

Please read and save these instructions. Read carefully before attempting to assemble, install, operate or maintain the product described. Protect yourself and others by observing all safety information. Failure to comply with instructions could result in personal injury and/or property damage. Retain instructions for future reference.

phase II⁺ Hand Tapper

Description

The Hand Tapper provides an efficient, economical means of obtaining straight, perpendicular tapped holes. Offset handle allows quick and easy operation. Hardened and ground spindle is balanced to provide a highly sensitive tap feel. Slide locking vise jaws reduce tap breakage. Unit comes with depth stop, counterbalance, adapter rack, and nine adapters: #6, #8, #10, 1/4", 3/16", 3/8", 7/16", 1/2" and 5/8".

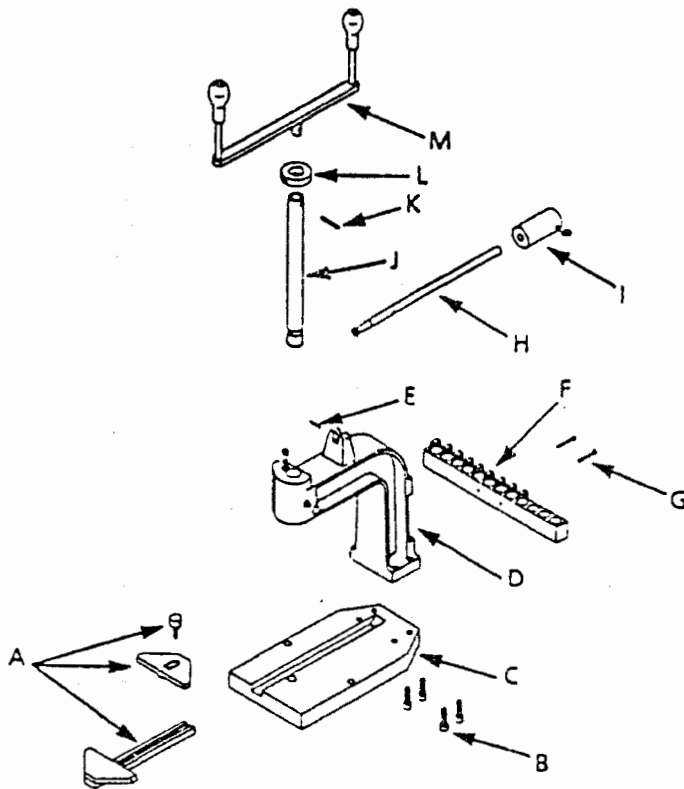


Figure 1
Unpacking

Unpacking

Check for shipping damage. If damage has occurred, a claim must be filed with carrier immediately. Check for completeness. Immediately report missing parts to dealer.

IMPORTANT: The tool has been coated with a protective coating. In order to ensure proper use and operation, the coating must be removed. Remove coating with mild solvents such as mineral spirits and a soft cloth. Nonflammable solvents are recommended. After cleaning cover all exposed surfaces with a light coating of oil.

CAUTION Never use highly volatile solvents.

Avoid getting cleaning solution on paint as it may tend to deteriorate these finishes. Use soap and water on painted components.

The hand tapper is shipped unassembled. Locate and identify the following assemblies and loose parts:

- A. Jaw plates with knob
- B. Four each Socket head bolts
- C. Base D. L-Frame
- E. 4 × 30mm Dowel pin
- F. Adapter rack with nine adapters
- G. Two each Round head screws
- H. Lever
- I. Counter balance with thumbscrew
- J. Spindle
- K. Taper pin
- L. Collar with setscrew
- M. Handle assembly

Specifications

Clearance height	7 3/4"
Throat depth	7 1/2"
Table size	6 1/2" × 12 1/2"
Spindle diameter	1"
Tap capacity	#0-5/2"
Weight	38 lbs

General Safety Information

1. Read and follow all operating instructions before operating tool.
2. Understand and obey all safety instructions supplied with accessories used with tool.
3. Always secure tool to machine table or other work surfaces using both holes provided in the tool base.
4. Maintain and lubricate tool properly.

phase II Hand Tapper

Assembly

Refer to figure 2.

MOUNT L-FRAME

Place the L-Frame (Ref. No. 8) on the base(Ref.No.1) so that spindle guide-way faces the front and the four holes in the flat bottom of the L-Frame are aligned with matching holes in the rear of the base. Insert bolts (Ref.No.2) from the bottom of the base and tighten securely.

MOUNT LEVER

Slide lever (Ref.No.23) through the U-slot in bracket so that the disc edge of the lever faces front and the hole in the lever is aligned with holes in the sides of the bracket. Secure lever to bracket using the dowel pin(Ref.No.12). Slide counterbalance (Ref.No.24) onto lever with scerwhole in the rear. Use thumbscrew(Ref.No.25)to secure counterbalance onto lever.

MOUNT HANDLE

Insert handle (Ref.No.20) into spindle (Ref.No.16) so that the pin hole in the spindle is aligned with the matching hole in the handle. Press taper pin (Ref.No.17) through the holes to secure the handle with spindle.

MOUNT SPINDLE

Slide collar (Ref.No.19) onto spindle until taper pin stops it and tighten setscrew (Ref.No.18). Insert spindle into L-Frame until collar contacts the lever.

MOUNT JAWPLATES

Slide fixed jaw (Ref.No.3) into U-slot in the base. Place the moving jaw(Ref.No.4) on the base so that the square slots in its base fits into the slot in fixed jaw rail.

Insert knob (Ref.No.5) into the keyhole of the moving jaw and tighten it into one of the holes in the fixed jaw rail.

MOUNT ADAPTER RACK

Secure adapter rack (Ref.No.26) to the rear of L-Frame using screws (Ref.No.36).

Installation

Always bolt hand tapper to table or work surface using both holes provided in the base (Ref.No.1).

Operation

Refer to Figure 2.

Select the desired tap (not provided) and secure it with the suitable adapter (Ref.Nos.27 to 35) using set screw Ref.No.13). Adjust spindle height so that tap will be above the workpiece when the adapter with tap is snapped inside the spindle. To adjust spindle height:

1. Loosen thumbscrew and move counterbalance until it touches the bracket, and tighten thumbscrew.
2. Loosen the set screw (Ref.No.18) in collar and raise or lower spindle to desired height. Tighten set screw after adjusting the height.
3. Return counterbalance to original position and tighten thumbscrew.

insert adapter with tap into the spindle and turn adapter until the flats in the adapter seats with flats in spindle. Press and snap adapter inside the spindle. To release adapter ,turn clip (ref.No.14) until the ball (Ref.No.15) is exposed. The adapter is released and can be taken out. Turn the clip back so that the ball is masked by the clip.

Position workpiece on the base so that the tap site is above the tap guide hole in the base. Slide the fixed jaw so that the the fixedjaw rests against one side of the workpiece. loosen knob (Ref.No.5) and move the moving jaw until it rests against the workpiece. Tighten knob to fix hole is found in the fixed jaw rail.

Loosen knob and retract the jaw so that the knob can be inserted into the nearest hole. Move the jaw along the keyway until it touches the workpiece. Tighten knob to clamp workpiece.

The tapping depth can be controlled by setting the spindle stop. To set depth control:

1. loosen hex nut (Ref No.9) and raise or lower blot (Ref.No.10) so that the distance between the collar (Ref. No.19) and the bolt equals the required tapping depth.
2. Tighten nut after setting bolt height. turn handle (Ref.No.20)clockwise and gradually lower the tap into the hole. Stop turning the handle when collar touches bolt (Ref.No.10). Turn handle counter clockwise to remove tap from hole and the tapping is complete.

Lubrication

Lubricate spindel frequently to ensure proper operation. Using light machine oil lubricate spindle through oil Zert (Ref.No.6). Frequently lubricate clip (Ref. No. 14) pathway in spindle.

