

These tools are identical to the Bant-A-Matic and Par-A-Matic units described on pages 12 and 13, except that these are fitted with tapping heads. All models are completely self-contained and have an adjustable stroke length of 2.0" maximum.

These tools are ideal for low-cost, automated hole tapping in applications where high precision is not required. Also excellent for thread-chasing operations.

Clutch-type tapping units may be used for both blind and thru-hole applications. Jaw-type units are for use in thru-hole applications only.

BANT-A-MATIC® SERIES Clutch-Type Tapping Head

No. 0 to 1/4" (M1.6 to M6) Capacity, Steel
.25 HP (.20 kW)



MODEL 8246-D8-2

PAR-A-MATIC® SERIES Clutch-Type Tapping Head

No. 0 to 1/2" (M1.6 to M12) Capacity, Steel
.50 HP (.37 kW)



MODEL 8256-C8-2

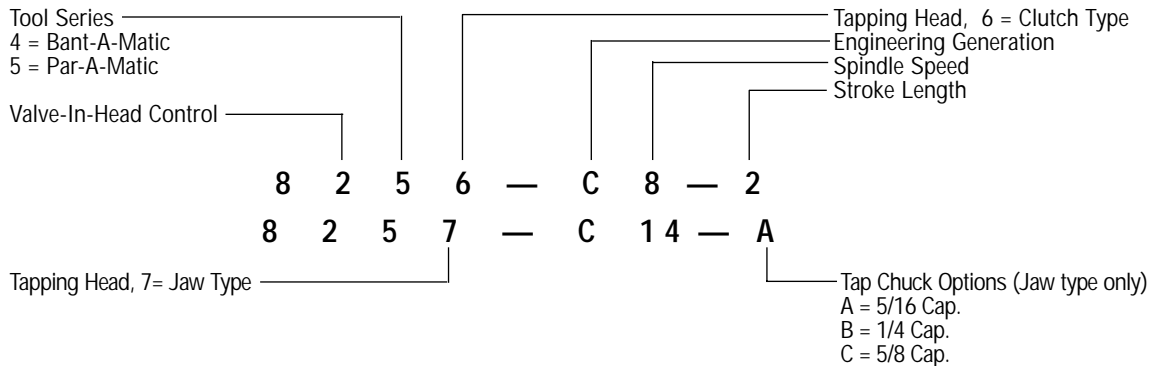
PAR-A-MATIC® SERIES Jaw-Type Tapping Head

No. 10 to 5/16" (M4.5 to M8) Capacity, Steel
.50 HP (.37 kW)



MODEL 8257-A8-()

MODEL IDENTIFICATION



SPECIFICATIONS

MODELS	STROKE LENGTH in. (mm)	FREE SPEED rpm	NOMINAL TAP CAPACITIES			HAND TAP CAPACITY	AIR CONSP† @ Working Speed		SOUND LEVEL dB(A)	GEAR REDUCTION
			Stnls. Steel Type 304	Mild Steel	Aluminum/ Brass		ft ³ /cycle	(L/cycle)		
BANT-A-MATIC SERIES (Clutch-Type)										
8246-D8-2	2.0 (51)	900		#8 (M6)	1/4 (M6)	No. 0-1/4"	15	(42)	77	Double
8246-D5-2	2.0 (51)	550		1/4 (M6)	1/4 (M6)**	(M1.6-M6)				Double
PAR-A-MATIC SERIES (Clutch-Type)										
8256-C14-2	2.0 (51)	1,450		#10 (M5)	1/4 (M6)		2.3	(65)	74	Double
8256-C8-2	2.0 (51)	850		5/16 (M8)	3/8	No. 0- 1/2"				Double
8256-C5-2	2.0 (51)	500		1/2 (M12)	1/2 (M12)	(M1.6-M12)				Double
PAR-A-MATIC SERIES (Jaw-Type)										
8257-A14-()	2.0 (51)	1,450		#10 (M5)	1/4 (M6)		2.3	(65)	74	Double
8257-A8-()	2.0 (51)	850		5/16 (M8)	3/8	No. 10-5/16"				Double
8257-A5-()	2.0 (51)	500		1/2 (M12)	9/16 (M14)	(M4.5-M8)				Double

† Consumption in cubic feet during a typical 6 second cycle time. **Tapping capacity is limited by the capacity of the tap chuck.
NOTE: Performance data given at 90 PSI (6.2 bar) air pressure.

