NIKKEN

D.T DRILLING & TAPPING

NON-STOP CHUCK DRILLING and TAPPING series

D.T and S.NQM series

As a standard attachment of the market boom product NPU Drill Chuck, it is an easy-touse, highly efficient set content.

D.T4-38BN and **D.T5-38BN** are not wooden box sets.

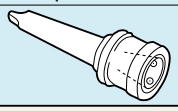
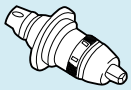
D.T 3 - 16 AN G

- G:with ZKG Tap Collet
- Max. drilling diameter:AN=ϕ32 BN=ϕ50
- Max. tapping capacity:M12, 16, 24 ,38
- Size of Taper 3:MT3, 4:MT4, 5:MT5
- D.T set:for drilling and tapping

◆Tapping from drilling can be done efficiently.
("Non-Stop Chuck"is the trade name, do not change tools during spindle rotation)

◆The floating mechanism is built into the Tupper chuck itself, so it can be used for most machines.

⚠Do not change tools during spindle rotation.

TAPER	D.Tセット Code No.	Max. Drilling Dia.	Tapping Cap.	Set Content **Code.No.** Non-Stop Chuck Holder	**NPU** Drill Chuck for ϕ1～ϕ13	**MT** Taper Sleeve
						
M T 3	**D.T3-12ANG**	ϕ32	(M)2～12 (U)1/16～1/2	**NQM3**-35(1P)	**N35**-NPU13	**N35**-MT1, 2, 3 (3P)
	D.T3-16ANG	ϕ32	(M)2～16 (U)1/16～5/8	**NQM3**-35(1P)	**N35**-NPU13	**N35**-MT1, 2, 3 (3P)
M T 4	**D.T4-12ANG**	ϕ32	(M)2～12 (U)1/16～1/2	**NQM4**-35(1P)	**N35**-NPU13	**N35**-MT1, 2, 3 (3P)
	D.T4-16ANG	ϕ32	(M)3～16 (U)1/8～5/8	**NQM4**-35(1P)	**N35**-NPU13	**N35**-MT1, 2, 3 (3P)
	D.T4-16BNG	ϕ50	(M)3～16 (U)1/8～5/8	**NQM4**-40(1P)	**N40**-NPU13	**N40**-MT1, 2, 3, 4(4P)
	D.T4-24ANG	ϕ32	(M)8～24 (U)1/2～1	**NQM4**-35(1P)	**N35**-NPU13	**N35**-MT1, 2, 3 (3P)
	D.T4-24BNG	ϕ50	(M)8～24 (U)1/2～1	**NQM4**-40(1P)	**N40**-NPU13	**N40**-MT1, 2, 3, 4(4P)
	D.T4-38BN	ϕ50	(M)14～38 (U)3/4～1 1/2	**NQM4**-40(1P)	**N40**-NPU13	**N40**-MT1, 2, 3, 4(4P)
M T 5	**D.T5-16BNG**	ϕ50	(M)3～16 (U)1/8～5/8	**NQM5**-40(1P)	**N40**-NPU13	**N40**-MT1, 2, 3, 4(4P)
	D.T5-24BNG	ϕ50	(M)8～24 (U)1/2～1	**NQM5**-40(1P)	**N40**-NPU13	**N40**-MT1, 2, 3, 4(4P)
	D.T5-38BN	ϕ50	(M)14～38 (U)3/4～1 3/8	**NQM5**-40(1P)	**N40**-NPU13	**N40**-MT1, 2, 3, 4(4P)

〔 **Note** 〕 1) When ordering D.T Set please decide model by taper shank of machine, max. tapping dia., and max. drill cap. e.g. **D.T5-38BN**
2) Please inform each Code No. when ordering as a single unit.

NON-STOP CHUCK - D.T BOXED SET

NIKKEN

☞ P.27

NON-STOP CHUCK set

D.T Set

NPU Drill Chuck
N35-NPU13, N40-NPU13

MT Taper Sleeve **MT1**

MT Taper Sleeve **MT2**

☞Please refer **REAMER SERIES catalogue**.

