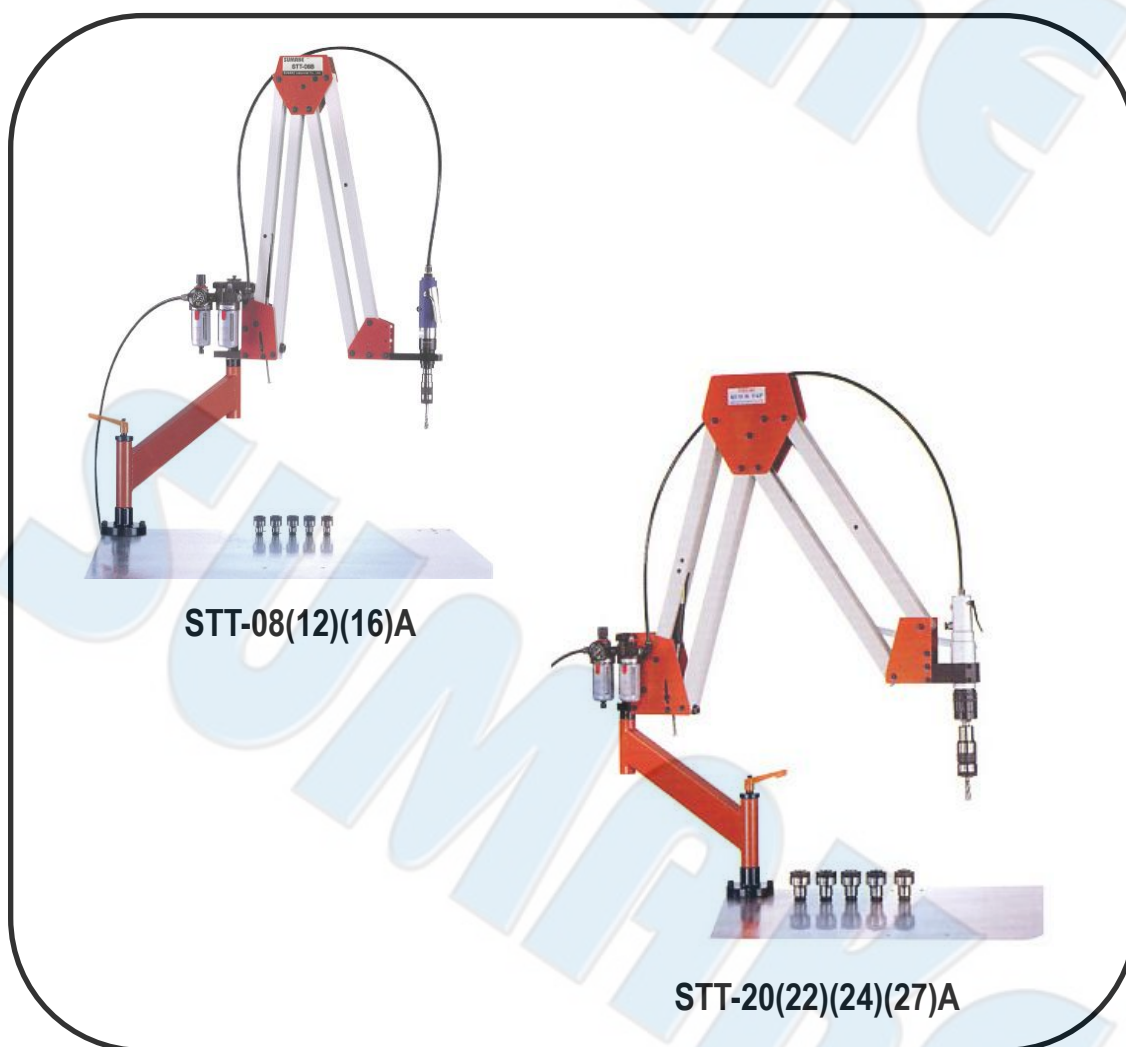


INSTRUCTION MANUAL

ITEM NO.: **STT-08(12)(16)(20)(22)(24)(27)A**
AIR TAPPING MACHINE



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1. DESCRIPTION

- Pneumatic tapping machine is suitable for different size taps (from M2 to M27).
- The arm is equipped with lubricated for life bearings at all swivel points, provides weightless operation through the use of gas counter balance springs and permits the operator to bring the tap to the hole with ease.

2. UNPACKING

Please check for completeness. Refer to Figure 2-1.

| ITEM DESCRIPTION | MODEL | |
|--------------------------|------------------|------------------|
| | STT-08A, STT-12A | STT-16A, STT-27A |
| A. Stretch arm | • | |
| B. Stretch arm | | • |
| C. Slanted arm | • | • |
| D. Table mounting column | • | • |
| E. Air unit | • | • |
| F. Air tapping spindle | • | |
| G. Air tapping spindle | | • |
| H. Air hose | • | • |

