

# **P-TAP**

**PNEUMATIC TAPPING ARMS**

## **User Manual**

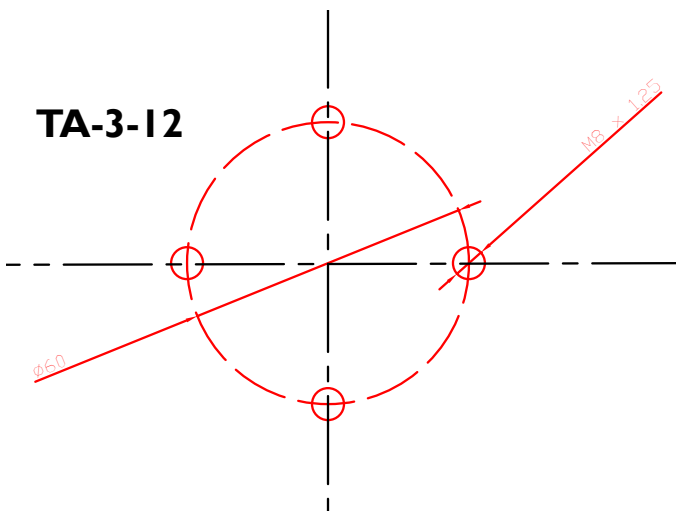
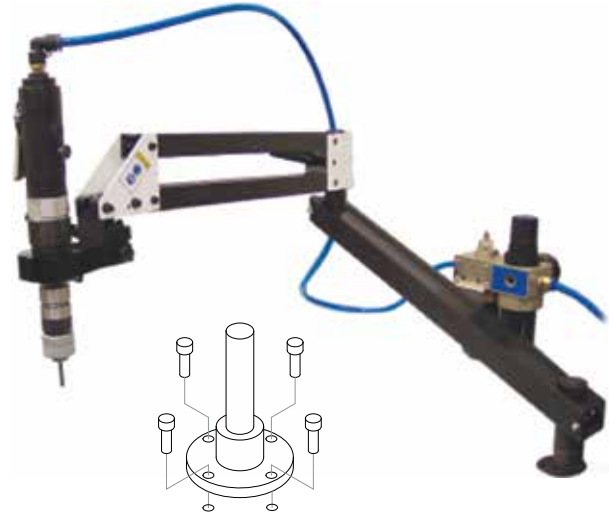
ARM 3-12, 1000-16

V2.1

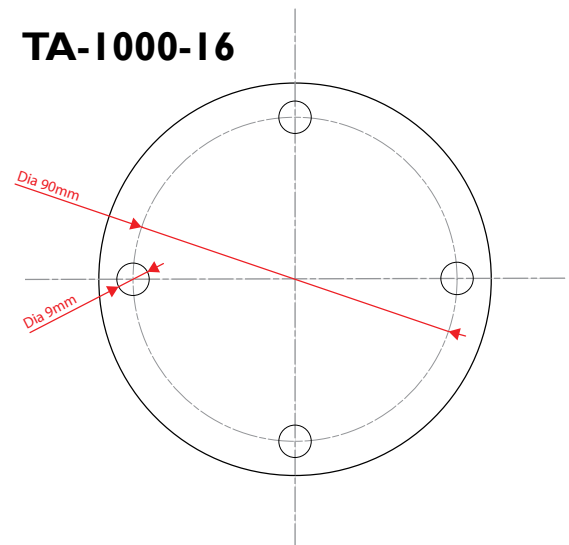
## Introduction

### Assembly

- Mount the machine base to a suitable flat working table, secure with the four M8 bolts supplied. (please see dimension diagram)
- Ensure the mounting base pivot is clean.
- Locate the radial arm to the mounting base.
- Ensure the top radial pivot is clean and apply a small amount of grease.
- Locate and slide the radial arm pivot on to the pantographic arm
- Ensure the motor clamp and pneumatic motor are clean. Slot the motor into the clamp and tighten (do not over tighten)



### TA-1000-16



### Setting the Angle of the Motor (optional)

The pneumatic motor can be set at any angle between the vertical and horizontal position. The motor has a locating peg for the vertical position and is secured by a threaded locking handle.

To adjust the angle simply loosen the locking handle, swivel to desired angle and tighten locking handle.



## Operating the Pneumatic Motor

The pneumatic motor has a large finger operated paddle trigger and thumb operated reverse button. Pull the trigger to start forward rotation, hold both paddle trigger and reverse button for reverse rotation.



## Air Motor Gear Change

The M16 air motor has a high and low speed gear. For smaller taps sizes the high can be selected. When larger taps are used select the low speed gear, this gives a much higher drive torque. Simply pull the black collar under the motor down, twist and locate the peg into the other position. If it does not engage, turn spindle, until it drops in place.

**Do not adjust gear with motor running.**

## Changing the Air Motor Gear

**Step 1;**



Grip the gear change collar in one hand and the motor in the other.

**Step 2;**



Pull down gear change collar.

**Step 3;**



Turn collar to second position.

**Step 4;**



Release collar.

## Air Supply and Lubrication

### Regulator & Lubricator Installation

- Fit the mounting bracket to the regulator. Attach the regulator to the arm using the two fixing bolts.
- Fit the gauge with PTFE and tighten by hand. (do not over tighten)
- Screw the air fittings into the lubricator and use 10mm flexible air hose to connect to the motor.
- Remove the plug on the top of the lubricator and fill with high grade pneumatic oil (DIN51524 or ISO VG32). Do not fill above the maximum line and refit the plug.
- Fit main air feed to the regulator.

### Adjusting Air Pressure



To adjust air pressure, pull the regulator knob upwards. Turn the knob clockwise to increase the pressure and turn the knob anti-clockwise to decrease the pressure.

Normal operating pressure for the pneumatic motor is between 6.5-8 BAR.

**Any water/moisture collected by the regulator bowl must be drained regularly.**

### Setting Lubricator Oil Feed

The lubricator injects a mist of oil into the air line to lubricate the pneumatic motor. The amount of oil injected is controlled by an adjustment screw located on top of the sight glass.

With the air supply on and the motor operating the screw should be adjusted so that 3 to 5 drops of oil can be seen every 60 seconds through the lubricator sight glass.

Fill with high grade pneumatic oil (DIN51524 or ISO VG32). Do not fill above the maximum line and refit the plug.



**The lubricator must be set up correctly, with suitable oil and oil level maintained, otherwise permanent damage to the pneumatic motor will occur.**

## Inserting a Machine Tap into Collet

Step 1;



Step 2;



Press the locking button on the front of the collet

Step 3;



Insert machine tap and locate the square of the tap with the square at the rear of the collet

Step 4;



Release the locking button

## Inserting a Collet into the Chuck

Step 1;



Lift the black knurled locking ring on the chuck.

Step 2;



Locate the collet with the chuck.

Step 3;



Align the two drive pegs.

Step 4;



Release the black knurled locking ring on the chuck



## Removing a Collet from the Chuck

Step 1;



Grip the collet and knurled locking ring.

Step 2;



Lift black knurled locking ring on the chuck

Step 3;



The collet can be removed.

Step 4;



## Maintenance

The lubricator must be set up correctly, with suitable oil and level maintained, otherwise permanent damage to the pneumatic motor will occur.

Any water/moisture collected by the regulator bowl must be drained regularly.

The pneumatic motor on the pantographic arm has a sealed gas strut counter balance, which can not be adjusted.

## Contact Details

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