



TRS1000 series Tap Right System Installation & troubleshooting

Warning

The TRS1000 series has been PARTIALLY pre-assembled. A cable tie has fastened the upper and lower arms, and gas cylinder has been compressed at same time. Please note there will be a torque reaction when you cut off the cable tie. Before connect with air supply. Make sure all hoses and fittings are well connected on TRS1000 unit. If you need any assistances. Please call 604-298-2933 or 905-428-1616 for technical support.

AC1000ARM

Step 1. Mounting base comes with 4x 0.35" bolt holes. Install base on a secured and flat table or work bench.

FRL unit

Step 2. Pre-installed. Please refer to FRL unit operation manual for more information. Please install air pressure gauge if packed separately.

Notes: For an optimum performance of tapping machine, the following conditions shall apply:

- 1/2" air feeding hose
- 3/8" NPT air inlet fitting to F.R.L. unit
- Dynamic pressure set at 90 p.s.i.

Tool Holder 39mm bore dia. (rigid or universal)

Step 3. Pre-installed.

Tapper (TR400S or TR700S)

Step 4. Pre-installed. Make sure tapper is in perpendicular position. Adjust the tool holder if necessary.

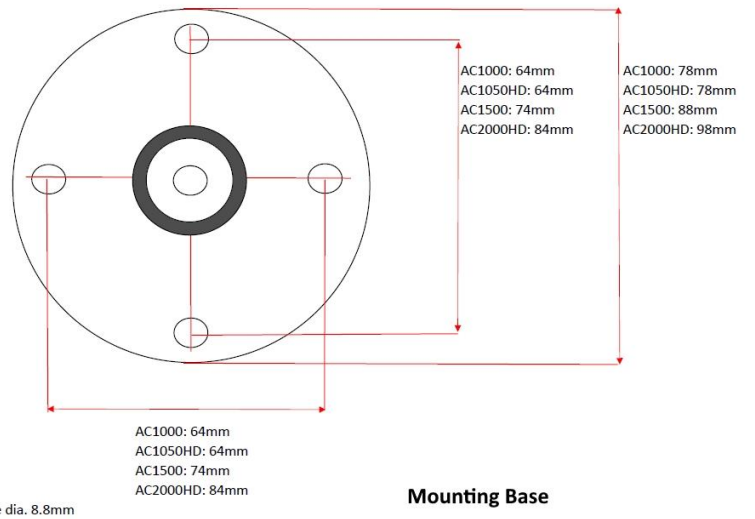
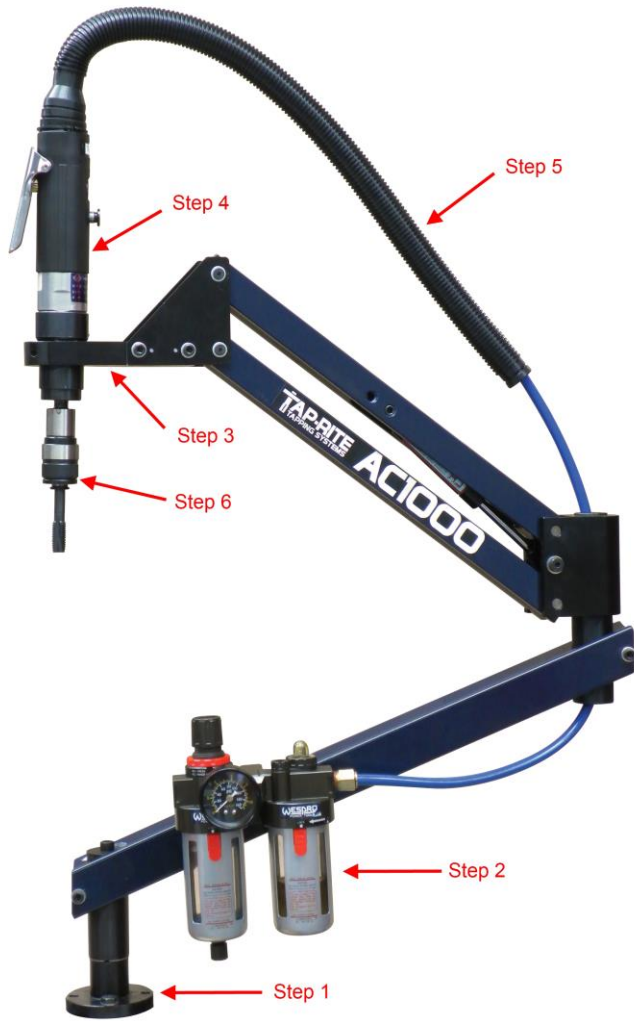
Notes: Lever-Start requires lever only to be depressed for right-hand (clockwise) direction - For left-hand (counter-clockwise) direction, reverse button must be depressed. For optimized performance, set the dynamic pressure at 90 p.s.i. on FRL unit

TRAEK1000 Air Line & Exhaust Hose Kit

Step 5. Pre-installed.

Tap collet (optional)

Step 6. Insert tap collet into tap chuck by pushing up the collar of tap chuck. Make sure the two flanges of tap collet engage the slots of the tap chuck. Pushing down the collar of tap chuck to secure the tap collet. Select the correct tap to match tap collet size required. Insert tap by depressing the lock ring on tap collet. Make sure the tap square seats into the tap collet. Release the locking ring after.

