

ELECTRIC TAPPING MACHINE

Multiple Processes can be solved in One Machine

UNIFAST®

Model: **ETM-24-1200**



OPTIONAL PART



SUITABLE FOR MANY MATERIALS

Applicable materials: aluminum, copper, A3 steel, 45 steel, cast iron, pig iron, Q235, S136, mold steel, 718H, 40Cr, stainless steel and other metal materials



PRODUCT INTRODUCTION

Model	ETM-24-1200
Customized	Yes
Power Type	Servo Motor
Rated Power	2000W
Supply Voltage	220V 50Hz
Spindle Rated Speed	0-200rpm
Tapping Range (steel, stainless steel, aluminum)	M6-M24
Working Range	1200mm
Weight	52kg
Universal Tapping	Yes
Oiling Function	No
Lifting Function	No

MAIN PARTS: WITHOUT CONSOLE

- 1 Imported servo motor
- 2 Touch screen control system
- 3 Universal head
- 4 Tap Holder(One set)



STANDARD ACCESSORIES

- 1 Tapping Arm (One set)
- 2 Servo Motor and reducer (One set)
- 3 Tap Holder M6-M30 (One Set)
- 4 Universal Joint (Tapping for a Vertical/Horizontal)

OPTIONAL ACCESSORIES

- 1 Magnetic Base Weight: 18kg (Magnetic Power: 1000kg) Realize tapping in any range
- 2 Moving workbench 600x800x900

HD Human-machine Interface

Adjustable forward and backward speed



Imported Servo Motor

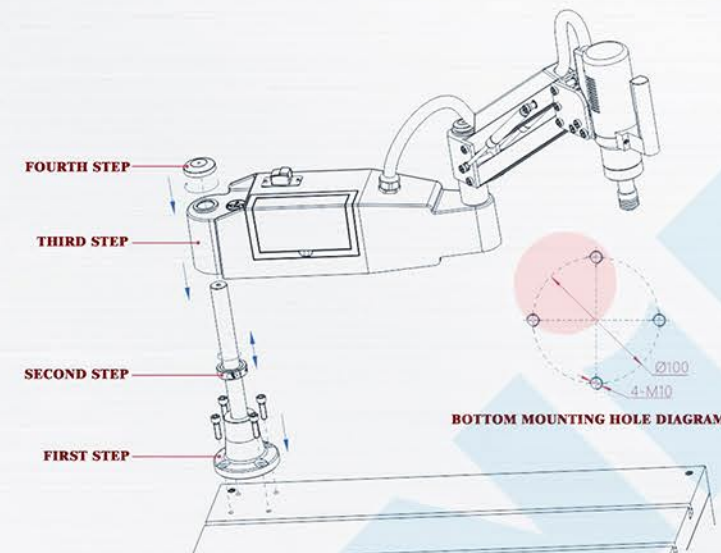
Strong output



TAPPING MODE INTRODUCTION

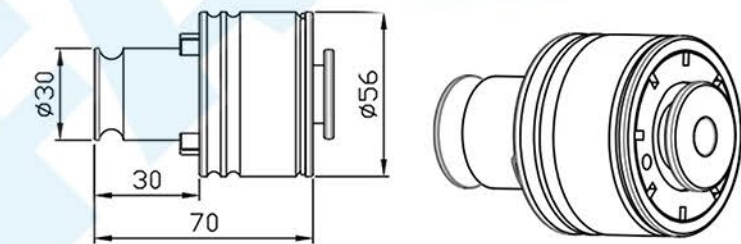
- MANUAL TAPPING**
Set the tapping speed and thread pitch by yourself, you can observe the depth value of the digital display on the screen. After reaching the required depth, you can manually press the rewind button (suitable for different single piece processing).
- AUTOMATIC TAPPING**
First click on the upper left corner of the screen to enter the thread selection, select the corresponding thread size, and then enter the tapping depth, advance speed, and retreat speed to realize automatic tapping operation. (Suitable for blind hole processing, can more effectively prevent the tap from touching the bottom, causing the tap to break due to excessive force).
- DEEP HOLE INTERMITTENT MODE**
This mode is mainly used for deep hole tapping, the CNC computer simulates the manual machining method. While performing deep processing, the processing chips are discharged to ensure the tapping effect (suitable for deep hole tapping).

INSTALLATION INSTRUCTIONS



- 01 INSTALL THE FOOT BASE**
Align the foot base with the screw holes on the workbench, and install four screws. If the company workbench is not selected, you need to machine four mounting holes on the workbench by yourself. The processing dimensions are detailed in the following "Foot base mounting hole position map".
- 02 ADJUST THE LIMIT RING**
According to the actual situation, adjust the appropriate height, and tighten the screws on the limit ring.
- 03 INSERT THE TAPPING HOLE**
Put the copper sleeve of the lower bracket of the tapping machine on the optical axis of the foot base, and make the bottom copper sleeve close to the limit ring.
- 04 SCREW ON THE OPTICAL AXIS COVER**
Align the optical axis cover with the screw hole on the top of the optical axis, insert it correctly and tighten it.

TAPPING COLLET CHUCK



If you don't know what standard tapping chuck to choose. Measure the diameter of the tap shank and the width of the square head, corresponding to the values listed in the table below.

A:Round Shank Diameter

B:Square Shank Width

ISO	AXB	JIS	AXB	DIN	AXB
M2	2.8x2.25	M2	3x2.5	M2	2.5x2.1
M3	3.15x2.5	M3	4x3.2	M3	3.5x2.7
M4	4x3.15	M4	5x4	M4	4.5x3.4
M5	5x4	M5	5.5x4.5	M5	6x4.9
M6	6.3x5	M6	6x4.5	M6	6x4.9
M8	6.3x5	M8	6.2x5	M8	8x6.2
M10	8x6.3	M10	7x5.5	M10	10x8
M12	9x7.1	M12	8.5x6.5	M12	9x7
M14	11.2x9	M14	10.5x8	M14	11x9
M16	12.5x10	M16	12.5x10	M16	12x9
M18	14x11.2	M18	14x11	M18	14x11
M20	14x11.2	M20	15x12	M20	16x12
M22	16x12.5	M22	17x13	M22	18x14.5
M24	18x14	M24	19x15	M24	18x14.5
M27	20x16	M27	20x15		
M30	20x16	M28	21x17		
M33	22.4x18	M30	23x17		
M36	25x20				
M39	28x22.4				
M42	28x22.4				