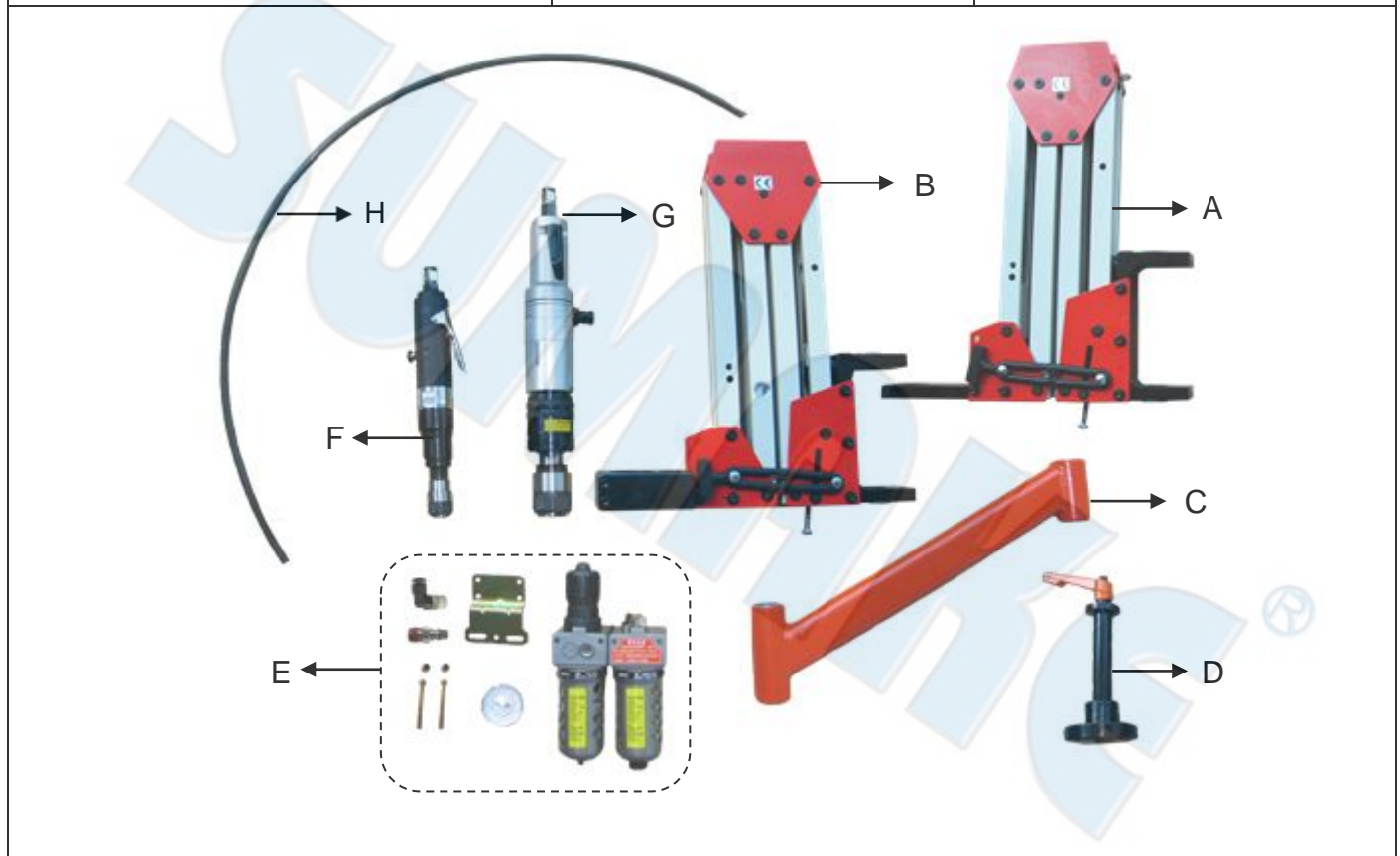


Figure 2-1

3. SPECIFICATIONS

| MODEL | STT-08A | STT-12A | STT-16A | STT-20A |
|-----------------------------|-------------------------|---------|----------------|-------------|
| Speed | 700 rpm | 400rpm | 300 rpm | 150/400 rpm |
| Air consumption required | 5 HP | 5 HP | 5 HP | 5 HP |
| For Tap | M2~M8 | M3~M12 | M3~M16 | M3~M20 |
| Tap holder size | STC-1E | | STC-1E, STC-2E | |
| Work range | Rmax 1900mm Rmin 200 mm | | | |

| MODEL | STT-22A | STT-24A | STT-27A |
|--------------------------|-------------------------|-------------|------------|
| Speed | 120/300 rpm | 100/300 rpm | 70/220 rpm |
| Air consumption required | 5 HP | 5 HP | 5 HP |
| For Tap | M3~M22 | M3~M24 | M3~M27 |
| Tap holder size | STC-1E, STC-2E | | |
| Work range | Rmax 1900mm Rmin 200 mm | | |

4. SAFETY RULES

- Some dust created by power sanding sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm.
- Always follow this operation manual – even if you are familiar with use this tools. Remember the being careless can result in severe personal injury.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

5. BE PREPARED FOR JOB

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
- Wear protective hair covering to contain long hair.
- Wear safety glasses (not everyday glasses) and shoes with non-slip soles.
- Wear dust mask and dustless clothes if operation is dusty.
- Wear ear protection if the work area may include exposure to excessive noise levels.
- Keep work area ventilation and clean. It should be properly lighted. Cluttered work areas invite accidents.
- Do not use the tools in dangerous environments or wet locations. Do not expose it to rain.

6. ASSEMBLY

STEP 1 : MOUNT TABLE MOUNTING COLUMN

Please assembly the table mounting column to a solid horizontal surface using 10mm bolts (see Figure 7-1).

《Reminder : the machine do not provide 10mm bolts.》

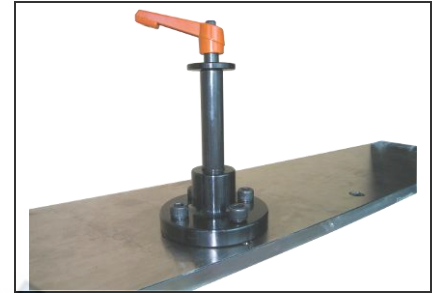


Figure 7-1

STEP 2 : ATTACH PARALLEL ARM AND SLANTED ARM

- (1) Remove locking handle and washer from table mounting column (see Figure 7-2).
- (2) Slider slanted arm over table mounting column. Make sure air unit mounting screws are away from the table mounting column (see Figure 7-2).
- (3) Replace locking handle and washer to secure in position (see Figure 7-2).
- (4) Insert stretch arm rod into slanted arm (see Figure 7-3).

