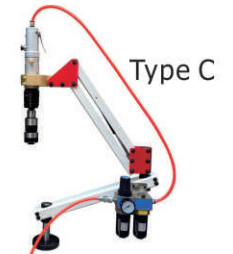
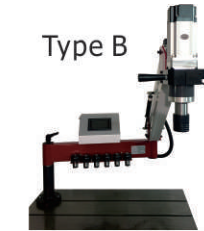
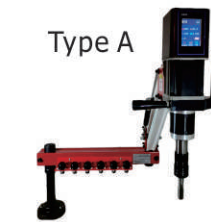


INTELLIGENT TAPPING MACHINE SERIES

— OPERATION MANUAL



(Disclaimer: The appearance and parameters of the products listed in this book are for reference only. The actual products issued by the company shall prevail. The company reserves the right to modify the relevant parameters of the book data without prior notice. If you have any questions, please call the customer service hotline)



CAUTION

Precautions before starting:

- Check whether the appearance of the equipment is complete and undamaged
- The power supply is single-phase 220V, and the allowable voltage range is 190V–245V
- The applicable temperature environment of this equipment is –10℃~40℃
- Do not place the device in a humid, high vibration, corrosive gas or liquid environment
- The power line and socket are recommended to support 16A current
- The equipment must be well grounded

Contents

A series of intelligent tapping machine operation introduction	1-5
B series of intelligent tapping machine operation introduction	6-12
Schematic diagram of equipment assembly	6
Controller interface description	7-10
C series of intelligent tapping machine operation introduction	
working principle	11-16
Assembly instructions	11
Precautions	11
Torque chuck and tap installation method	12
Oil feeding instructions on air supply processor	12
Assembly schematic diagram	13
Verticality and torque adjustment	14
	15-16

Tapping operation guide

● Power on start interface



Choose language
(do not select, press the last
selected language to enter)

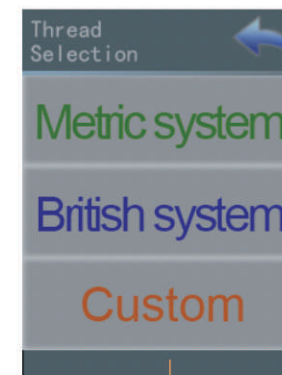
● Main control interface



Broken wire protection switch

Tapping operation guide

● Before machining, select the corresponding thread type



The processing parameters of non-standard
thread can be set by custom



Click the corresponding thread name to select
the pre stored processing parameters

Note: the controller will remember the currently selected thread model and processing parameters

Tapping operation guide

● Modify current processing parameters

- ※Only custom threads can modify the pitch
- ※The parameters you modify will be automatically memorized
- ※The controller presets the protection torque. If there is a broken wire, please decrease the value; if the 01 alarm occurs, please increase the value.



Tip: Click to return to the previous page

Tapping operation guide

● Tapping processing—manual/automatic processing

- ※Press the "tapping" button on the control handle to start tapping
- ※Press the "Exit" button to stop or reverse to exit
- ※When the motor is running, it will enter the following interface to monitor the processing status in real time



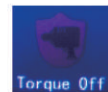
Manual tapping needs to keep pressing the handle button. Once released, the motor will stop.



During automatic tapping, once the "tapping" button is pressed, the tapping operation will be completed at the set speed and depth.

Tapping operation guide

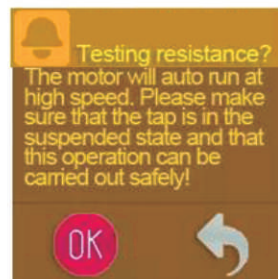
● Broken wire protection



※Broken wire protection closed



※The broken wire protection function is effective, and the controller will protect according to the "protective torque" value of the currently selected thread

