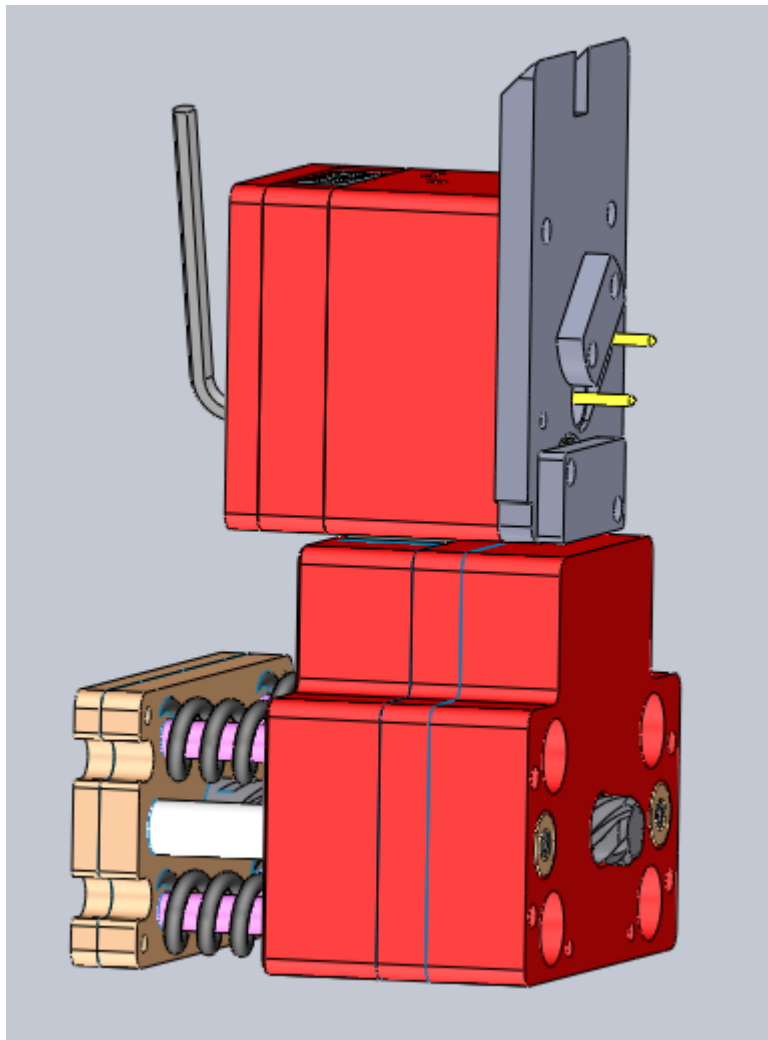


IN DIE TAPPING UNITS
FT500D 系列模内攻牙机
USER MANUAL
用户手册



FASTOP FOR FOXCONN

您已经购买 FASTOP 模内攻牙机。You already buy FASTOP in-die tapping units
感谢您对我们的信任，同时希望能达到您的要求。Thank you for having confidence in our
equipment, look forward to meet your need.

您在打开包装后，请第一时间阅读此手册，它将为您提供服务指南和操作指导。

Please read the manual first time when you open packing. It will provide service guide and
operation guide for you.

此手册根据课题分成几个部分，方便您快速查阅。

The manual cover the following several parts in order to look up quickly for you

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- 一. 建立模内攻牙机 Plan in-die tapping units
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- 三. 安装模内攻牙机 assemble in-die tapping units
- 四. 交换丝锥 exchange tap
- 五. 丝锥润滑冷却 micro-lubricating for tap
- 六. 定期保养 regular maintenance

一. 建立模内攻牙机 Plan in-die tapping units

客户 customer: FOXCONN

型号 model: FT500D 系列

丝锥 tap: 6-32

丝锥标准 tap standard: 美制(公制)the U.S.system(the Metric system)

制品材料 Material: secc

材料厚度 Material Thickness: 1mm

翻边后牙孔总深度 tapping depth: 2.3mm

翻边向下 screw hole turnout downward

冲床行程 Press stroke: 250mm (并适用于行程为 120 mm 以上的所有冲床)

上死点丝锥顶点到针位板面的高度 Tap on the dead plate surface peak to the height of ZWB
position: 9.0mm 丝锥移动量 Taps range of movement: 8mm

总移动空间 Total movement space : 11.5mm

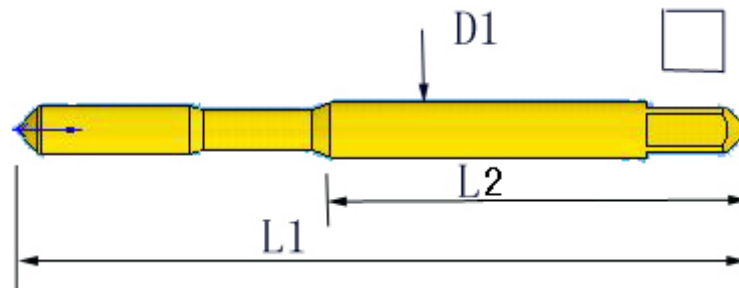
手动轮每圈丝锥移动量: Manual a circle round each, Taps range of movement: 0.81mm

