

PNEUMATIC 4 SPINDLES NUT TAPPING MACHINE

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MODEL : LS-NT-19B-4TF

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Operation manual

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I. Preface

Our company researches exclusively "Four Shaft Pneumatic Tapping Machines." It has provided the industry with a highly effective, high quality production tool. Nevertheless, based on the spirit of "excellence," We continuously research and develop to meet the needs of the industry in automatic production. This decreases the cost and increases the profit.

Thank you for wisely choosing our "FT" system "Four Shaft Pneumatic Tapping Machine" to add to your production line. This users' guide contains sections about specifications, installation procedures, operating methods, safety matters and maintenance tips.

Before using the machine, please read the Users' Guide carefully. Keep it in a safe Place. If you use the machine properly, and give it the proper care, We assure that the machine will function at its best.

II. Description of Capacity.

1. Special features of the machine, sizes, functions, etc., are listed in the this User's Guide. Please read it.

2. Special Capacity

The capacity sizes in the manual are the standard sizes of our production. If you require a special capacity, Please contact us.

III. To install the .

1. Tips for moving, (essential points). Please reference (Fig-1) for moving the machine. Use a steel chain to wrap around the swing arm shaft set of Hopper A according to the arrow as indicated, and be careful that the machine weight is within the steel chain's load capacity. When lifting, be careful not to scratch the paint to keep the machine looking nice.

2. Installation.

a. Machine's style and size.

b. Motor(HP), air exhaust (L/MIN), lubricant(L)

Type of Machine	FT11B	FT19B	FT24B	FT33B
Motor (HP)	5.3	9.5	13.5	23
Air Exhaust	200	210	260	400
Lubricant	300	400	450	600

IV. Lubricating System

1. Gear Motor Lubricating System

2. Agitating Structure Lubricating System

The oil in the gap between rolling wheel and swing arm evaporates easily. It needs to be oiled frequently.

3. Ball Bearing Unit Lubricating System

4. Thrust Ball Bearing Lubricating System

5. Service Unit Lubricating System

1. Dropping Rate: The lubricator in the service units is based on the Venturi principle. It gets the oil from the oil reservoir into the dropper, which then drops into a nozzle. After vaporizing, it will disperse into the air to lubricate

the valve and the cylinder. The dropping rate can be adjust by adjusting the screw. The following is the dropping rate chart (unit=drops/minute)

機械型式	FT11B	FT19B	FT24B	FT33B
油滴量	1-2	1-2	1-3	1-4

2. Adding lubricating oil to the oil reservoir.

Shut off the main motor and the cylinder. Make sure they are completely stopped.

Loosen the quick connector and lower the pressure to "0". Check again.

Turn the oil reservoir to the left (counter-clockwise) to bring the oil reservoir down.

After adding the proper amount of oil to the reservoir, push it up and turn it to the right (clockwise).

Make sure it is tight before connecting to the air intake quick connector. Then adjust to the proper pressure, then turn on the main motor and the cylinder.

Air Pressure System

1. Air Pressure System Circuit Diagram

2. Air Pressure System Pictorial Diagram

VII. User's Guide for control function

A. Control panel description: (Please see Fig. 6)

1. Ampere meter : (only for displaying motor's electrical current usage.)
 - a. to assess whether main motor is normal or overloading.
 - b. When tap gradually wears out or seems to be abnormal, the electrical current will increase. When it reaches the 'caution' range, it will need to be replaced. Be sure to take care of it.
 - c. Chart of machine models, their horsepower and electric current limits.

Note: This chart is only for reference, The actual loading is according to the label on the motor.

Type of Machine	機械型式	FT-19B
Main Motor(HP)	主馬達 (HP)	2
Full Load	滿載電流 220V (A) 380V	5.9 3.2

2. Counter: To calculate the number of movements of the cylinder.
 - a. On Fig. 6-2-a, on the upper left, there is a button. push to reset the counter to 0.
 - b. On Fig. 6-2-b, on the upper right, there is a square switch. It will lock the number when you push it to the left.
3. Motor(on/off) Switch.
 - a. light will be on when the main motor starts to operate.
4. Motor Stop.
 - a. push to stop.
5. Cylinder Operating Switch
 - a. Before pushing cylinder ON button, be sure to turn on the motor.
 - b. Push the ON button to operate the cylinder.
6. Power ON/OFF Switch
 - a. Turn right to start, turn left to stop.
7. Manual / Auto Switch
 - a. turn left to operate manually, turn right to operate automatically.

NOTE: automatic function includes: a. automatic shut-off when supply is empty. b. automatic shut-off when supply is obstructed. Manual operation does not have this function.
8. Oil filter ON. OFF
 - a. Turn right (ON) to start filter. Turn left(OFF) to stop.
 - b. This switch is a resered switch to install filter motor. Please connect to the lower part of the control box where U5, V5, and W5 wires connect.
9. Oil Pump ON/OFF Switch
 - a. Turn right to start. Turn left to stop.
10. Hopper ON/OFF Switch
 - a. Turn right to start. Turn left to stop.
11. Full Stop (emergency stop)
 - a. When there is an emergency, push the FULL STOP and then the four main