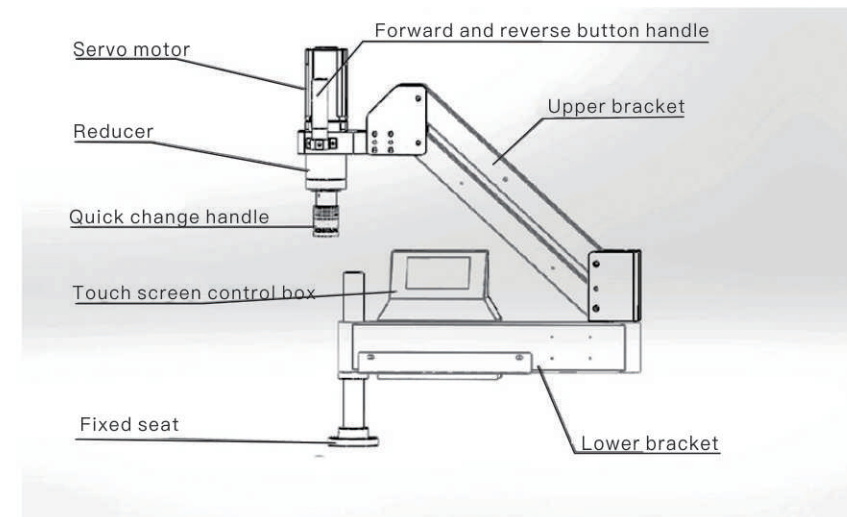


Because the equipment has mechanical resistance, it can be automatically detected by the "Intelligent Resistance Measurement" function in "System Parameter Settings" To improve the accuracy of broken wire protection.

Note: As shown on the left, before you start to test the resistance, please make sure your tap is empty

Schematic diagram of equipment assembly

● Double folding arm icon



Controller interface operation instructions

● Ordinary processing interface



- (1) Screw teeth choose to click on the button of the screw teeth, according to the need to select the specifications of the screw teeth, the metric–British system can be selected. If you need the M8 screw teeth, click the M1 icon, and select the settings of the back interface regression parameters. The screw teeth choose to display as M8, and the screw teeth automatically display as the pitch corresponding to the metric M8 screw teeth 1.25, and automatically generate the protection torque.
- (2) The tapping pitch can automatically generate the corresponding pitch after selecting the screw teeth in the selection of screw teeth. Or any non–international pitch value can be set.
- (3) The tapping depth is set to the actual tapping depth, the minimum unit is 0.01mm.
- (4) Tapping speed setting tap tapping speed, the maximum motor speed 3000rpm, when setting speed multiplied by transmission ratio greater than the maximum set speed, will increase the speed setting error alarm, need to reset the speed.
- (5) The tap unwinding speed is set with the highest motor speed of 3000rpm. When the set speed multiplied by the transmission ratio is greater than the set maximum speed, the speed setting error alarm will be raised, and the speed should be reset.
- (6) When the torque protection value is selected as the pitch, the torque setting will automatically generate a torque protection value, or manually set the torque protection value to protect the tap. When the system detects that the torque value is greater than the setting value, the alarm of the torque protection will be raised. When the input value is 0, the torque protection function is turned off.

Controller interface operation instructions

- (7) For each complete workpiece processed by the automatic production counting mode, the number will be increased by one. The counting value can still be saved after the power is cut off. No counting can be made after the protection falls back in tapping, up to 50,000. Click the "Clear" button to count to zero.
- (8) The manual and automatic mode switching system defaults to manual mode after power–on. Manual mode and automatic mode need to be switched by clicking the button. When displayed as "manual", the system will work in manual mode; when displayed as "automatic", the system will work in automatic mode; when the number of linkage is set to more than 1, the automatic mode is equal to linkage mode.

● Deep hole machining interface

- (1) When the depth of feed is less than the depth of withdrawal, the depth of feed is equal to the depth of withdrawal plus 0.1 mm.
 - (2) The depth of tool withdrawal is set for deep hole processing. When the depth of tool withdrawal is greater than the depth of tool feeding, the depth of tool withdrawal is equal to 0.1 mm less than the depth of tool feeding.
- Note: In deep hole processing, the depth of feed and withdrawal is n. When working, first advance m depth, then retreat n depth, then advance m depth, and then retreat n depth until the preset depth is attacked, and then withdraw once.



