

Pneumatic Tapping Machine

Operating Manual

Model AS/AT - 08, 12

(I) INSTALLATION

1. Provide with 5HP or above air compressor power supply.
2. Installation procedure : Please fastening the lock base (Fig-1 no.3) to the required place.
To put tapping arm on it, fasten up and put the air unit, spindle, tubes, process Fig-1 by ③→②→④→① in order.
3. If there is a radial jib, please assemble as Fig-2.

(II) Adjustment

1. Pour the appropriate lubrication in air unit from (C) opening of Fig-4 , adjust the pressure to 7kgf/cm^2 or above, if you want to tap M8~M12 it must to adjust over 8kgf/cm^2 , please watch the pressure gauge the part B in Fig-4.
2. Try to operate the spindle in Fig-3, press the (C) forward handle, when get reversion please press both the (C) forward handle and (D) reverse button, then check the Fig-4 (E) drops 3~5 lubrication in continuously operating one minute. To adjust oil drop please see Fig-4 (D), clockwise the oil dropping decreases, and counterclockwise the oil dropping increase.

(III) Operating Instrument

1. Shift the tapping spindle on the workpiece. Can not operate the spindle until the screw tap aims at the hole. After aiming, put the tip of screw tap on the hole and start to operate. Press the Fig-3 (C) forward handle and start to force, let the whole manual tapping machine down toward the hole. After tapping to the required depth, push the Fig-3 (D) reverse button in the same time that the screw tap will leave.
2. If tapping in the half depth of the hole, the screw tap can not make progress and Fig-3 (F) is idling, it is because there is not enough torsion in the tap holder, please displace the C type spring of the Fig-3 (G), and rotate the sun-type screw nut of the Fig-3 (H), clockwise the torsion increases, and counterclockwise the torsion will be decreasing, one time of rotation make it be 1~3 degrees adjustment till the tapping work can do progress.
3. If the requirement necessary when operating, you can adjust speed of spindle by pressed the Fig-3 (C) forward handle in the same time rotate the Fig-3 (E) adjust either left or right direction, till it to the appropriate speed
4. If the torsion of the telescopic arm in Fig-1 (2) needs to be loose or tight please adjust the Fig-1 (6) (7), clockwise is increasing and counterclockwise will be decreasing.

Fig1.

