

Tap series Certificate

Product number: Y3/Y5

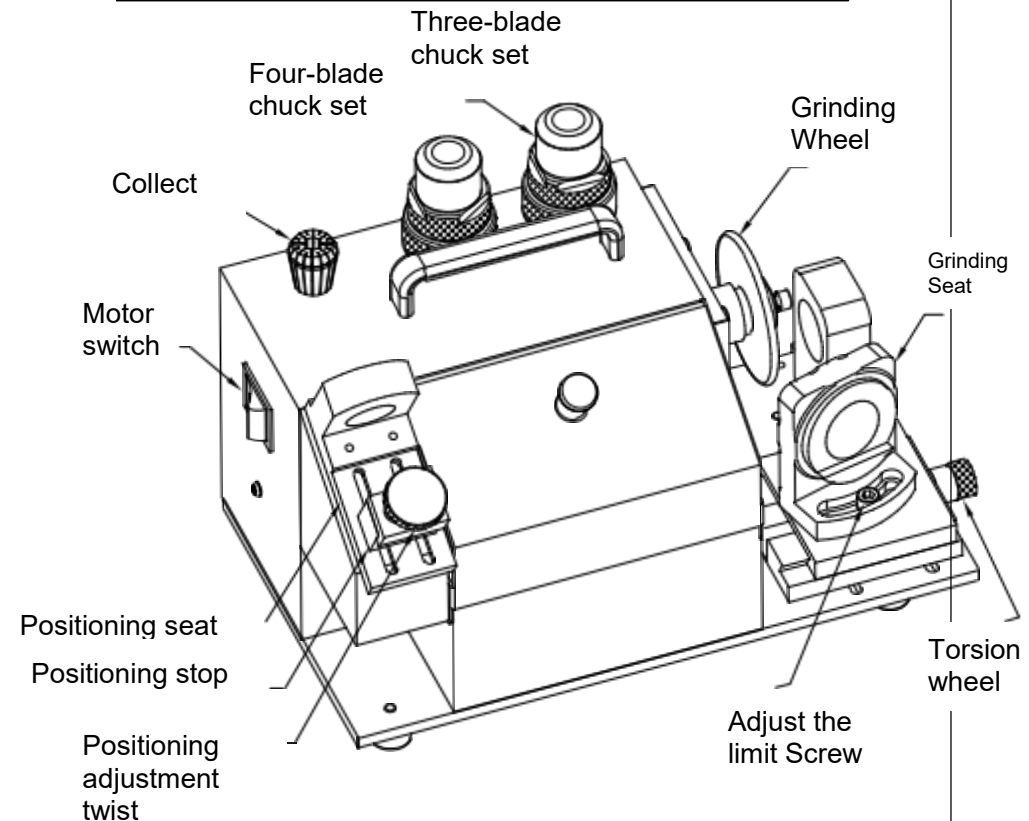
Product number: _____

Inspector: _____

Date of manufacture: _____

The manufacture, assembly and performance of this product have been tested and meet the factory quality standards and are allowed to leave the factory

Y3/Y5 Screw Tap Grinder



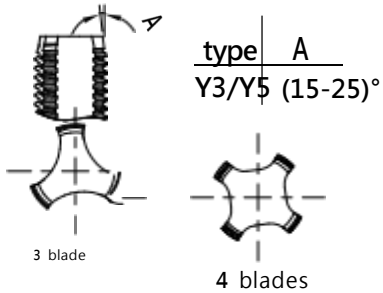
Main Function and feature:

- Self-developed Y3/Y5 can repair and grind the entire front cutting surface and front cutting edge of the wire tap.
- This machine is a special equipment that can grind 3 blades, 4 blades, and wire tapping knives. Accurate, fast, simple operation, easy to grind without skill, save cost and improve use efficiency.
- Equipped with a diamond grinding wheel, the angle of the grinding wheel is scientifically designed, the angle is accurate, and the life is long.
- Electronic control type powerful DC motor: stable frequency, strong horsepower, can be used for a long time.

