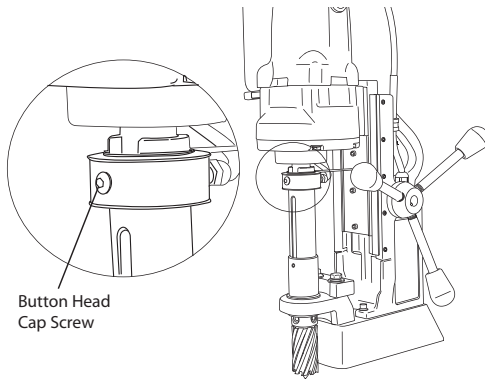


TAPPING ATTACHMENT KIT 10937

For use on Hougen Drill Models 10914 & HMD914

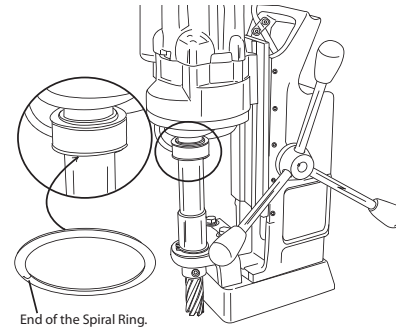
The 40341 Kit is used to install a Tapping Attachment onto a 10914 & HMD914 spindle. These machines use 2 mounting styles. One style incorporates a set screw with an access window in the Brass Coolant Inducer (see diagrams A1-A3). The other style uses a retaining ring around the base of the Brass Coolant Inducer (see diagrams B1-B3).

(A1)



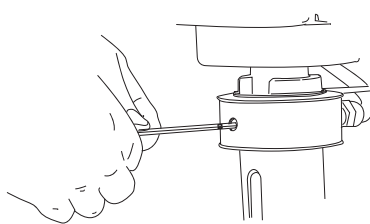
Locate and remove the 1/4-28 X 1/4 Button Head Cap Screw from the Coolant Inducer with a 5/32 Hex Wrench.

(B1)



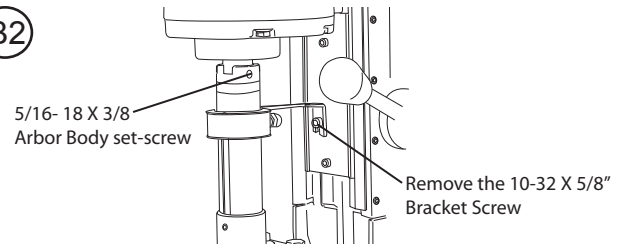
Locate the end of the Spiral Retaining Ring under the Brass Coolant Inducer, and with a pick, pull the end down. Once started, pull the rest of the Retaining Ring down the Arbor Body.

(A2)



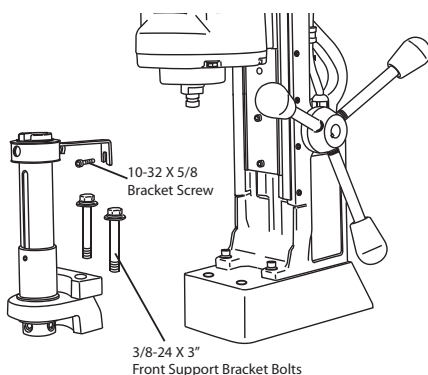
Rotate the Arbor Body so the 5/16-18 X 3/8 set screw inside, aligns with the hole in the Coolant inducer. Insert the 5/32 Hex Wrench and turn the inside set screw 1 full turn counterclock-wise or until loose.

(B2)



Remove the 10-32 X 5/8" Bracket Screw with a 5/32 Hex Wrench and slide the Brass Coolant Inducer down. Turn the 5/16-18 X 3/8 Set Screw until loose and slide the Arbor Body OFF the Motor Spindle.

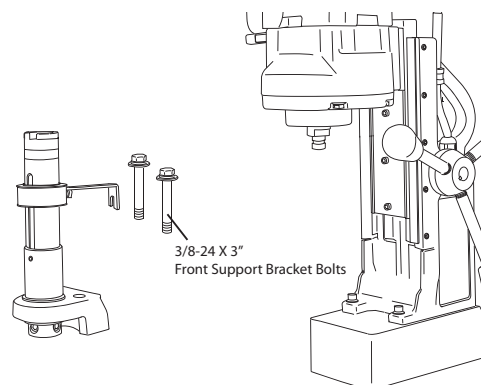
(A3)



Locate and remove the 10-32 X 5/8" Bracket Screw with a 5/32 Hex Wrench. Remove both 3/8-24 X 3" Hex Bolts from the Front Support Bracket using a 9/16 wrench. Now the entire Arbor Body Assembly can be removed.

