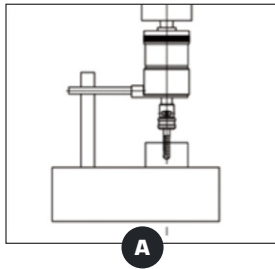
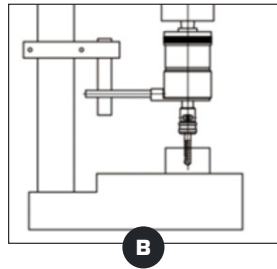


SELF-REVERSING TAPPING CHUCKS

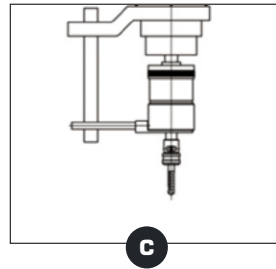
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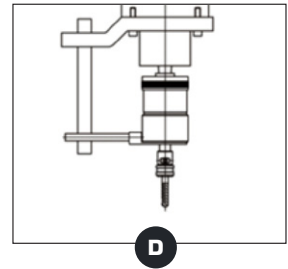
The brake rod is mounted on the work table



The brake rod is mounted on the column of the machine tool



The brake rod is mounted on the spindle quill



The brake rod is mounted on the flange of the spindle quill end

Figures A, B, C and D

1. MOUNTING INSTRUCTIONS

1.1 Mounting the Chuck

Clean the connecting parts of both the adaptor and the chuck. Assemble the chuck onto the machine spindle.

1.2 Mounting the Tap

Insert the tap into the chuck, ensuring the correct positioning of the tap handle using the window.

Insert the square end of the tap handle into the square hole of the clamping device.

Tighten the lock nut with a wrench before fastening the top screw of the clamping device.

1.3 Mounting the Brake Rod

Refer to Figures 1 for positioning the brake rod.

Use a rigid brake rod to withstand the torque of a reversing tap.

Recommended material: Steel 45#, 20-30, HRC45.

The brake rod should be mounted either on the non-rotating part of the spindle end or on the worktable.

2. ADJUSTING THE TORQUE

- The chuck's torque settings are indicated by numbers 1, 2, 3, and 4 on the main body.
- Select the appropriate torque based on the tap diameter and the material of the workpiece.
- For difficult-to-tap materials, performing the tapping operation twice is recommended.

3. TAPPING OPERATION

Follow these steps while referring to Figures 1-6:

1. Positioning: Lower the spindle until the tap makes contact with the workpiece.

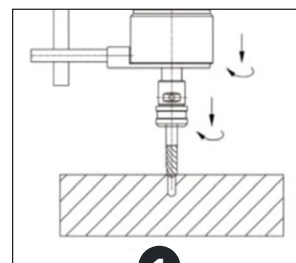
2. Tapping Start: Begin tapping with the machine spindle moving downward along with the chuck.

3. Stopping the Axial Movement: When reaching the desired depth, stop the axial movement while the chuck continues tapping until fully extended.

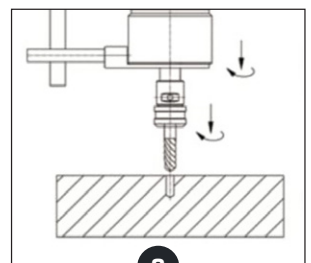
4. Reversal Process: Raise the machine tool spindle—this triggers the chuck to automatically rotate in reverse and retract the tap.

5. Controlled Retraction: Ensure the machine spindle raising speed matches the tap's retreating speed to prevent stopping or jamming.

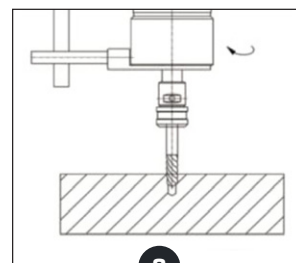
6. Completion: The tap resumes positive rotation once fully withdrawn from the workpiece.



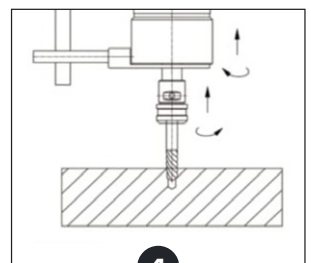
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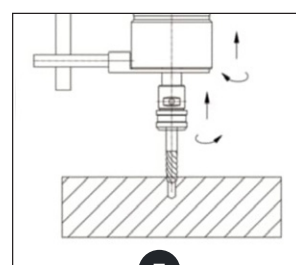
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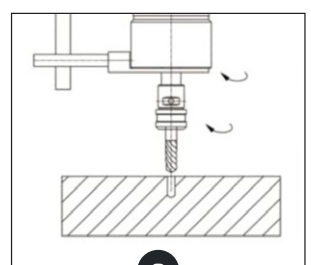
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