

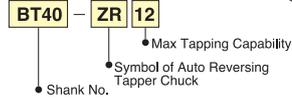
AUTO. REVERSING TAPPER CHUCK

NIKKEN

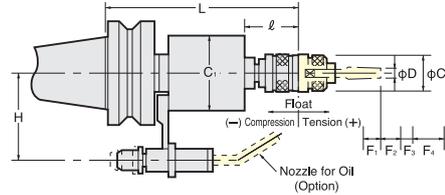


ZR

Explanation of the Code No.

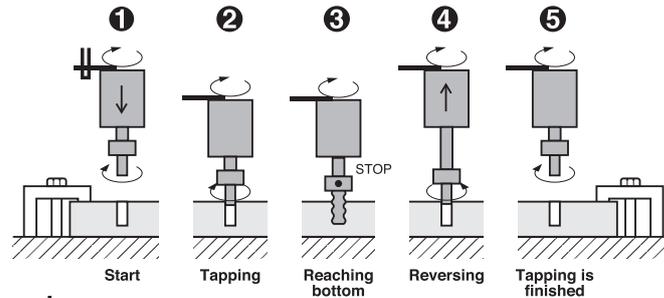
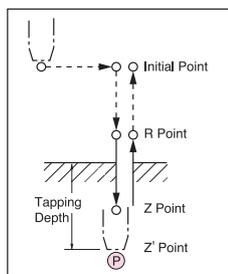


- As Self-Reversing Mechanism is built in Tapper Chuck body, this tapper is very suitable for the operation that the main spindle rotates and reverses frequently.
- Floating Mechanism: With a built in Floating Mechanism, High Accuracy Tapping Operations can be achieved.
- Tapping depth can be kept within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



TAPER	Code. No.	Tapping Capability D	L	l	C	C1	H	Float				MAX.min ⁻¹	Weight (Kg)	Tap Collet
								F1	F2	F3	F4			
No.40	BT40-ZR 8*1	M 3 ~ 8	157	43	23	55	60	4	5	2	9	1,500	2.6	ZKN 8
	-ZR12	M 3 ~ 12	171	51	38	70						1,000	3.7	ZKG12
	-ZR20	M10 ~ 16	199	66	56	80						600	4.8	ZKG16
No.50	BT50-ZR 8*1	M 3 ~ 8	166	43	23	55	82	4	5	2	9	1,500	5.2	ZKN 8
	-ZR12	M 3 ~ 12	180	51	38	70						1,000	6.3	ZKG12
	-ZR20	M10 ~ 16	208	66	56	80						600	7.5	ZKG16

★Marked *1 ZR8 Tapper Chuck and ZK8 Tap Collet are available as semi-standard.
 ★Please refer P.51 for ISO, IMPERIAL, DIN Tap Collet, P.53 for JIS Tap Collet, and P.55 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.

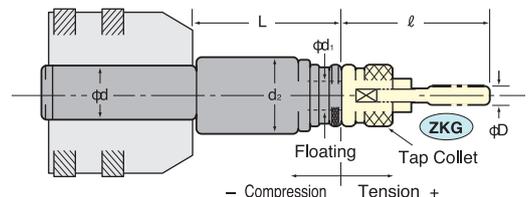
Straight Shank TAPPER CHUCK

NIKKEN

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



NZ



Style	Code. No.	Tapping Capability		L	d1	d	d2	Float		Weight (kg)	Tap Collet
		M	P					Compression	Tension		
32	NZ32-12-105	M 2~12	P1/16 ~ 1/4	105~125	19	32	45	5	15	1.3	ZKG12
	-16-125	M 3~16	P1/8 ~ 3/8	125~145	25		55	8	20	2.2	ZKG16
	-24-140	M 8~24	P1/4 ~ 5/8	140~160	30		63	8	20	2.8	ZKG24
42	NZ42-12- 90	M 2~12	P1/16 ~ 1/4	90~125	19	42	45	5	15	2.0	ZKG12
	-16-125	M 3~16	P1/8 ~ 3/8	125~160	25		55	8	20	3.0	ZKG16
	-24-140	M 8~24	P1/4 ~ 5/8	140~175	30		63	8	20	3.6	ZKG24