冲床速度 Press speed: SPM

冲压最高速度 Max.speed: 行程为 250mm 的冲床最高冲压速度可达 50SPM

行程为 120mm 的冲床最高冲压速度可达 100SPM

丝锥尺寸:



Dimension	L1	□	L2	D1
6-32	48	3.2	21.59	4.0

二. 准备模内攻牙机设备 PREPARE IN-DIE TAPPING UNITS

1. 模内攻牙机传动体(图 1)

检查传动体，确认驱动装置是否能够上下运动顺畅。螺杆和导柱部位加润滑油 (图 1)

Die tapping machines within the transmission body (Fig. 1)

Check the transmission, confirmed the drive is able to move up and down smoothly. Screw and lubricating pillar parts (Fig. 1)

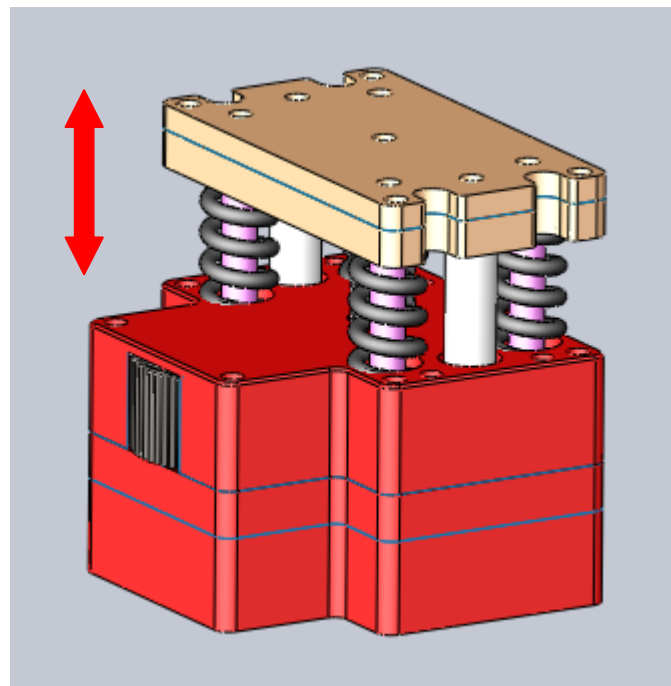


图 1 Fig. 1

2. 检查固定左、右导轨，喷油嘴 (图 2)

喷油嘴油雾是否能够正常喷出，并试装导轨无干涉。

Check the fixed left and right rails, injectors (Fig. 2)

Check whether the normal spray mist nozzle, and test equipment rails without interference.

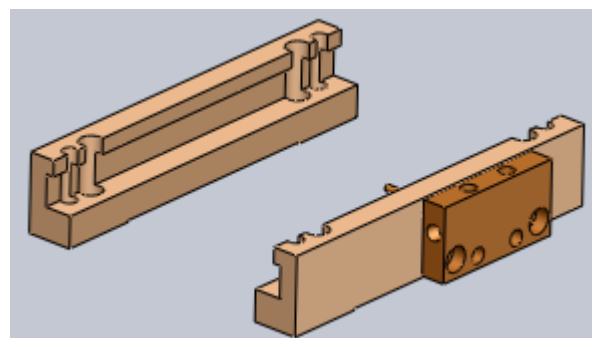


图 2 Fig. 2

3. 检查攻牙机锁紧装置(图 3)

检查锁柄是否能够顺利旋入锁杆。

Check to the teeth of the locking device(Fig. 3)

Check whether the lock handle the lock rod screw smoothly.

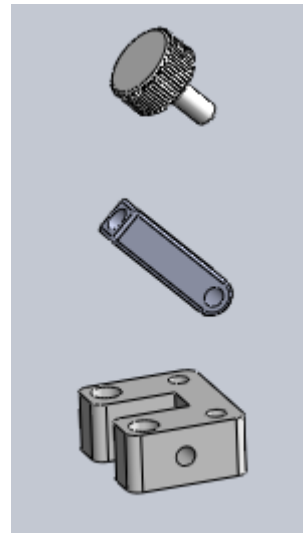


图 3 Fig. 3

4. 模内攻牙机攻牙体(图 4)

用手旋转接传轮，旋转灵活，用卡尺确认丝锥顶点凸出针位板底面 9mm.

Body of in-die tapping units(Fig. 4)

Then passed by hand wheel rotation, rotation and flexible, with the caliper confirm tap the underside of the vertex protruding ZWB 9mm.