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list

Address parts correspondence to:



14Caesar Place
Moonachie, NJ 07074
Tel: 201-933-6300
FAX: 201-933-3801

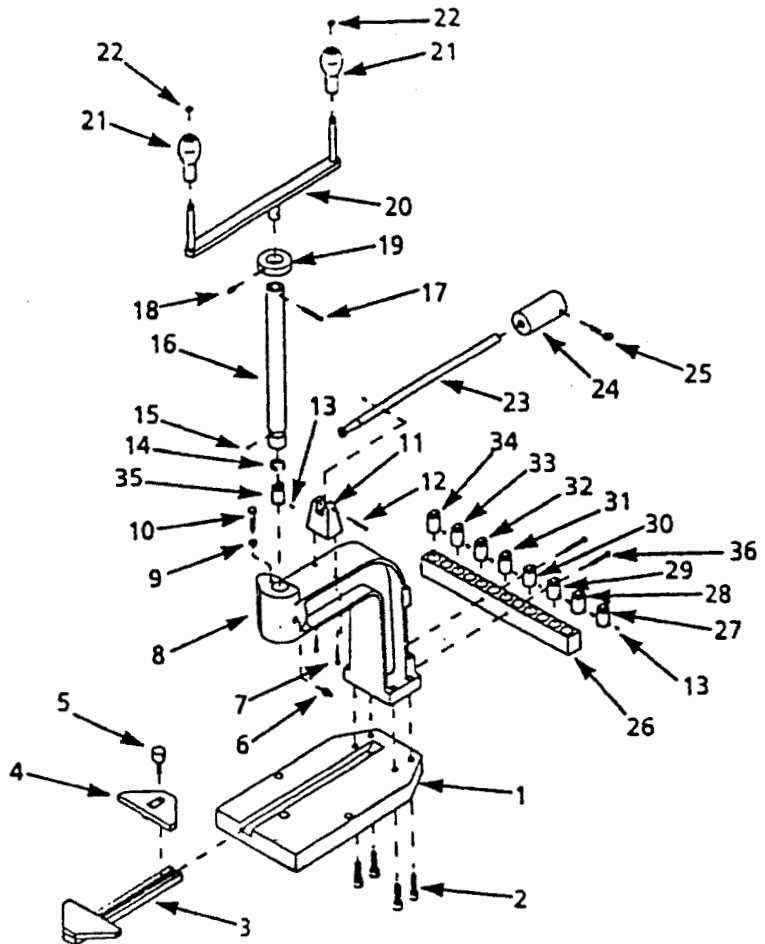


Figure 2-Replacement Parts Illustration

Replacement Parts List

Reference Number	Description	Part Number	Qty-
1	Base	8931.00	1
2	10-1.5×35mm Socket hd. bolt	*	4
3	Fixed jaw	8932.00	1
4	Moving jaw	8933.00	1
5	knob	8934.00	1
6	Oil zert	8935.00	1
7	5-0.8×16mm Hex head bolt	*	1
8	L-Frame	8936.00	1
9	Smm-0.8 Hex nut	*	1
10	5-0.8×28mm Hex head bolt	*	1
11	Bracket	8937.00	1
12	4×30mm Dowel pin	8938.00	1
13	5-0.8×5mm Set screw	*	9
14	Clip	8939.00	1
15	3/16" Ball	8163.00	1
16	Spindle	8940.00	1
17	Taper pin	8941.00	1
18	6-1.0×12mm Set screw	*	1

Reference Number	Description	Part Number	Qty-
19	Collar	8942.00	1
20	Handle	8943.00	1
21	Knob	8944.00	2
22	Retaining ring	8945.00	2
23	Lever	8946.00	1
24	Counterbalance	8947.00	1
25	Thumbscrew	8948.00	1
26	Adapter rack	8949.00	1
27	#6 Adapter	8950.00	1
28	#8 Adapter	8951.00	1
29	#10 Adapter	8952.00	1
30	1/4" Adapter	8953.00	1
31	5/16" Adapter	8954.00	1
32	3/8" Adapter	8955.00	1
33	7/16" Adapter	8956.00	1
34	1/2" Adapter	8957.00	1
35	5/8" Adapter	8958.00	1
36	5-0.8×38mm Round hd. screw	*	2

(* Standard hardware item available locally)

