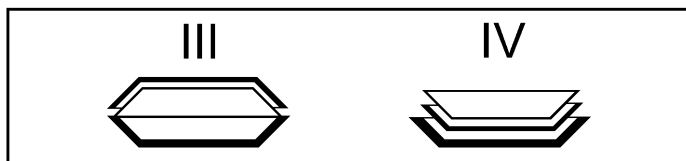


Example:

In the case of thread M12 with insert GE34-MT2, the setting is at number 4 for spring setting IV. In this case the knurled nut should be set to number 4 at the second rotation.



Installation position of disc springs

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05/10/F-SF/GE-EN-B

**Operating Instructions
Tapping Adaptors GE for Quick Change Chucks****1. Product features**

- The quick change chuck SF is used in the machine spindle as a basic chuck.
- Using the quick change adaptors E for drilling and countersinking, PE for reaming and GE for tapping, you can quickly and easily change the machine over from one drill hole to another or from drilling to tapping.
- The tool adaptors E have a female Morse taper with ejection slot. In addition to the female Morse taper, the tapping adaptors feature an adjustable safety slip clutch which allows you to make any torque adjustment required within the designated cutting range by slight repositioning.
- The drills and countersinks in the tool adaptors and the taps in the tapping adaptors are clamped using split sleeves as per DIN6329 or DIN6328 if they have a cylindrical shaft, or, if they have a Morse taper shank, they are held directly in the adaptor.
- Thanks to its simple and uncomplicated design this quick change system is one of the most competitive priced systems on the market, despite its high practical value and long lifetime.

2. Applications

The tool adaptors and tapping adaptors are generally used together with the quick change chuck on vertical drilling and boring machines with right and left hand spindle rotation.

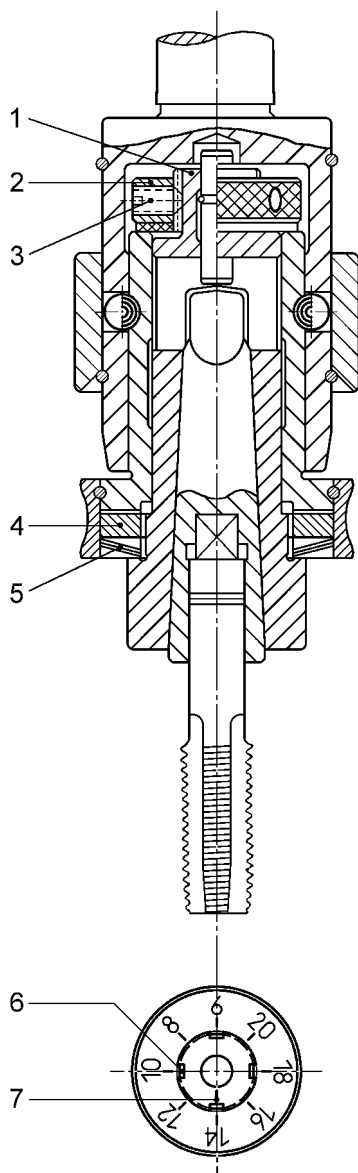
They are also used on lathes with a reversible work spindle in the tailstock or turret.

3. Versions

The quick change chuck is available in five different sizes with MT 1 to MT 5 chucks. There are 15 quick change adaptors for drilling and countersinking, depending on the basic chuck and with various internal Morse tapers from MT 0 to MT 5. The tapping adaptors come in 11 different versions from the size of the quick change chuck with SF26-MT2 for different cutting ranges from M1-M10 to M22-M39.

Please ask for a copy of our catalogue.

4. System structure and setting the safety slip clutch



If, for example, you want to cut a thread M12 in steel 70-2 with tap insert GE34-MT3, the setting for this according to the table on page 3 is IV/12. IV refers to the position of the built-in disc springs (5) and 12 is the setting number on the knurled nut (2).

First, undo the adjusting screw (3) to screw back the knurled nut (2) connected to the threaded peg (1) until you can feel that the clutch disc (4) is only just still engaged.

Now turn the knurled nut (2) in a clockwise direction, set the stamped number 12 to the marking range (7) and then secure the knurled nut. Please ensure that the adjusting screw (3) engages in one of the four grooves (6) and is not resting on the threaded peg.

When determining the settings for materials with high or low rigidity, select the next setting number up or down. The very simple determination must, however, be carried out with a cleanly ground tap. When the setting is correct, the safety clutch is activated when the tap runs aground or is about to break off due to blunt cutting.

You can also control the torque setting by inserting or removing the disc springs (5) and by turning the built-in clutch disc (4). It is recommended that you dismantle and oil the adaptors every now and then.

5. Settings for tapping adaptors GE26, GE34 and GE46

The settings refer to steel processing St. 70-2.

Thread	GE26		GE34		
	MT 1	MT 2	MT 1	MT 2	MT 3
M 3	III/3		III/3		
M 4	III/4	III/4	III/4	III/4	
M 5	III/5	III/5	III/5	III/5	
M 6	III/6	III/6	III/6	III/6	IV/6
M 8	III/8	III/12	III/8	III/8	IV/8
M 10	III/10	III/14	III/10	III/12	IV/10
M 12		III/4*		IV/4*	IV/12
M 14		III/5*		IV/5*	IV/14
M 16		III/8*		IV/6*	IV/16
M 18					IV/18
M 20					IV/20

Thread	GE46			GE60		
	MT 2	MT 3	MT 4	MT 3	MT 4	MT 5
M 4	III/4					
M 5	III/5					
M 6	III/6	IV/6				
M 8	III/8	IV/8		III/8		
M 10	III/10	IV/10		III/10		
M 12	III/12	IV/12		III/12		
M 14	III/14	IV/14		III/14	IV/18	
M 16	III/16	IV/16	IV/16	III/16	IV/18	
M 18		IV/18	IV/18	III/18	IV/20	
M 20		IV/20	IV/20	III/20	IV/22	IV/22
M 22			IV/22		IV/24	IV/24
M 24			IV/24		IV/27	IV/27
M 27			IV/27		IV/30	IV/30
M 30			IV/30		IV/14*	IV/20*
M 33			IV/33		IV/18*	IV/22*
M 36					IV/14*	IV/24*
M 39					IV/18*	IV/27*

Please note that for the settings marked with a * the setting number for the second rotation of the knurled nut must be aligned with the zero mark.