



**Before Operating Your Tools,
Please Read This Instruction Carefully**



Tapping Heads

**ITEM NO.85-002-001/002/003/004
MODEL NO . #Th0210**

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Appliance and property

Type J46 Chucks are featured of a reversible rotation, overload protection and adjustable torque as well as advantages like a compact structure, high efficiency. Safe and reliable and simple operation.

Working range: The chuck can be supplied with three specifications for various taps from M2 to M20, with their working ranges referring to the following table, and can be selected for connecting with the machine tool based on the machine spindle tapered hole. Adapters with a taper of MS3 are attached.

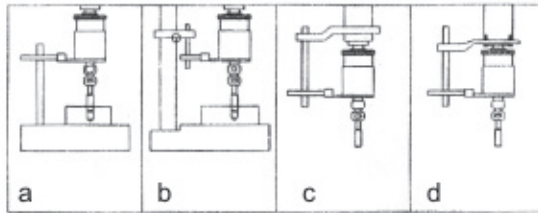
Main technical specification

Specifications	Working Range	Forward Extensibility	Adapter NO.
J467	M2-M7	3.5mm	MS2
J4612	M5-M12	5mm	MS3
J4620	M8-M20	5mm	MS4

Method and step

1. Mounting the check: Clean up the connecting parts of both the adaptor and the chuck and mount them onto the machine spindle after they have been assembled.
2. Mounting the tap: Insert the tap into the chuck while watching the position of the tap handle from a window. Then, insert the square end of the tap handle into the square hole of the clamping device and tighten the lock nut with a wrench prior to fastening the top screw of the clamping device.
3. Mounting the brake rod: Referring to figures(1), the brake rod which should be of a certain rigidity to with stand the torque of reversing tap (A rod made of steel 45#, ϕ 20~30.HRC 45 is recommended) is mounted either on the no rotating part of the spindle end or on the work table.

- The brake rod is mounted on the worktable.
- The brake rod is mounted on the column of the machine tool.
- The brake rod is mounted on the flange of the spindle quill.
- The brake rod is mounted on the flange of spindle quill end.

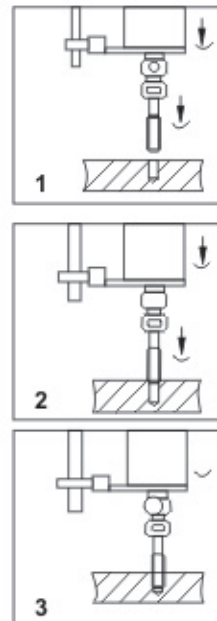


4. Adjusting the torque:

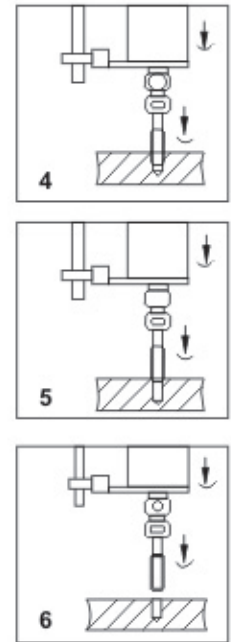
A proper torque shown with numbers 1.2.3.4 on the man body periphery is selected according to the diameter to be topped and the material of the work piece. Showing that the chuck can stand the torque varies form small to large and can be selected by the operator himself. In case of materials which are difficult to be tapped two operations are recommended.

5. Tapping: The operator should align the tap mounted on the machine tool with the machined screw blank hole on the work piece and operate referring to Figures.