Y3/Y5Standard accessories

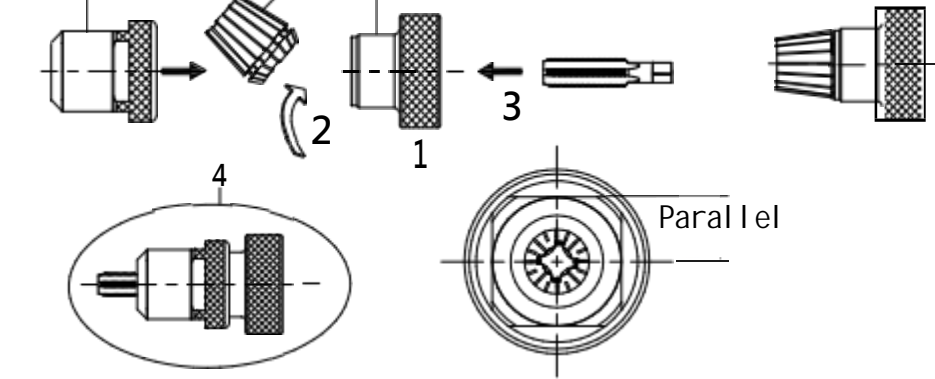
Hexagonal wrench		Each for (3、4、5、6、8)mm
Chuck set		One for 3-blade, one for 4-blade
Collet	Y5	φ (13、14、16、18、20、23、25、28、30)
	Y3	φ (5、7、8、9、13、14)
Grinding wheel		CBN or SDC
Cube		Spiral tap for tool holder 1

- 1. High efficiency, high quality and good grinding effect.
- 2. Easy to operate and fast.
- 3. Grinding wheel CBN: suitable for grinding white steel knives.
- SDC: Suitable for grinding hard alloy knives. The above two should not be confused!



Operating Procedures

A. Assembling of end wire tapping fixture group, 1"collet clamp"3and 2"end wire tapping"



- *.Please assemble according to the steps in the figure 1.2.3.4 above. "Do not lock"
- 1. First confirm the diameter of the tapping tool holder, and then select the appropriate collet and tool set.
 - 2. Insert the collet into the fixture at an appropriate angle and lock the nut.
 - 3. Put the wire tap into the collet, Y3 protrudes about 59mm (Y5 protrudes about 86mm).
 - 4. Before calibrating the knife, please find out the center cutting edge by visual inspection, and approximately parallel to the reference groove for easy operation
- Calibration knife positioning (4. 4-blade chuck for 3 blades, 3-blade chuck for 3 blades)

Warranty

Dear user:

Thank you for purchasing the products made by Taiwan Star! In order to ensure that you get reliable after-sales service, please read the following instructions carefully:

The products guaranteed by this certificate are manufactured by Taiwan Star Smart or sold by designated distributors, and are registered in this certificate;

The contents of this certificate must be filled in effectively, otherwise it will be regarded as an invalid warranty certificate. The model of the body registered in the product information must be consistent with the actual model of the product to be guaranteed;

Please keep the necessary vouchers for the warranty service of this certificate in a safe place. When customers need technical support services, please show this certificate, we will provide you with the best quality and satisfactory service;

The following conditions are not covered by the warranty:

- 1. Failure to provide a valid warranty certificate and valid purchase certificate, or alter the warranty certificate without authorization.
- 2. The product model and body number on the warranty certificate do not match the actual product.
- 3. Failure to use, maintain, and store the product in accordance with the requirements of the product manual and cause damage.
- 4. Failure caused by accidental disasters, self-demolition, man-made damage, or maintenance by a non-authorized center of the company.
- 5. Damage caused by irresistible factors. (natural disaster)

The warranty period of this product: From the date of purchase (subject to the date of purchase invoice), the motor is guaranteed for one year. Other accessories are not covered by the warranty. (Such as: artificial damage to packaging, product appearance, and missing accessories are not covered by the warranty)

For products not covered by the warranty or beyond the warranty period, the customer still enjoys maintenance services, but the maintenance cost will be charged. This certificate is an important basis for product warranty service, please keep it properly!

