

TROUBLE SHOOTING

1. **Striker cap on tool stays down: DO NOT ATTEMPT TO FIX.** The tapping unit must be sent back to the factory. Internal tool damage has occurred. Up to 2500 pounds of pressure may be compressed within the tapping tool. **DO NOT TAMPER, SHAKE, HAMMER, OR DISASSEMBLE THE TAPPING UNIT! This may cause injury to the operator and/or equipment. Send the tool back to d/k technologies. The return address is 1980 Petra Lane Suite B, Placentia, CA 92870. In case of warranty issues, a sample piece must be sent in with the hole that the tool broke on as well as the next hole that was to be tapped.**
2. **Distorted threads:** Threads are distorted and the go gauge will not go into the tapped hole. Check to see if any portion of the nosepiece is hitting the top of the threads on subsequent holes. If obstruction is present, alter your program for the turret press. Also, check for the strippers of other tools hitting the threads. See **figure #17**. Custom nosepieces are available from d/k technologies. See **figure #18**.
3. **Tap breaks on every hit:** Make sure the hole is the correct size for a metal forming tap. Do not use a cutting tap pre-hole size; it will be too small and will result in tap breakage and/or severe tool damage.
4. **Tap breaks after one to five hits:** Tap height may not be adjusted correctly. Verify that the tap is recessed 0.050 inside the nosepiece. See **figure #12**. Improper tap height often results in the tap catching on the material as the material moves.
5. **Tap breaks prematurely or is burning out:** Check for lubrication at the threaded hole. A discolored or black tap indicates improper lubrication. Verify the type and amount of lubricant being used is correct. The oil nozzle could be bent, preventing oil flow from getting to the proper point of the tap. If the nozzle is bent it will more than likely need to be replaced.
6. **Burr on top of extrusion:** Tap height is too long. Adjust pitch insert deeper into stripper plate. See **figure #12**.
7. **Burr on bottom of threads:** After hole is tapped there is a burr on the bottom of the threads. To correct this, use more die clearance – 10% clearance is good. See **figure #17**.
8. **Threads are not completely through the hole:** Tap is adjusted too far in nosepiece. Increase the tap to 1.810 (46.0mm) until the threads go through. If the tap breaks, the tap is protruding too far out of the stripper. **Note: The tap can extend out of the nosepiece about 0.05 or (1.25mm).** The no hole spring is not strong enough in the pitch insert, a stronger spring will be required. See **page 35** and **figure #20** for spring details.
9. **Threads are defective after part goes through the line grainer:** The sanding belt is worn out thus pushing the burr back into the threaded hole. Replacement of the sanding belt is needed.

10. **Threaded hole is too small after part is plated:** The (H) factor for American thread or (D) factor for metric threads is too small. An oversize tap will be needed. This tap will compensate for the plating built up on threads. Please refer to **page 28** for information on oversized taps.
11. **Threaded holes are too large:** The (H) factor for American threads or the (D) factor for metric threads is too large. A smaller H/D factor will be needed. Please refer to **page 28** for undersized taps.
12. **Tapping fluid will not come out of tool:** Remove oil nozzle on tool and blow it out with pressurized air. Also, check to make sure the female and male coupler function together correctly. Check that the tool has not lost prime. To prevent clogged oil lines always use the funnel filter provided when adding tapping fluid to your system.
13. **Oil housing runs out of fluid in 1000 hits:** The on/off valve may be opened too far. Decrease the amount of fluid by moving the indicator pin closer towards the minimum line. See **figure #8**.
14. **Nosepiece is denting the material:** A custom nosepiece can be used, (optional). The custom nosepiece has a larger surface area to hold the material down. See figure #18.