Continued on next page.

(B3)

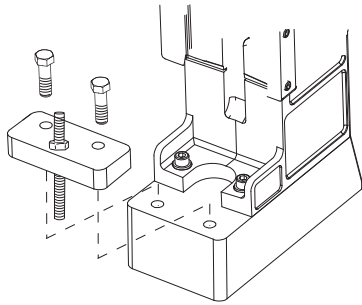


Remove both 3/8-24 X 3" Hex Bolts from the Front Support Bracket using a 9/16 wrench. Now the entire Arbor Body Assembly can be removed.

Continued on next page.

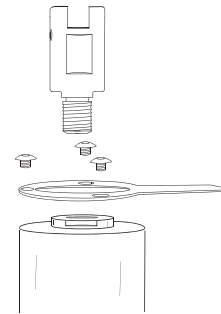
NOTE: Installation of the Tapping Attachment is the same on either system covered by the first page.

4



Install the 1/4-20 X 2-1/2 Set Screw (02432) and 1/4-20 Lock Nut (10859) into the Stop Block as shown. Mount the Stop Block Assembly to the Magnet with the supplied 3/8-24 Hex Bolts and tighten with a 9/16 Wrench.

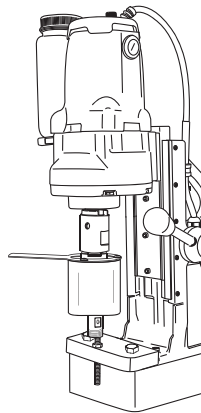
5



Install the Stop Arm to the Tap-Matic Assembly with the 3 Button Head Screws supplied with the Tap-Matic. Thread the Adapter (40226) into the top of the Tap-Matic Assembly and install the 5/16-18 X 3/8 Set Screw (40256) into the side of the Adapter.

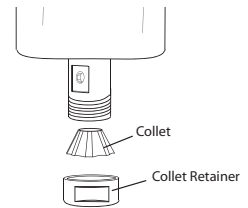
6

Slide the Adapter and Tap-Matic Assembly up onto the Motor Spindle at the base of the Motor making sure the Spindle sits down in the notch of the Adapter. While holding the Assembly up, tighten the 5/16-18 X 3/8 Set Screw at the top of the Adapter.



7

Select the correct size Collet for the Tap that will be used and install it into the bottom of the Tap-Matic.

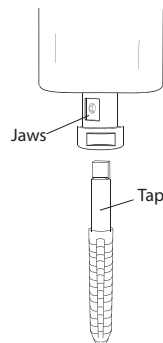


Collet 10807 - Taps #10 thru 1/2"
Collet 10808 - Taps 1/2" thru 3/4"

Thread the Collet Retainer onto the Tap-Matic holding the Collet in place. Do not tighten the Collet Retainer until the next step.

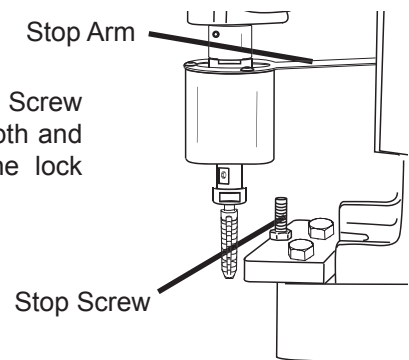
8

Install the appropriate Tap up thru the Collet Retainer until the flat sides of the Tap are in the Jaws of the Tap-Matic. Tighten the Jaws so the Tap is held. Then tighten the Collet Retainer with the supplied wrenches.



9

Adjust the long Stop Screw to the appropriate depth and lock in place with the lock nut.



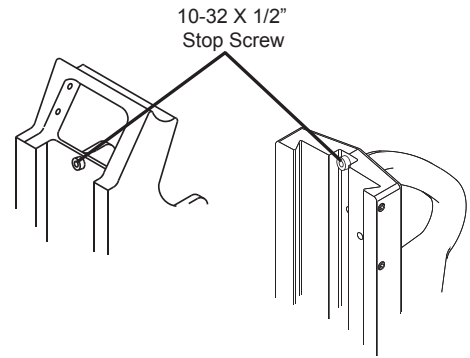
CAUTION

When the Tap is working down into the material the Stop Arm will rotate and make contact with the Drill Housing on the opposite side that is shown. When the Tap direction changes and the Tap is working out of the material it will rotate again to the opposite side. Keeps hands clear of the Stop Arm while operating.