Chamfering tool ☞**P.32**

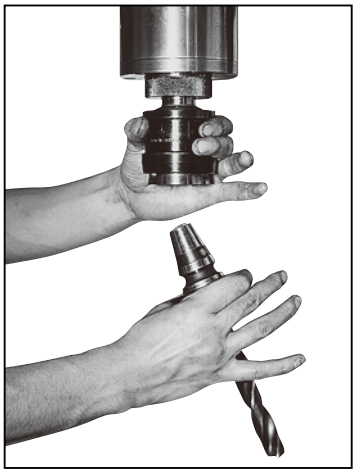
MT Taper Sleeve **MT3**

Tapper Chuck

Tapper Chuck
ZQ35-12
ZQ35-16
ZQ35-24
ZQ40-16
ZQ40-24
ZQ40-38

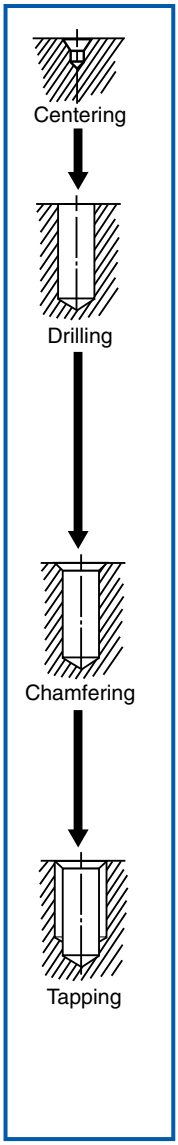
MT taper sleeve can be used as a centering tool by installing a commercial center.

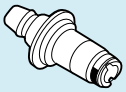
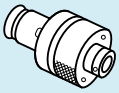
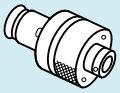
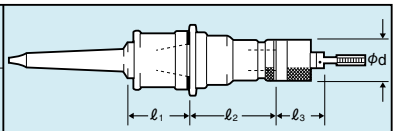
Tap Collet
M2～M38



●Tapper Chuck with safety clutch mechanism.

⚠**Do not change tools during spindle rotation.**



Set Content **Code.No.**			Tap collet outside the set (for unified, pipe etc)				
	TAPPER CHUCK	Tap Collet (JIS)					
							
				ℓ_1	ℓ_2	ℓ_3	ϕd
	ZQ35-12(1P) Float : 15mm･5	**ZKG12**-(M)4, 5, 6, 8, 10, 12 Each one (6P)	for **ZKG12** **ZKG12** -(M)2, 3 -(U)1/8～1/2 -(P)1/16, 1/8, 1/4	75	120	55	32
	ZQ35-16(1P) Float : 20mm･8	**ZKG16**-(M)4, 5, 6, 8, 10, 12, 14, 16 Each one (8P)		79	130	66	39
	ZQ35-12(1P) Float : 15mm･5	**ZKG12**-(M)4, 5, 6, 8, 10, 12 Each one (6P)		75	120	55	32
	ZQ35-16(1P) Float : 20mm･8	**ZKG16**-(M)4, 5, 6, 8, 10, 12, 14, 16 Each one (8P)	for **ZKG16** **ZKG16** -(M)3 -(U)1/8～5/8 -(P)1/8～3/8	75	130	66	39
	ZQ40-16(1P) Float : 20mm･8	**ZKG16**-(M)4, 5, 6, 8, 10, 12, 14, 16 Each one (8P)		98	130		
	ZQ35-24(1P) Float : 20mm･8	**ZKG24**-(M)12, 14, 16, 18, 20, 22, 24 Each one (7P)	for **ZKG24** **ZKG24** -(M)8, 10 -(U)1/2～1 -(P)1/4～5/8	75	134	74	46
	ZQ40-24(1P) Float : 20mm･8	**ZKG24**-(M)12, 14, 16, 18, 20, 22, 24 Each one (7P)		98	135		
	ZQ40-38(1P) Float : 0	**ZKN38**-(M)18, 20, 22, 24, 27, 30, 33, 36 Each one (8P)		98	105	64	78
	ZQ40-16(1P) Float : 20mm･8	**ZKG16**-(M)4, 5, 6, 8, 10, 12, 14, 16 Each one (8P)	for **ZKN38** **ZKN38** -(M)38 -(U)3/4～1 3/8 -(P)3/8～1	82	130	66	39
	ZQ40-24(1P) Float : 20mm･8	**ZKG24**-(M)12, 14, 16, 18, 20, 22, 24 Each one (7P)		82	135	74	46
	ZQ40-38(1P) Float : 0	**ZKN38**-(M)18, 20, 22, 24, 27, 30, 33, 36 Each one (8P)	For more information ☞ **P29, 30, 31**	82	105	64	78

