

Mechanical feed type tapping unit

SYNCHROTAPPER STB-H/L

Drilling capacity

Aluminium **Max.φ12**

Steel **Max.φ10**

Stroke

Max.80mm

Rotation speed

Max.2,100min⁻¹



Feature

1. Fast approach and fast return mechanisms cut down cycle time.

The built-in automatic switching of fast approach and fast return significantly cut down idling time during tapping.

2. Capable of setting at any angle.

The small, lightweight unit can be set in any angle.

This SYNCHROTAPPER helps you produce your original space-saving tapping machine.

SPEC (Standard type)

Model	Rotation speed		Tapping capacity								Stroke			Fast approach speed	Maximum tapping cycle time per minute	Thread pitch		Weight	Motor spec.			
	50Hz	60Hz	1 spindle		2 spindles		3 spindles		4 spindles		Full Stroke	Fast approach stroke	Pitch feed stroke			50Hz	60Hz		mm	Therads /inch	kg	3phase Volts.
	min ⁻¹		mm		mm		mm		mm					mm/s				time/min				V
STB-H108	1,750	2,100	M5	M4	M4	M2	M3	M2	—	—	12	10	0	88	105	30	0.25	100	27	220	50	2.0
			M4	M3	M3	M2	M3	M2	0.3	80												
	1,200	1,440	M6	M4	M5	M4	M4	M3	M4	M2							0.35	64				
			M5	M4	M4	M3	M3	M2	M3	M2							0.4	56				
	750	900	M8	M5	M6	M4	M5	M3	M4	M3							0.45	48				
			M6	M5	M5	M4	M4	M3	M3	M2							0.5	44				
	520	620	M8	M6	M6	M5	M6	M4	M5	M4							0.6	40				
			M8	M6	M6	M5	M5	M4	M4	M3							0.6	36				
STB-L108	920	1,100	M8	M5	M5	M4	M4	M3	M4	M2	80	75	40	88	105	30	0.7	28	27	400	50	1.0
			M6	M4	M5	M3	M4	M2	M3	M2							0.75	27				
	580	690	M8	M6	M6	M5	M5	M4	M5	M3							0.8	24				
			M8	M5	M6	M4	M5	M3	M4	M3							1	20				
	350	420	M10	M8	M8	M6	M6	M5	M5	M4							1.25	18				
			M8	M6	M6	M5	M5	M4	M4	M3							1.5	16				
	220	260	M12	M10	M10	M8	M8	M6	M6	M5							1.5	14				
			M10	M8	M8	M6	M6	M5	M5	M4							1.75	13				

Note 1. The upper column of the chart is for a spiral tap and a point tap. The lower column is for hand tap No.2.

Tapping capacities are conditional on the depth of tapping being limited to 1.5 times of the tap diameter.

2. Allowable weight of multi spindle head to be attached to SYNCHROTAPPER is as follows.

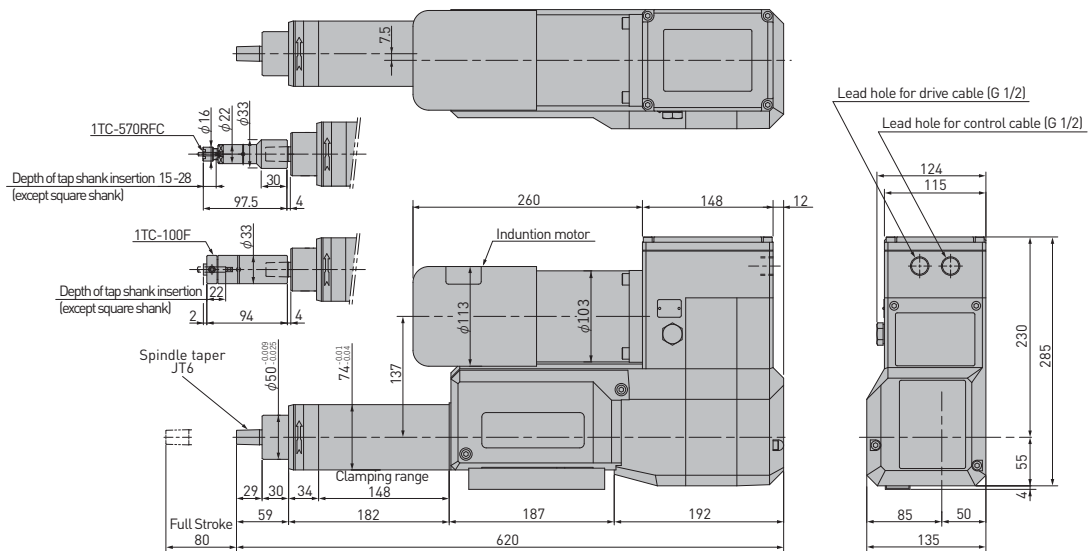
Water proofing and dust proofing must be required when processing upward direction.

