

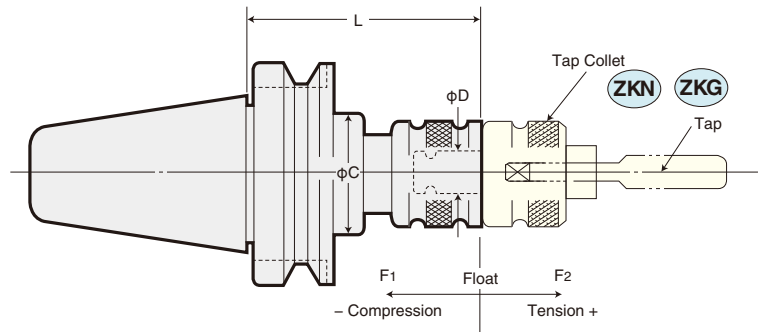
# AUTO. DEPTH CONTROL TAPPER CHUCK

**NIKKEN**

- Most suitable for tapping gas threads, blind-end threads and light alloys.
- When normal rotation of machine is stopped at specified position, the Tapper Chuck runs idle after progressing by its elongation (4mm for ZL12 type). Simply rotate the machine in the reverse direction, and the tap depth will be made uniform within a high-precision.

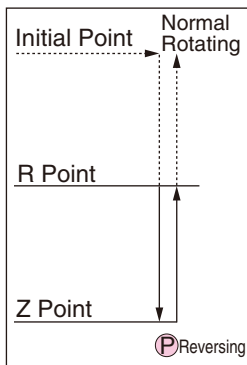


ZL



TAPER	Code No.	Tapping Capability			D	L	C	Float		Tap Collet	Weight (kg)
		M	U	P				F <sub>1</sub>	F <sub>2</sub>		
No.30	BT30-ZL 8-110*1	M 2~8	1/8~1/4	—	13	110	34	3	3	ZKN 8*1	1.5
	-ZL12-130	M 2~12	1/8~1/2	P1/16~1/4	19	130	58	5	4	ZKG12	1.9
No.40	BT40-ZL 8-120*1	M 2~8	1/8~1/4	—	13	120	34	3	3	ZKN 8*1	1.6
	(IT40)-ZL12-100	M 2~12	1/8~1/2	P1/16~1/4	19	100	58	5	4	ZKG12	1.9
	-ZL12-130					130					2.3
	-ZL16-150	M 3~16	1/8~5/8	P1/8~3/8	25	150	60	6	7	ZKG16	2.9
	-ZL24-160	M 8~24	1/2~1	P1/4~5/8	30	160	73	6	7	ZKG24	3.3
	-ZL38-190	M18~38	3/4~13/8	P3/8~1	45	190	92	8	10	ZKN38	6.0
No.50	BT50-ZL 8-130*1	M 2~8	1/8~1/4	—	13	130	34	3	3	ZKN 8*1	4.2
	(IT50)-ZL12-85	M 2~12	1/8~1/2	P1/16~1/4	19	85	58	5	4	ZKG12	3.4
	-ZL12-130					130					4.3
	-ZL16-135	M 3~16	1/8~5/8	P1/8~3/8	25	135	60	6	7	ZKG16	4.6
	-ZL24-100	M 8~24	1/2~1	P1/4~5/8	30	100	73	6	7	ZKG24	4.5
	-ZL24-142					142					5.8
	-ZL38-150	M18~38	3/4~13/8	P3/8~1	45	150	92	8	10	ZKN38	6.9

★In Case of IT40, IT40-ZL16-160 and IT40-ZL24-175 are standard.  
 ★In Case of IT50, IT50-ZL12-130, IT50-ZL24-142 and IT50-ZL38-180 are standard.  
 ★Marked \*1 ZL8 Tapper Chuck and ZK8 Tap Collet are available as semi-standard.  
 ★Please refer to P.59 (ZKG) ~P.52 (ZK) for ISO, IMPERIAL, DIN Tap Collet, P.61 (ZKG) ~P.54 (ZKN) for JIS Tap Collet, and P.63 for Long Size Tap Collet.  
 ★Centre Coolant type Tapper Chuck is also available. Please contact with us.  
 ★Flange through type Tapper Chuck is also available. Please contact with us.



## Program of Auto-Depth Control Tapper Chuck

(ZL)

- NO. 1 M03 S—; Spindle Rotating
- NO. 2 G00 X—Y—; Initial Point
- NO. 3 G00 Z—; R Point
- NO. 4 G01 Z—F—; Z Point
- NO. 5 G04 P—; Dwell
- NO. 6 M05 Spindle Stop
- NO. 7 M04 Spindle Reversing
- NO. 8 G01 Z—; R Point
- NO. 9 M05 Spindle Stop
- NO.10 G00 Z— M03; Initial Point, Spindle Normal Rotating

⚠ When using ZL Tapper Chuck, please make sure of the following program.

**G04 P** —; — Threads are made only by Spindle Rotation during Dwell. Thus, exact depth is controlled.

**M05** ; — Spindle stop.

**M04** ; — First command Spindle Reversing. Then, upward movement of Z. If upward movement of Z is commanded earlier than Spindle Reversing, down movement of tap and up movement of Z may cause breakage of tap.

**G01 Z** —; —