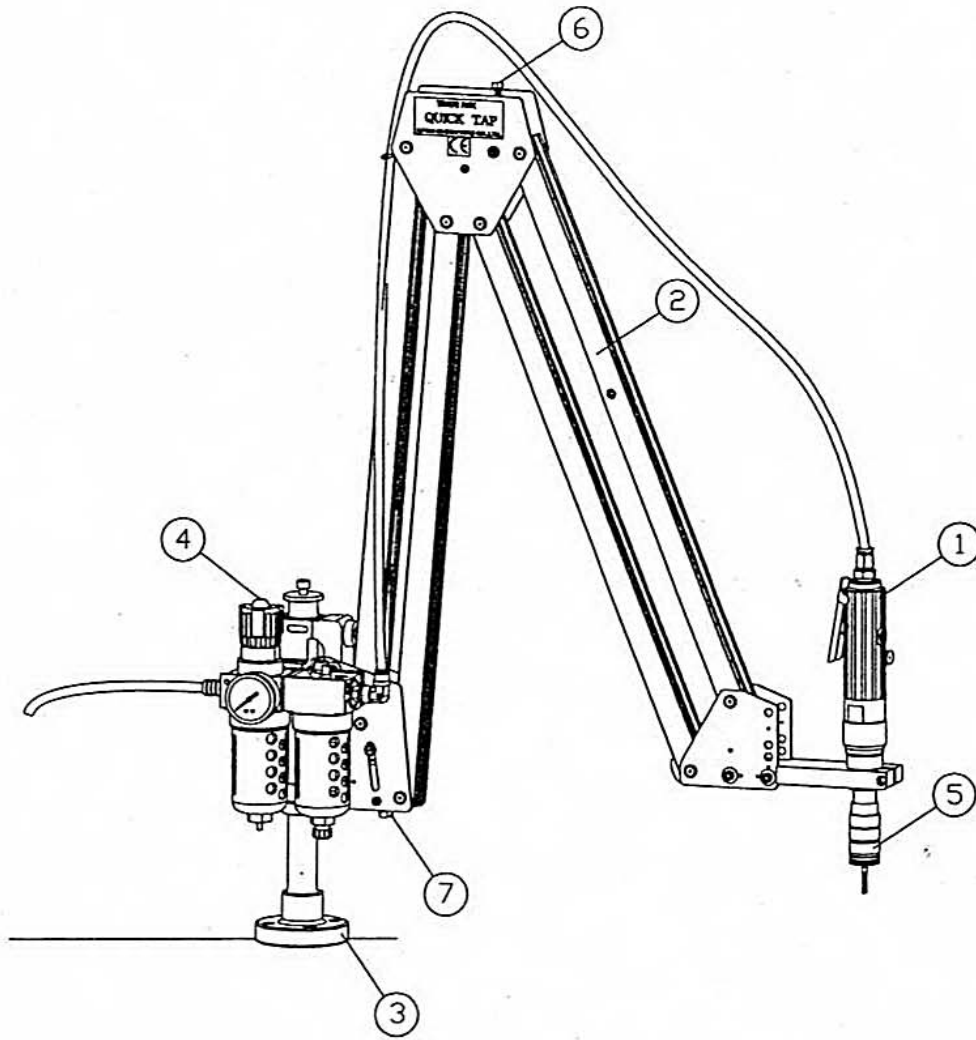


Fig2

