



Tapping Chuck Instructions

These instructions cover these products:

- 5591 Tapping Chuck, 33JT

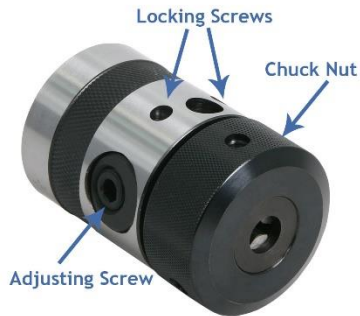


The 5591 tapping chuck works with taps for threading #10 through 1/2" threads. The chuck comes with three wrenches; two hex (Allen) wrenches, and a spanner wrench.



Installing a Tap

Identify the controls called out in the photo.



Follow these steps to mount a tap in the tapping chuck:

1. Loosen the adjusting screw all the way so the two jaws are as far apart as possible.

Chris' Tip: The adjusting screw has right hand threads on one end and left hand threads on the other end. If you work with the end that's counterclockwise from the locking screws (when viewed from the tap end) you will find that it works the "right" way.

2. Loosen the chuck nut enough for your tap shank to enter the tapping chuck.
3. Insert the shank of the tap into the tapping chuck.



4. Snug the chuck nut so the three jaws are centering the chuck, but so you can still rotate it by hand.
5. Tighten the adjusting screw while you rotate the tap so the two jaws close on the square shank of the tap. The adjusting screw should be snug. It does not have to be tight.
6. Tighten the chuck nut with the spanner wrench.

Chris' Tip: Tightening the locking screws locks the two jaws in place. You might want to do this if you need to change the tap for a tap with the same size shank. The adjusting screw should be a bit less than tight so the replacement tap will fit between the two jaws.