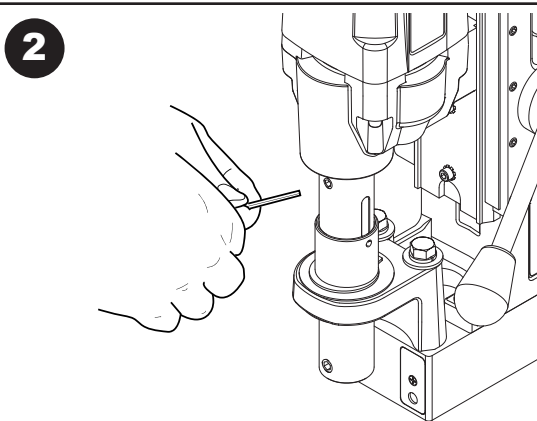
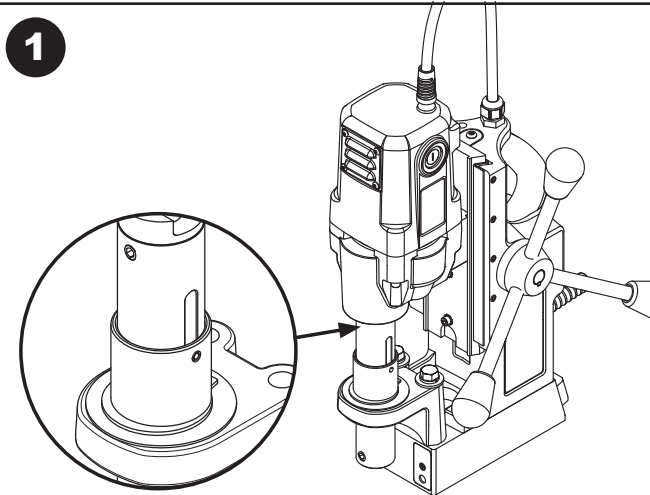


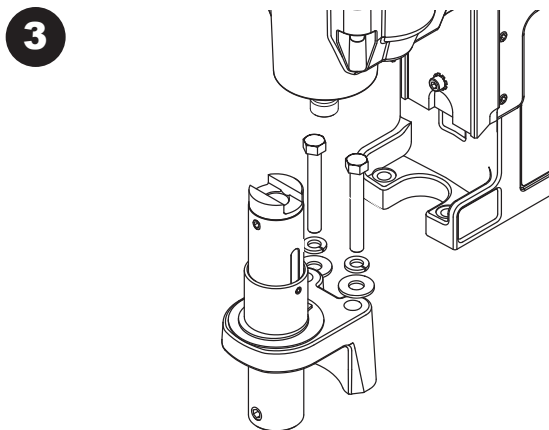
08177 TAPPING ATTACHMENT KIT

For use on Hougen Drill Models HMD904 & HMD905

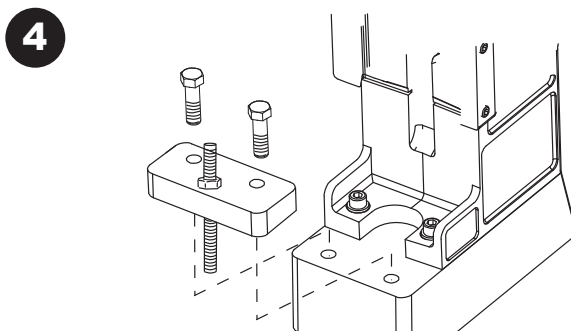
The 08177 Kit is used to install a Tapping Attachment onto a "Slot Drive" spindle. The Slot Drive assembly will have One 5/16-18 x 3/8 set screw (Fig.1) at the top of the arbor body.



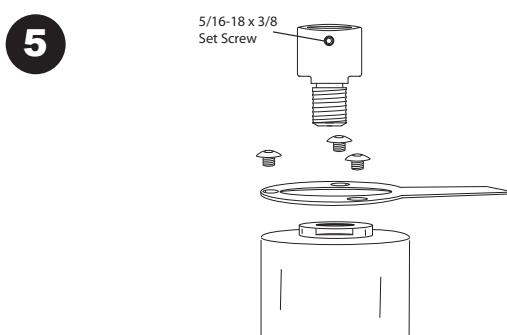
Remove the 5/16-18 x 3/8 set screw from the top of the Arbor Body with a 1/8" Hex Wrench.