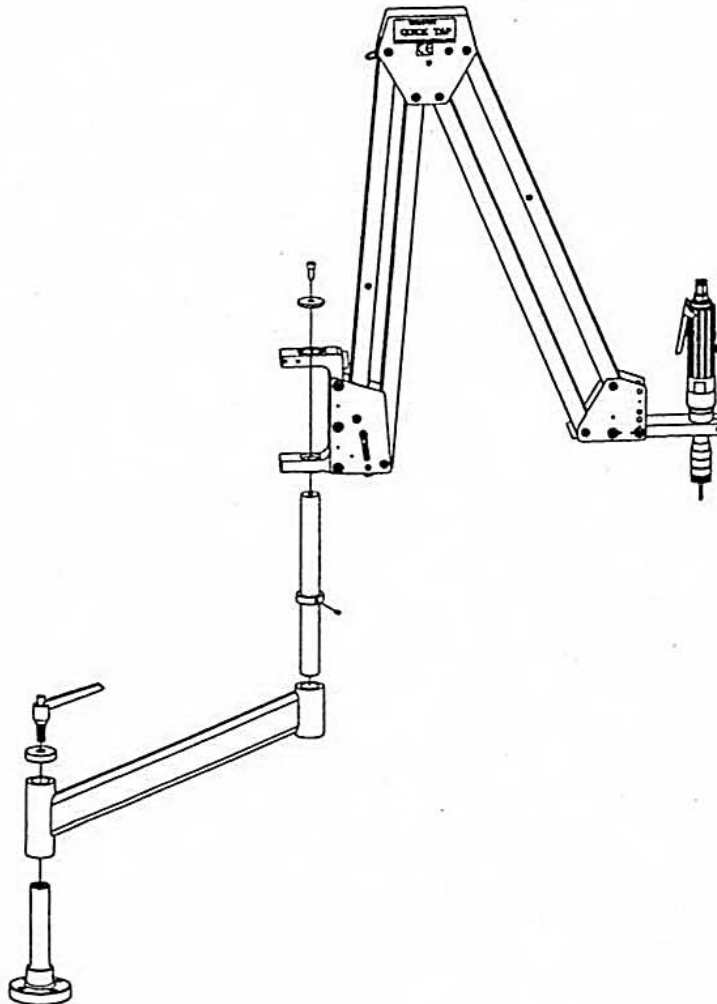