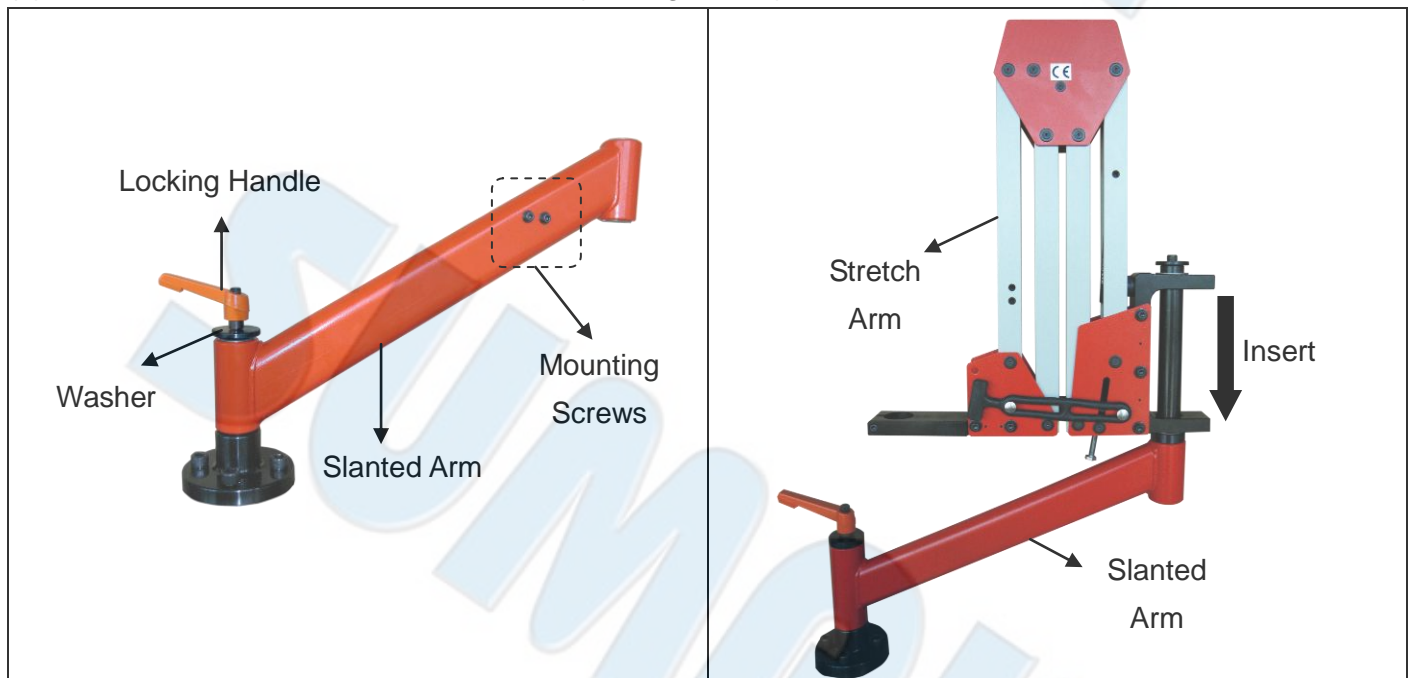


Figure 7-2

Figure 7-3

STEP 3 : ATTACH SPINDLE

● **STT-08A & STT-12A**

- (1) Loosen the socket head bolt (see Figure 7-4).
- (2) Insert spindle into bracket of tapping arm, make sure spindle is completely into the bracket (see Figure 7-5).
- (3) Fasten the socket head bolt to avoid damages which may be caused by loosened parts.

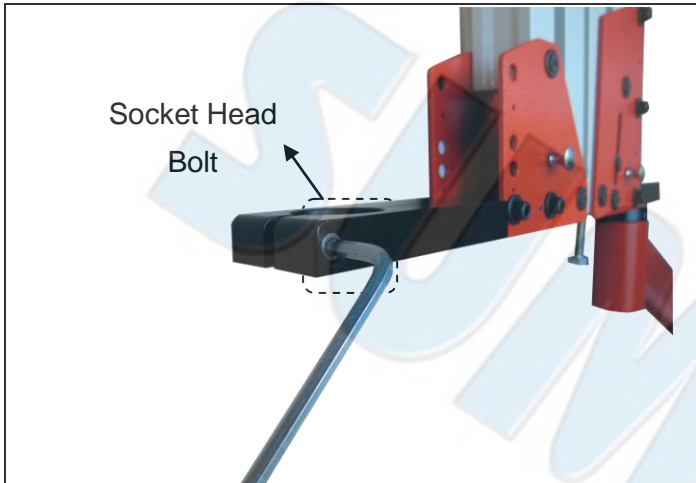


Figure 7-4

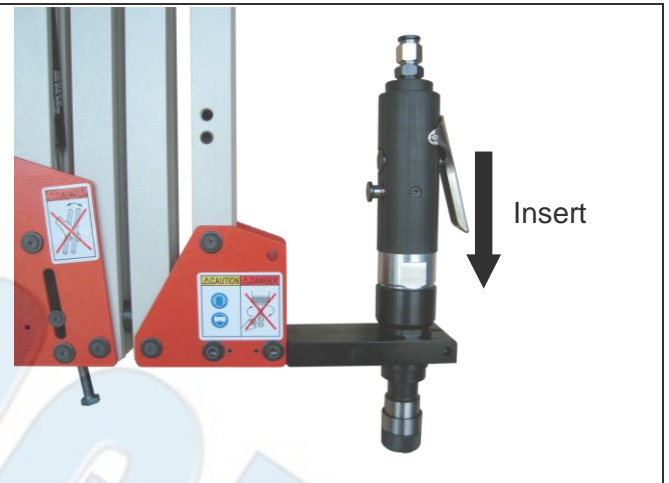


Figure 7-5

● **STT-16A ~ STT-27A** (see Figure 7-6)

- (1) Loosen the socket head bolts.
- (2) Insert spindle into bracket of tapping arm, make sure spindle is completely into the bracket and correct position.
- (3) Fasten the socket head bolt to avoid damages which may be caused by loosened parts.

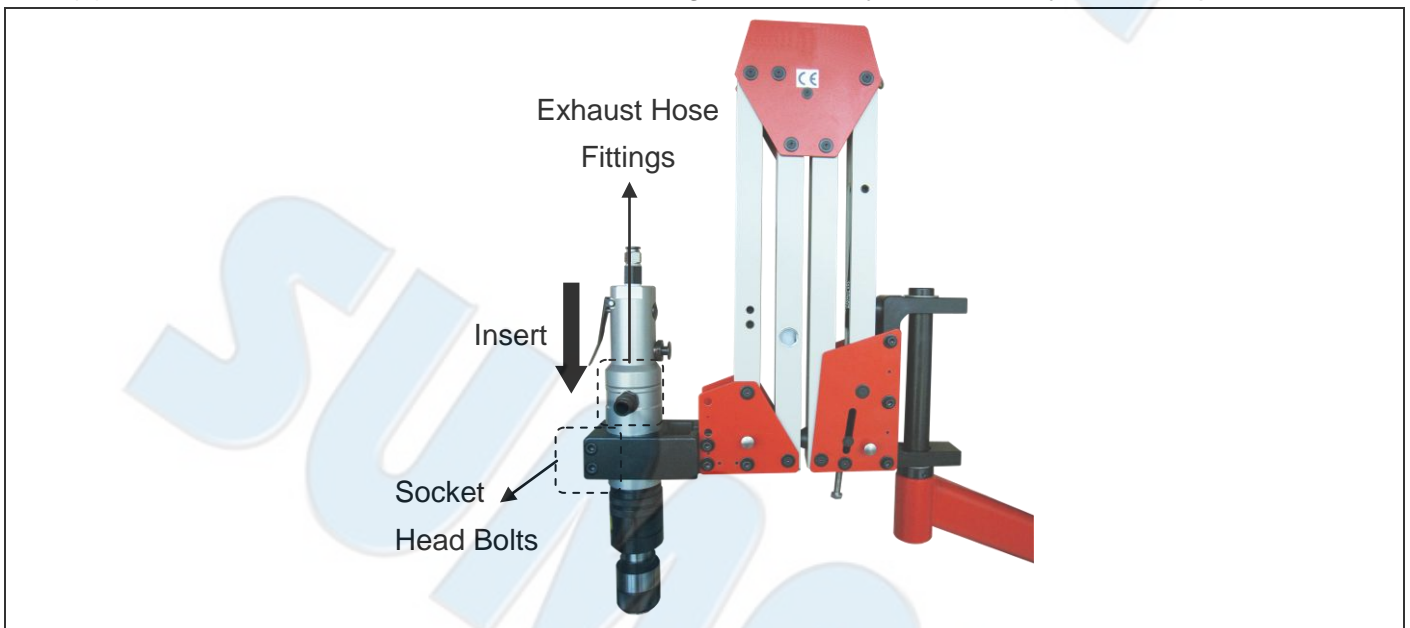


Figure 7-6

STEP 4 : MOUNT AIR UNIT

- (1) Attach pressure gauge, 3/8" quick connect and air hose fitting (see Figure 7-7).
- (2) Remove front cover of air unit body by lifting tab at top of cover and insert the two mounting bolts as Figure 7-7.
- (3) Attach mounting bracket to the back of air unit body with two nuts, and replace front cover (see Figure 7-8).
- (4) Secure air unit to the slanted arm using socket head bolts provided on slanted arm. Attach bracket using center hole and right slot of bracket (see Figure 7-8).

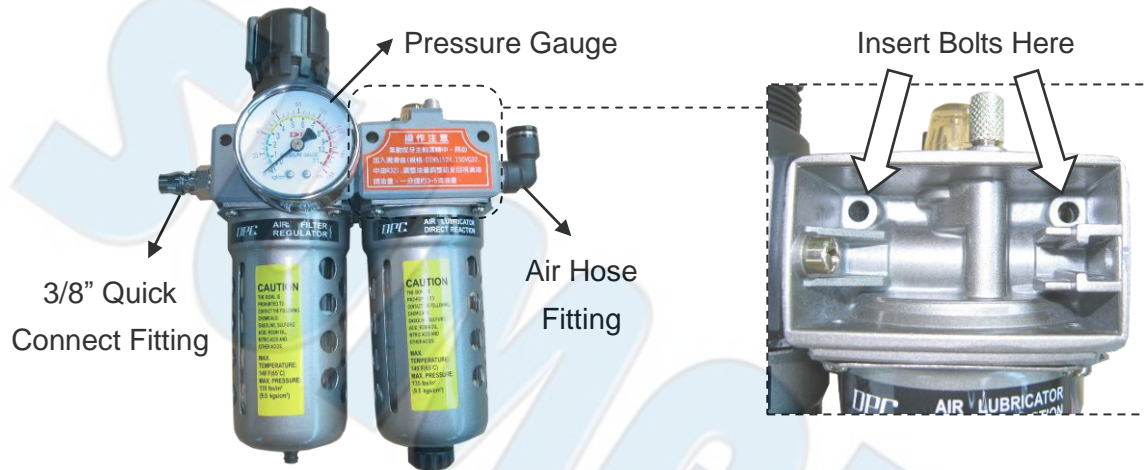


Figure 7-7



Figure 7-8

STEP 5 : ATTACH AIR HOSE

- (1) Attach air hose into outlet fitting of air unit and inlet fitting of spindle (see Figure 7-9).
- (2) Press hose firmly into fittings. Fittings are spring loaded. Hose can be removed by depressing lip of fitting.

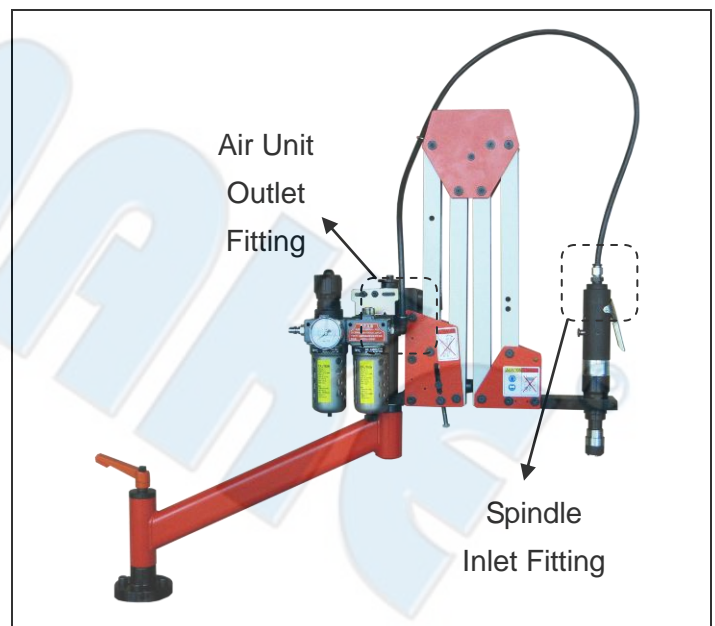


Figure 7-9

7. PREPARATION BEFORE OPERATION

A. ADJUSTMENT OF AIR UNIT

① Lacking of oil will cause the parts of spindle get damaging easily in a short time. ①

- (1) Add lubricant to the air unit body. Unscrew the oil filling plug and add approximately 8-10 ounces of oil. Replace plug and tighten securely. The oil filling plug has to be closed to original situation (see Figure 8-1).
- (2) Recommended lubricant : ISO VG22, CPC Circulation Oil R32
- (3) Pull the adjustment knob up and adjust air pressure to 7~9 kgf/cm². Turn the adjustment knob clockwise to increase the pressure and counter clockwise to reduce the pressure. After adjusting the pressure, press the knob down into its locked position to prevent accidental setting change (see Figure 8-1).
- (4) Depress and hold the operation lever of the spindle. While the spindle is operating, check the oil flow rate through the sight glass on top of the air unit body. The air unit should operate 3-5 drops/minute. Rotate the oil adjusting screw clockwise to decrease the oil flow rate; counterclockwise to increase the oil flow rate (see Figure 8-1 and 8-2).

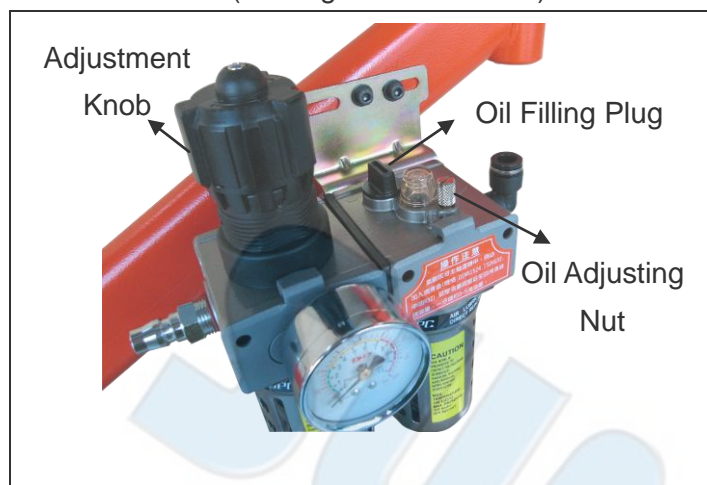


Figure 8-1

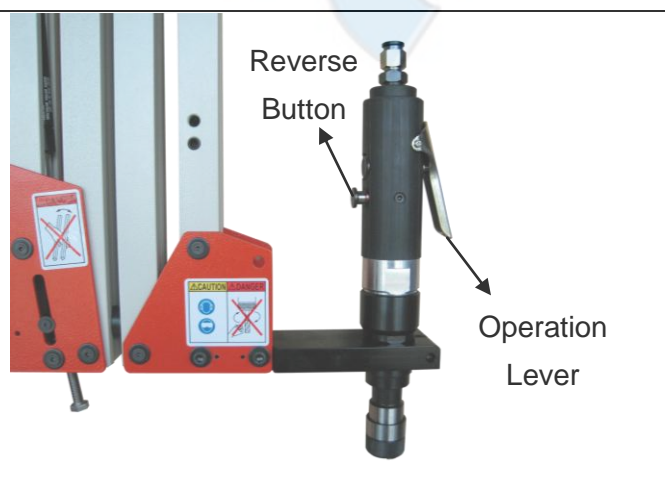


Figure 8-2

Caution :

- Do not exceed 9.5 kgf/cm². It will cause bursting of the filter and lubricator bowls.
- Keep the pressure over 5 kgf/cm² when operation.
- The valve opens automatically and discharges water or dist when air pressure is under 0.7 kgf/cm². It will automatically close when it is over 1.2 kgf/cm², and also can be also operated manually (see Figure 8-3).



Figure 8-3

B. ATTACH THE TAP AND TAP HODLER

- (1) Slide tap into tap holder until tap locks in place. Tap can be removed by simultaneously depressing flange and pulling out tap (see Figure 8-4).
- (2) Insert tap holder with tap into spindle. Pull up tap holder sleeve, insert tap holder with tabs aligned to slots in tap holder sleeve, and then release sleeve (see Figure 8-5).