TOOL SERIES	AIR INLET	CONTROL PORTS	SPINDLE THREAD	RECOMMENDED HOSE SIZE	RECOMMENDED OPERATING PRESSURE
Bant-A-Matic	1/8" NPT male	1/8" NPT female	1/2"-20 male	1/4" ID	90 PSI (6.2 bar)
Par-A-Matic	1/4" NPT male	1/8" NPT female	1/2"-20 male	5/16" ID	90 PSI (6.2 bar)

STANDARD EQUIPMENT

Bant-A-Matic Series (Clutch-Type)

- 42123-1 Tapping Head Attachment
- 37431-1 No. 0-No. 10 Cap. Rubber Flex Collet Insert
- 37431-2 No. 10-1/4" Cap. Rubber Flex Collet Insert
- 47884 Pneumatic Controls Interface Kits*
- Necessary Wrenches

Par-A-Matic Series (Clutch-Type)

- 38021-4 Tapping Head Attachment
- 38036 No. 0-1/4" Cap. Rubber Flex Collet Insert
- 38036-1 No. 1/4-1/2" Cap. Rubber Flex Collet Insert
- 47884 Pneumatic Controls Interface Kits*
- Necessary Wrenches

Par-A-Matic Series (Jaw-Type)

- 34000-1 Tapping Head Attachment
- 31432 No. 10-5/16" Cap. Tap Chuck (See Model Identification Chart on page 20)
- 31427 No. 1/4 Cap. Tap Chuck (See Model Identification Chart on page 20)
- 32060 No. 1/4-5/8" Cap. Tap Chuck (See Model Identification Chart on page 20)
- 47884 Pneumatic Controls Interface Kits*
- Necessary Wrenches

*Contains (2) 6045 90° street elbows and (2) 9600 pilot bleeder valves.

ACCESSORIES AT EXTRA COST

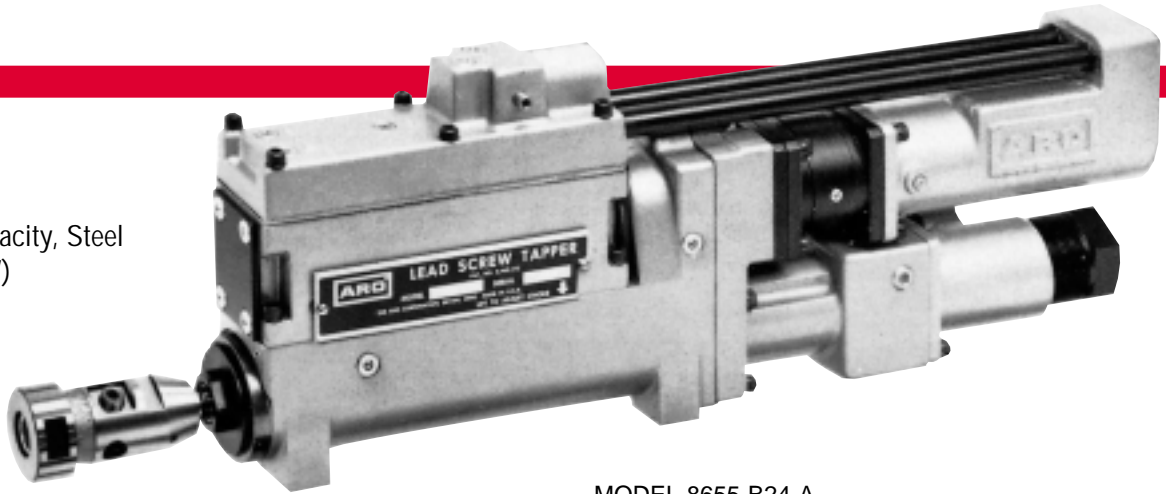
Bant-A-Matic Series

- 40301-() Hydraulic Checks
- 39486 Flange Bracket
- 39485-1 Foot Bracket
- 45053 H.D. Foot Bracket
- 36042 Split-Block Clamp
- Service Kits