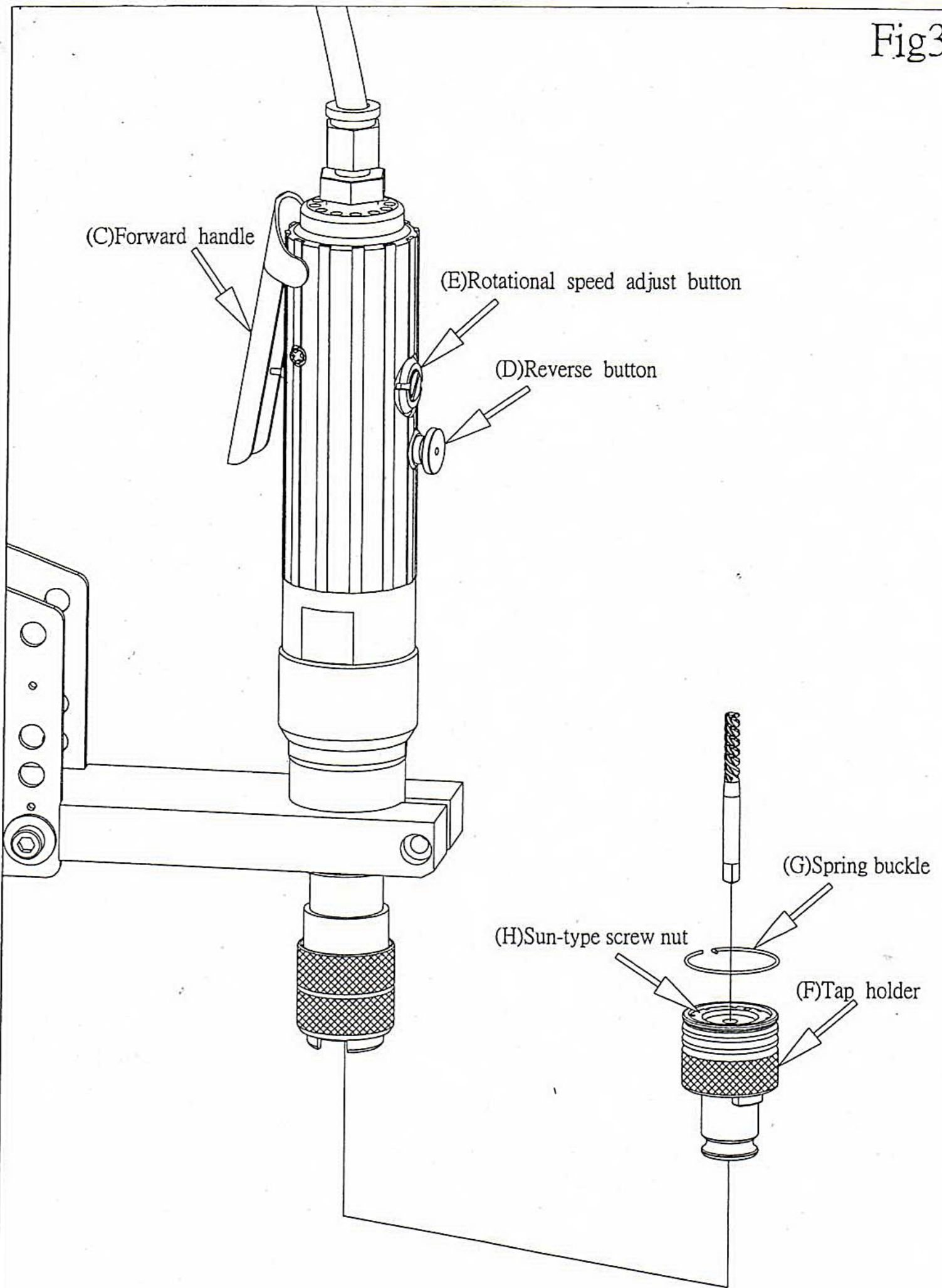
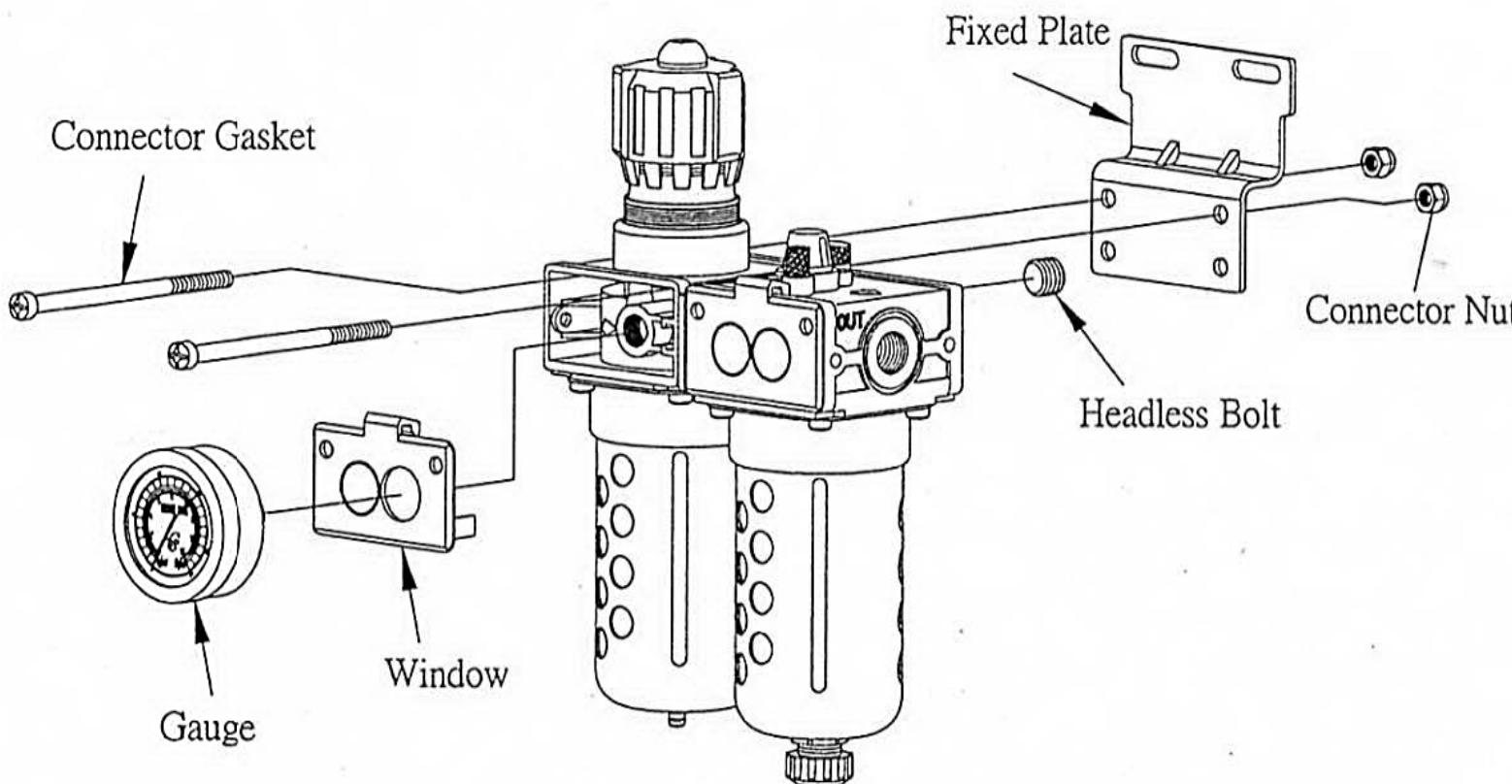
