

Mechanical feed type tapping unit

SYNCHROTAPPER STE-H/L

Drilling capacity

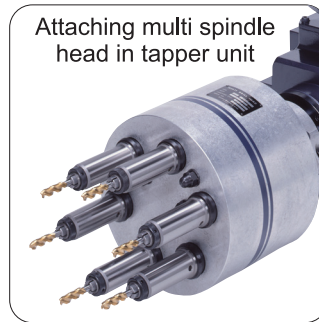
Aluminium Max.φ48
Steel Max.φ36

Stroke

Max.100mm

Rotation speed

Max.420min⁻¹



Feature

1. Capable of tapping R1(Aluminium)

The powerful motor enables processing large-diameter thread, taper thread and multi-start thread. Capable of tapping R3/4, M20 roll forming tap in S45C steel.

2. Capable of mounting multispindle tapper head on STE.

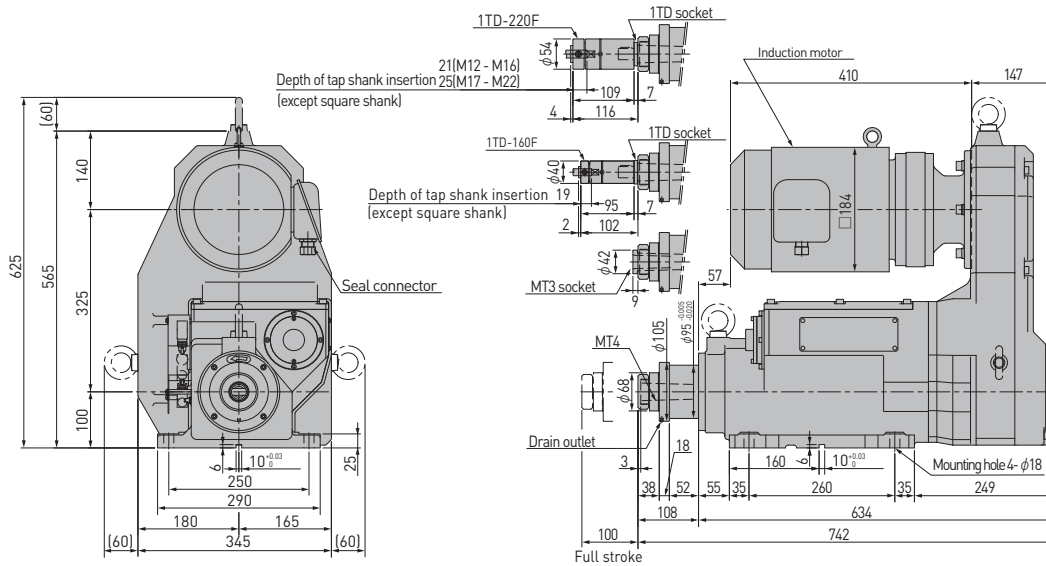
Tapping process cost can be reduced by mounting multi-spindle tapper head.

SPEC (Standard type)

Model	Rotation speed	Tapping capacity								Full Stroke	Maximum tapping cycle time per minute	Motor spec.		Thread pitch		Weight
		1 spindle		2 spindles		3 spindles		4 spindles				Power	Poles	mm	Therads /inch	
		AL*	ST* [S45C]	AL*	ST* [S45C]	AL*	ST* [S45C]	AL*	ST* [S45C]							
		min ⁻¹	mm		mm		mm		mm			mm	time/min	kW	P	
STE-H527	420	M27	M16	M20	M12	M16	M10	M16	M10	20 , 100	15	2.2	4	0.8	28	175
		M22	M12	M16	M10	M12	M8	M12	M8					1	24	
	310	M33	M20	M22	M16	M20	M12	M16	M10					1.25	19	
		M24	M16	M16	M10	M16	M10	M12	M8					1.5	18	
	210	M36	M22	M27	M16	M22	M14	M22	M12					1.75	16	
		M27	M16	M22	M12	M16	M10	M16	M10					2	14	
STE-L527	100	M45	M30	M36	M22	M30	M20	M27	M16	6				2.5	12	
		M39	M24	M27	M18	M24	M16	M22	M12					3	11	
	70	M48	M36	M42	M27	M33	M22	M33	M20					3.5	9	
		M45	M27	M33	M22	M27	M16	M24	M16					4	8	

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. Tapping speed is same in both 50hz and 60Hz regions. [Power supplied to the motor by inverter inside the controller is 60Hz.]
 3. The speed can be changed by replacing pulleys. But speed changeover between STE-H and STE-L requires a motor and a belt replacement in addition to the pulleys.
 4. 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: 100Kg, in a vertically upward direction: 90Kg, in a vertically downward direction: 90Kg]
 5. AL*: Aluminium ST*: Steel
 6. Motors for 200, 220, 400, 440 voltage are available.