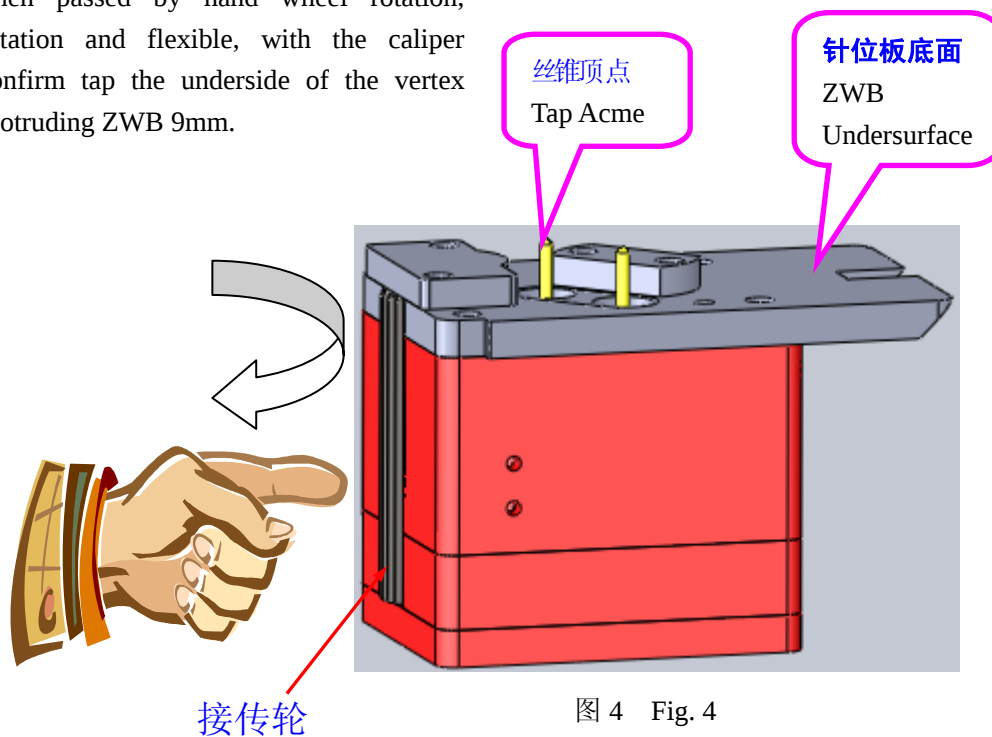
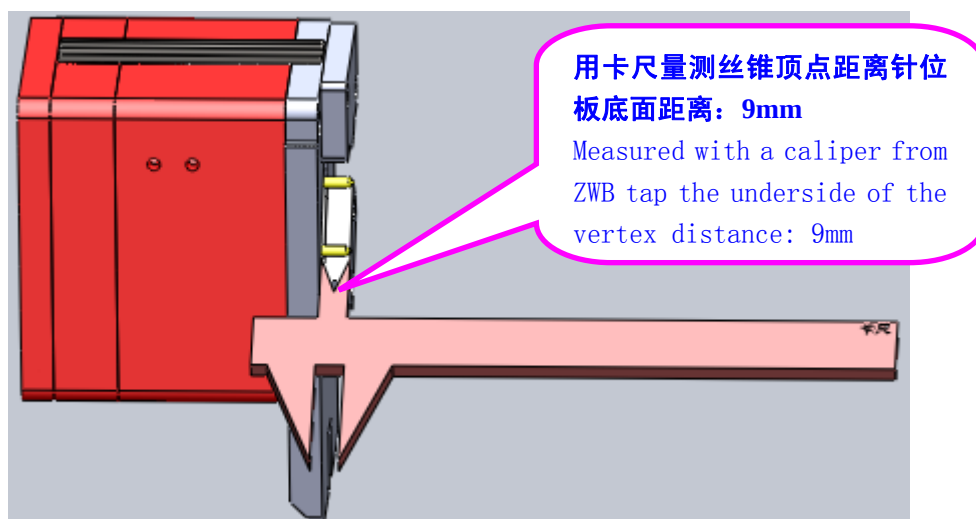
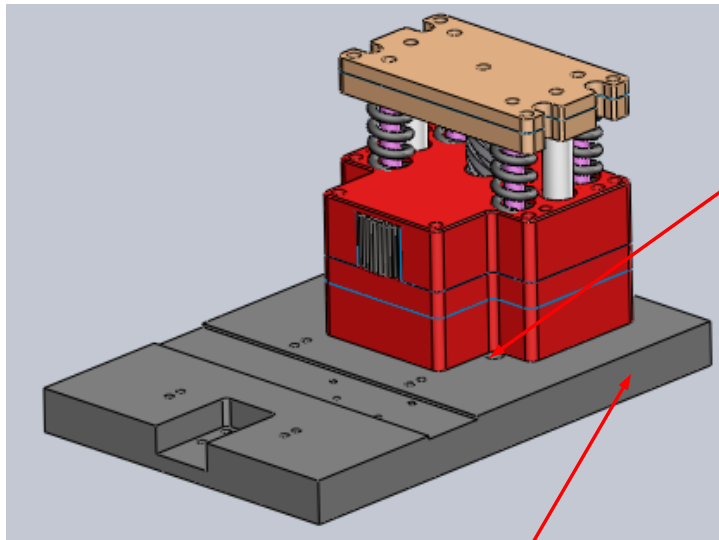