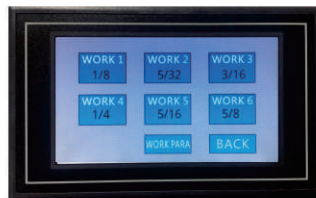
Controller interface operation instructions

● Machine parameter interface

The interface is the system parameters of the manufacturer. It is very likely to cause internal system failure if the parameters of the manufacturer are entered or changed. If you need to change the parameters of the manufacturer, please use it under the guidance of the professional and technical personnel of the manufacturer.

● Programming interface

- (1) After clicking on the entry, different screw teeth can be saved by programming.
- (2) For example, in programming 1, M10–tapping depth 15MM–tapping speed 150rpm–unwinding speed 200rpm is selected. After setting up, the system has automatic memory function, so the next time you want to attack the same M10 screw, you can choose programming 1 directly in the programming.



Controller interface operation instructions

● User parameters interface

- (1) Hole bottom delay time sets the pause time at the bottom of the hole for each tapping.
- (2) The tapping direction can be set by clicking the button in the direction of the motor, and the square teeth can be processed.
- (3) When the linkage interval time is linked, the interval time between the completion of each tapping and the opening of the next tapping can be set at a minimum of 0.1s.
- (4) When the number of linkage tapping is set and the number of linkage tapping is greater than 1, the automatic mode is equal to the linkage mode.

The device consists of two button switches from bottom to top. The top button is tapping button (forward turn), and the bottom button is unwinding button (reverse turn).

● Manual function operation

Always hold down the tapping button (forward turn) for tapping operation, always hold down the back button (reverse) for stripping operation, loosen the button motor to stop turning.

● Automatic function operation

Select the screw specification and set the tapping depth, tap the thread close to the contact surface of the bottom hole, press the tapping button and loosen it. It can be seen that the motor automatically starts cutting, automatically withdraws after reaching the set depth, and completes a tapping operation.

Operating principle

This product is powered by high pressure air . Cog down trigger when the high pressure air is connected to tapping motor through air-pressure regulator . Passing the air inlet valve and the reversing button assembly parts , entering the inside part of motor , driving the rotor blades of motor , producing the axial rotation force , the powerful torsion is lutput through each gear and drive the screw tap to perform the tapping work after rotor moving . The tap chuck tube used by this product has the over load protective device . The adjustable safety clutch will declutch when moment of torque is over the rated value and avoid the screw tap being damaged.

Assembly instruction

1. Please check whether the components and parts are complete according to the packing list when unpacking .
- 2.Read and understand the assembly schematic diagram on the back before install .
- 3.Choose a proper mounting table, which shall be flat, steady and has enough expansion space.
- 4.Make the mounting hole of fixed seat on the proper position of mounting table, and then install the fixed seat assembly parts on the table.
- 5.Install the air supply processor and connect the adaptor and air supply.
- 6.Take out the tapping motor and install it on the fixed seat, connect the adaptor and air pipe, turn on the air supply, then the machine will begin working.

Precautions

- 1.Check whether the installation is correct or not in accordance with the assembly schematic diagram .
- 2.Check whether the air pipes are connected correctly or not .
- 3.Recommended allocation of air compressor :
Air capacity (l/min):0.9
exhaust pressure(bar):8
holding capacity of air collector (L):220
- 4.the products being processed shall be fixed to the working table when tapping.
- 5.If the screw tap stops running caused by parallel pins, please make the machine rotate on the clockwise and anticlockwise direction by using the reverse button .
- 6.To ensure the normal lubrication,please check the grease oil feeding amount of air supply processor occasionally

Torque chuck and tap installation method

1. GX-12 clutch bracket is an advanced thread processing tool with automatic pitch compensation function and safety overload protection device.
2. Operation method
 - a) Install the tap: Push in the positioning sleeve at the front end of the tap chuck, insert the tap into the square hole of the sleeve body, loosen the positioning sleeve, and then lock the tap.
 - b) Install the screw chuck: push in the movable sleeve at the front of the magic chuck, insert the screw chuck tube into the hole, then insert the chuck tube into the hole (the screw is stuck on the flute), and loosen the movable sleeve Then the screw chuck tube will be locked.