[when working in a horizontal direction: 15Kg, in a vertically upward direction: 10Kg, in a vertically downward direction: 8Kg]

3. AL*: Aluminium ST*: Steel

Power 0.35kW
Poles 4P

Dimensions(mm)

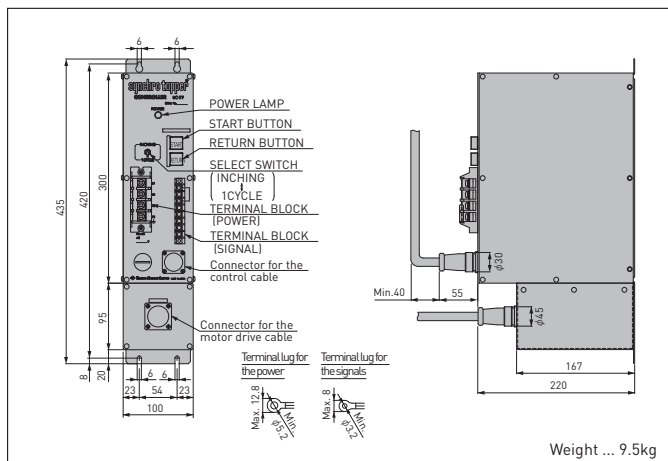


- Note 1. Single taper head 1TC-570RFC(optional) has chucking capacity of M1 - M3 with centering system.
 Note 2. Single taper head 1TC-100F has chucking capacity of M3 - M12 with floating system. (radial floating : 0.4mm in diameter)
 Note 3. If spindle rotation speed exceeds 1200min⁻¹, we recommend you to use 1TC-570RFC or 1TC-100C.

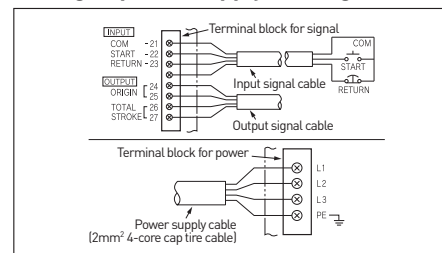
Controller UC-27U model

(For STB-H/L 108 : Protects motor by its built-in thermal relay.)

Dimensions(mm)



Wiring of power supply, I/O signals

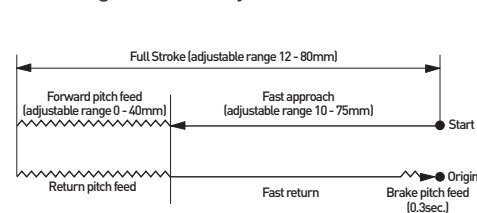


Specifications of I/O signals

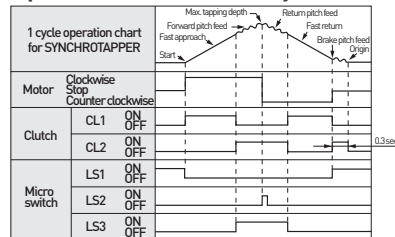
Input signal	Form	No-voltage contact
Input time	Min. 0.1 second	
Circuit voltage	DC24V (Internal supply)	
Description	Start...Normally open contact Return...Normally closed contact	
Output signal	Form	No voltage 1a contact output (Relay contact) Max. applicable load AC220V 1A(Inductive load)
Description	ORIGIN...Continuous signal at full return position. TOTAL STROKE...Continuous signal from full forward position until 0.5 sec. After unit retracts to full return position.	

Basic operation

Traveling chart of a cycle



Operation chart for one cycle



Note : Sequencer operation mode is also available. For circuit examples, please contact your nearest office.

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