图 4 Fig. 4



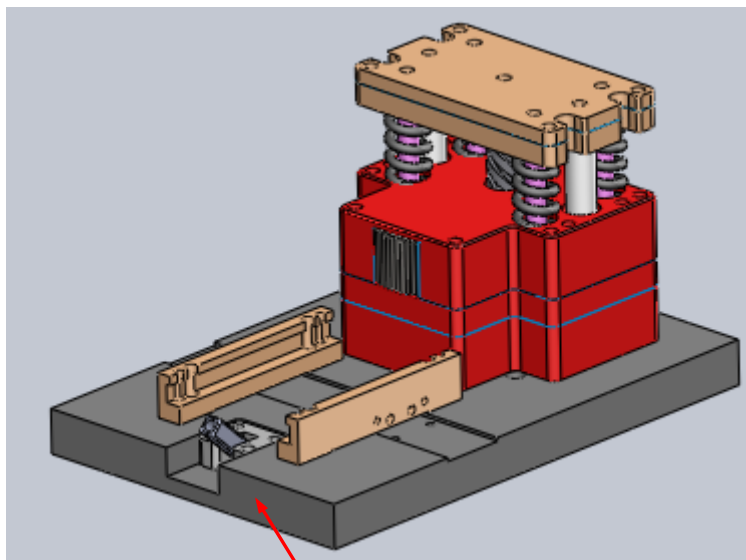
三. 安装模内攻牙机



后端为模板，此处示意

Ø10 销钉孔位置

1. 安装攻牙机传动体。
将传动体安装于模板上，传动体靠紧两侧Ø10 销钉位置后，用螺丝将传动体锁死，并使螺杆处于最上方。
Tapping Machine drive to install the body
The drive mounted on the template, the drive pin Ø 10 on both sides of the body try to be location, drive the body with screws locked and make the screw at the top.



前端为浮升板，此处示意

2. 安装导轨和锁紧装置
将导轨和锁紧装置按图示装与浮升板上。
Mounting rails and locking devices
Rail and locking devices will be installed as shown with the floating or on-board

