BGS technic

BGS 904

Tap and Die Set | M6 - M30

TOOLS

Tap + Die M6x1.0 / M6x0.75
Tap + Die M8x1.25 / M8x1.0
Tap + Die M10x1.5 / M10x1.25
Tap + Die M12x1.75 / M12x1.5
Tap + Die M14x2.0 / M14x1.5
Tap + Die M16x2.0 / M16x1.5
Tap + Die M18x2.5 / M18x1.5
Tap + Die M20x2.5 / M20x1.5
Tap + Die M22x2.5 / M22x1.5
Tap + Die M24x3.0 / M24x1.5
Tap + Die M26x3.0 / M28x3.0 / M30x3.5
Tap holder
Tap holder with sliding bar ratchet
Die holder (x2)
Slot screw driver

ATTENTION

Read the operating instructions and all safety instructions contained therein carefully before using the product. Use the product correctly, with care and only according to the intended purpose. Non-compliance of the safety instructions may lead to damage, personal injury and to termination of the warranty. Keep these instructions in a safe and dry location for future reference. Enclose the operating instructions when handing over the product to third parties.

SAFETY INFORMATIONS

- Keep children and other persons away from the working area.
- Do not allow children to play with this tool or its packaging.
- Do not use the tool if parts are damaged.
- Always wear safety goggles when using this product.
- Always add some oil when cutting threads.

CORE HOLE

M6.0 x 0.75 - Drill Ø 5.25	M18 x 1.50 - Drill Ø 16.50
M6.0 x 1.00 - Drill Ø 5.00	M18 x 2.50 - Drill Ø 15.50
M8.0 x 1.00 - Drill Ø 7.00	M20 x 1.50 - Drill Ø 18.50
M8.0 x 1.25 - Drill Ø 6.80	M20 x 2.50 - Drill Ø 17.50
M10 x 1.00 - Drill Ø 9.00	M22 x 1.50 - Drill Ø 20.50
M10 x 1.50 - Drill Ø 8.50	M22 x 2.50 - Drill Ø 19.50
M12 x 1.50 - Drill Ø 10.50	M24 x 1.50 - Drill Ø 22.50
M12 x 1.75 - Drill Ø 10.20	M24 x 3.00 - Drill Ø 21.00
M14 x 1.50 - Drill Ø 12.50	M26 x 3.00 - Drill Ø 23.00
M14 x 2.00 - Drill Ø 12.00	M28 x 3.00 - Drill Ø 25.00
M16 x 1.50 - Drill Ø 14.50	M30 x 3.50 - Drill Ø 26.50
M16 x 2.00 - Drill Ø 14.00	

Instruction Manual

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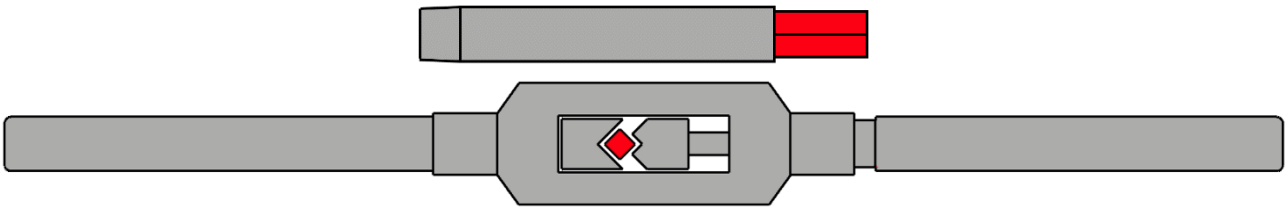
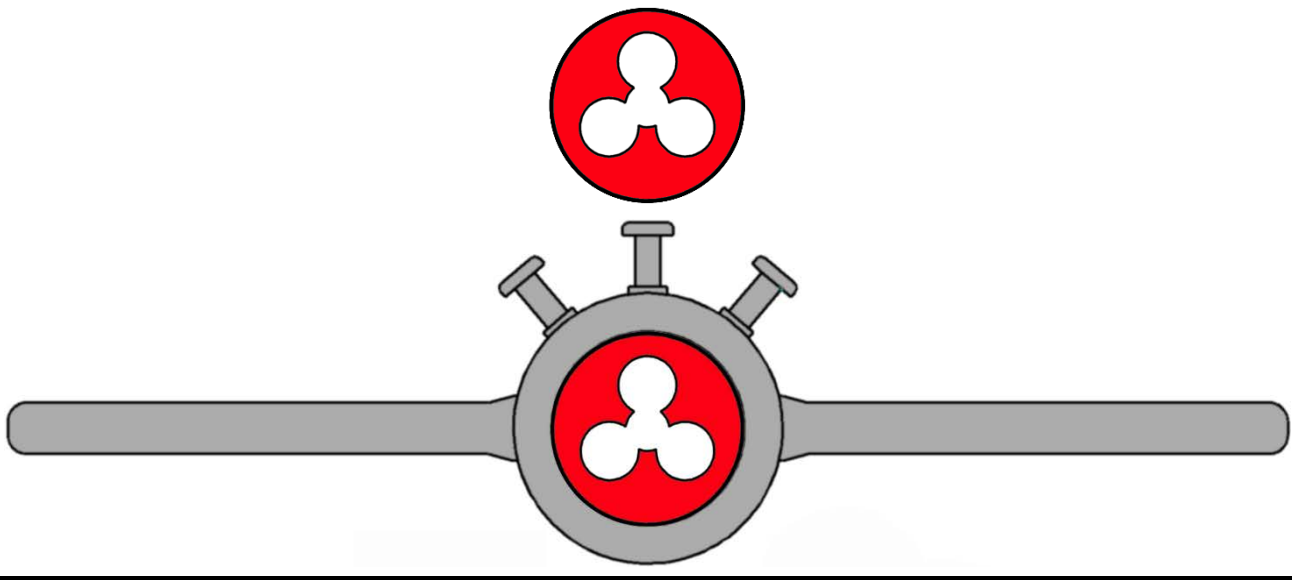
INNER THREAD



1. Choose the required tap and fix it in the tap wrench by turning the handle.
2. Use the table on page 1 to determine the size of the drill and drill a hole of the appropriate diameter in the workpiece.
3. Place the tap in the hole at right angles to the workpiece and turn the tap slowly and carefully into the core hole. Oil or fat reduce the resistance when cutting and improve the evacuation of the chips.
4. If the tap jams, do not continue with force, but instead try to break the chips with slight back and forth turns.
5. Stop cutting when, for through holes, you no longer feel any resistance, or for blind holes, the tap hits the end of the blind hole.

OUTER THREAD



1. Insert the required die into the tap wrench and fasten with the fixing screws.
2. Position the tap at a right angle to the workpiece and turn the die slowly and carefully. Oil or fat reduce the resistance when cutting and improve the evacuation of the chips.
3. If the tap jams, do not continue with force, but instead try to break the chips with slight back and forth turns.
4. The cutting process is finished when the required thread length is reached.

ENVIRONMENTAL PROTECTION

Recycle unwanted materials instead of disposing of them as waste. Packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. Contact your local solid waste authority for recycling information.

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