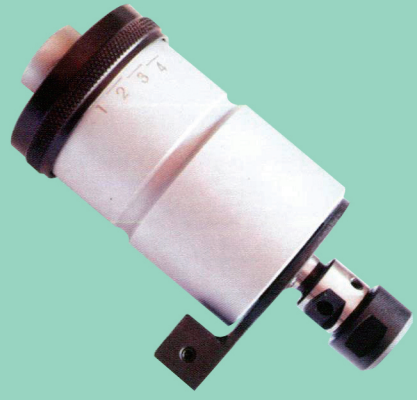


TYPE JSN REVERSIBLE TAPPING HEAD

OPERATION INSTRUCTIONS

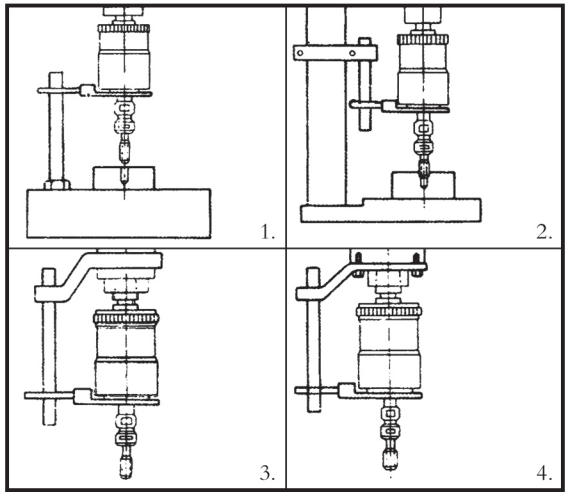
OPERATIONAL INSTRUCTION
OF
TYPE JSN REVERSIBLE TAPPING HEAD

Type JSN Reversible Tapping Head are featured of a reversable rotation, over load 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 renges referring to the following table, and can be selected for connecting with the machine tool based on the cachine spindle tapered ho1e. Adapters with a taper of ms–jacobs 60rms–m20 × 2.5 are attached.

Specifications	Working range
JSN7	M2–M7
JSN12	M5–M12
JSN20	M8–M20

Figures (Ⅰ)



1. The brake rod is mounted on the worktable.

2. The brake rod is mounted on the column of the machine too1.

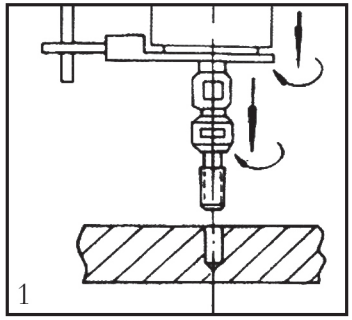
3. The brake rod is mounted on the spindle quill.

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

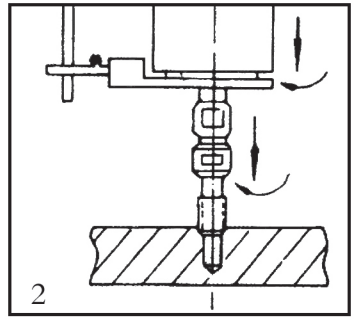
OPERATIONS

1. Mounting the chuck: 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 in to the chuck 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–ritht–handed bolt. Turn 1eft–right–handed bolt with six–sided wrench in order to clamp it.
3. Mounting the brake rod: Referring to figures(I), the brake rod which should be of a certain rigidity to with stand the torque of a reversing tap. (A rod made of steel 45#, ϕ20–30, HRC45 is recommended.) is mounted either on the nonrotating part of the spindle end or on the worktable.
4. Adjusting the torque: A proper torque shown with numbers 1, 2, 3, 4 on the manin bade periphery is selected according to the diameter to be tapped and the material of the workpiece, showing that the chuck can stand the torque varies form small to large and can be selected by the operator himself. In case of materiale which are difficult to be tapped, two operations are recommended.
5. Tapping: The operator should align the tap mountad on the machine tool with the machined screw blank hole on the workpiece and operate referring to Figures (II).

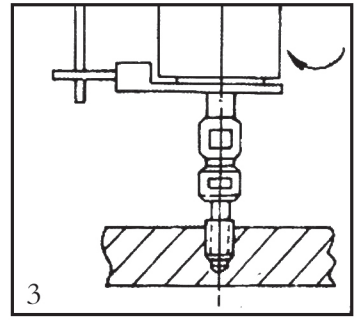
Figures (Ⅱ)



1. Lower the spindle to make the tap get contact with the workpiece, and ready to be cutting.

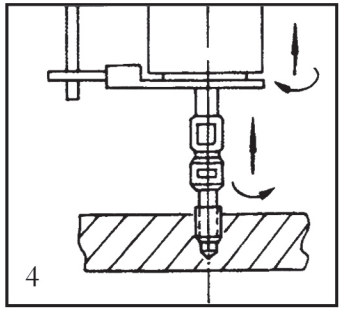


2. Start tapping, with the machine spindle moving down along with the chuck.

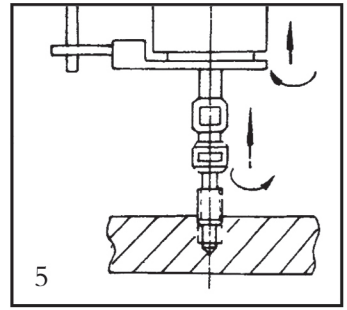


3. Stop the axial movement of the machine spindle upon approaching to the desired depth, meantime the chuck spindle will continue to tap untile the extended amount of chuck is reached, then it is automatically stoped to rotate.

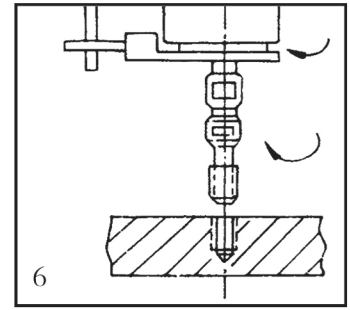
Figures (Ⅱ)



4. Raise the machine tool spindle, then the chuck spindle and the tap is automatically rotated in reversely direction and retreated rapidly.



5. The raising of the machine spindle should be in correspon dence with the retreating speed of the tap. Other wise, the tap will stop at one time and act at another time.



6. The tap starts a positive rotation as soon as it has fully withdrawn from the workpiece.