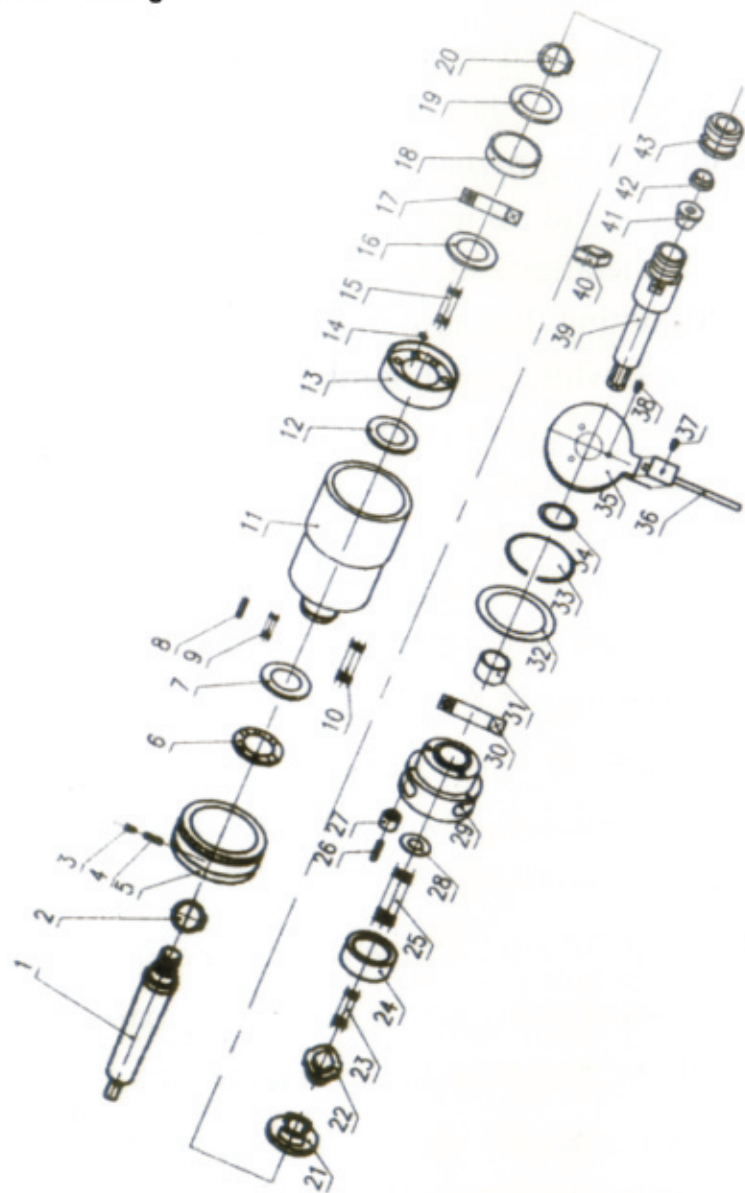
- Lower the spindle to make the tap get contact with the work piece, and ready to be cutting.
- Star tapping. With the machine spindle moving down along with the chuck.
- Stop the axial movement of the machine spindle upon approaching to the desired depth, meantime the chuck spindle will continue to tap until the extended amount of chuck is reached, then it is automatically stopped to rotate.



- Raise the machine tool spindle, then the chuck spindle and the tap is automatically rotated in reversibly direction and retreated rapidly.
- The raising of the machine spindle should be in correspondence with the retreating speed of the tap. Otherwise the tap will stop at one time and act at another time.
- The tap starts a positive cotmion as soon as it has fully with draw from the work piece.



◆ Part Drawing



◆ Part Listing

No.	Description	No.	Description
1.	Arbor	23.	Return driving spring
2.	Elastic ring	24.	Return gear
3.	Hex head socket screw	25.	Reset spring
4.	Pin	26.	Pin
5.	Adjust nut for clutch	27.	Gear
6.	Thrust bearing and frame	28.	Pad for return bearing
7.	Pad	29.	Bearing stage
8.	Pin	30.	Bearing
9.	Cluth spring (small)	31.	Bushing
10.	Cluth spring (big)	32.	Ring for spindle
11.	Case	33.	Slit ring
12.	Spring washer	34.	Elastic ring
13.	Cluth ring	35.	Thrust stop
14.	Ball	36.	Stop bar
15.	Buffer spring	37.	Hex bead socket screw
16.	Pad	38.	Cross bead socket screw
17.	Bearing	39.	Driving spindle
18.	Bearing bush	40.	Block
19.	Bearing pad	41.	Flexible collet
20.	Elastic ring for hole	42.	Pod
21.	Driver	43.	Nut
22.	Driving jaw		