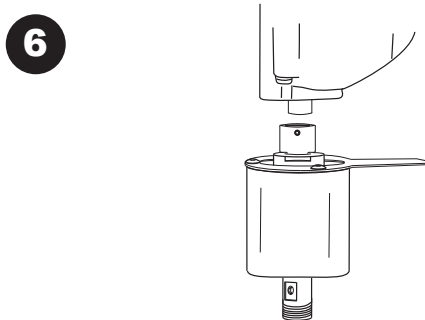
Remove both 3/8-24 Hex Bolts from the Front Support Bracket using a 9/16" Wrench.



Install the 1/4-20 x 2-1/2 Set Screw and 1/4-20 Lock Nut 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 Slot Drive Adapter into the top of the Tap-Matic Assembly and install the 5/16-18 x 3/8 Set Screw into the side of the Slot Drive Adapter.



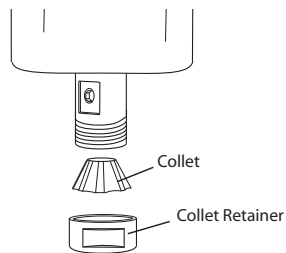
Slide the Slot Drive Adapter and Tap-Matic Assembly up onto the Motor Spindle at the base of the Motor. While holding the Assembly up, tighten the 5/16-18 x 3/8 Set Screw supplied with the Kit.

7

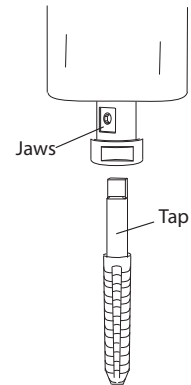
Select the correct size Collet for the Tap that will be used and install it into the bottom of the Tap-Matic.

Collet 02495 - Taps #6 thru 1/4"
Collet 02496 - Taps 1/4" thru 1/2"

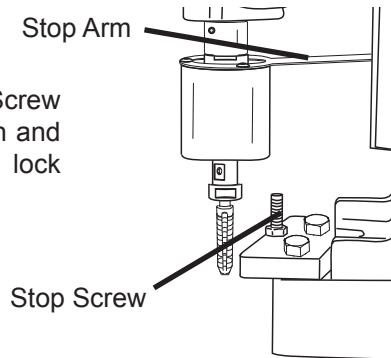
Thread the Collet Retainer onto the Tap-Matic holding the Collet in place. Do not tighten the Collet Retainer until the next step.

**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.

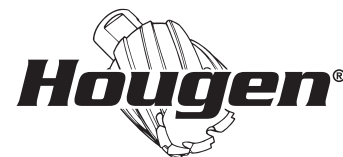
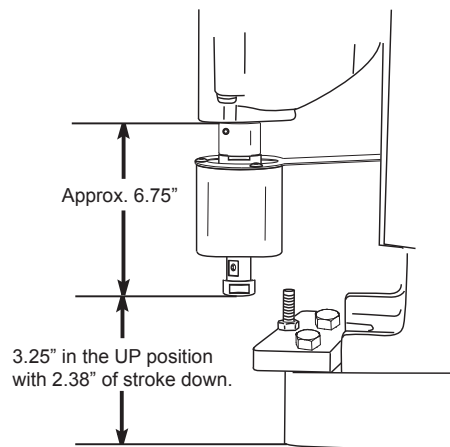
**CAUTION**

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.

Operating the Tapping Attachment

FOR HMD905 ALWAYS TAP IN LOW GEAR 250RPM

1. Produce the correct size hole for the Tap you are using.
2. Install the Tap-Matic using the instructions above.
3. Position the machine so the Tap is centered and just above the hole.
4. Apply Slick-Stik Lubricant or an alternative oil appropriate for tapping.
5. Lock the magnet in position and verify the Tap is still centered over the hole.
6. Start the motor using the operating instruction in the Operators manual.
7. Rotate the feed handles down until the Tap pulls thru the material. Feed handles are not used to drive the tap down.
8. When the Tap-matic Assembly makes contact with the Stop Screw the gears will disengage and the Tap will stop turning.
9. While rotating Feed Handles to bring the Tap-Matic UP, the Tap will engage and turn counter-clock-wise.
10. Rotate the Feed Handles until the Tap is clear of the work piece and push the Motor OFF button.



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