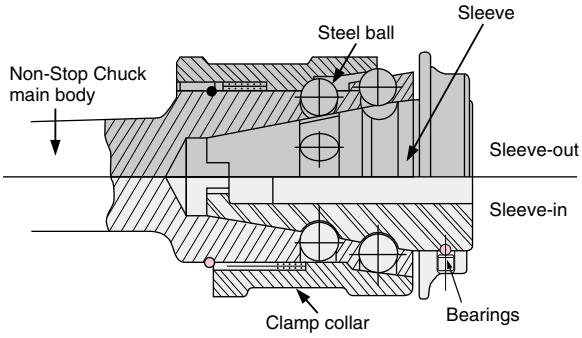
3)There are also shank shape of National Taper, NT 40, NT 50.
4)For drilling and reaming only, please use **NON-STOP CHUCK** set.

NON-STOP CHUCK - BOXED SET

NIKKEN

S.NQ

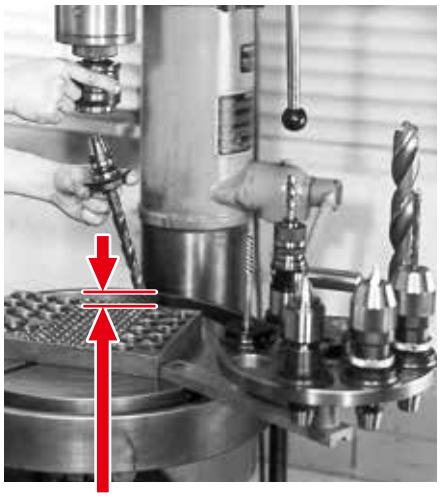
【Non-Stop Chuck internal mechanism】



◆Quick and easy tool change system.
("Non-Stop Chuck"is the trade name, do not change tools during spindle rotation)
◆Damage to the machine tool spindle can be kept to a minimum as the tool change is carried out smoothly and efficiently.
◆Only 10mm clearance between the tool and the workpiece is required for a tool change.
◆Powerful tool clamping.
◆NPU drill chuck is available.

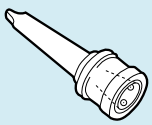
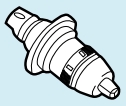
S. NQ M2 - 30N

- Internal Taper N30 / N40
- Shank Type : MT2, 3, 4, 5 : 40=NT40, 50=NT50
- Non-Stop Chuck
- Set Code No.



Only 10mm clearance between the tool and the workpiece is required for a tool change.

■Non-Stop Chuck Set Contents

TAPER	Non-Stop Chuck Set **Code No.**	Max. Drilling Dia.	Non-Stop Chuck 	NPU Drill Chuck ϕ1~13mm 	MT Taper Sleeve 
M T 2	**S.NQM2-30N**	ϕ23	NQM2-30(1P)	N30-NPU13(1P)	N30-MT1, 2 Each one(2P)
M T 3	**S.NQM3-35N**	ϕ32	NQM3-35(1P)	N35-NPU13(1P)	N35-MT1, 2, 3 Each one(3P)
M T 4	**S.NQM4-35N**	ϕ32	NQM4-35(1P)	N35-NPU13(1P)	N35-MT1, 2, 3 Each one(3P)
	S.NQM4-40N	ϕ50	NQM4-40(1P)	N40-NPU13(1P)	N40-MT1, 2, 3, 4 Each one(4P)
M T 5	**S.NQM5-40N**	ϕ50	NQM5-40(1P)	N40-NPU13(1P)	N40-MT1, 2, 3, 4 Each one(4P)
N T 40	**S.NQ 40-35N**	ϕ32	NQ 40-35(1P)	N35-NPU13(1P)	N35-MT1, 2, 3 Each one(3P)
N T 50	**S.NQ 50-40N**	ϕ50	NQ 50-40(1P)	N40-NPU13(1P)	N40-MT1, 2, 3, 4 Each one(4P)

