
NIMOVA

electric tapping machine instructions

Power on , the system will enter into the boot interface , click anywhere on this picture it will enter into the operation interface .

The Servo Electric Tapping Machine

[Click to enter the running interface](#)

一、 Ordinary operation

- (1) **Thread** Click the Thread enter into the 'Metric thread 1' , choose the thread , it will automatically generate the thread pitch and torque.

Thread	Thread pitch	Tapping depth	
M1.00	0.250 mm	10.00 mm	
Feed speed	Torque	HAND	
200 rpm	0.40 N.m		
Rollback speed	Counter		
300 rpm	1	Clear	
User parameter	Machine parameter	Deep hole operation	Ordinary operation

- (2) **Thread pitch** In the Metric thread interface , if you choose the thread , it will automatically generate the thread pitch . Or you can use nonstandard pitch setting value.
- (3) **Tapping depth** The tapping depth setting, minimum value is 0.01mm.
- (4) **Feed speed** The tapping machine feed speed setting , maximum speed of the motor is 3000rpm , when the value it is multiply the feed speed by the register ratio that bigger then 3000, it will show error 'Speed setting error' ,you need to set again.
- (5) **Rollback speed** The tapping machine rollback speed setting , , when the value it is multiply the rollback speed by the register ratio that

bigger than "Motor speed limit", it will show error 'Speed setting error', you need to set again.

- (6) **Torque setting** When you choose the thread, it will automatically generate the torque.
- (7) **Counter** In the auto mode, add a number if you have done a complete process. Maximum value is 50000.
- (8) **The shift of the hand mode and auto mode** The system default hand mode, change the mode you need to click the button. When show the hand the system is hand mode, when show the auto the system is auto mode. When the system is running, if you click the button it will be stop and change to new mode. When "Number of linkage" more than 1, the system is linkage mode.

Metric thread 1					
M1	M2	M3	M4	M5	Inch
M6	M8	M9	M10	M12	Page up
M14	M16	M18	M20	M22	Page down
M24	M27	M30	M33	M36	Return

Metric thread 2					
M39	M42	M45	M48	M52	Inch
M56	M60	M64	M68	M72	Page up
M76	M80				Page down
					Return

Inch thread 1					
1/16	3/32	1/8	5/32	3/16	Metric
7/32	1/4	5/16	3/8	7/16	Page up
1/2	5/8	3/4	7/8	1	Page down
1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	Return

Inch thread 2					
1 3/4	1 7/8	2	2 1/4	2 1/2	Metric
2 3/4	3	3 1/4	3 1/2	3 3/4	Page up
4					Page down
					Return

二、 Deep hole operation

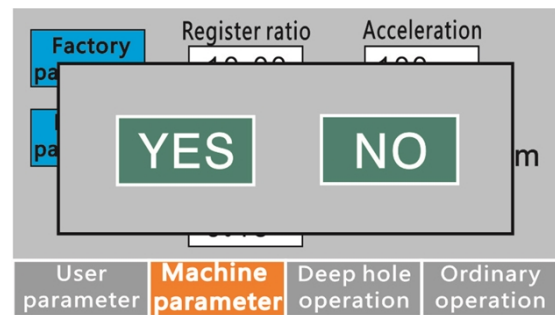
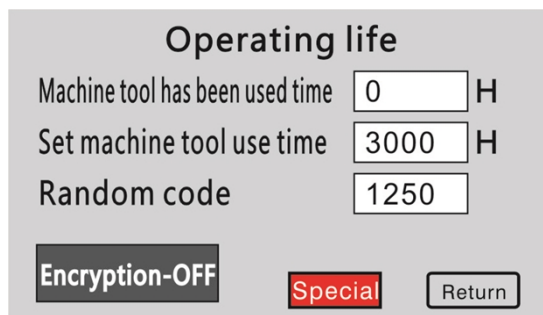
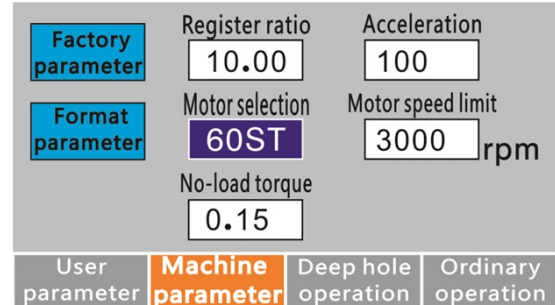
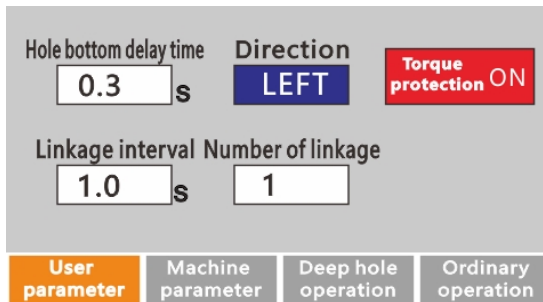
- (1) **Thread** Click the Thread enter into the 'Metric thread 1', choose the thread, it will automatically generate the thread pitch and torque.
- (2) **Thread pitch** In the Metric thread interface, if you choose the thread, it will automatically generate the thread pitch. Or you can use nonstandard pitch setting value.
- (3) **Tapping depth** The tapping depth setting, minimum value is 0.01mm.
- (4) **Feed speed** The tapping machine feed speed setting, maximum speed of the motor is 3000rpm, when the value it is multiply the feed speed by the register ratio that bigger then 3000, it will show error 'Speed setting error', you need to set again.
- (5) **Rollback speed** The tapping machine rollback speed setting, when the value it is multiply the rollback speed by the register ratio that bigger then "Motor speed limit", it will show error 'Speed setting error', you need to set again.
- (6) **Feed depth** Set the feed depth of the Deep hole operation.
- (7) **Rollback depth** Set the Rollback depth of the Deep hole operation.
- (8) **The shift of the hand mode and auto mode** The system default hand mode, change the mode you need to click the button. When show the hand the system is hand mode, when show the auto the system is auto mode. When the system is running, if you click the button it will be stop and change to new mode. When "Number of linkage" more then 1, the system is linkage mode.

Thread	Thread pitch	Tapping depth	
M1.00	0.250 mm	10.00 mm	
Feed speed	Feed depth		HAND
200 rpm	2 mm		
Rollback speed	Rollback depth		
300 rpm	1 mm		
User parameter	Machine parameter	Deep hole operation	Ordinary operation

三、 User parameter

- (1) **Hole bottom delay time** Delay time set in the bottom of the hole. The default value of 0.3 s.

- (2) **Thread direction** Click the button to choose the thread direction.
- (3) **Linkage interval** In the linkage mode, When tapping time after the completion of the next tapping on the intermittent time.
- (4) **Number of linkage** When "Number of linkage" more than 1, the system is linkage mode.
- (5) **Torque protection** Click the button to open or close it.



四、 User parameter (Password:112233)

- (1) **Register ratio** Register ratio of the machine, minimum value is 1.
- (2) **Acceleration** Set system acceleration. The default value of 100.
- (3) **Motor speed limit** Set the top speed of the motor, top speed is 5000RPM.
- (4) **Motor selection** Select the current motor model.
- (5) **Factory parameter** (Password:135246)
- (6) **General/Special**

General: Does not show the name of the client company when the boot.

Special: Display the name of the client company at boot time.

(7) **Format parameter** Click on the button, "YSE" to Format the parameter , "NO" to close it,When Format the parameter, You will be prompted "power off please!"