



AUTOMATION ASSOCIATES INC.

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Steco Precision Tapping Machines

Models CAT-8, NAT-16, NAT-32

Features:

- ◆ Automatic precision feed mechanism with one pitch per one spindle revolution.
- ◆ Repeat cycle and single cycle. No skill required.
- ◆ Double safety devices for preventing breakage of machine and tap.
- ◆ Precise and simple control of the stroke length.
- ◆ High speed repeat cycle.
- ◆ High productivity with multi-spindle heads

Optional accessories:

- ◆ Quick change tap chuck
- ◆ Multiple spindle heads
- ◆ Foot switch
- ◆ Pole change unit
- ◆ Left hand attachment
- ◆ Pole change unit
- ◆ External output unit
- ◆ Extension cable 197" (5m)

Standard accessories:

- ◆ Double ended wrench
10x13 (0.39" x 0.51"), 41x27 (1.61" x 1.06")
32x19 (1.26" x 0.75") for BT61, BT71
50x36 (1.97" x 1.42") for BT81
- ◆ Hexagon bar wrench 0.16" (4)
- ◆ Lubricant 0.5 Liter (0.13 gal.) for BT61,
1.0 liter (0.26 gal.) for BT81
- ◆ Instruction manual



SPECIFICATIONS FORDUAL SPINDLE ATTACHMENT

Productivity thru Ingenuity
 AUTOMATION ASSOCIATES INC.

Model	Type	NAT-8		NAT-16		NAT-32	
Specification	Vertical	NAT-8B		NAT-16B		NAT-32B	
Tapping Capacity* <small>(*Dependent upon material, pitch etc.)</small>		0-1/2"		#6-1"		5/16-1-3/8"	
Max. Spindle Stroke		1 1/2"		2 1/2"		2 3/4"	
Spindle Taper		2A Jacobs		#2 Morse		#3 Morse	
Distance Spindle C/L to Column		13"		17"		18"	
Horizontal Base to Spindle C/L		6 1/2"		8 1/2"		9 1/4"	
Travel of Head on Column		10 1/4"		12"		12"	
Distance from Spindle to Table w/o Tap Holder		3 1/2" to 13 1/4"		6 1/2" to 18 1/2"		6 1/2" to 18 1/2"	
Work Table Surface		8 1/2" x 9"		13 1/2" x 13 1/2"		13 1/2" x 15"	
Space Required		24" DP x 13" W x 29" H		32 1/2" DP x 16 1/2" W x 41" H		34" DP x 20" W x 45" H	
Max. No. Strokes/Min.		50		25		20	
Repeatability of Stroke		1/5 of pitch per Rev.		1/5 of pitch per Rev.		1/5 of pitch per Rev.	
Motor Rating (220/440V-3Ø, 60 CY) Control Circuit: 115-60-1Ø		1/2 H.P.		1 H.P.		2 H.P.	
Shipping Weight Approx.		210#		530#		700#	
Spindle Speed (rpm)		1600, 900, 500		620, 340, 190		240, 120, 60	
Available Standard Tapping Pitch Gears	Threads Per Inch	80, 72, 64, 56, 48, 44, 40, 36, 32, 28, 27, 24, 20, 19, 18, 16, 14, 13		44, 40, 36, 32, 28, 24, 20, 18, 19, 16, 14, 12, 11 1/2, 11, 10, 9		32, 28, 27, 24, 20, 19, 18, 16, 14, 13, 12, 11, 11 1/2, 10, 9, 8, 7	
SPECIAL PITCHES AVAILABLE ON REQUEST							
Metric Pitch Gears		0.25, 0.3, 0.35, 0.4, 0.45, 0.5, 0.6, 0.7, 0.75, 0.8, 0.9, 1.0, 1.25, 1.5		.45, 0.5, 0.6, 0.7, 0.8, 0.9, 1.0, 1.25, 1.5, 1.75, 2.0, 2.5		1.00, 1.25, 1.5, 1.75, 2.0, 2.5, 3.0, 3.5	
Available Tap Adapter Sizes		0-6, 8, 10, 12, 1/4, 5/16, 3/8, 7/16, 1/2		6, 8, 10, 12, 1/4, 5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8, 15/16, 1		5/16, 3/8, 7/16, 1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8, 15/16, 1, (1 1/16, 1 1/8), (1 3/16, 1 1/4), (1 5/16, 1 3/8)	
Available Pipe Tap Adapters		1/8		1/8, 1/4, 3/8, 1/2		1/8, 1/4, 3/8, 1/2, 3/4	



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Represented by

