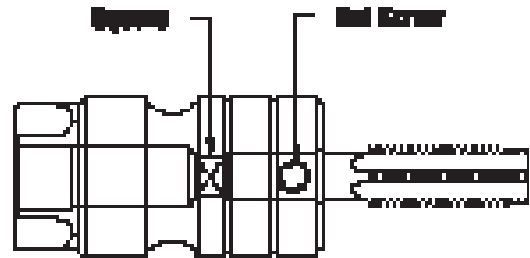


Tap Installation

NUMERTAP® 80, 88, 700, 6000 & 6500 ADAPTERS

1. Loosen the set screw in the tap adapter.
2. Insert the tap into the adapter and twist until the square on the tap is aligned with the square in the adapter. Push back until the adapter is fully seated against the shoulder of the square.
3. Do not grind grooves or flats on the tap shank

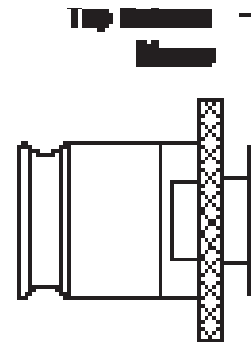
If, for some reason a tap sticks in a hole, the set screw will allow the tap to pull out of the adapter without damaging the part, tapping head or tap. Grinding flats on the tap shank overrides this safety feature.



NUMERTAP® 100, 200, 300 & 7716QR ADAPTERS

1. Push back the tap release sleeve.
2. Insert the tap into the adapter and twist until the square on the tap is aligned with the square in the adapter. Push back until the adapter is fully seated against the shoulder of the square.

Both fine and course pitch taps are used in the same adapters. Left or right hand taps can be used in any NUMERTAP® system without alteration.



COOLANT FED 700 & 770 ADAPTERS

When used in through-spindle-coolant applications, coolant fed NUMERTAP® units must be used with coolant fed tap adapters. Coolant fed tap adapters feature a sealing plug at the back. The "O" ring in the ID of the plug should be periodically checked for cuts or tears. If damage is noted, the "O" ring should be replaced.

