

TYPE J46
REVERSIBLE TAP HOLDER

Technical Documents
Operation Instruction
Certificate of Quality
Packing List



TABLE OF CONTENTS

I 、 Appliance and property	Page2
II 、 Main technical specification	Page2
III 、 Parts of name and quantity	Page3
IV 、 Method and step	Page5
V 、 Certificate of quality	Page10
VI 、 Packing List	Page11

I 、 Appliance and property

Type J46 Chucks are featured of a reversible rotation, overload protection and adjustable torque as well as advantages, like a compact structure, high efficiency, safe and reliable and simple operation.

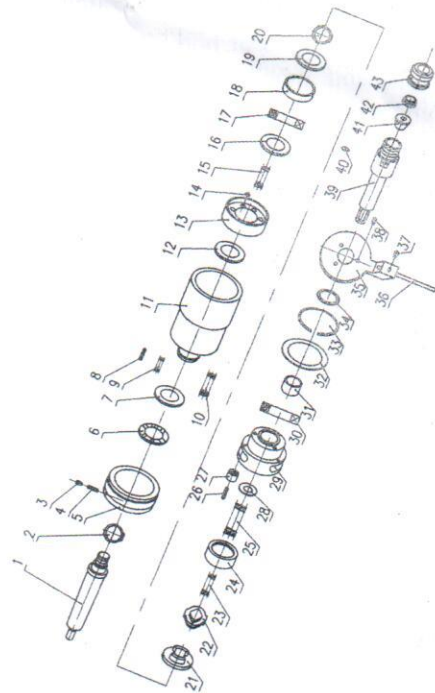
Working range: The chuck can be supplied with three specifications for various taps from M2 to M20, with their working ranges referring to the following table, and can be selected for connecting with the machine tool based on the machine spindle tapered hole. Adapters with a taper of MS4 or MS3 are attached.

II 、 Main technical specification

Specifications	Working range	Forward extensibility	Adapter NO.
J467	M2-M7	3.5mm	MS2 MS3
J4612	M5-M12	5mm	MS3
J4620	M8-M20	6mm	MS4

III、 Parts of name and quantity

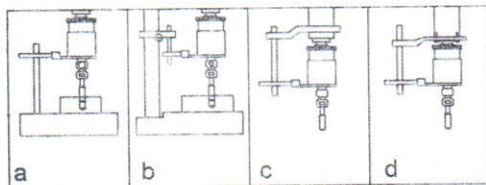
- | | |
|--------------------------|----------------------------|
| 1.arbor | 2.elastic ring |
| 3.hex head socket screw | 4.pin |
| 5.adjust nut for clutch | 6.thrust bearing and frame |
| 7.pad | 8.pin |
| 9.cluth spring(small) | 10. cluth spring(big) |
| 11.case | 12.spring washer |
| 13. cluth ring | 14.ball |
| 15.buffer spring | 16.pad |
| 17.bearing | 18. bearing bush |
| 19. bearing pad | 20.elastic ring for hole |
| 21.driver | 22.driving jaw |
| 23.return driving spring | 24.return gear |
| 25.reset spring | 26.pin |
| 27.gear | 28.pad for return bearing |
| 29.bearing stage | 30. bearing |
| 31.bushing | 32.ring for spindle |
| 33.slit ring | 34.elastic ring |
| 35.thrust stop | 36.stop bar |
| 37.hex head socket screw | 38.cross head socket screw |
| 39.driving spindle | 40.block |
| 41.flexible collet | 42.pod |
| 43.nut | |



IV、Method and step

- 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 into the chuck while watching the position of the tap handle from a window. Then, insert the square end of the tap handle into the square hole of the clamping device and tighten the lock nut with a wrench prior to fastening the top screw of the clamping device.
- ③ Mounting the brake rod: Referring to Figures (1), the brake rod which should be of a certain rigidity to withstand the torque of a reversing tap (A rod made of steel 45#, ϕ 20~30, HRC45 is recommended) is mounted either on the non-rotating part of the spindle end or on the worktable.

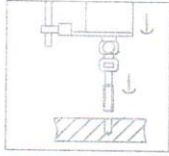
- a. The brake rod is mounted on the worktable.
- b. The brake rod is mounted on the column of the machine tool.
- c. The brake rod is mounted on the spindle quill.
- d. The brake rod is mounted on the flange of the spindle quill end



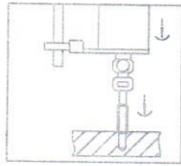
- ④ Adjusting the torque: A proper torque shown with numbers 1,2,3,4 on the main body periphery is selected according to the diameter to be tapped and the material of the work piece, showing that the chuck can stand the torque varies from small to large and can be selected by the operator himself. In case of materials which are difficult to be tapped, two operations are recommended.

⑤ Tapping: The operator should align the tap mounted on the machine tool with the machined screw blank hole on the work piece and operate referring to Figures.

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

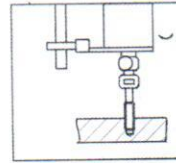


2. Start tapping, with the machine spindle moving down along with the chuck.

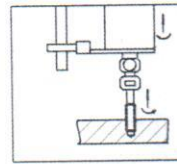


7

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

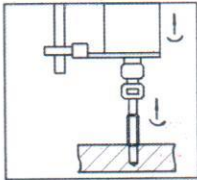


4 Raise the machine tool spindle, then the chuck spindle and the tap is automatically rotated in reversibly direction and retreated rapidly.

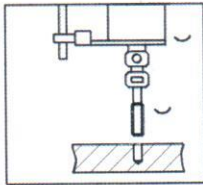


8

5 The raising of the machine spindle should be in correspondence with the retreating speed of the tap. Otherwise, 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 work piece.



TYPE J46 REVERSIBLE TAP HOLDER

Certificate of Quality

This unit has been tested and approved to be delivery.

Type

Inspector:

12
2021.02

Date

Packing List

1. Tap Holder	1
Morse Tap Sleeve	2
Key	2
Brake rod	1
Hex Wrench J467, J4612	1
Hex Wrench J4620	2
2. Technical Documents	
Operation Instruction	1
Certificate of Quality	1
Packing List	1

Inspector:

Date: