

**SPECIFICATIONS**  
Ref.: Dwg. 21888-01

<b>Capacity</b>	Taps and threads 48 to 7 straight threads per inch and 11 ½ taper pipe threads per inch.
<b>Stroke</b>	⅛ " to 2" maximum, lead screw feed only.
<b>Stroke Control</b>	Positive screw action. Feed per revolution results from turning lead screw attached to spindle thru a stationary nut. Spindle is advanced and retracted by drive motor turning forward and reverse. When recommended electric power and cycle system is used, motor is started by energizing cycle circuit, reversed by a built-in stroke end limit switch, and plugged to a stop by a built-in retract position limit switch thru an electric motor reversing relay.
<b>Feed Rate</b>	Selective by interchanging lead screws and nuts. Standard pitches are 7, 8, 9, 10, 11, 11 ½, 12, 13, 14, 16, 18, 20, 24, 27, 28, 32, 36, 40 and 48—all right hand. Left hand and metric available.
<b>Depth Repeatability</b>	⅛ revolution of spindle at 1000 R.P.M.
<b>Thrust Overload Safety</b>	Built-in safety limit switch causes spindle reversal if forward motion is obstructed.
<b>Mounting</b>	Unlimited, mount in any position at any angle.
<b>Weight</b>	Average, less spindle motor, 40 lbs.

**PROCEDURE TO CONFIRM PROPER SWITCH & CAM BAR ADJUSTMENTS**

As viewed from the front of the unit—

Advance cam bar should be assembled with stop pin in the cam bar knob in line with the straight side of the spiral groove in the cam bar.

Retract cam bar should be assembled with stop pin in the cam bar knob one hex notch counterclockwise from the straight side of the spiral groove in the cam bar.

Set the advance depth knob counterclockwise as far as it will go (for maximum depth) and the retract position knob clockwise as far as it will go.

When the unit is cycled, the spindle should travel out 2 ½ " including ¾ " stand-off, then reverse and stop at the ¾ " position. The switch levers can be adjusted to obtain this condition.