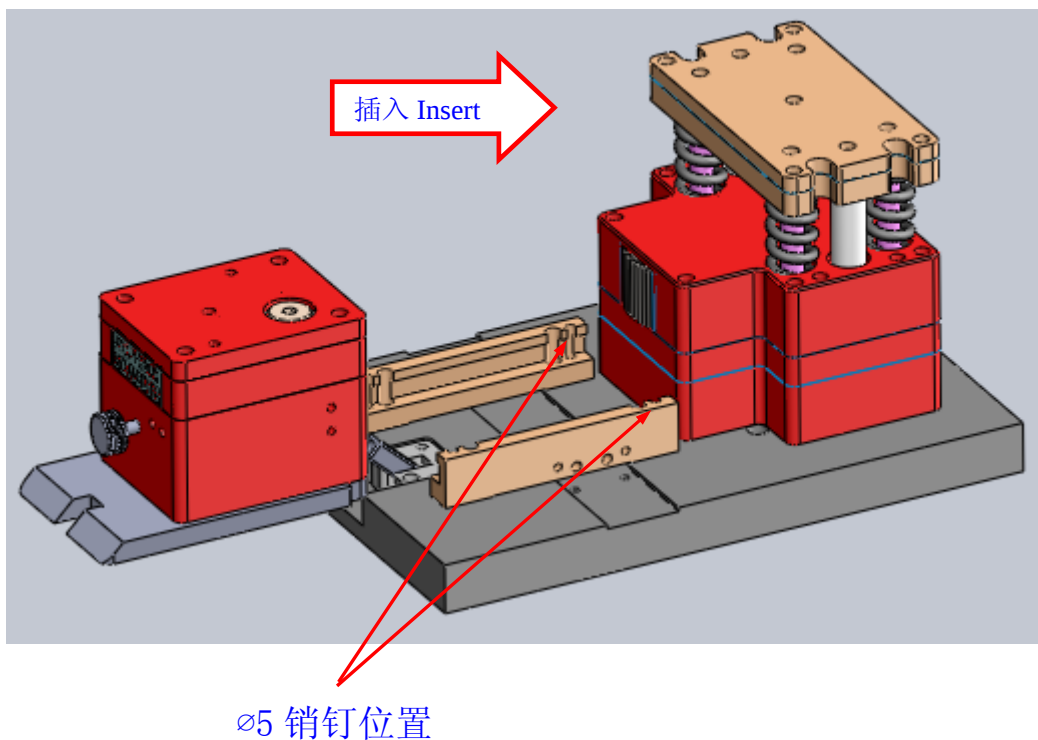
注意：

左右导轨不能装反

Note: The left can not hold against rail

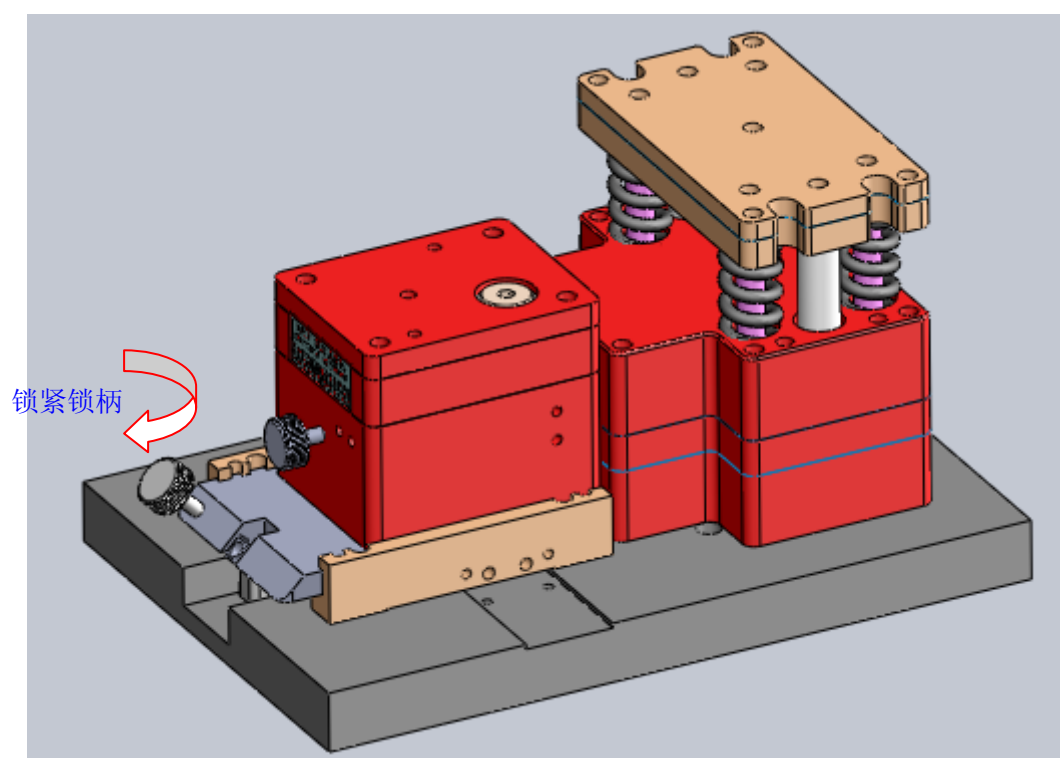
3. 将攻牙体沿导轨插入，两侧靠紧 $\varnothing 5$ 销钉

Tapping into the body along the rail, both sides try to be $\varnothing 5$ pin

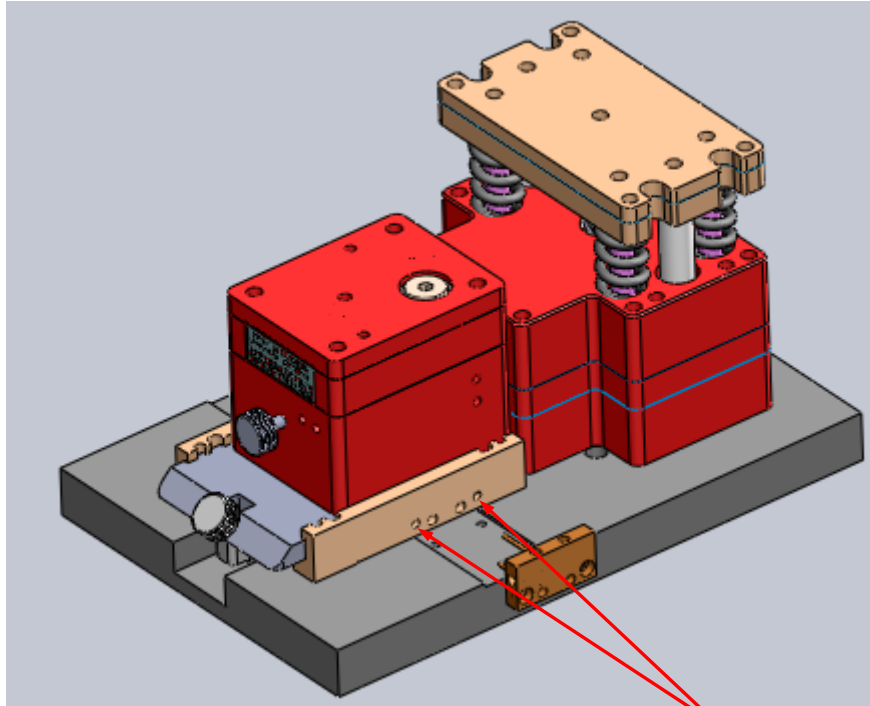


4. 将锁柄锁紧

Tighten the lock handle