Customer Feedback Form

User name : _____ product name : _____

Phone number : _____ purchase date: _____

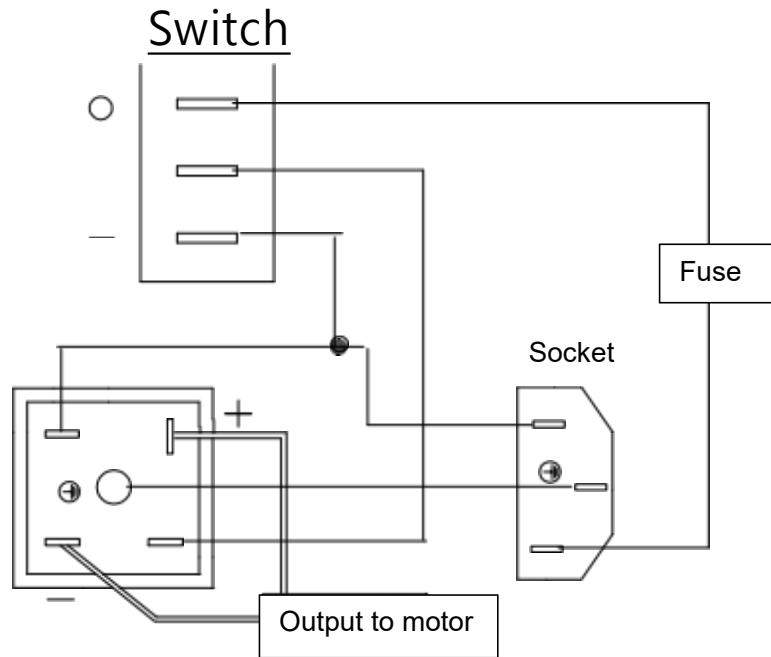
Address : _____

Signature : _____ tel : _____

Feedback : _____

Stamp here : _____

Power switch wiring diagram :



Attention

1. Check whether the voltage and frequency of the motor are consistent with the power supply before starting up.
2. The tentacles on the power plug and socket of the machine tool should be fastened and reliable without looseness or poor contact.
3. In the event of malfunction or abnormal sound, unplug the plug immediately, and then perform inspection and repair.
4. Don't let the machine tool run without unattended.
5. Do not operate the machine when the person is tired or taking alcohol or anesthetics.

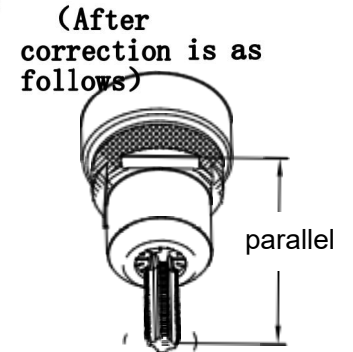
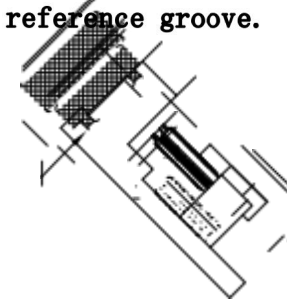
Adjustment and operation

1. Before starting the machine tool, check whether the locking mechanism is locked, and whether the machine power is normal.
2. After the work is finished, the dust particles should be removed, and the unpainted surface should be coated with engine oil to prevent rust.

B. Correct positioning

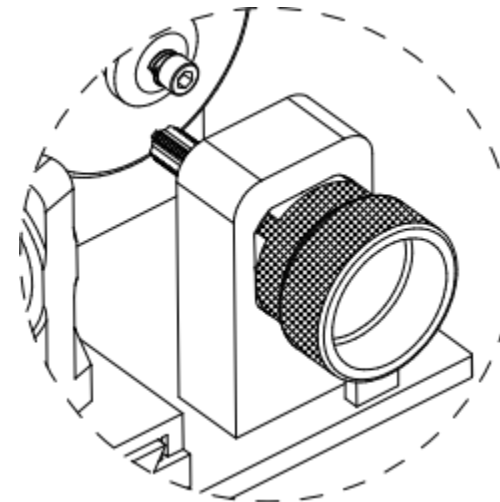
1. Put the nut of chuck into the positioning seat, and turn it clockwise to the right for positioning after being tightly connected.
2. After the wire tap is against bottom, gently push it to the flat surface and turn it right to lock it.
3. Turn the chuck seat to the right to the end and lock it.
4. Hold the fixed chuck nut and rotate it slightly to the left when taking it out.

*.The over-center knife edge should be parallel to the reference line under the reference groove.



C. Cutting end face grinding

1. Open the side cover, put the wire tapping group into the leveling head column, gently push it to the grinding wheel, and rotate it to grind and level.
- *. Don't forget to turn off the motor(can't run more than 1 hour)