3. List of rated torque

Specification/mm	M3	M4	M5	M6	M8	M10	M12
Moment of torsion/N.mm	0.54	1.10	2.30	4.2	8.5	15	25

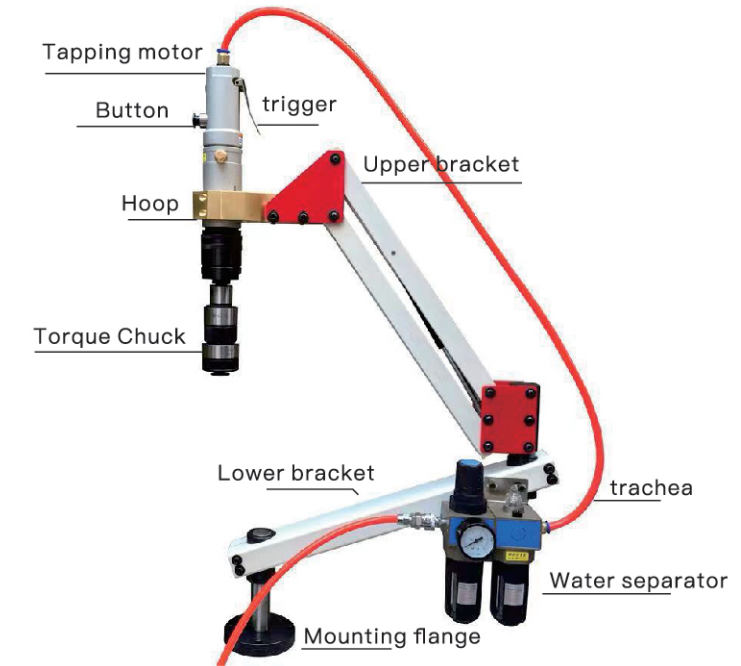
Oil feeding instructions on air supply processor



When in use, first adjust the oil intake adjustment screw clockwise to the minimum, and then add lubricating oil from the oil filling hole.

Then according to actual needs, adjust the oil volume adjustment screw to the appropriate position after ventilation (clockwise decrease, vice versa).

Assembly schematic diagram



Vertical and torque adjustment

● Verticality

Make sure that the quick-change connector under the electric motor is in contact with the worktable or workpiece plane, and make sure that the quick-change connector is vertical to the worktable (the quick-change connector should have no gap with the working plane), and then lock the fastening screw of the vertical plate or universal head.

● Adjustment of collet

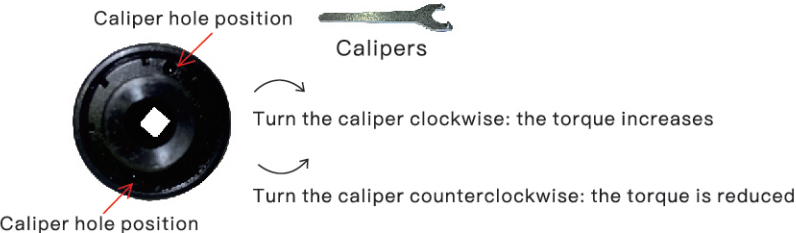
Step 1: before adjusting the torque, remove the clamp ring on the clamp head with hand or needle-nosed pliers. It can be seen that the clamp ring plays a role in fixing the torque. Press the clamp ring hole on the side of the clamp head with your left thumb as the reference point for adjusting the torque.

Tap button force protection collet



Controller interface operation instructions

Step 2: Use pointed tongs to pry into the round hole of the end face to adjust, clockwise adjust the torsion to become larger, and vice versa, adjust the anti-loosening clasp back to its original place.



When tapping the blind hole, the torque should be adjusted from the minimum to ensure the continuous tap. How to judge the torque in the minimum state? First dispatch torque to counterclockwise, until we are using the right hand gently clamp the force, under the main handle a little card can turn in the past, when the torque is the smallest, the retaining ring, set screw tap tapping, if a thread in the process of tapping can cutting or not in place, cutting torque is not enough, then remove retaining ring, also hold down the left hand thumb side reference hole, right hand will collet with snap ring spanner to tighten all the way, clockwise on the retaining ring, tapping again, in accordance with this method a tight one, until just tapping tapping to the blind hole position, chuck skid protection, then the torsion in tune.

Switch on the 220V power and start the system switch to enter the starting screen. Click the button in the picture to reach the working interface (as shown below).