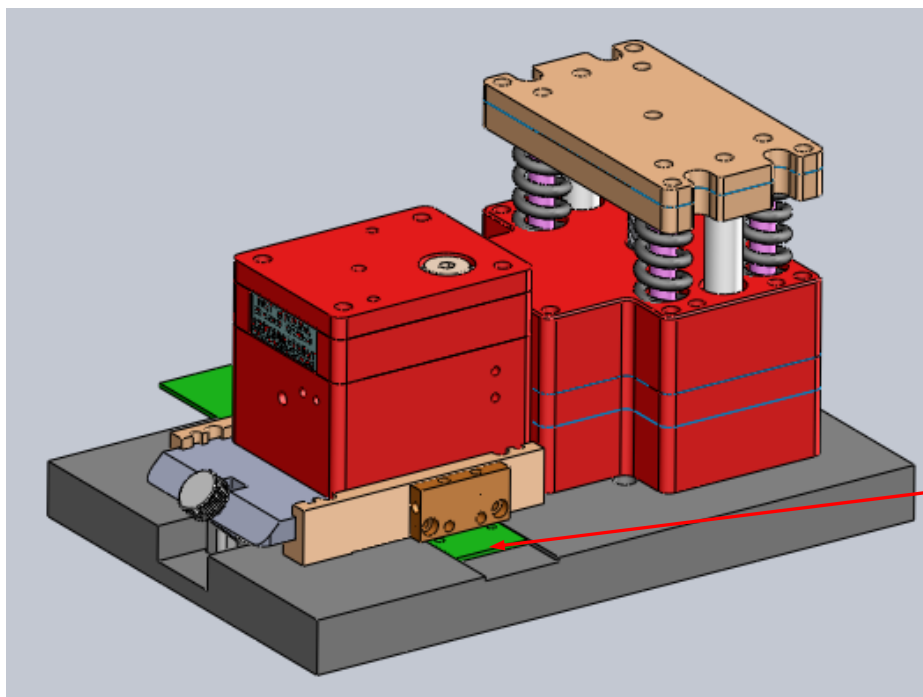


- 6 将喷油嘴对准螺丝孔位置，锁紧
Align the screw hole nozzle position,
locking



螺丝孔位置

注意事项 ATTENTIONS



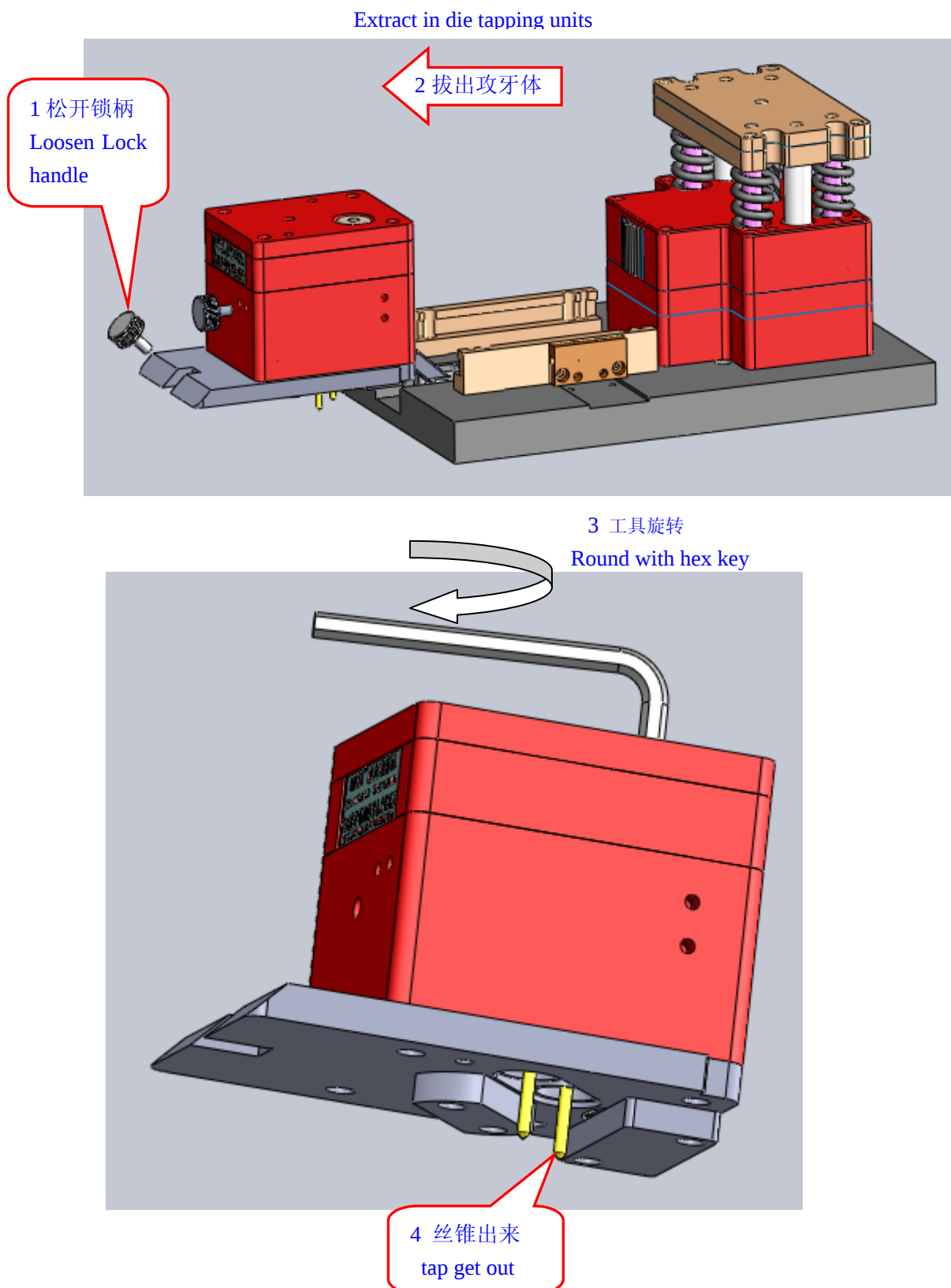
送料开始时，丝锥高度，距离工件安全距离 0.5~1 毫米

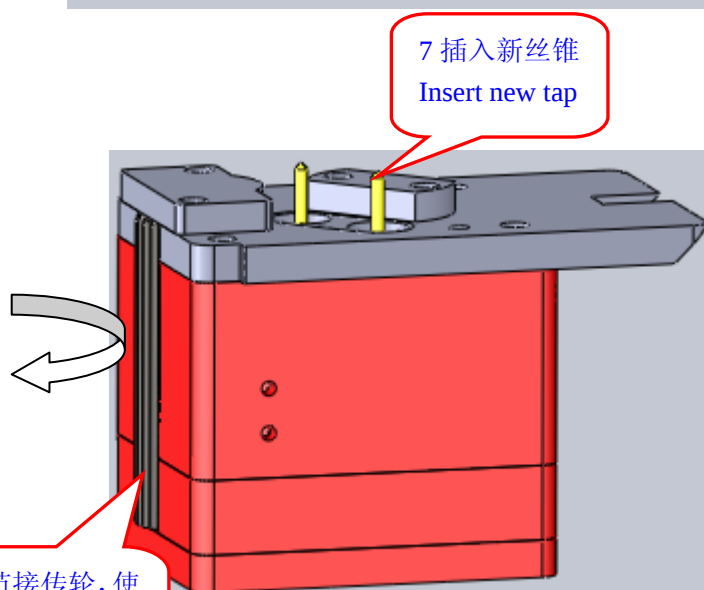
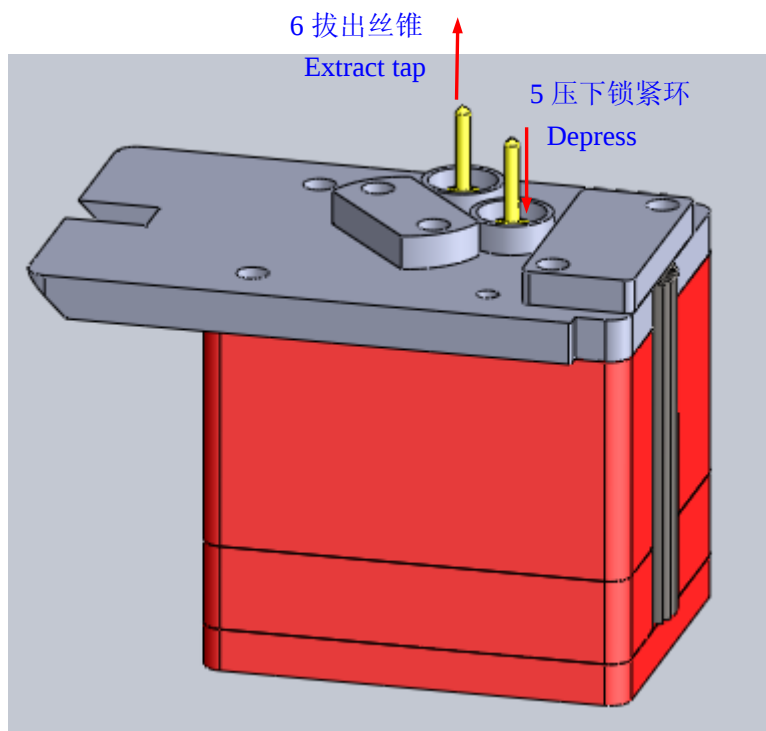
Safety margin before tapping is 0.5~1mm between components

四. 交换丝锥

松开锁柄，将攻牙体拔出。使用工具将丝锥旋转到最外，取出丝锥，然后旋转接传轮，并确认丝锥的顶点突出针位板表面 9MM。插入攻牙体，锁紧锁柄。

Loose lock handle will pull out tapping the body. Rotated using a tool to tap into the outside, remove the tap, and then rotate then passed round, and confirm tap the surface of the apex prominent ZWB 9MM. Tapping into the body, the lock locking handle.