Continued on next page.

With either system, verify that the 10-32 X 1/2" Stop Screw (10648) is in place and tight.

Your 3-Jaw Chuck is now installed. Select the proper twist bit for your application and follow Operating Procedures for the Hougen Magnet Based Drill you are using.

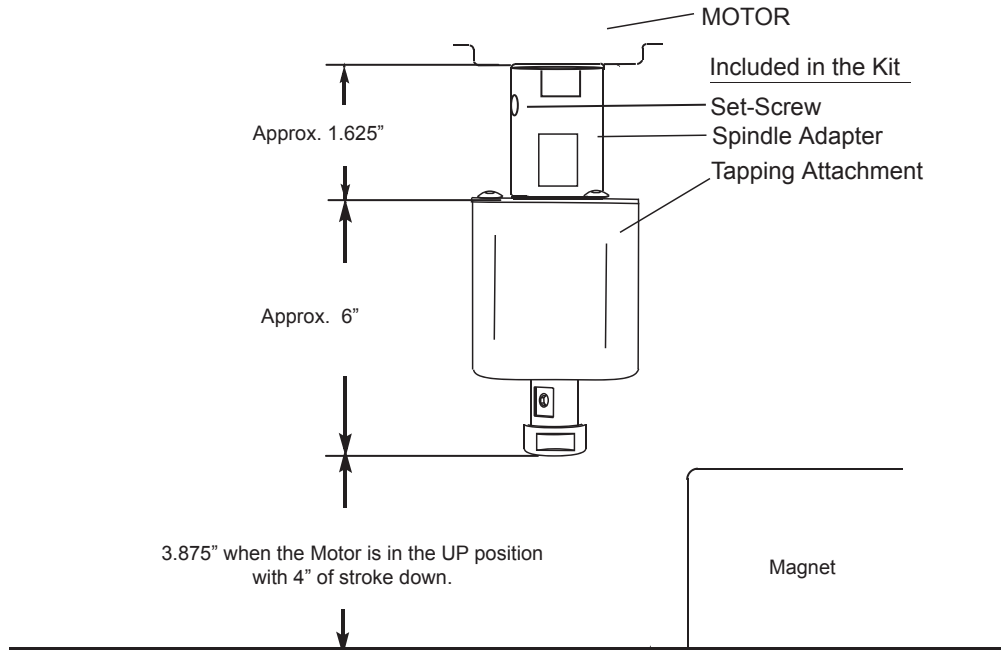


Operating the Tapping Attachment

1. Produce the Correct size hole for the Tap you are using.
2. Install the Tap-Matic unit using the instructions above.
3. Position the machine so the Tap is centered and just above the hole.
4. Applied Slick-Stik Lube or a alternative oil appropriate for tapping.
4. Lock the magnet in position and verify the Tap is still centered over the hole.
5. Start the Motor using the Operating Instruction in the Operators Manual.

6. Rotate the Feed Handles down until the Tap pulls thru the material. Feed handles are not used to drive the Tap down.
7. When the Tap-matic Assembly makes contact with the Stop Screw the gears will disengage and the Tap will stop turning.
8. While rotating Feed Handles to bring the Tap-Matic UP, the Tap will engage and turn counter-clockwise.
9. Rotate the Feed Handles until the Tap is clear of the work piece and push the Motor OFF button.

