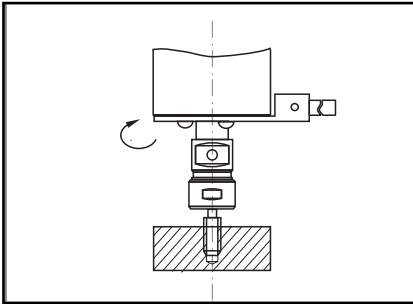


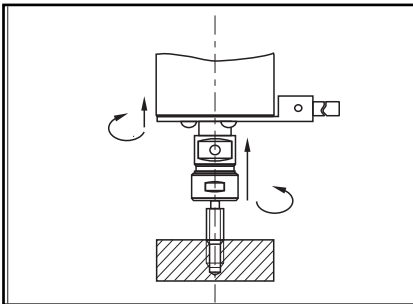
C

Stop the axial movement of the machine spindle when approaching the desired depth, meantime the tapping attachment spindle will continue tapping until the extended amount of chuck is reached, then it automatically stops rotating.



E

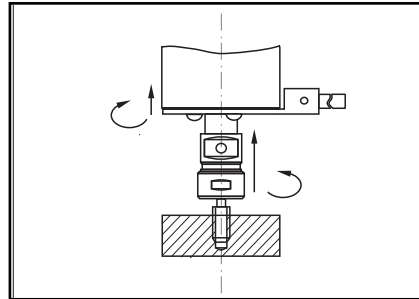
The raising of the machine spindle should work at the same speed as the tap. Otherwise, the tap will stop and start threading again on the same workpiece hole.



Ref.: OGN-JT6/RF15
OGN-JT6-RF23
OGN-M20/RF32

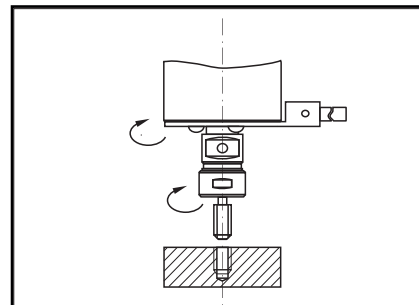
D

First, raise the machine tool spindle, then the tapping attachment spindle, and the tap is automatically rotated in reverse and retreated quickly.



F

The tap will turn to its normal rotating position as soon as it has fully withdrawn from the workpiece.



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FOR-7.5-16



Reversing tapping attachment
instruction manual

SPECIFICATIONS

Self reversing tapping attachment with turning gear mechanism for fast tapping cycles.

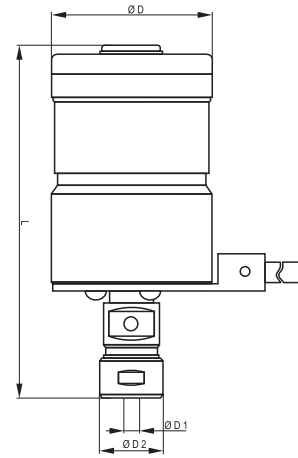
Rubber Flex collets and adjustable drive square.

Length compensation on tension and on compression.

Integrated overload clutch to prevent tap breakage.

Interchangeable adapters inclosed in the set.

The set is supplied in a compact case and encloses tapping attachment and accessories.



For use on drilling machines with non reversing spindles, only suitable for cutting right hand threads equipped with safety clutch

	TA 7	TA 12	TA 20	
Tap Range	M2 - M7 Nº0 - 1/4"	M4 - M12 Nº6 - 7/16"	M8 - M20 5/16" - 3/4"	
Revolution	max. R.P .M	1500	1000	600
Clamping Range	Ø D1 mm	2,5 - 6,5	3,5 - 10	6,0 - 16
Shank Receipt	J6	J6	M20 x 2,5	
Sizes				
Ø D	55	75	91	
Ø D2	23	28	40	
L	130	156	204	
Weight	Kg.	1	2,4	4,5

INSTALLATION AND OPERATIONS

1 Mounting the tapping attachment: Clean the connecting parts of both the adaptor and tapping attachment and mount them on to the machine spindle after they have been assembled.

2. Mounting the tap: Insert the tap in to the tapping attachment while watching the position of the tap handle from a window. Then insert the square end of the tap handle into the clamping plate on the left-right-handed bolt. Turn left-right-handed bolt with six-sided wrench in order to clamp it.

3. Mounting the brake rod: The brake rod should be mounted either on a non rotating part of the spindle, on the worktable or on the column of the machine.

4. Adjusting the torque: A proper torque can be selected between the scale numbered 1 2 3 4 printed on the tapping attachment, according to the diameter to be tapped and the material of the work- piece. To obtain the optimum performance it is recomended to start tapping from minor to major torque.

5. Tapping :

A Align the tap with the hole to be thread. Approach carefully the tap with the hole to be threaded.

B To start tapping, press down the machine spindle.

