

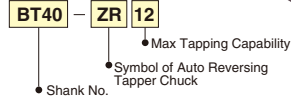
# AUTO. REVERSING TAPPER CHUCK

**NIKKEN**

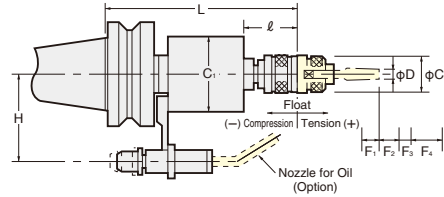


**ZR**

Explanation of the Code No.

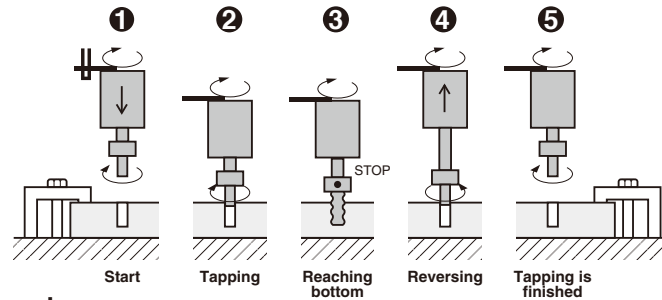
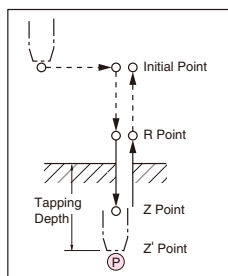


- As Self-Reversing Mechanism is built in Tapper Chuck body, this tapper is very suitable for the operation that the main spindle rotates and reverses frequently.
- Floating Mechanism: With a built in Floating Mechanism, High Accuracy Tapping Operations can be achieved.
- Tapping depth can be kept within  $\pm 0.1\text{mm}$ .



TAPER	Code. No.	Tapping Capability D	L	l	C	C1	H	Float				MAX.min <sup>-1</sup>	Weight (Kg)	Tap Collet
								F <sub>1</sub>	F <sub>2</sub>	F <sub>3</sub>	F <sub>4</sub>			
<b>No.40</b>	<b>BT40-ZR 8*1</b>	M 3 ~ 8	157	43	23	55	60	4	5	2	9	1,500	2.6	<b>ZKN 8</b>
	<b>-ZR12</b>	M 3 ~ 12	171	51	38	70		6	7	4	14	1,000	3.7	<b>ZKG12</b>
	<b>-ZR20</b>	M10 ~ 16	199	66	56	80		6	7	4	14	600	4.8	<b>ZKG16</b>
<b>No.50</b>	<b>BT50-ZR 8*1</b>	M 3 ~ 8	166	43	23	55	82	4	5	2	9	1,500	5.2	<b>ZKN 8</b>
	<b>-ZR12</b>	M 3 ~ 12	180	51	38	70		6	7	4	14	1,000	6.3	<b>ZKG12</b>
	<b>-ZR20</b>	M10 ~ 16	208	66	56	80		6	7	4	14	600	7.5	<b>ZKG16</b>

★Marked \*1 ZR8 Tapper Chuck and ZK8 Tap Collet are available as semi-standard.  
 ★Please refer P.59 for ISO, IMPERIAL, DIN Tap Collet, P.61 for JIS Tap Collet, and P.63 for Long Size Tap Collet.  
 ★Positioning Block is not included. When ordering, please advise name of M/C Builder and Model No. and so on.



## Program example of ZR Tapper Chuck

- No. 1 M03 S \_\_\_\_\_ ; Spindle Rotating  
 No. 2 G00 X \_\_\_\_\_ Y \_\_\_\_\_ ; Initial Point  
 No. 3 Z \_\_\_\_\_ ; R Point  
 No. 4 G01 Z \_\_\_\_\_ F \_\_\_\_\_ ; Z Point  
 No. 5 G04 P \_\_\_\_\_ ; Dwell: Only tap going to Z' Point  
 No. 6 G01 Z \_\_\_\_\_ F \_\_\_\_\_ ; Only tap going to R Point with reversing  
 No. 7 G00 Z \_\_\_\_\_ ;

- ★ZR tapper can be fed one block at a time. Check correct positions at the point No.3-No.5 and input correct values.
- ★Allow about 15mm for distance between Z-Z' (self-feed of the ZR tapper)
- ★Value F of No.4 is tapping self-feeding speed X 0.9.
- ★Value F of No.6 is tapping self-feeding speed X 1.1.

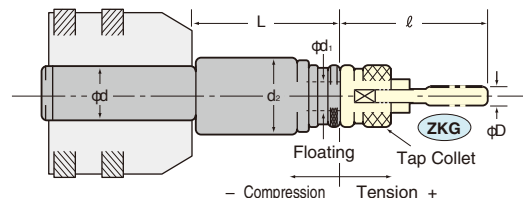
# Straight Shank TAPPER CHUCK

**NIKKEN**

- For Slim body and Ultra Smooth Tapping Operations with Float Mechanism.



**NZ**



Style	Code. No.	Tapping Capability		L	d <sub>1</sub>	d	d <sub>2</sub>	Float		Weight (kg)	Tap Collet
		M	P					Compression	Tension		
<b>32</b>	<b>NZ32-12-105</b>	M 2~12	P1/16 ~ 1/4	105~125	19	32	45	5	15	1.3	<b>ZKG12</b>
	<b>-16-125</b>	M 3~16	P1/8 ~ 3/8	125~145	25		55	8	20	2.2	<b>ZKG16</b>
	<b>-24-140</b>	M 8~24	P1/4 ~ 5/8	140~160	30		63	8	20	2.8	<b>ZKG24</b>
<b>42</b>	<b>NZ42-12- 90</b>	M 2~12	P1/16 ~ 1/4	90~125	19	42	45	5	15	2.0	<b>ZKG12</b>
	<b>-16-125</b>	M 3~16	P1/8 ~ 3/8	125~160	25		55	8	20	3.0	<b>ZKG16</b>
	<b>-24-140</b>	M 8~24	P1/4 ~ 5/8	140~175	30		63	8	20	3.6	<b>ZKG24</b>