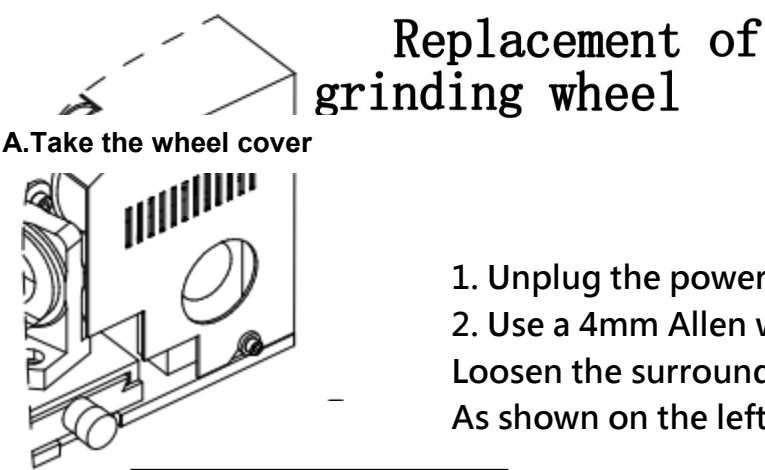
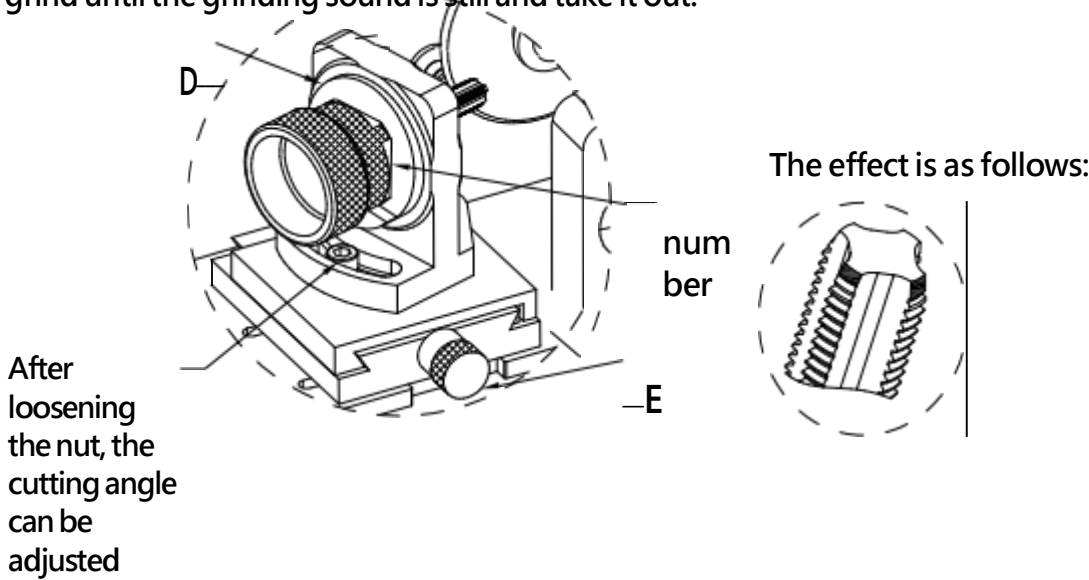


The effect is as follows



D. Oriented grinding first

*Before grinding, please return (E) to the original point, and then advance to the appropriate grinding amount. After the switch light is on, place the tapping fixture in the end face angle grinding seat hole (D), and the notch of the fixed chuck nut is aligned with the grinding seat. After the digital plug, gently push the bottom and rotate left and right to grind until the grinding sound is still and take it out.



A.Take the wheel cover

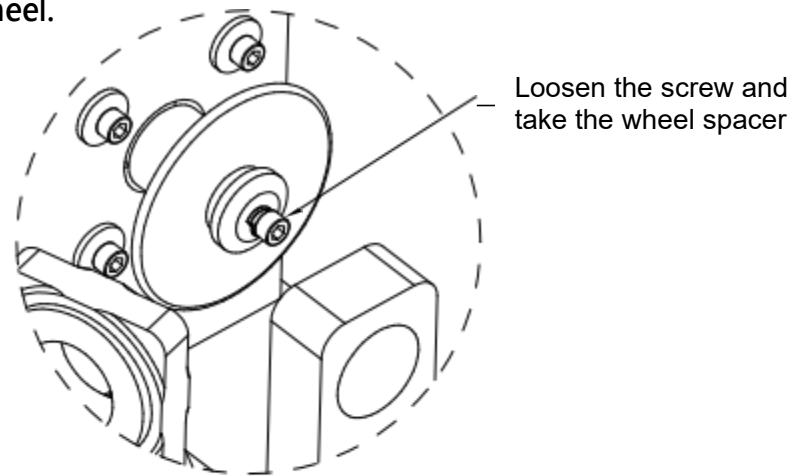
Replacement of grinding wheel

1. Unplug the power cord to ensure safety.
2. Use a 4mm Allen wrench to cover the sharpener. Loosen the surrounding screws counterclockwise. As shown on the left:

Loosen the screw

B.Take the grinding wheel gasket

1.1.After removing the upper cover, use a brush to remove the powder, and then wipe the surface with a dry cloth. Hold the grinding wheel with your left hand, turn it counterclockwise with a 4mm Allen key with your right hand, and pick up the diamond grinding wheel.



C.Changing the wheel

- 1.Replace with a new grinding wheel.
2. Gently put it back into the spindle of the grinding wheel, and lock the screw and the cover of the grinding wheel.

