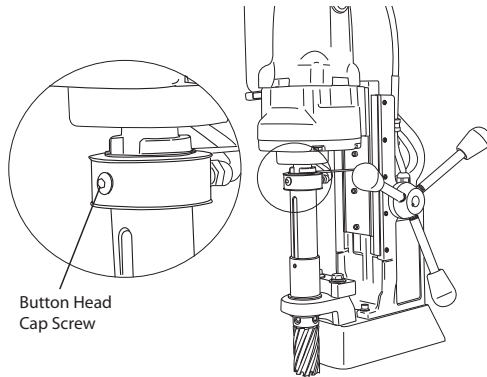


TAPPING ATTACHMENT KIT 10937

For use on Hougen Drill Models 10914 & HMD914

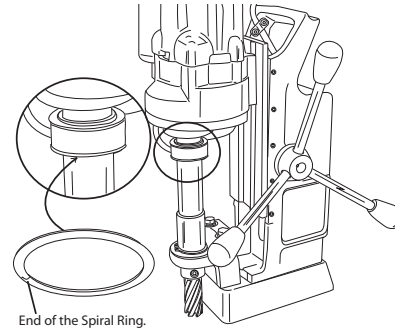
The 40341 Kit is used to install a Tapping Attachment onto a 10914 & HMD914 spindle. These machines use 2 mounting styles. One style incorporates a set screw with an access window in the Brass Coolant Inducer (see diagrams A1-A3). The other style uses a retaining ring around the base of the Brass Coolant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

A1



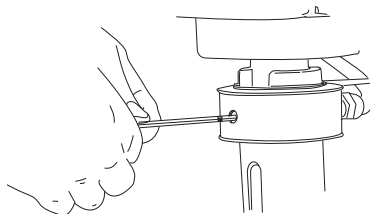
Locate and remove the 1/4-28 X 1/4 Button Head Cap Screw from the Coolant Inducer with a 5/32 Hex Wrench.

B1



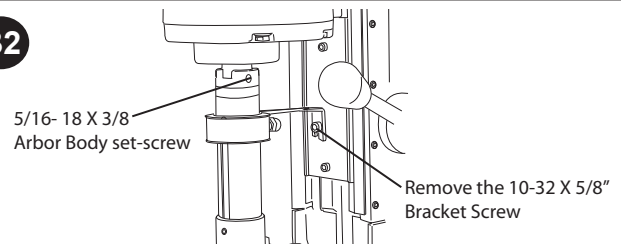
Locate the end of the Spiral Retaining Ring under the Brass Coolant Inducer, and with a pick, pull the end down. Once started, pull the rest of the Retaining Ring down the Arbor Body.

A2



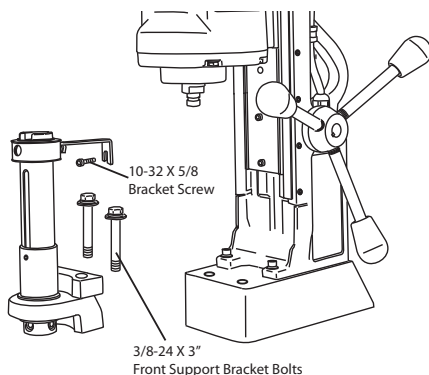
Rotate the Arbor Body so the 5/16-18 X 3/8 set screw inside, aligns with the hole in the Coolant inducer. Insert the 5/32 Hex Wrench and turn the inside set screw 1 full turn counterclock-wise or until loose.

B2



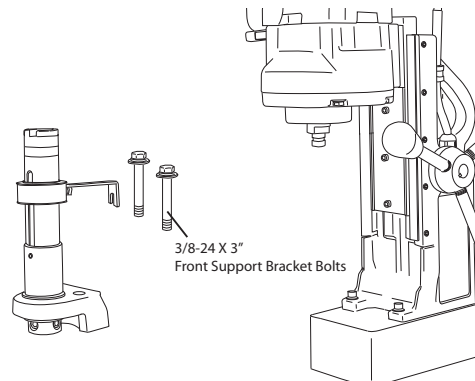
Remove the 10-32 X 5/8" Bracket Screw with a 5/32 Hex Wrench and slide the Brass Coolant Inducer down. Turn the 5/16-18 X 3/8 Set Screw until loose and slide the Arbor Body OFF the Motor Spindle.