10937 TAPPING ATTACHMENT KIT



HOUGEN AUTHORIZED WARRANTY REPAIR CENTERS

ACC Machinery Co Inc.
747 Grand Avenue
Phoenix AZ 85007
602-258-7330

Fastenal Services Co.
4025 Finch Rd.
Modesto CA 95357
209-548-5000

Kenbil Service Center
2900 Adams St #B-14
Riverside CA 92504
951-689-6633

Caltool Industrial
470 Hester Street
San Leandro CA 94577
510-729-0600

Aviation Industrial Supply
3900 Ulster Street
Denver CO 80207
303-355-2391

Jossam Tool Repair
411 Burnham Street
East Hartford CT 06108
860-290-9044

Colony Hardware Supply
15 Stiles Street
New Haven CT 06512
203-466-5252

Fastenal Services Co.
6445 Fulton
Atlanta GA 30336
404-346-4520

Idaho Tool & Equip
452 Caldwell
Nampa ID 83651
208-465-7533

Fastenal Services Co.
5851 Guion road
Indianapolis IN 46254
317-280-2502

Fastenal Services Co.
9911 Woodend Road
Edwardsville KS 66111
913-422-8221

Allied Sales & Service
1508 River Oaks Rd West
Jefferson LA 70123
504-734-9566

N.H. Bragg & Sons
90 Perry Road
Bangor ME 04401
207-947-8611

Hougen Manufacturing
3001 Hougen Drive
Swartz Creek MI 48473
810-635-7111

Westbrook Engineering
23501 Mound Road
Warren MI 48091
586-759-3100

Oxygen Service Repair
1111 Pierce Butler Rte.
St. Paul MN 55104
651-644-7273

Fastenal Services Co.
4730 N. Service Drive
Winona MN 55987
507-453-8280

Ceekay Repair Center
5835 Manchester Ave
St. Louis MO 63110
314-644-3500

Mid-South Welding Supply
505 51st. Ave
Meridian MS 39307
601-483-9331

Fastenal Services Co.
4110 Premier Dr. #102
High Point NC 27265
336-841-6555

A&A Industrial Supplies Inc.
251 Meacham Ave
Elmont NY 11003
516-437-0114

Awisco NY Corp.
55-16 43rd. Ave
Maspeth NY 11378
718-786-7788

Hanes Supply Repair Cntr.
10 Cairn Street
Rochester NY 14611
716-826-2636

Ace Tool Repair
2201 Wantagh Ave.
Wantagh NY 11793
516-783-8899

Awisco NY Corp.
20c Gleam Street
West Babylon NY 11704
631-643-1308

Cincinnati Electrical Repair
2023 Elm Street
Cincinnati OH 45210
513-621-2183

Pennsylvania Tool Sales
625 Bev Road
Youngstown OH 44512
330-758-0845

Wilbanks Repair Center
5532 S. 94th East Ave
Tulsa OK 74145
918-627-8445

Quimby Welding Repair
7926 NE Killingsworth St
Portland OR 97209
503-221-1100

Fastenal Services Co.
1225 Mid Valley Drive
Jessup PA 18434
570-307-6555

Boyer Machinery
2280 Wyandotte Road
Willow Grove PA 19090
215-657-2242

Fastenal Services Co.
1432 Macarthur Drive
Carrollton TX 75007
972-446-4389

Arcmaster Repair Center
301 Woodrow Ave.
Fort Worth TX 76105
817-531-8101

Power Tool Service
3718 Polk Street
Houston TX 77003
713-228-0100

ATS Repair Center
2780 West Directors Row
Salt Lake City UT 84104
801-972-3182

Arcet Equipment Co.
3416 Odd Fellows Road
Lynchburg VA 24501
434-847-1234

Pro Tool Repair
2238 James
Bellingham WA 95225
360-733-7343

American Equip Services
22418 72nd. Ave. South
Kent WA 98032
253-395-9947

Fastenal Services Co.
9725 47th. Ave SW
Lakewood WA 98489
253-983-0015

Universal Repair
1611 Boylston
Seattle WA 98122
206-322-2726

Jensen Equipment
27 w23015 Roundy Dr
Pewaukee WI 53072
262-547-5548

CANADA

Celtic Ind. Tool & Repair
5736-103 A Street
Edmonton Alberta
Canada T6H 3J5
780-431-0970

Power Tool Clinic
#105 19835-56 Ave.
Langley British Columbia
Canada V3A 3Y1
604-530-3550

Anchor Products
1810 Dublin Ave
Winnipeg Manitoba
Canada R3H 0H3
204-633-0064

Hougen Canada, Inc.
309 Nash Road North
Hamilton Ontario
Canada L8H 7P4
905-573-9088

Outiltech Orleans, Inc.
4975 Rue Rideau Local 180
Quebec City Quebec
Canada G2E 5H5
418-877-7776

Brunswick Ind. Supply
136 Savoie Dr.
Moncton, New Brunswick
E1C 8H5
Phone: 506-859-1303

New Zealand

Trade Tools Ltd
23-27 Olive Road
Penrose, Auckland
Phone: (09) 525-8900
Fax: (09) 525-3524

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IMATECH
Distribution Center
Unit 7, 6 Gladstone Road
Castle Hill NSW 2154
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