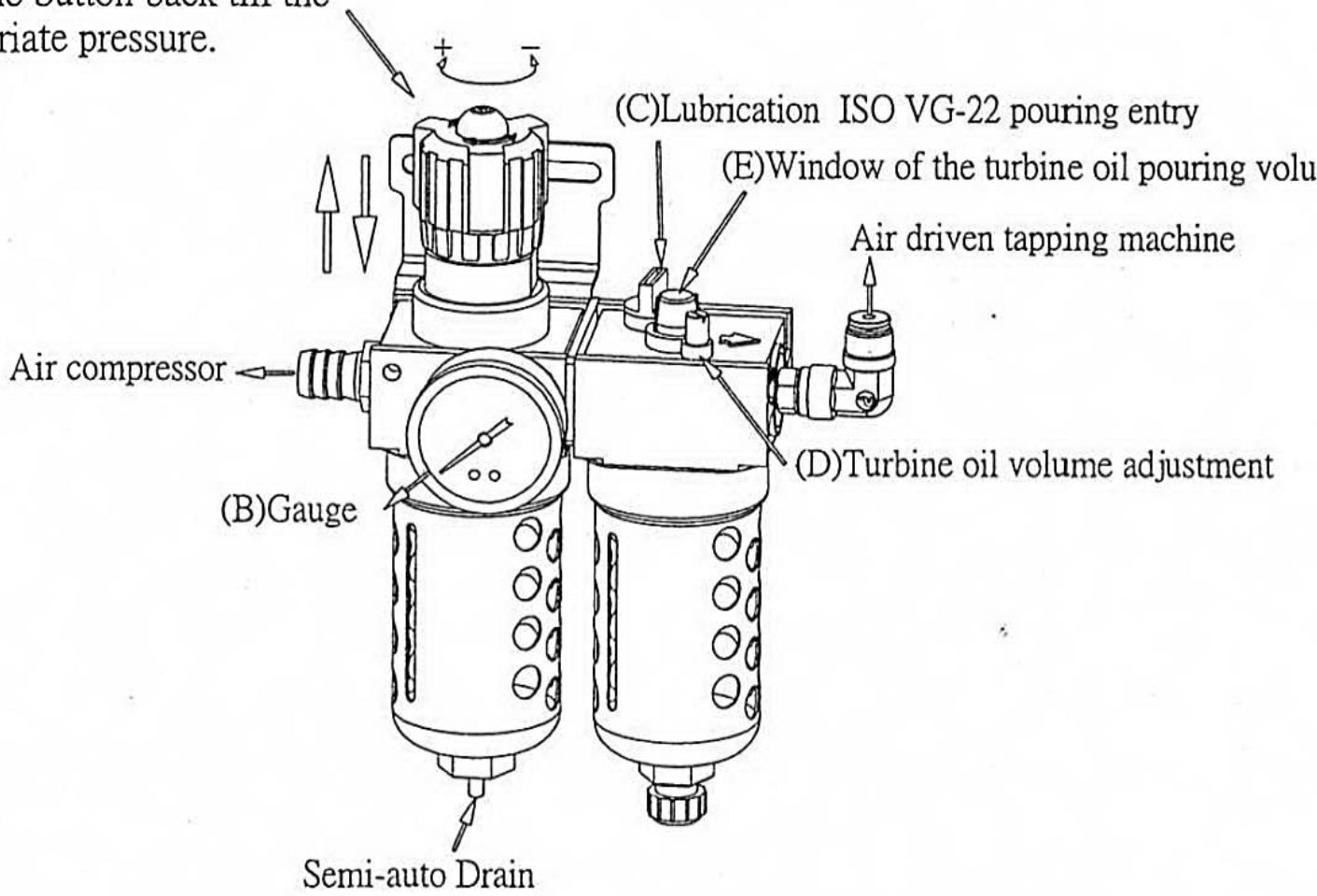


