829	59829
5.9mm	.232	.193	50831	51831	52831	53831		55831			
6.0mm	.236	.193	50832	51832	52832	53832		55832			
5/16" Nut	.240	.180	50833	51833	52833	53833		55833			
6.2mm	.244	.193	50834	51834	52834	53834		55834			
#14	.247	.185	50835	51835	52835	53835		55835	56835		
6.3 ISO	.248	.197	50836	51836	52836	53836		55836			
1/4" W	.253	.197	50837	51837	52837	-		55837			
1/4"	.255	.191	50838	51838*	52838*	53838*	54838	55838	56838	58838	59838
3/8" ss	.275	.206			52839	53839	54839	55839	56839		
7.0mm	.276	.217			52840	53840	54840	55840			
7.1 ISO	.280	.221			52841	53841	54841	55841			
7.2mm	.284	.217			52842	53842	54842	55842			
9/32"	.286	.214			52843	53843	54843	55843			
3/8" Nut	.294	.220			52844	53844	54844	55844			
1/8" ss PT.	.313	.234			52845	53845	54845	55845			
8.0mm	.315	.244			52846	53846	54846	55846			
8.0 ISO	.315	.248			52847	53847	54847	55847			
5/16"	.318	.238			52848*	53848	54848	55848	56848		59848
7/16"	.323	.242			52849	53849	54849	55849			59849

\*FURNISHED AS STANDARD EQUIPMENT UNLESS OTHERWISE SPECIFIED.



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# Tap Collets

## Order Numbers for Drill Collets



**#1 MT TAP DRIVER**



**ADJUSTABLE ADAPTER**

<sup>5</sup>/<sub>8</sub>" adjustable adapter for use with #1-MT tap driver. **Order No. 56600.**

**NOTE: On MM Taps, check round and square dimensions for proper Collet selection.**

TAP SIZE	TAP DIMENSIONS		#0 PRO #1 ROC 7/16" HEX	#1 PRO 3/8" O.D.	#2 PRO 1/2" O.D.	#3 3/4" O.D.	#4 1" O.D.	#5 PRO #2 ROC 5/8 HEX	#1 MT TAP DRIVER	#1 Quick Change
	ROUND	SQUARE								
8.4mm	.331	.276			52850	53850	54850	55850		
8.5mm	.335	.276			52851	53851	54851	55851		
7/16" Nut	.345	.259			52852	53852	54852	55852		
9.0mm	.354	.276			52854	53854	54854	55854		
9.0 ISO	.354	.280			52855	53855	54855	55855		
1/2"	.367	.275			52856	53856*	54856	55856		59856
9.4mm	.370	.276			52857	53857	54857	55857		
3/8" W	.377	.294			52858	53858	54858	55858		
3/8"	.381	.286			52859*	53859*	54859	55859		59859
10.0mm	.394	.315				53860	54860			
1/2" Nut	.400	.300				53861	54861			
10.5mm	.413	.315				53862	54862			
9/16"	.429	.322				53863	54863			
11.0mm	.433	.354				53864	54864			
1/8" Pipe	.438	.328				53865	54865			
7/16" Pul.	.444	.333				53866	54866			
9/16" Nut	.450	.337				53867	54867			
12.0mm	.472	.354				53868	54868			
5/8"	.480	.360				53869*	54869*			
12.5mm	.492	.394				53870	54870			
5/8" Nut	.503	.377				53871	54871			
1/2" Pul.	.507	.380				53872	54872			
13.0mm	.512	.394				53873	54873			
1 1/16"	.542	.406				53874	54874			
14.0mm	.551	.433				53875	54875			
1/4" Pipe	.563	.421				53876	54876			
1 1/16" Nut	.565	.424				53877	54877			
3/4"	.594	.442				53878	54878*			
15.0mm	.591	.472				53879	54879			
3/4" Nut	.616	.462					54880			
16.0mm	.630	.472					54881			
5/8" Pul.	.633	.475					54882			
1 3/16"	.652	.489					54883			
1 3/16" Nut	.679	.509					54884			
1/2" Pipe	.687	.515					54885			
7/8"	.697	.523					54886*			
3/8" Pipe	.700	.531					54887			
18.0mm	.709	.571					54888			
7/8" Nut	.727	.545					54889			
19.0mm	.748	.571					54890			
1 5/16"	.760	.570					54891			
20.0mm	.787	.630					54892			
1 5/16" Nut	.789	.592					54893			
1"	.800	.600					54894*			
1" Nut	.834	.625					54895			
22.0mm	.866	.709					54896			
22.4mm	.881	.709					54897			
1 1/8"	.896	.672					54898			
3/4" Pipe	.906	.679					54899			

\* FURNISHED AS STANDARD EQUIPMENT UNLESS OTHERWISE SPECIFIED.

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**Tension Tap Holders**

Compact, economical tension tap holders for use on CNC machining centers, screw machines, automatic lathes and chuckers, CNC lathes and milling machines. Eliminates tap breakage caused during machine reversal by automatically providing overtravel, and compensating for improper feed rate.