Dimensions(mm)

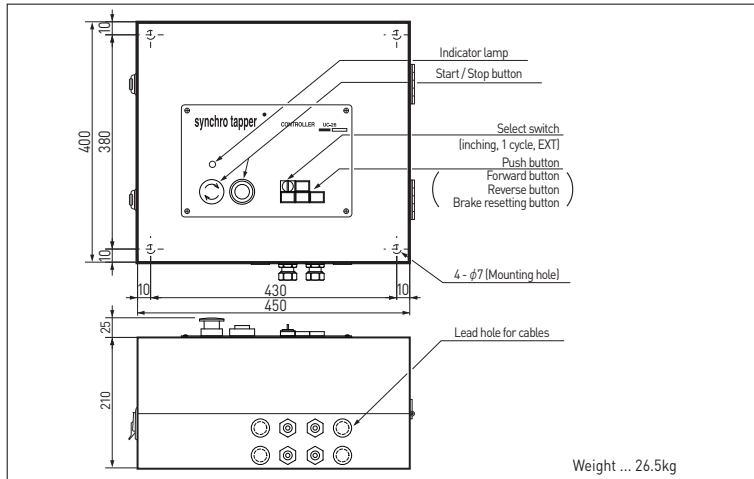


- Note 1. A single taper head can be attached by mounting optional 1TD socket. 1TD-160F/220F is optional.
 2. Tap holders WFLP340-0/MT4(M16-M38) manufactured by NT Tools, Co. are attachable to MT4 spindle. Tap holder is to be supplied to our customers.
 3. WFLP240-0/MT3(M6-M22) can be attached by mounting optional MT3 socket. Tap holder is to be supplied to our customers.
 4. When SYUNCROTAPPER is attached horizontally, set drain outlet downward direction.

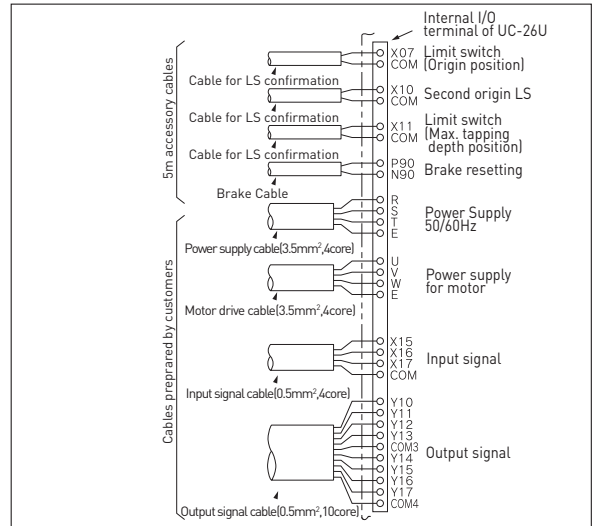
Controller UC-26U model

For STE-H/L527: Controls cw. and ccw. rotation and protects its motor by built-in inverter

Dimensions(mm)

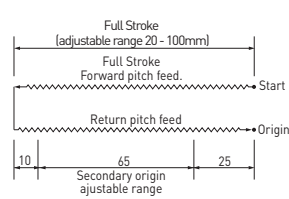


Wiring of power supply, I/O signals

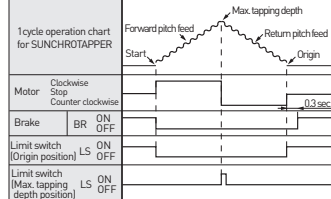


Basic operation

Traveling chart of a cycle



Operation chart for one cycle



Note: Above is a sequence chart of mechanical movement. The arrow diagram shows that the brake movement is off, when the electric signal is on, and on when the electric signal is off.

- Note 1. By using LS, which comes standard with the unit, secondary origin can be set within secondary origin adjustable range.
 2. Sequencer operation mode is also available. For circuit examples, please contact your nearest office.

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 open contact
Output signal	Form	No-voltage contact output
	Description	Max. applicable load AC220V (Inductive load)

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