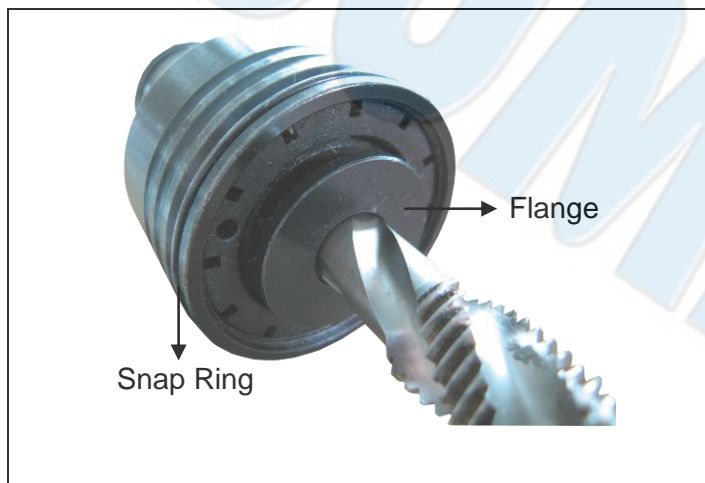


Figure 8-4

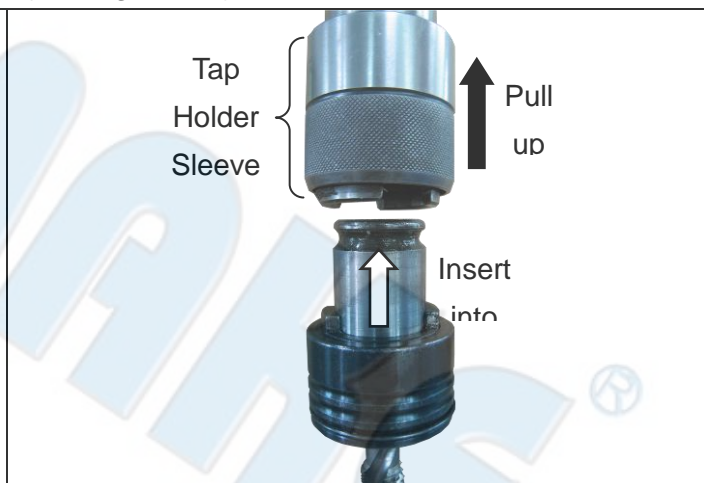


Figure 8-5

C. ADJUST SPEED OF SPINDLE

● **STT-08A & STT-12A**

Spindle speed can be changed by using flathead screwdriver (see Figure 8-6).

● **STT-16A** (This model cannot be changed speed.)

● **STT-20A ~ STT-27A** (Refer to Figure 8-7)

① Caution: Never change speed while spindle is in operation. ①

- (1) These models have two speeds. It can be changed by grasping sleeve, pulling downward so that pin is out of the notch in the body, rotating sleeve to the other notch and then releasing the sleeve so that pin seats in the notch.
- (2) Rotate sleeve to seat the pin in the notch. Turn the sleeve clockwise to increase the speed and counter clockwise to reduce the speed.

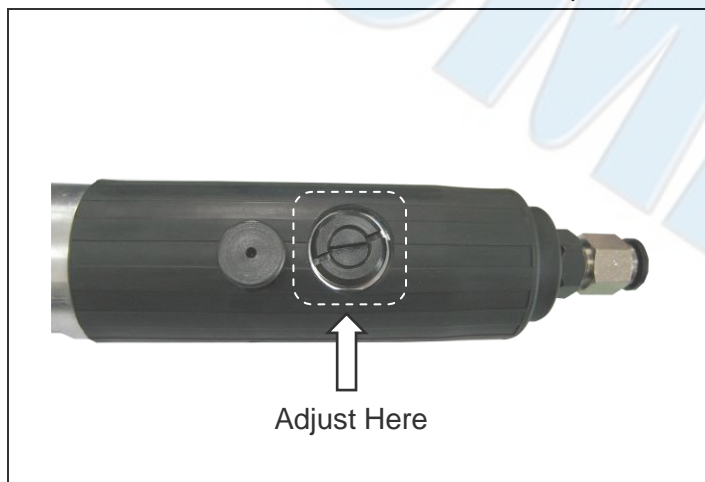


Figure 8-6

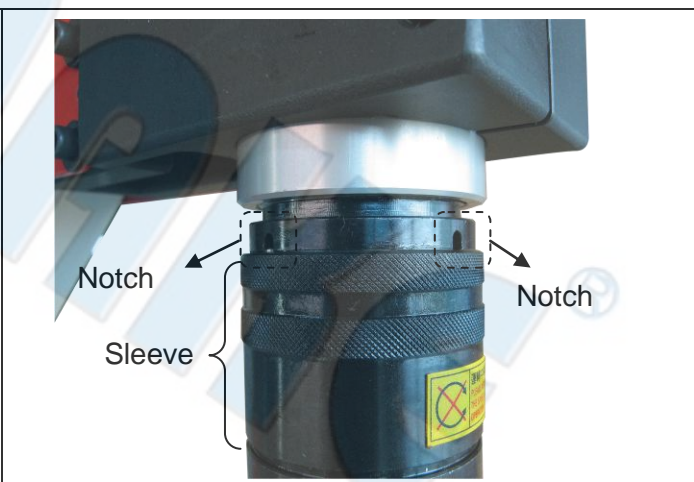


Figure 8-7

8. OPERATION

- A. Take the spindle with tap to the hole to be tapped and place the tip of the tap on the hole.
- B. Press the operation lever. The tap will self-center and begin tapping. Let the tap arm guide the tap into the hole.
- C. After tapping to the required depth, press the reverse button while also depressing the operating lever. The tap will reverse out from the hole (see Figure 8-2).