★**N30-NPU8, N35-NPU8 and N40-NPU8** are also available.
★Jacobs Taper Adapter are also available. **e.g. N35-J6, N40-J6**

⚠ Do not change tools during spindle rotation.

⚠Caution for Tooling

General
- **Please use a NIKKEN collet for the NIKKEN chucks.**
- **Please use a NIKKEN chuck for the NIKKEN collets. may not be performed 100% using on the other makers chucks.**
- Please be careful not to inflict personal injury at your handling of cutting tools.
- Please clean the contact surface on a holder & cutting tool shank.
- Please pay attention to prevent from the rust at the storage.
- Please do not use the tooling that has scratches, damaged or rusted on its taper. This may cause false accuracy readings and reduce cutting performance.
- Please pay attention not to inflict personal injury with the broken tools or swarfs.
- Please do not modify the holders by yourselves.
- Please do not touch the tool at its rotating.
- Please do not touch the tool just after machining, it might be very hot.
- Please check if the cutting tool is held with the holder properly before the machining.

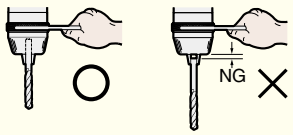
Quatation fee of the repair is always necessary whether repair or not.

MT Tapper Sleeve
- Please insert the tool shank into the bore of the holder with adjusting the tang location, and hold them with facing tool front end upwards, and hit the bottom end of the holder(pull stud end) by copper hammer hardly.
- For removal of the tool, insert a bar into tang hole and hit the bar by hammer with special care to prevent the tool from popping out.

Stub Arbor
- When setting of side cutter or metal saw onto the arbor, please adjust the location of the drive key.

Drill Chuck Adapter
- When setting drill chuck onto the arbor please put the chuck onto the arbor with adjusting the locations of male & female tapers and hit the bottom end of the holder(pull stud end) by copper hammer.

NPU Drill Chuck
- Please insert the drill shank into the bottom, and chuck the shank with the total chucking length of **NPU**.
- Please check the run-out accuracy before machining especially for the small diameter drill.
- When setting the drill onto the chuck, set the drill into the chuck and tighten the chuck ring by hand then tighten the ring by attached spanner to complete.

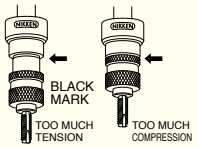


Face Mill Arbor
- Please use the bolt specified by the cutter maker.
- When setting the face milling cutter onto the arbor, insert the spigot of the arbor into the cutter bore and minimize the backlash between the drive key and the slot against the direction of rotation, then tighten the end bolt.

Tapperr Chuckck
- NIKKEN Tapper Chucks have a built-in floating mechanism which creates tension and compression of the spindle body. This mechanism prevents double threading and also ensure the synchronized movement between pitch thread of tap and Z axis feed is smooth. Please use the floating system within its limitation.

1). Too Much Tension
When tension movement exceeds the limitation, the black line will appear. In this caseincrease machine feed.

2). Too Much Compression
When machine feed is too fast for the tap thread pitch, the compression floating mechanism will work. The machine program should be modified to slow feed rate down.



- When the drilled hole diameter is too small (this is often caused by the drilling of the tough materials, extended drilling diameter is not large enough.), the tap will slip before the breakage due to torque limitter mechanism. In this case enlarge the drilled hole and do not adjust the torque setting.