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.

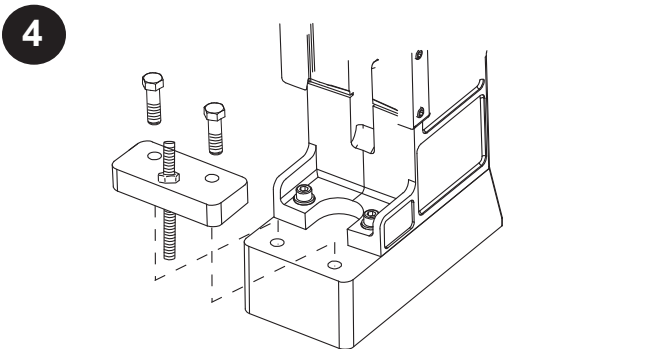
B3



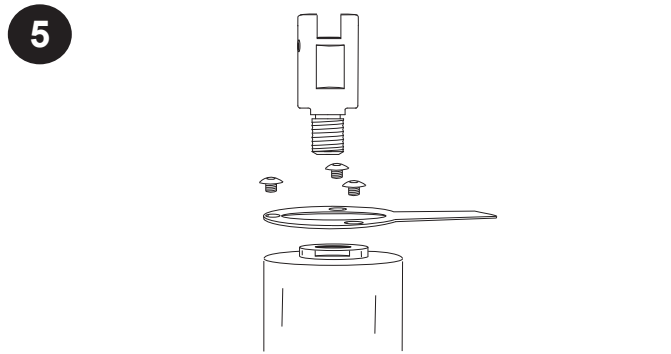
Remove both 3/8-24 X 3" Hex Bolts from the Front Support Bracket using a 9/16 wrench. Now the entire Arbor Body Assembly can be removed.

Continued on next page

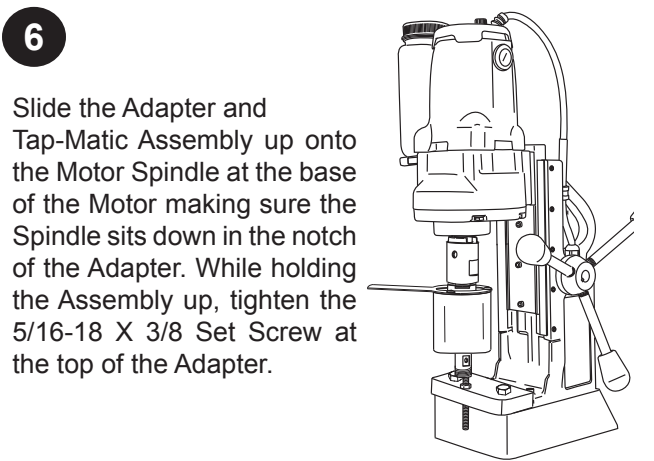
NOTE: Installation of the Tapping Attachment is the same on either system covered by the first page.



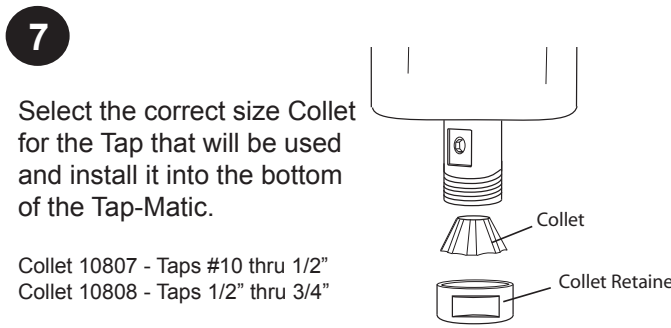
Install the 1/4-20 X 2-1/2 Set Screw (02432) and 1/4-20 Lock Nut (10859) into the Stop Block as shown. Mount the Stop Block Assembly to the Magnet with the supplied 3/8-24 Hex Bolts and tighten with a 9/16 Wrench.