Caution:

If the tap holder “clicks” or “ratchets”, the tap holder clutch torsion needs to be adjusted.

- (1) Remove the spring clip from the groove of the tap holder (see Figure 8-4).
- (2) Use the tools to adjust the torsion as Figure 9-1.
- (3) Rotate notched nut clockwise to increase torsion, counterclockwise to decrease torsion (see Figure 9-2).
- (4) Replace spring clip into groove of the tap holder.

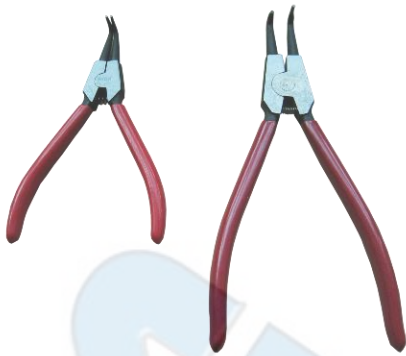


Figure 9-1

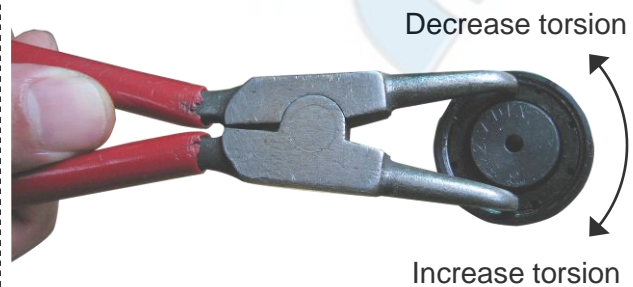


Figure 9-2

9. MAINTENANCE

- A. Always unplug tool prior to inspection.
- B. Do not adjust, remove or maintain tool in operation.
- C. Consult manual for specific maintaining and adjusting procedures.
- D. Keep tool lubricated and clean for safest operation.
- E. Remove adjusting tools. Form habit of checking to see that adjusting tools are removed before switching machine on.
- F. Check for damaged parts. It may affect a tool's operation.
- G. Damaged parts should be properly repaired or replaced. Do not perform makeshift repairs.
- H. Never brush away chips while the machine is in operation. All clean up should be done when the machine is stopped.
- I. Never modify machine without consulting manufacturer.
- J. Use sharp cutters and keep the tool clean for safest operation.

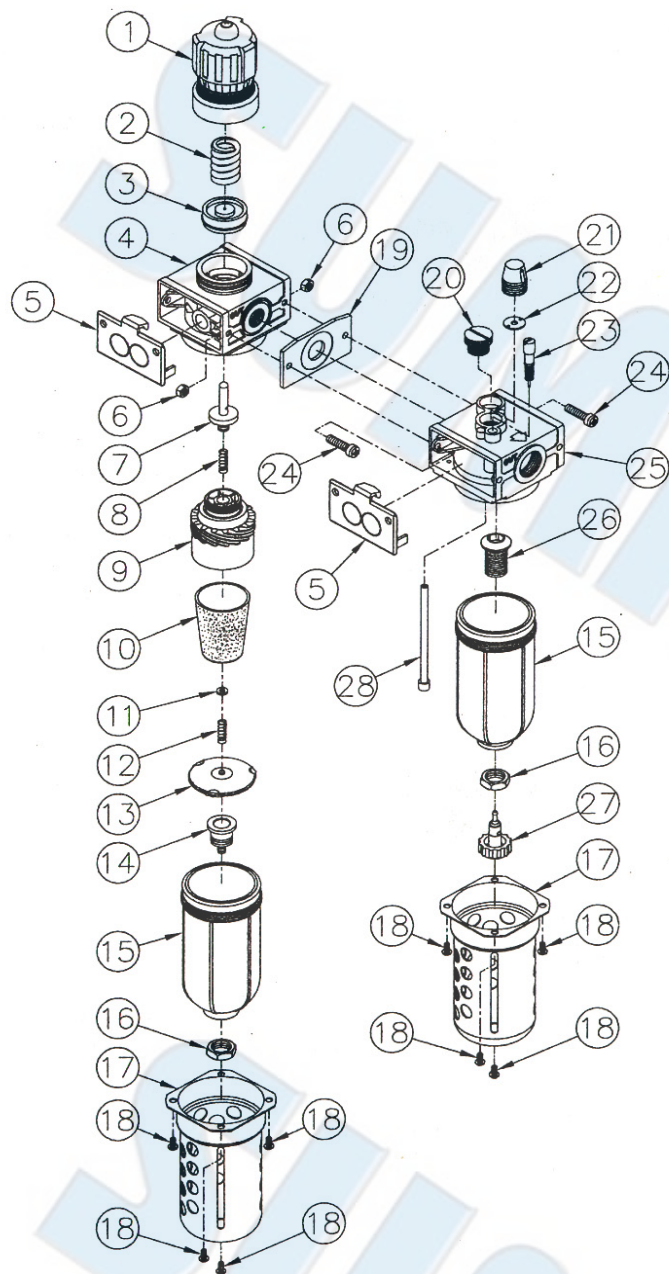
10. NOTICE FOR USING TOOLS

- A. Keep visitors at a safe distance from work area.
- B. Keep children out of workplace.
- C. All workpieces must be clamped to work table when using tapping machine. It is unsafe to use your hands to hold any workpiece.
- D. Avoid accidental start-up. Make sure that tool switch is in OFF position before connection to air supply.
- E. Do not force tool. It will work most efficiently at the rate for which it was designed.
- F. Keep hands away from moving parts. Protect hands from possible injury.
- G. Never leave a tool running unattended. Turn the power off and do not leave tool until comes o a complete stop.
- H. Do not use tool for a long time. Please take a rest for 5-10 minutes after using one hour.