Par-A-Matic Series

- 40591-() Hydraulic Checks
- 38877 Flange Bracket
- 38875-1 Foot Bracket
- 45055 H.D. Foot Bracket
- 35283 Split-Block Clamp
- Service Kits

2200 SERIES
 1/2" (M12) Capacity, Steel
 .62 HP (.47 kW)



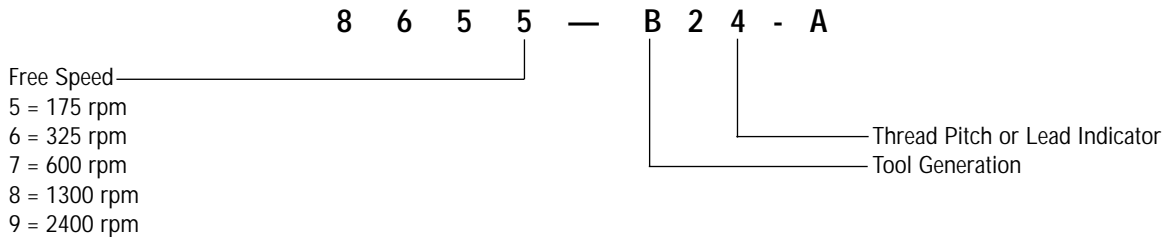
MODEL 8655-B24-A

The ARO Lead Screw Tapper is designed for precision hole tapping in medium and high-production machining applications. The tool is air operated and is fully automatic, with a built-in pressure-operated valve, manual controls and remote control ports for starting and retracting. Installation is easy, with only simple pneumatic circuitry required. It can be used individually or in conjunction with other pneumatic and electric self-feed tools and machine components.

Additional features/benefits include—

- Repeatability tapping depth accuracy of $\pm .005"$ (.127 mm).
- Stroke length is fully adjustable from 3/16" (4.8 mm) minimum to 2.0" (50.8 mm) maximum for use in a wide range of setups.
- A built-in "no-hole" sensing system prolongs tap life by automatically retracting the spindle when a pilot hole is missing or when excessive misalignment exists.
- Modular tool design enables easy servicing of air motor and gearing, and offers convenient, economical speed and lead screw conversions as job requirements change.
- Compact size requires less machine space for increased design flexibility.
- Fixed-position foot mounting requires no additional mounting hardware while providing added rigidity.
- A wide selection of models is available for both American and metric threads.
- Twin and multi-spindle tapping heads are available for close-center machining requirements.