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.



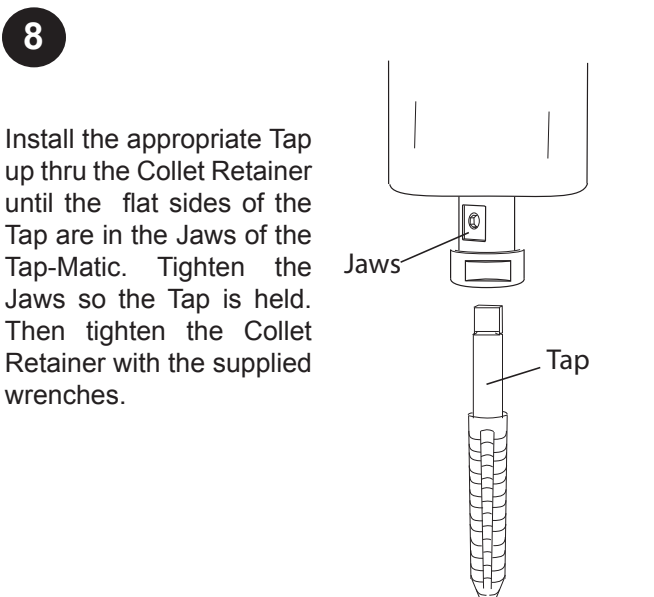
Slide the Adapter and Tap-Matic Assembly up onto the Motor Spindle at the base of the Motor making sure the Spindle sits down in the notch of the Adapter. While holding the Assembly up, tighten the 5/16-18 X 3/8 Set Screw at the top of the Adapter.



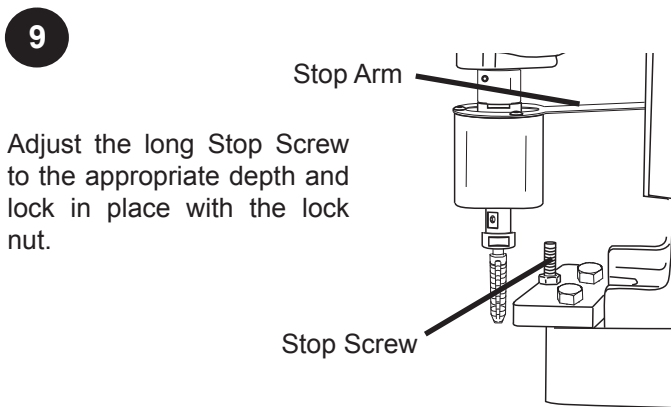
Select the correct size Collet for the Tap that will be used and install it into the bottom of the Tap-Matic.

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.



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.



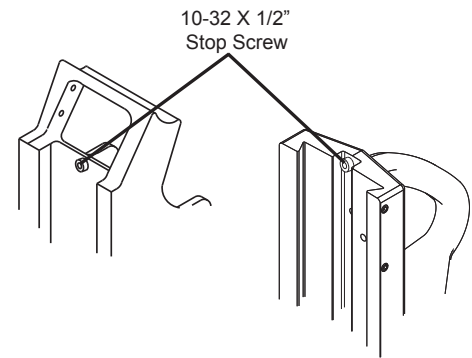
Adjust the long Stop Screw to the appropriate depth and lock in place with the lock nut.

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.