SERIES ORDER NUMBER	CAPACITY	HOLDING O. D.	TOOL LENGTH	TAP COLLET SERIES NO.	TENSION TRAVEL
57407	#0-1/4"	3/4"	3 1/4"	51800	3/8"
57410	#8-1/2"	1"	4 1/4"	52800	1/2"
57413	#10-3/4"	1"	4 7/8"	53800	5/8"
57515	1/4 - 1"	1 1/2"	5 7/16"	54800	5/8"



**TRU-GRIP™ Tap Chucks**

These tap holding chucks incorporate the time-proven Proconier TRU-GRIP Tap Holder with a straight or a morse taper shank for machines with reversible spindles. Chucks are one-piece, hardened and ground for greatest accuracy. Small-light-compact-durable. Complete chucks include shank, locking nut and wrenches. Order collets separately.

STYLE	CHUCK DIM.		CAPACITY	SERIES ORDER NUMBERS					TAP COLLET SERIES NO.
	O. D.	PROJ.		STRAIGHT SHANK	1 MT	2 MT	3 MT	4 MT	
2TG	1"	2 1/8"	#6-1/2"	57420 (1/2")	57421	57422			52800
3TG	1 7/16"	2 1/2"	#8-3/4"	57430 (9/16")		57432	57433		53800
4TG	2"	3 1/8"	1/4"-1 1/8"	57440 (3/4")		57442	57443	57444	54800



**TRU-GRIP Tap Holder Reducer**

Allows greater range for the size 3 TRU-GRIP tap holder. Includes adapter holder, shank, lock nut and wrenches. Does not include tap collet.

3-TG – 1-TG Reducing Tap Holder: Order Number 57405.

Uses #1 collets (51000 series).

**Round Die Holder Collets**

These holders are made to be used with "Adjustable Round Split" dies. Precision ground and made to fit into Proconier TRU-GRIP tap holders.



STYLE	HOLDS ROUND O. D. DIE SIZE	FITS TAP HEAD SIZE	SHANK DIA.	CAPACITY		MAXIMUM LENGTH OF THREADS	ORDER NUMBER
				INCH	MM		
1-TRC	5/8"	1	3/8"	#0-#12	M2-M5	1"	57490
1-TRC	13/16"	1	3/8"	#0-1/4"	M2-M6	1"	57491
2-TRC	1"	2	1/2"	#6-7/16"	M4-M10	1 1/2"	57492
3-TRC	1 1/2"	3	3/4"	#8-3/4"	M5-M18	1"	57495
4-TRC	2"	4	1"	1/4-1 1/8"	M6-M28	1 1/4"	57497

*Designers & Manufacturers of Drilling & Tapping Solutions*

SIZE TAP	THREAD PITCH		DRILL SIZE		MATERIAL					
	N.C.	N.F.	CUT THD.	ROLL THD.	ALUMINUM		SOFT STEEL		STAINLESS STEEL	
					RPM	H.P.	RPM	H.P.	RPM	H.P.
#0		80	3/64"	#54	2000	1/16	2000	1/16	1270	1/8
#2	56		#50	5/64"	2000	1/16	2000	1/16	750	1/8
#4	40		#43	#39	2000	1/16	2000	1/8	580	1/4
#6	32		#34	1/8"	2000	1/16	1870	1/8	470	1/4
#8	32		#29	#25	2000	1/16	1560	1/8	390	1/4
#10	24		#23	11/64"	1700	1/8	1360	1/4	340	1/3
		32	#20	#16	1800	1/8	1600	1/4	400	1/2
1/4"	20		#6	#1	1600	1/4	800	1/3	200	1/2
		28	#3	A	1800	1/4	1200	1/4	300	1/3
5/16"	18		G	7.3mm	1260	1/4	640	1/3	160	3/4
		24	I	M	1500	1/4	960	1/3	240	1/2
3/8"	16		O	S	1050	1/4	530	1/2	130	1
		24	R	T	1300	1/4	800	1/2	200	3/4
7/16"	14		3/8"	13/32"	1200	1/3	450	3/4	110	1
1/2"	13		27/64"	15/32"	800	1/3	400	3/4	100	1
		20	29/64"	31/64"	1200	1/3	600	3/4	150	3/4
5/8"	11		17/32"	15.0mm	640	1/2	320	1	80	1 1/2
		18	37/64"	19/32"	975	1/2	490	3/4	120	1
3/4"	10		21/32"	45/64"	540	1/2	266	1	66	2
		16	11/16"	23/32"	815	1/2	405	1	100	1 1/2
7/8"	9		49/64"	—	460	3/4	230	1 1/2	56	2
1"	8		7/8"	—	400	3/4	200	1 1/2	50	3
1/8" NPT	27		R	—	1200	1/4	900	1/2	300	1/2
1/4" NPT	18		7/16"	—	1000	1/2	600	3/4	250	1
3/8" NPT	18		37/64"	—	700	3/4	350	1	150	1 1/2
1/2" NPT	14		23/32"	—	500	1	250	1 1/2	90	2
3/4" NPT	14		59/64"	—	350	1 1/2	175	2	50	3
<b>COOLANT →</b>					Soluble Oil.		Sulphur Base Oil.		Chlor. Sulphur Base Oil.	

NOTE: Water soluble coolant not recommended.

### Drill Press Adaptations

PROCUNIER Cover Clamps can be supplied to adapt to virtually any drill press. When ordering cover clamp style heads, the dimensions indicated, including the Taper "T", must be supplied. Dimension "A" always refers to the Quill diameter to a tolerance of .001.

