

NIKKEN Tap Collets can be used only with NIKKEN Tapper Chucks.

- There are proper combination between Tap Collets and Tapper chucks, please use properly.
- The length of ZKG Tap Collets and ZKN Tap Collets are different, please check the length of Tap Collet before use.
- 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 limiter mechanism. In this case enlarge the drilled hole and do not adjust the torque setting.



Tapper Chuck	ZKG Tap Collet	ZKN Tap Collet	ZMK Tap Collet
	ZKG12,16,24	ZKN8,38,65 (ZKN12,16,24)	ZMK8,12,16,24
Z Tapper Chuck	Suitable	Suitable	Unsuitable**
NZ Straight Shank Tapper Chuck			
ZL Auto.Depth Control Tapper Chuck			
ZM Conventional Tapper Chuck			
ZQ Tapper Chuck for Non-Stop Chuck			
ZR Auto.Reverse Tapper Chuck	Unsuitable	Unsuitable	Suitable
ZH Tap Holder for Synch.Tapping			
ZT Tapper Chuck for NC Lathe			

** : ZMK Tap Collet can be used for a Multi Tapper Chuck or an exceptional case.

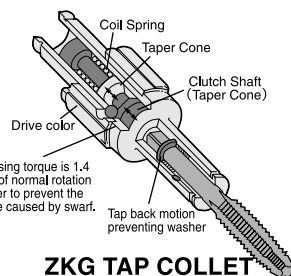
1.ZKG Tap Collet (Torque Limiter Mechanism built-in)

1). Insertion of Tap into Tap Collet

One touch operation - Push front end of Tap Collet and insert Tap down to the bottom. Insertion of Gas Tap into ZKG Tap Collet for Gas Tap is same operation as ZKN Tap Collet.

2). Setting Torque

Mechanical setting torque is not adjustable. It is already set at 60% of tap breakage torque, however due to internal torque limiter mechanism, ZKG Tap Collet responds sensitively against tapping torque. ZKG Tap Collet also has a mechanism which increase reversing torque to 1.4 times that of normal rotation. **ZKG Tap Collet with Higher Torque Setting** is available for tough material such as stainless. Example of code No.:**ZKG12-4HT**
Adjustment, alteration for torque limiter and the repair for ZKG Tap Collet is also available.



ZKG TAP COLLET

2.ZKN Tap Collet (Torque Limiter Mechanism built-in)

1). Insertion of Tap into Tap Collet

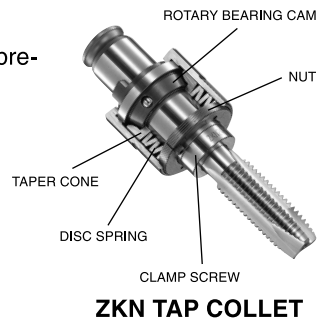
Rotation of Tap is driven by square shank of Tap. The Tap is then held by a clamp screw to avoid it slipping down.

- ① Insert Tap into Tap Collet down to the bottom. Twist the Tap in order to locate the brass washer, ensure it locates in the square hole. Once this has been achieved, further changing of Tap should be trouble-free.
- ② Tighten clamp screw with L Wrench provided.

2). Adjustment of Setting Torque

Basically it's not necessary to adjust setting torque since each Tap Collet has a pre-adjusted torque set at 60% of Tap breakage torque for each size. However if you need to adjust, the following routine must be adhered to;

- ① Take note of original number on the dial ring.
- ② As the lock bolt is screwed into taper nut underneath dial ring, tap its head slightly after loosening the lock bolt.
- ③ Turn the dial ring clockwise to increase setting torque, and counter clockwise to reduce torque, the graduation on the dial ring is just giving you an indication of how much to adjust. It is recommended to adjust two graduations each time.
- ④ After adjustment, tighten lock bolt to fit taper nut.



ZKN TAP COLLET

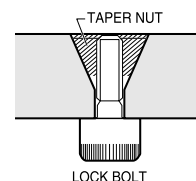
3.ZMK Tap Collet (No Torque Limiter Mechanism built-in)

1). Insertion of Tap into Tap Collet

Rotation of Tap is driven by square shank of Tap. The Tap is then held by a clamp screw to avoid it slipping down.

- ① Insert Tap into Tap Collet down to the bottom. Twist the Tap in order to locate the brass washer, ensure it locates in the square hole. Once this has been achieved, further changing of Tap should be trouble-free.
- ② Tighten clamp screw with L Wrench provided.

Torque Limiter Mechanism is a safety clutch mechanism, when tapping torque arises more than setting torque, a clutch will go to off and tap is free to prevent tap broken.



4. Storage

Please wipe/clean all dust/coolant and spray the oil to prevent from the rust at the storage.



- Quotation fee of the repair is always necessary whether repair or not.

This manual is for basic instruction and information for safety use of our product. Please contact with us for the further details.

Please note that we could not take a responsibility of the accidental damage on our product which is modified the specifications by the customer without our approval.

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