

# Tapping Arm



Machine Purpose: Tap or Ream Holes

Safety: **Must wear safety glasses while operating machine. Keep.** Beware of objects that dangle and could get caught in cutting tool. Beware of flying metal chips **This machine has no built-in safety system.**

Materials: No limitations

Machine Specs: m3-m12, #4-1/2", Head tilts allowing for any angle tapping, arm reach radius up to 40", 400rpm

Tooling: Remember to always use appropriate style tap for machine tapping

Accessories: Rigid Tap Collets: 1/8", 3/16", 1/4", 5/16", 3/8", 1/2",

Clutch Tap Collets: m3, m4, m5, m6/8, m10, m12

Quick set up vises

Instruction Required: no, but if uncertain book help session with shop staff

Notes: THIS TOOL IS NOT FOR DRILLING,

always clean up after your self



**MHUB**

## Prep

1. Using the drill press, drill the appropriate size hole for the tap size you are looking to thread (reference chart on the wall).

Tooling Selection - You must use a machine style tap with this machine or you will break a tap and ruin your part.

1. Depending on your put of hole (blind hole vs through hole) you will need to reference the chart

## OK TAP TO USE WITH TAPPING ARM

Make sure tap being used is appropriate for machine tapping

Figure 1 Angles Sprial Point Tap



Figure 2 For Through-Hole Threading



Figure 3 Plug-Chamfer Taps for Closed-End Hole Threading



Figure 4 Bottoming-Chamfer Taps for Closed-End Hole Threading



#### Inserting Tool to collet

1. Find appropriate size collet for shank of tool being used
2. Compress retaining nose
3. Insert tool until seated
4. Release ring

#### To remove tool

1. Press down on spring loaded retaining nose of tool
2. Gently slide tool out of holder, being careful of sharp edges of tap

#### Inserting Collet

1. Align collet lugs with tapping tool nose
2. Fully seat collet into tool nose, retaining sleeve should snap into place

#### Removing Collet

1. Pull back on retaining sleeve of tool
2. Collet should pop loose

#### Using tool to tap

1. Securely hold work piece in a fixture, jig, vise or other work holding device
2. Make sure tool is perpendicular to work piece. If adjustment is needed use allen wrenches to loose and adjust head tilt and twist as necessary.
3. Apply tapping fluid to hole or tap
4. Align tap with predrilled hole
5. Press on flat trigger of the tapping arm to activate the spindle, tap should pull its self into the hole
6. Once bottom of hole is reached press button on opposite side of silver trigger, then press trigger to reverse threading direction