MODEL IDENTIFICATION



SPECIFICATIONS

NOMINAL TAP CAPACITIES							LEAD SCREW and NUT ASSEMBLY	AIR CONSP.+ @ Working Speed ft ³ /cycle (L/cycle)	STD. CHUCK CAPACITY in. (mm)
Steel SAE 1213	3/8" to 1/2" (M10 to M12)	1/4 to 7/16 (M6 to M10)	No. 8 to 1/4 (M4 to M6)	No. 2 to No. 10 (M2 to M5)	No. 2 to No. 8 (M2 to M4)				
Aluminum 2024-T4	7/16 to 5/8 (M10 to M16)	5/16 to 1/2 (M8 to M12)	1/4 to 5/16 (M6 to M8)	No. 2 to 5/16 (M2 to M8)	No. 2 to No. 10 (M2 to M5)				
MODELS									
Free Speed	175 rpm	325 rpm	600 rpm	1,300 rpm	2,400 rpm				
11	8655-B11-A	8656-B11-A	8657-B11-A	—	—	45453-11			
12	8655-B12-A	8656-B12-A	8657-B12-A	—	—	45453-12			
13	8655-B13-A	8656-B13-A	8657-B13-A	8658-B13-A	—	45453-13			
14	8655-B14-A	8656-B14-A	8657-B14-A	8658-B14-A	—	45453-14			
16	8655-B16-A	8656-B16-A	8657-B16-A	8658-B16-A	—	45453-16			
18	8655-B18-A	8656-B18-A	8657-B18-A	8658-B18-A	—	45453-18			
AMERICAN THREAD	20 8655-B20-A	8656-B20-A	8657-B20-A	8658-B20-A	—	45453-20			
PITCH (T.P.I.)	24 8655-B24-A	8656-B24-A	8657-B24-A	8658-B24-A	8659-B24-A	45453-24			
	27 8655-B27-A	8656-B27-A	8657-B27-A	8658-B27-A	8659-B27-A	45453-27			
	28 8655-B28-A	8656-B28-A	8657-B28-A	8658-B28-A	8659-B28-A	45453-28			
	32 8655-B32-A	8656-B32-A	8657-B32-A	8658-B32-A	8659-B32-A	45453-32			
	36 8655-B36-A	8656-B36-A	8657-B36-A	8658-B36-A	8659-B36-A	45453-36			
	40 8655-B40-A	8656-B40-A	8657-B40-A	8658-B40-A	8659-B40-A	45453-40			
	44 8655-B44-A	8656-B44-A	8657-B44-A	8658-B44-A	8659-B44-A	45453-44			
	48 8655-B48-A	8656-B48-A	8657-B48-A	8658-B48-A	8659-B48-A	45453-48			
	56 8655-B56-A	8656-B56-A	8657-B56-A	8658-B56-A	8659-B56-A	45453-56			
.40	—	—	8657-B1-A	8658-B1-A	8659-B1-A	45785-40			
.45	—	—	8657-B2-A	8658-B2-A	8659-B2-A	45785-45			
.50	—	—	8657-B3-A	8658-B3-A	8659-B3-A	45785-50			
METRIC THREAD	.60 —	8656-B4-A	8657-B4-A	8658-B4-A	8659-B4-A	45785-60			
LEAD (mm)	.70 —	8656-B5-A	8657-B5-A	8658-B5-A	8659-B5-A	45785-70			
	.75 8655-B6-A	8656-B6-A	8657-B6-A	8658-B6-A	8659-B6-A	45785-75			
	.80 8655-B7-A	8656-B7-A	8657-B7-A	8658-B7-A	8659-B7-A	45785-80			
	1.00 8655-B8-A	8656-B8-A	8657-B8-A	8658-B8-A	8659-B8-A	45785-100			
	1.25 8655-B9-A	8656-B9-A	8657-B9-A	8658-B9-A	—	45785-125			
	1.50 8655-B10-A	8656-B10-A	8657-B10-A	8658-B10-A	—	45785-150			

Special Tappers available, featuring high duty cycle, twin and multi-spindle heads, and left hand threads. Consult factory.

+Consumption in cubic feet during a typical 6 second cycle time. NOTE: Performance data given at 90 PSI (6.2 bar) air pressure.

AIR INLET	CONTROL PORTS	SPINDLE THREAD	RECOMMENDED HOSE SIZE	RECOMMENDED OPERATING PRESSURE
3/8" NPT female	1/8" NPT female	No. 1 Morse Taper female	1/2" ID	90 PSI (6.2 bar)

STANDARD EQUIPMENT

- 41376 Tap Chuck, No. 0-1/2" (M4.5 - M12) Cap.
- Necessary wrenches

ACCESSORIES AT EXTRA COST

- 44889 Floating Tap Chuck, No. 0-5/8" (M1.6 - M16) Cap.
- 44890-() Collets for 44889 Chuck

44889 Floating Tap Chuck



Provides parallel float up to 0.030" (0.76 mm) to ensure the tap being driven aligns properly with the drilled hole. Order the desired size 44890-() Collet separately from the chart at the right.

AMERICAN HAND TAP SIZE	METRIC HAND TAP SIZE	COLLET ID		COLLET NO.
		in.	mm	
No. 0 - No. 6	M1.6 - M6	.141	3.58	44890-1
No. 8	M4	.168	4.27	44890-2
No. 10	M4.5 - M5	.194	4.93	44890-3
No. 12	—	.220	5.59	44890-4
No. 14 & 1/4"	M6	.255	6.48	44890-5
5/16"	M7 - M8	.318	8.08	44890-6
3/8"	—	.381	9.68	44890-7
7/16"	M10	.323	8.20	44890-8
1/2"	M12	.367	9.32	44890-9
9/16"	M14	.429	10.90	44890-10
5/8"	M16	.480	12.19	44890-11
1/8" S.S. Pipe*	—	.313	7.95	44890-12
1/8" L.S. Pipe*	—	.438	11.12	44890-13

*S.S. = Small Shank, L.S. = Large Shank