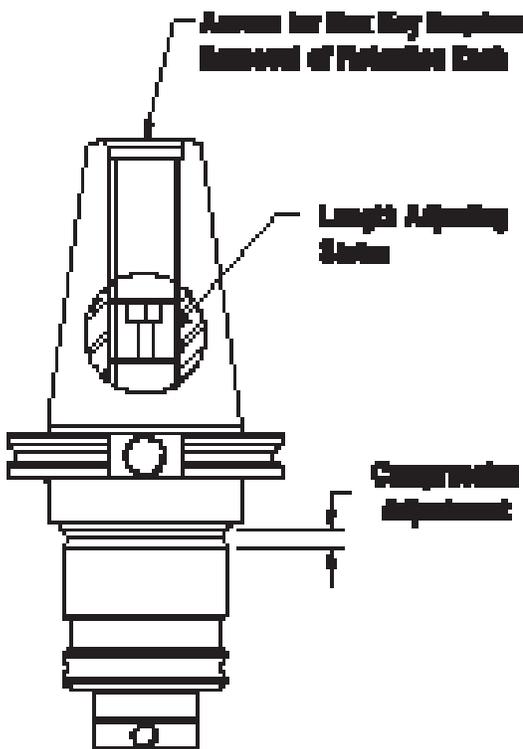


Compression Stroke Adjustment

NUMERTAP® 100, 200, 300, 700 & 770 UNITS

The NUMERTAP® 100, 200, 300, 700 and 770 series tapping attachments with machine tapers, feature a length adjustment screw. This allows the compression stroke to be reduced or eliminated, if desired, to provide more accurate depth control. Adjusting the compression stroke to zero will result in a tension only set-up, the best solution for synchronous tapping. Turning the length adjustment screw counterclockwise reduces the compression stroke but does not affect the tension stroke.



The projections of the unit can be adjusted by turning the screw in either direction until the desired length is reached. Changing the length in this manner does not affect the tension stroke. This is an important feature if redundant tools are being set or if reground taps are being used in existing programs.

Adjust the compression stroke counterclockwise until the tapping attachment body contacts the shank. This will set for tension only. This is recommended to eliminate or avoid tap elongation in synchronous tapping cycles.

TENSION-ONLY, THE BEST SOLUTION FOR SYNCHRONOUS TAPPING

The NUMERTAP® 100, 200, 300, 700 and 770 units can be purchased as tension only units (TT) or can be adjusted to tension only units by following the instructions above. Tension only is the best solution for synchronous tapping. If the unit is purchased as a TT, the tension spring is eliminated during assembly.

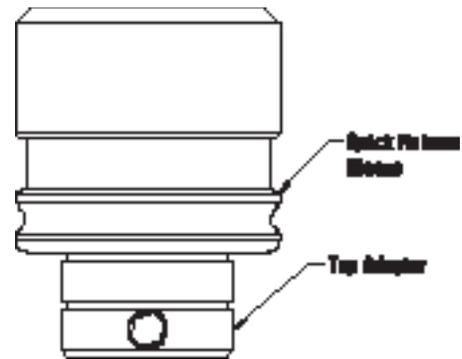
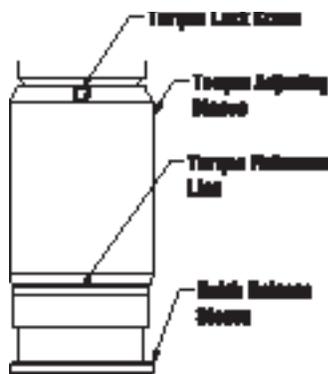
The unit will be the same length as a TA unit. If a TA unit is adjusted to eliminate the compression stroke, the unit will be 1/4" shorter than its original projection length. NUMERTAP® 700 units can be adjusted for tension only, but cannot be used in synchronous tapping cycles.

Compression Stroke Adjustment

NUMERTAP® 80, 700 & 770 ADAPTERS

To install a tap adapter into a NUMERTAP® 80, 700 or 770:

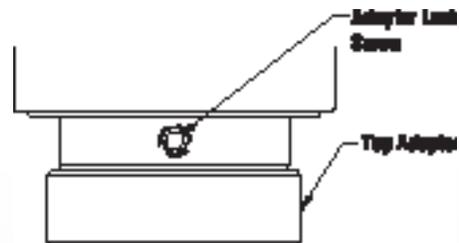
1. Pull back the quick-release sleeve.
2. Insert the tap adapter into the unit and push back until it seats. A slight twisting motion while pushing will ensure proper seating.
3. Release the quick release sleeve. It should return to its normal position. If it does not return, the adapter is not seated. Twist and push back until it seats.



NUMERTAP® 6000

To install a tap adapter into a NUMERTAP® 6000:

1. Loosen the adapter lock set screw.
2. Insert the tap adapter into the unit and push back until it seats. A slight twisting motion while pushing will ensure proper seating.
3. Tighten the adapter lock screw.



NUMERTAP® 80

The factory setting for the torque adjusting sleeve is at maximum torque. In this state, the first (closest to the tap) torque reference line will be barely visible. This setting provides a large safety factor against tap breakage and should not need to be changed unless low tensile materials are being tapped.

When tapping soft materials, particularly with small taps, it is advisable to use less torque to prevent thread distortion when the tap bottoms.

To adjust the torque, loosen the torque lock screw and rotate the torque adjusting sleeve to its upper limit. All three torque reference lines will be visible. Take a test cut. If the tap does not cut, increase the torque by turning the adjusting sleeve. When the proper setting is reached and there is enough torque pressure, turn the torque adjusting ring another 1/8 turn and secure the lock screw. Always adjust the torque to coarse pitch when using more than one tap in the same tapping head.