Fig3



(A) Air pressure adjustment*pull up first * if want to increase please rotate clockwise ,want to decrease please rotate counterclockwise* push the button back till the appropriate pressure.



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Model AS/AT - 20 , 22 , 24, 27

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3. If there is a radial jib, please assemble as Fig-2.

(II) Adjustment

1. Pour the appropriate lubrication in air unit from (C) opening of Fig-4 , adjust the pressure to 7kgf/cm² or above, if you want to tap maximum size it must to adjust over 8kgf/cm², please watch the pressure guage the part B in Fig-4.
2. Try to operate the spindle in Fig-3, press the (C) forward handle, when get reversion please press both the (C) forward handle and (D) reverse button. Then check the Fig-4 (E) drops 3~5 lubrication in continuously operating one minute. To adjust oil drop please see Fig-4 (D), clockwise the oil dropping decreases, and counterclockwise the oil dropping increase.

(III) Operating Instrument

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2. If tapping in the half depth of the hole, the screw tap can not make progress and Fig-3 (F) is idling, it is because there is not enough torsion in the tap holder Fig-3 (F), please displace the C type spring of the Fig-3 (G), and rotate the sun-type screw nut of the Fig-3 (H), clockwise the torsion increases, and counterclockwise the torsion decrease. One time of rotation make it be 1~3 degrees adjustment till the tapping work can do progress.
3. You can adjust speed of spindle by pull down cover Fig-3 (I) then rotate to fit the Fig-3 (B) is higher speed, rotate to Fig-3 (A) is lower speed pin fit, when tapping above M12 should put to the lower speed Fig-3 (A).
4. When the torsion of the telescopic arm in Fig-1 (2) needs to be loose or tight please adjust the Fig-1 (6) (7), clockwise is increasing and counterclockwise will be decreasing.

Fig1

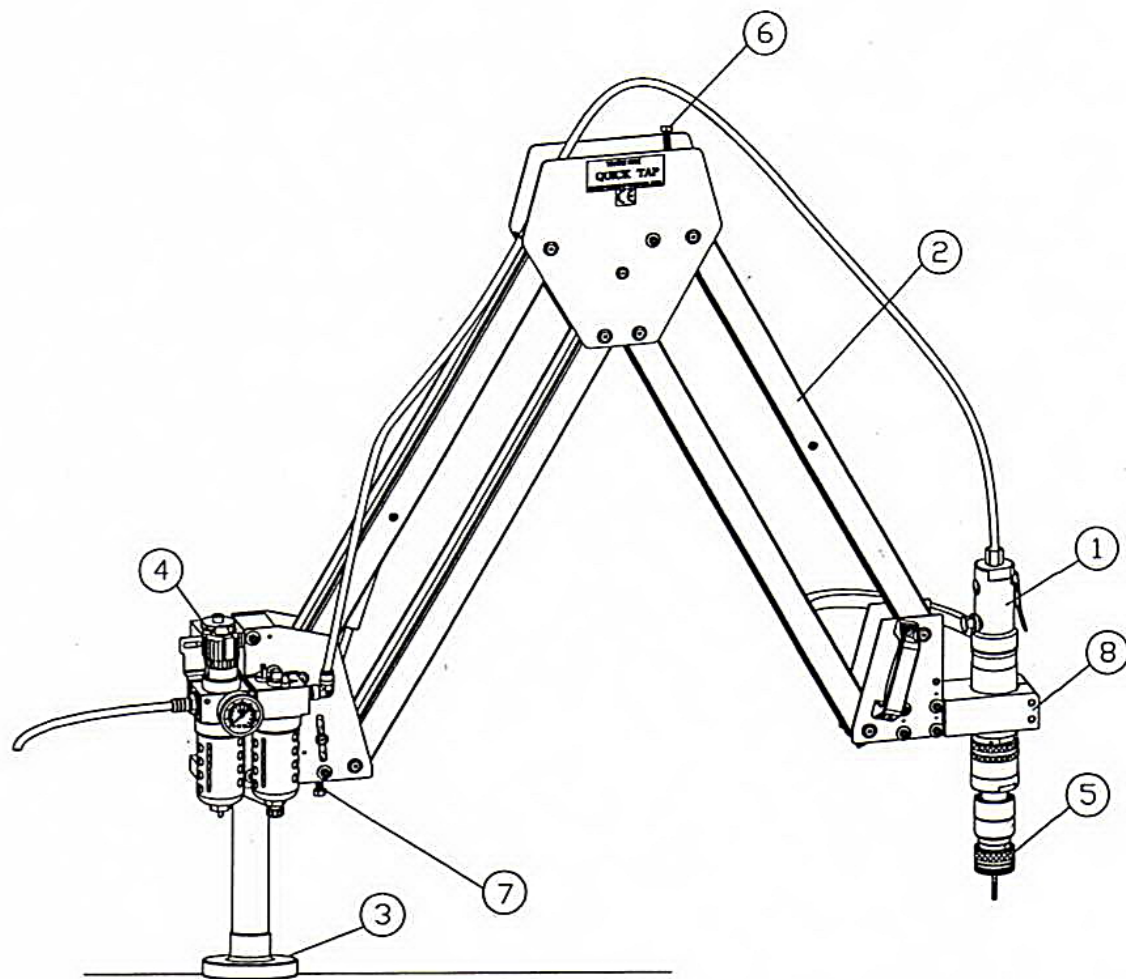


Fig2

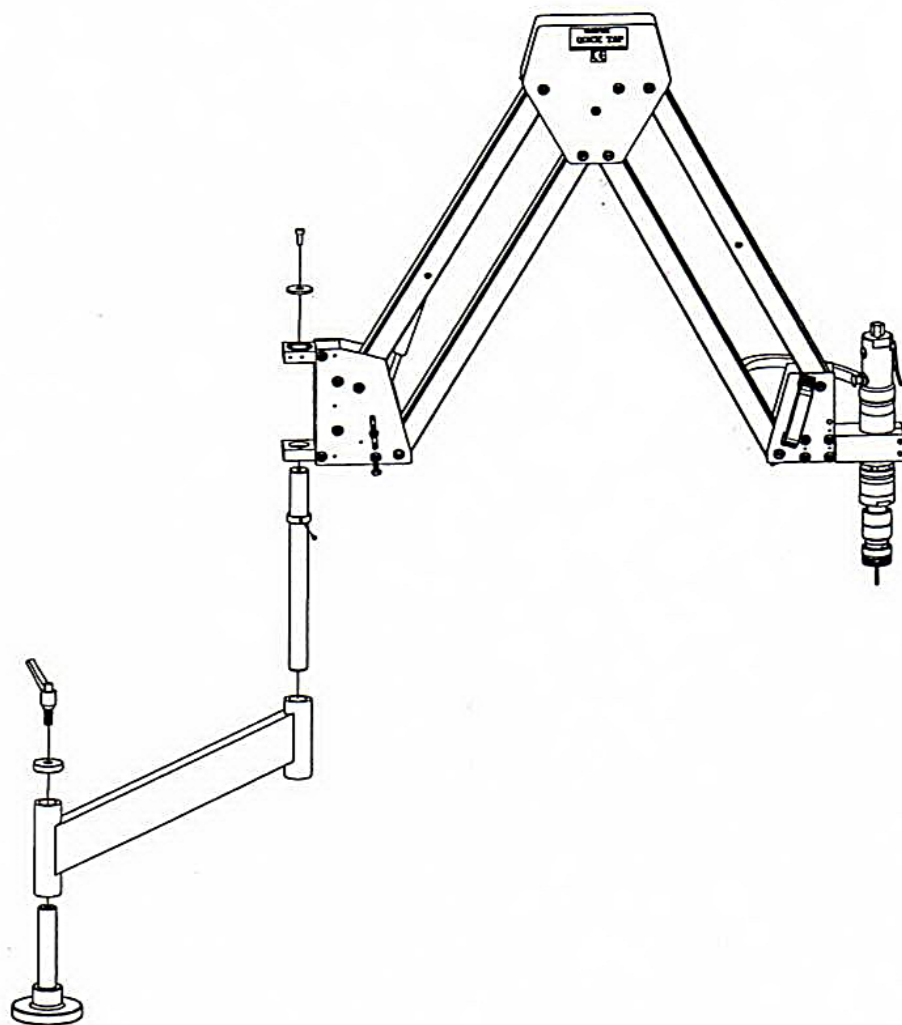


Fig3

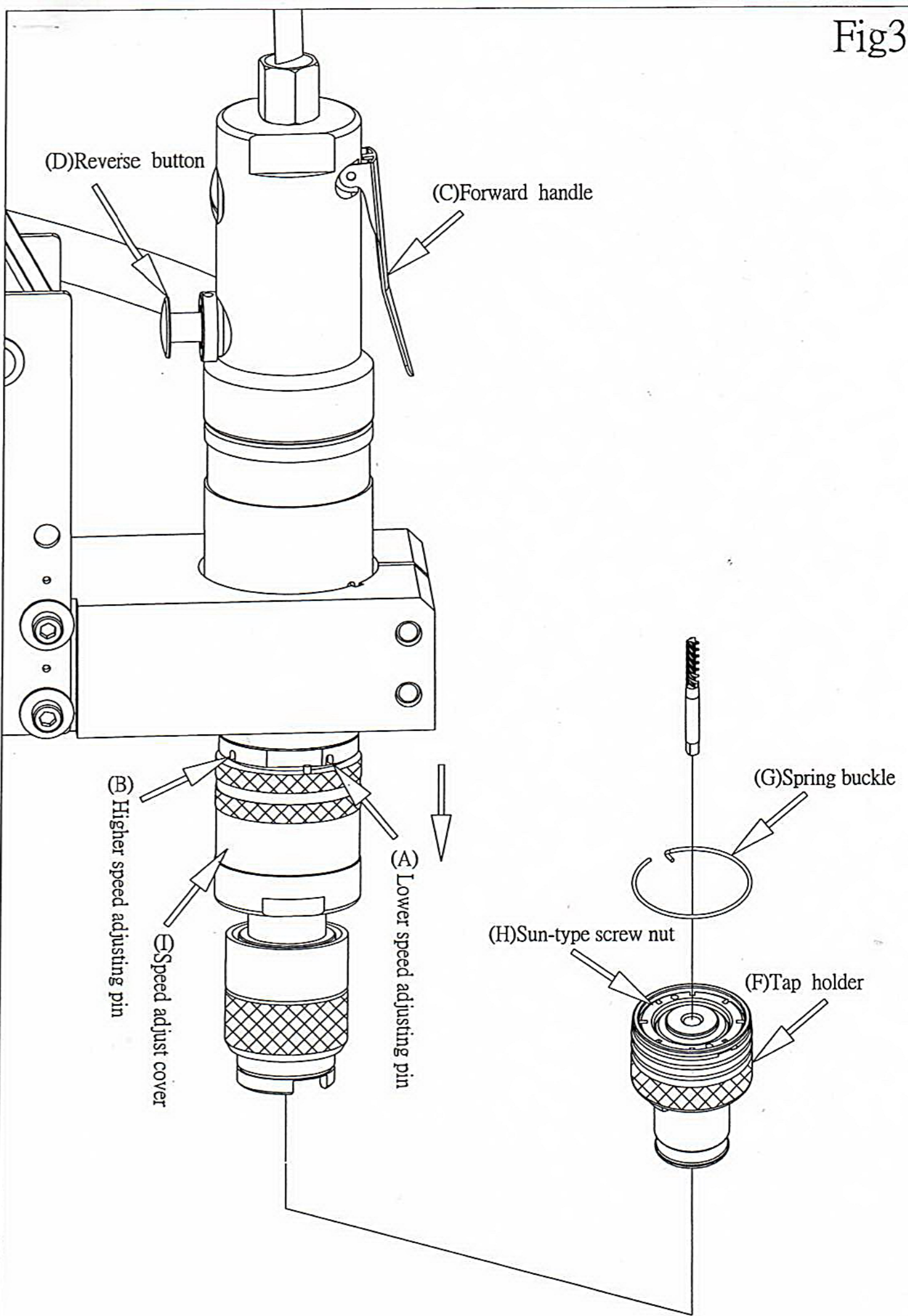


Fig4

(A) Air pressure adjustment*pull up first * if want to increase please rotate clockwise ,want to decrease please rotate counterclockwise* push the button back till the appropriate pressure.

