

REVERSING TAPPING HEADS



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GUARANTEED DEPTH CONTROL WITHIN ± 0.004 "

FEATURES:

- **Chatter-free clutch** has positive engagement which allows for a smoother, more accurate tapping operation and more rapid reversal
- Guaranteed **Depth Control** to ± 0.004 "
- **Radial Float** is SELF-CENTERING to compensate for hole center misalignment to 0.005"
- Unique Double Spring Mechanism produces **Automatic Feed** and **Cushion Drive**. There are two springs for the feed and two springs for the reversal. Each set gives you double smoothness for ULTRA accurate tapping applications (not possible with this type of tapping head in the past)
- **Pre-set Torque Control** permits easy operation of tap brake torque control
- **FOR DEPTH CONTROL:**

Tapping Depth	2.00"
- Clockwise Expansion (B)	-0.14"
Hold Machine spindle travel	1.86"

Set your machine travel to feed up to 1.86", then stop your machine travel, the tap holding spindle will continue to feed out (self-feed) up to 0.14" (clockwise expansion B), the drive clutch will go into the neutral zone and stop automatically. We guarantee this Depth Control within ± 0.004 " (0.1 mm).

- For NC machine, set torque as high as possible within the safe limits of the tap. NC machine Cutting Feed equals (tap pitch x spindle r.p.m). Reverse Feed equals 2 x (tap pitch x spindle rpm)



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Model	Mount Jacobs Taper No.	Tapping Cap. in Steel	Standard Collet Code No.	Rec. Max. Speed	Gear Ratio	Clockwise Compression (A)	Expansion (B)	Code No.	Price \$
YSN7	J-6	No. 0 - 1/4" M2 - M7	354-032 (No.0 - 10)	1,500 rpm	1:1.6	0.197"	0.14"	354-002	460.80
			354-034 (No.10 - 1/4)						
			354-036 (No.8 - 1/4)						
YSN12	J-6	No.8 - 1/2" M4 - M12 1/8 NPT	354-038 (1/4 - 1/2)	1,000 rpm	1:1.75	0.197"	0.16"	354-012	560.90
			354-042 (5/16 - 5/8)						
			354-044 (9/16 - 3/4)						
YSN20	M20	5/16 - 3/4" M8 - M20 1/8, 1/4 NPT	354-044 (9/16 - 3/4)	600 rpm	1:1.7	0.236"	0.24"	354-022	653.10
			354-044 (9/16 - 3/4)						

RUBBER FLEX COLLET

Capacity	Code No.	Price \$
No. 0 - 10	354-032	38.40
No. 10 - 1/4	354-034	38.40
No. 4 - 1/4	354-036	38.40
1/4 - 1/2	354-038	38.40
5/16 - 5/8	354-042	38.40
9/16 - 3/4	354-044	38.40



SHANKS FOR 354-022

Capacity	Code No.	Price \$
Morse Taper 3-M20	354-062	39.20
Morse Taper 4-M20	354-064	39.20
R8-M20	354-066	54.90

CLAMP, BOLT AND NUT

Model	Code No.	Price \$
YSN12	354-075	27.10
YSN20	354-080	25.50