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

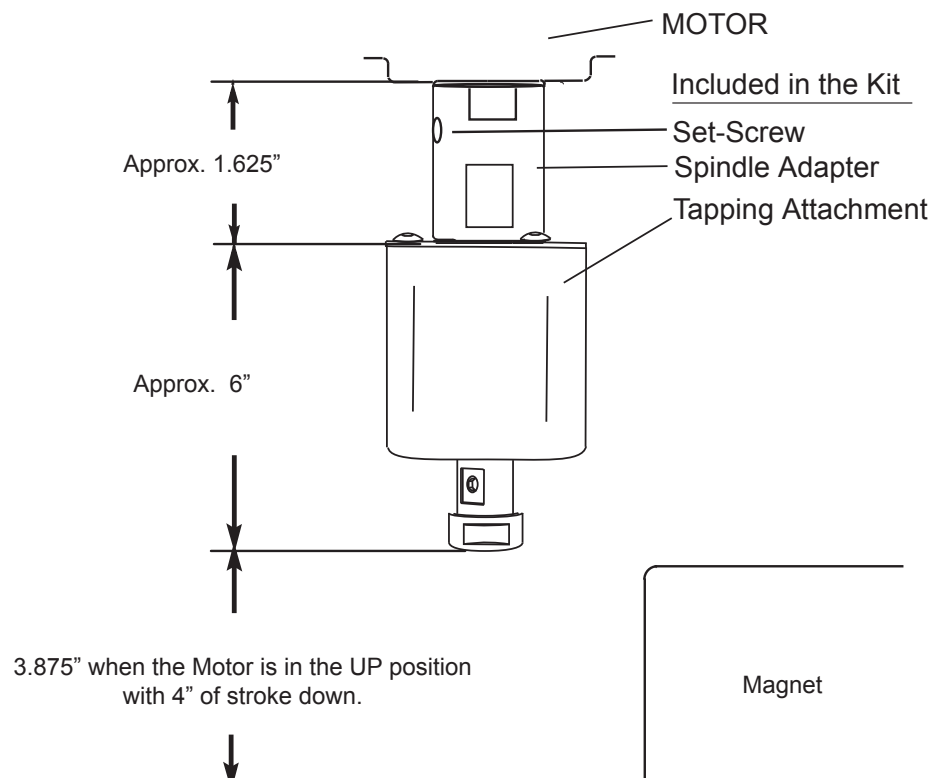
Your 3-Jaw Chuck is now installed. Select the proper twist bit for your application and follow Operating Procedures for the Hougen Magnet Based Drill you are using.



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



COMMERCIAL / INDUSTRIAL LIMITED WARRANTY

Hougen Manufacturing, Inc. warrants its Portable Magnetic Drills, Trak-Star Rail Drills, Hydraulic Rail Saw and Tornado II Paint Shakers for two (2) years, Electro-Hydraulic Hole Punchers for one (1) year, and it's Husqvarna Saw and other products for ninety (90) days from date of purchase against defects due to faulty material or workmanship and will repair or replace (at its option) without charge any items returned. This warranty is void if the item has been damaged by accident or unreasonable use, neglect, improper service, or other causes not arising out of defects in material or workmanship. No other expressed warranty is given or authorized. Hougen Manufacturing, Inc. disclaims any implied warranty of Merchantability or fitness for any period beyond the expressed warranty and shall not be liable for incidental or consequential damages. Some states do not allow exclusion of incidental or consequential damages or limitation on how long an implied warranty lasts and, if the law of such a state governs your purchase, the above exclusion and limitation may not apply to you. This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

To obtain warranty service, return the item(s), transportation prepaid to your nearest Factory Authorized Warranty Service Center, or to Hougen Manufacturing, Inc., 3001 Hougen Drive, Swartz Creek, MI 48473.

This warranty is in lieu of any other warranty, expressed or implied, including any warranty of merchantability or fitness for a particular purpose.

Photographs and Specifications shown are accurate in detail at time of printing. Manufacturer reserves the right to make improvements and modifications without prior notice. Hougen, Rotabroach, and Hougen-Edge are proprietary trademarks of Hougen Manufacturing Inc.

HOUGEN AUTHORIZED WARRANTY REPAIR CENTERS

Hougen Authorized Warranty Repair Centers have been factory trained to properly service and repair Hougen Portable Magnetics Drills. To locate an Authorized Warranty Repair Centers near you, please visit:

www.hougen.com



Hougen Manufacturing, Inc.
P.O. Box 2005 • Flint, MI 48501-2005
3001 Hougen Drive • Swartz Creek, MI 48473
Phone (810) 635-7111 • Fax (810) 635-8277
www.hougen.com • info@hougen.com
© 2019 Hougen Manufacturing, Inc.

FORM 01229