

Ettco-Emrick number 22 tapping head, version 2

By R.G. Sparber

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I bought this tapping head on eBay and am starting to understand how to use it.



Here is the head next to a 6" ruler. It weighs about 13 pounds.



The tap chuck has 3 spring loaded fingers that adjust to hold a little less than 1/4" to maybe 1/2".



You can see the floating vise that holds the square shank of the tap to the right of the chuck.



Here is the chuck with no tap in it. This part makes sense to me and seems to work just fine.



Here is what it looks like down the quill clamp end. I can put a screw driver into that slotted disk and it does move a tiny amount. I can hear and feel a slight movement of gears but it certainly does not turn freely. A little oil and it now is fine.



Here is the tapping head mounted on my Gingery drill press. The attachment is almost as large as the head of the drill press. I had to make a split ring so the top clamp of the tapping head could grab the quill. I also made a drive adapter that is held in the drill chuck and drives the slotted disk.



Here you can see a little of how the drill chuck attaches to the tapping head.



Here are the two parts I made to get the tapping head to mount on my drill press. The top part is a split ring that fits inside the clamping flange at the top of the head. It is made of CRS and took about an hour to bore out.

The bottom part joins the chuck to the drive slot. I started with a 7/8" diameter piece of round 12L14 and turned the shank to 1/2" to fit the chuck. I then transferred to the mill and cut the rectangular part. The rest of the round stock was then sawed off. Clean up was done on the lathe.

The drill chuck can hold this adapter solidly enough that the motor actually stopped during a particularly difficult tapping try.

I need to run the tapping head at a lower speed in order to get more torque.

Rick Sparber
rgsparber@AOL.com