

Tapmatic Extra Short Tap Driver OPERATING INSTRUCTIONS for GSW 830 C

1. Application

These Extra Short Tap Drivers can be used on all types of machines with reversing motor capabilities. The «Tapping Cycle» is normally used on N/C machines. The feed rate should be equal to the pitch of the tap or slightly slower (up to 5 %).

2. Features

The Extension/compression feature compensates any lead error between the tap and the machine feed. A Hard Start with Override to Safety Compression provides added pressure to make even slightly dulled taps cut immediately into the workpiece and guarantees the full stroke of compression available in case of an urgency (e. g. tap breakage). The universal Tap Chuck accepts all taps of all standards within the rated capacity. The 'Rubber-Flex' collet centers the tap shank while a set of steel jaws transmits the drive to its square.

3. Mounting the tap

Put the appropriate Rubber-Flex collet into the chuck and open the Back Jaws entirely by turning the Hex Key counter-clockwise. Insert the tap and close the Nut 18 as far as to still permit the shank to turn freely. First always tighten the Back-Jaws 16 on the square of the shank - check correct seat through hole on flats - and secondly tighten Tap Chuck Nut 18 with the wrenches provided.

4. Setting the Override of the Hard Start Feature

This device (Screws item 3) is preset by the factory in such a way that a sharp tap will immediately cut into the material without receding, causing a taper bore at the entrance and finishing with an insufficient thread depth. The initial pressure can be adjusted by equally tightening or loosening the two Set Screws item 3. These screws should not be tightened too strongly in order to permit the compression Spring, once compressed, to relocate the Tap Chuck Spindle in its starting position.

Disassembly

1. Loosen Screws 8 and extract Housing 7
2. Take away Drive Balls 6
3. Unscrew the Retaining Screws 2 and pull-out Spindle 13
4. Unhook Return Spring 11 from Spring Hanger 9 using Threaded Spring Puller and Hook supplied with unit
Parts 10 and 12 are thus freed.

Assembly

Reverse instruction outlined above.

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