Troubleshooting

(Tap adapter)

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Tool will not fit.	① Wrong adapter size (ID, square portion) (Because difference in size between JIS and OSG standards, shank and tang dimensions are different.) ② Scratch or dent in ball bushing I.D.. ③ Scratch or dent on tool shank.	① 2. Check adapter size and tap standard (shank diameter, square portion size). ② Ask NT for repair. ③ Replacement of tool.
2	Cannot mount tap adapter into tapping chuck.	① Wrong choice of tap adapter size. ② Operating sleeve on tapping chuck not functioning properly. ・Dust on or stuck into operating sleeve. ・Deterioration of spring.	① Check adapter and holder sizes.. ② Check to see if operating sleeve moves smoothly by hand. ・Cleaning of operating sleeve I.D.. ・Ask NT for repair.
3	Too much play when tapping chuck is mounted.	① Wear on tapping chuck steel ball. ② Dent on tap adapter R groove.	① Ask NT for repair. ② ・Replacement of tap adapters. ・When denting often occurs, change cutting conditions. ・Increase feed per rotation （must be less than tap pitch.） ・Return timing is premature. → Approach point should be distanced. （Guidelines：Tapping chuck's maximum tension＋5㎜）
4	Tool is pulled out.	① Pulling force is being applied to tap, which is stronger than tapping chuck tension. ② Deformation or breakage of steel balls in tap adapter. ③ Ball locking mechanism of tap adaptor does not work (in the case of carbide tap). ④ Malfunction of ball bushing. ・Dust on or stuck into operating sleeve. ・Deterioration of spring.	① ・Increase feed per rotation （must be less than tap pitch.） ・Return timing is premature. → Approach point should be distanced. （Guidelines：Tapping chuck's maximum tension＋5㎜） ② Ask NT for repair. ③ Use collet type tap adaptor. ④ ・Ask NT for repair. ・Ask NT for repair.
5	Tap breakage when used with adapter with safety-torque feature.	① Adapter with “safety torque clutch” is used in conjunction with holder that does not have “tension and compression” feature. ② Torque setting is not appropriate.	① ・Replacement of holder or tap adapter. ・For adapter with “safety torque clutch”, use holder with “tension and compression” feature.. ② Reset torque setting..
6	When using adaptor with safety torque clutch, feeding does not take place at rate as set, with screw backlash being taken up.	① Tap does not feed into work smoothly..	① ・Larger chamfering for the entrance of prepard hole ・Use tap with more threads for chamfering.（2.5 threads and more）

		② Torque setting is not appropriate.	② Reset torque setting..
7	In spite of length adjustment feature that adapter has, length adjustment cannot be made..	① Operational error. ② Cutting chips, dust deposited on or stuck into sliding surfaces. ③ Component parts are turning idly due to adapter housing breakage.	① Put a wrench into hexagon hole and turn it while pushing it down. ② Clean sliding surfaces. ③ Ask NT for repair.
8	Cutting edge of tap comes into contact with ball bushing.	① In the case of pipe thread tap, tap adapter for M thread is being used. ② In the case of –R type, stopper is broken and inserted length is too deep.	① 11. In the case of pipe thread tap, use (PT type) adapter. ② Ask NT for repair.
9	Ball bushing does not operate properly.	① Operational failure due to dust deposited or stuck in. ② Deterioration of spring.	① Ask NT for repair. ② Ask NT for repair.