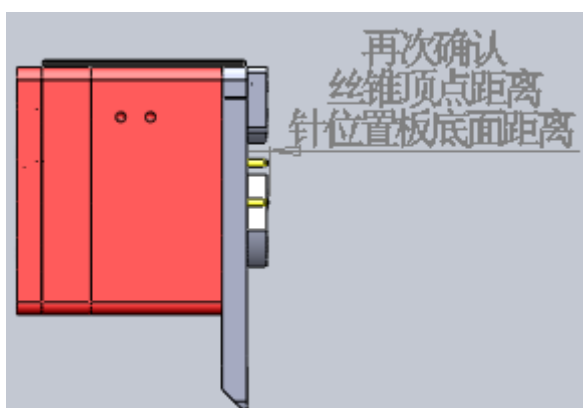




8 调节接传轮,使
丝锥顶点凸出
ZWB 低面 9MM

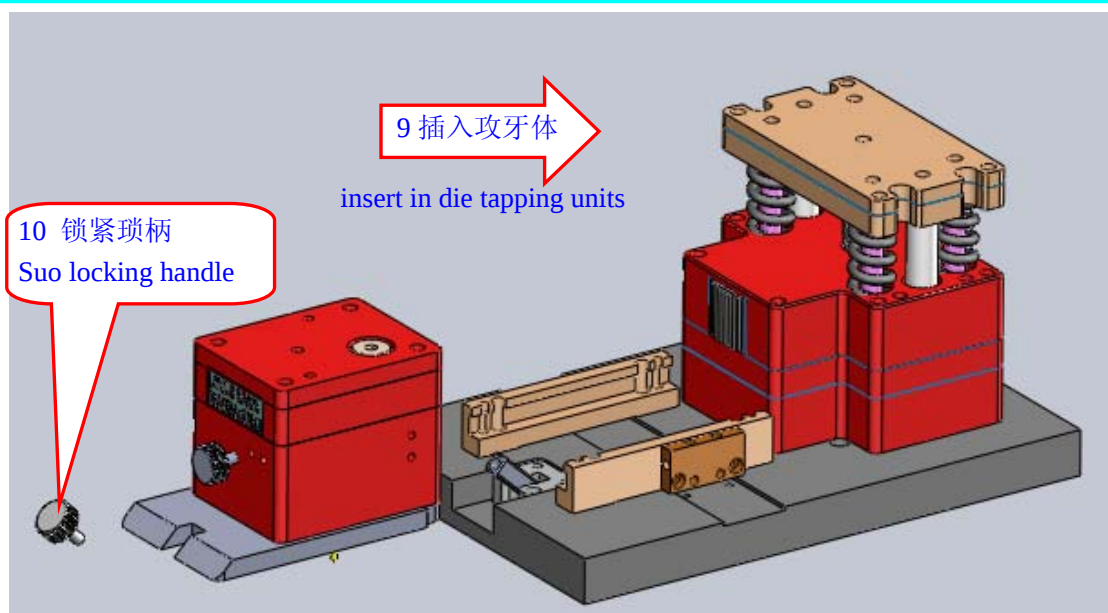
调节接传轮可以调
整螺丝贯穿量大小
及丝锥高度

Then adjust the screws
pass through the volume
wheel to adjust the
height of the size and
Taps



注意: 插入新丝锥的同时, 一定要再
次测量丝锥顶点距离针位板端面的距
离: 9MM。

Note: Insert a new tap at the same time,
we must again measure the distance of
the tap needle position board end vertex
distance: 9MM。



五.丝锥润滑冷却 MICRO-LUBRICATING FOR TAP

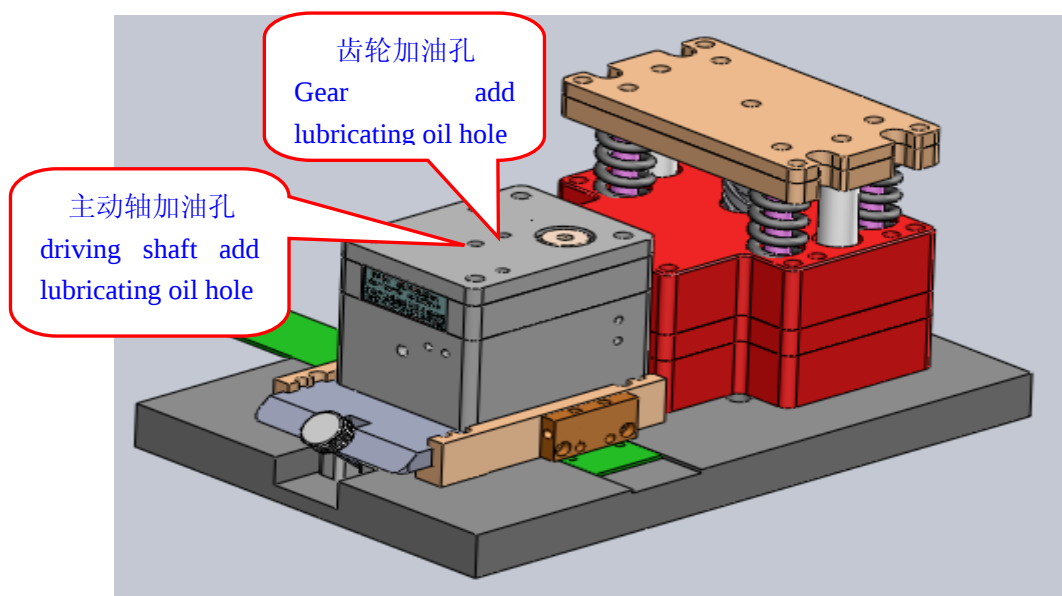
丝锥上应保有润滑油,冷却润滑气压 0.2~0.3Mpa

tap must be have lubricating oil .

it provides lubrication by spraying micro-droplets carried in an airflow which also provides a cooling blast, pressure is between 0.2~0.3Mpa

六.定期保养 REGULAR MAINTENANCE

1.螺杆、导柱保持清洁,每班加油一次.Keep clean of drive screw and guide post stem, and add lubricating oil each shifts



2.丝锥定期清洗. Clean tap regular

3.轴承保养更换, 每年更换一次 Bearing maintenance and replacement, Replaced once a year

4.主动轴、齿轮每班加油一次 Driving shaft and Gear add lubricating oil each shift

东莞拓朴机电设备有限公司

电话 Tel: 0769-86108152/86108153

传真 Fax: 0769-86108151