11. TROUBLESHOOTING

| SYMPTOM | POSSIBLE CAUSE(S) | CORRECTIVE ACTION |
|---|--|--|
| Clutch slips and tap will not turn | Tap holder clutch torsion needs to be adjusted. | Adjust tap holder torsion (see Figure 9-1 and 9-2) |
| | Not tap lubrication | Apply lubrication to tap |
| | Dull tap | Replace tap |
| | Hole and tap misaligned | Reposition tap arm |
| | Hole diameter too small | Enlarge hole |
| | Wrong tap for workpiece materials | Replace tap |
| Spindle does not turn or stops | Check air supply pressure | Adjust pressure between 7~9 kgf/cm |
| | Excessive pressure drop | Keep air supply compressor over 5 HP |
| | Insufficient lubrication | Make sure oil flow rate from air unit is 3-5 drops per minute |
| | Clogged spindle exhaust filter | Clean or replace filter |
| | Clogged air unit | Clean or replace air unit |
| | Worn rotor blade | Replace rotor blade |
| | Spindle inner parts too dry | Add lubricant into spindle |
| Stretch arm drops or is difficult to move | Workpiece material with hardness | According to the hardness, upgrade bigger capacity spindle |
| | Worn air spring | Replace air spring |
| Spindle body is hot | 1. massive tapping 2. Use spindle for a long time | 1. Prepare another spindle to exchange 2. Let your spindle rest for 5-10 minutes Caution: Keep using a hot spindle will cause the spindle gear lubricant evaporating and break easily. |

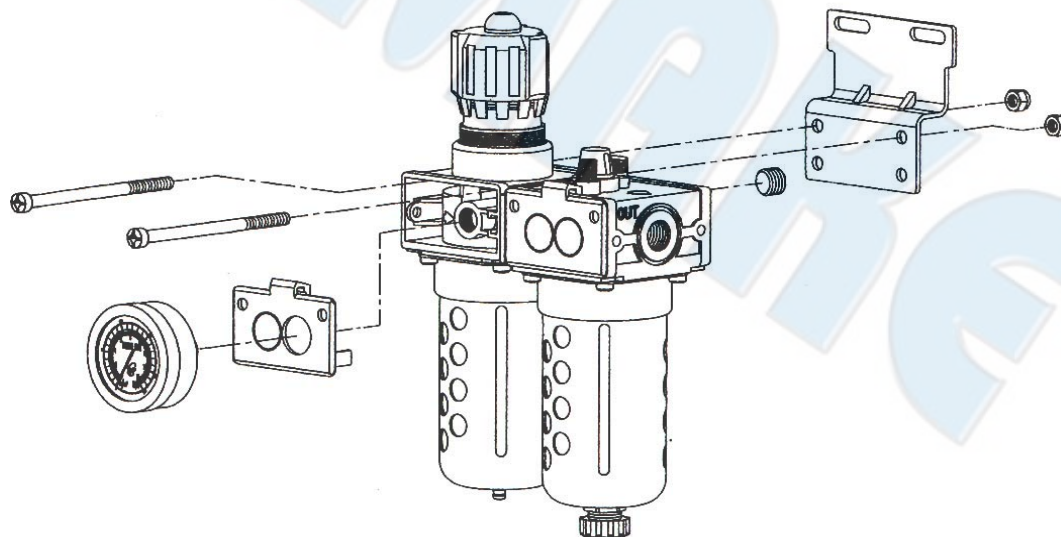
AIR FILTER, REGULATOR & LUBRICATOR



PARTS LIST

| No. | Description | Q'ty |
|-----|---------------------|------|
| 1 | Adjusting Knob | 1 |
| 2 | Control Spring | 1 |
| 3 | Piston | 1 |
| 4 | F&R Body | 1 |
| 5 | Window | 1 |
| 6 | Connector Nut | 1 |
| 7 | Valve Assembly | 1 |
| 8 | Spring | 1 |
| 9 | Spiral | 1 |
| 10 | Filter Element | 1 |
| 11 | O-Ring | 1 |
| 12 | Spring | 1 |
| 13 | Umbrella Baffle | 1 |
| 14 | Semi-Auto Drain | 1 |
| 15 | PC Bowl | 1 |
| 16 | Drain Nut | 1 |
| 17 | Bowl Protector | 1 |
| 18 | Screw | 1 |
| 19 | Connector Gasket | 1 |
| 20 | Oil Filling Plug | 1 |
| 21 | Sight Dome | 1 |
| 22 | Gasket | 1 |
| 23 | Oil Adjusting Screw | 1 |
| 24 | Connector Screw | 1 |
| 25 | Lubricator Body | 1 |
| 26 | Manual Drain Cup | 1 |
| 27 | Manual Drain Knob | 1 |

Installation





EC DECLARATION OF CONFORMITY

We: **SUMAKE INDUSTRIAL CO., LTD.**

4F, No. 351, Yangguang St., Neihu District, Taipei City, Taiwan

declare in sole responsibility that the equipment

Equipment : **TAPPING MACHINE**

Model/ Serial No. : **HTT-22(32)(42)(50), HT-220(320)(420)(500)**

STS-08(12)(16)(20)(22)(24)(27)B

STT-08(12)(16)(20)(22)(24)(27)A, STT-08(12)(16)(20)(22)(24)(27)B

STQ-08(12)(16)(20)(22)(24)(27), STT-R16(20)(22)(24)(27)

to which this declaration applies, complies with these normative documents:

- Machinery Directive: 2006/42/EC

and conforms to the following EN standard,

- EN ISO 12100: 2010
- EN 60204-1:2018

Name and Signature/Position



Mike Su - Managing Director

Date and Place

2019/10/7

Taipei, Taiwan

TAPPING MACHINE-D-1910A-T4F

NOTE

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