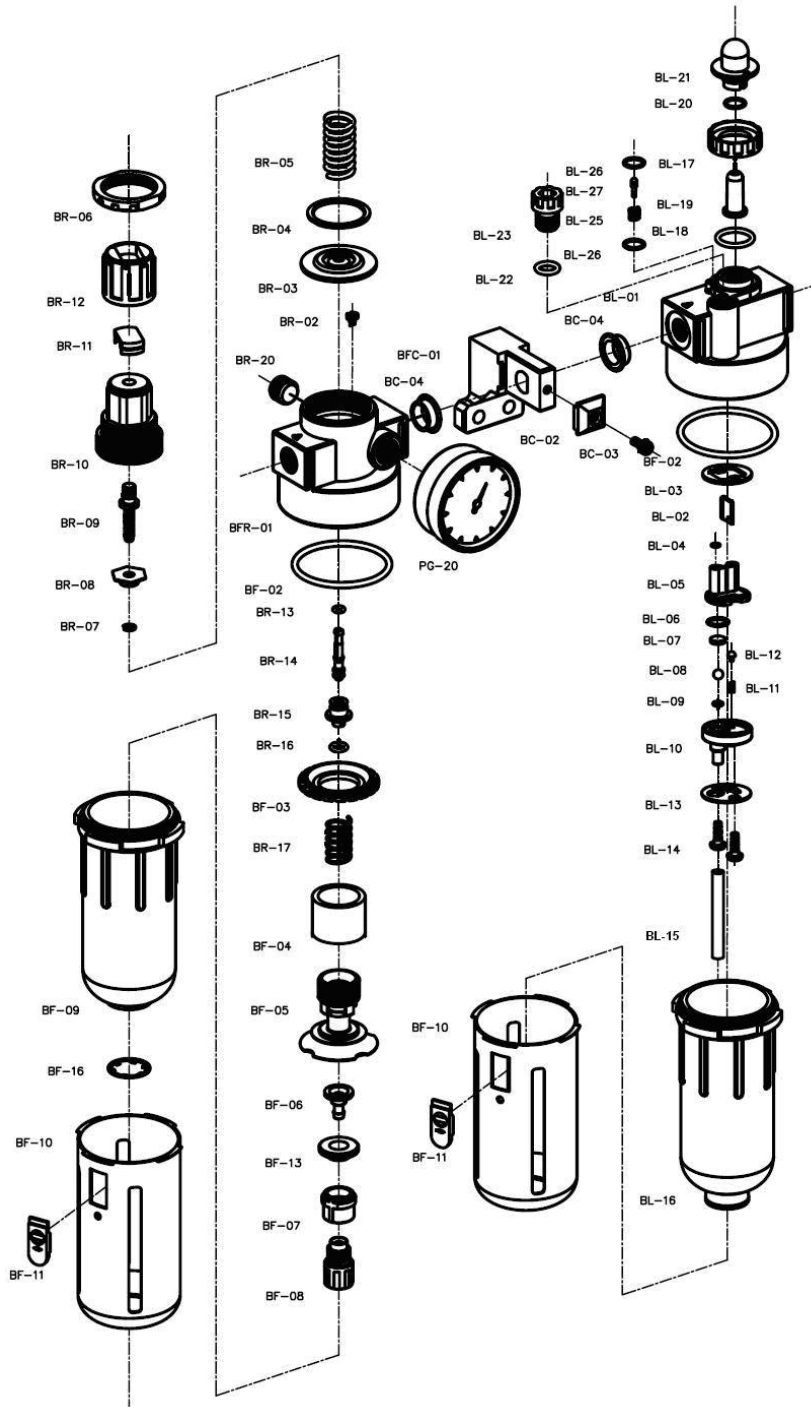




BFC200H & BFC300H series

2-piece F.R.L. units

Wespro Power Tools



| Index NO: | Part NO: | Description |
|-----------|----------|-----------------------|
| 1 | BFR-01 | Filter Regulator Body |
| 2 | BF-02 | O-Ring |
| 3 | BF-03 | Spiral Baffle |
| 4 | BF-04 | Filter Element |
| 5 | BF-05 | Umbrella Baffle |
| 6 | BF-06 | Drain Cap |
| 7 | BF-07 | Drain Nut |
| 8 | BF-08 | Drain Screw |
| 9 | BF-09 | Plastic Bowl |
| 10 | BF-10 | Bowl Guard |
| 11 | BF-11 | Push Button Key |
| 12 | BF-13 | Rubber |
| 13 | BF-16 | Locking Ring |
| 14 | BR-02 | Exhaust Nozzle |
| 15 | BR-03 | Pressure Packing |
| 16 | BR-04 | Plastic Ring |
| 17 | BR-05 | Spring |
| 18 | BR-06 | Anchor Ring |
| 19 | BR-07 | E-Ring |
| 20 | BR-08 | Regulating Nut |
| 21 | BR-09 | Governor Spindle |
| 22 | BR-10 | Governor Socket |
| 23 | BR-11 | Push Button |
| 24 | BR-12 | Pressure Governor |
| 25 | BR-13 | O-Ring |
| 26 | BR-14 | Spool |
| 27 | BR-15 | Pressure Plug |
| 28 | BR-16 | O-Ring |
| 29 | BR-17 | Spring |
| 30 | BR-20 | Screw |
| 31 | PG-20 | Pressure Gauge |
| 32 | BL-01 | Lubricator Body |
| 33 | BL-02 | Distance Piece |
| 34 | BL-03 | Packing |
| 35 | BL-04 | O-Ring |
| 36 | BL-05 | Distance Block |
| 37 | BL-06 | O-Ring |
| 38 | BL-07 | Filter Leaf |
| 39 | BL-08 | Ball Steel |
| 40 | BL-09 | O-Ring |
| 41 | BL-10 | Governor |
| 42 | BL-11 | Spring |
| 43 | BL-12 | Stack Adjuster |
| 44 | BL-13 | Setting up piece |
| 45 | BL-14 | Screw |
| 46 | BL-15 | Tube |
| 47 | BL-16 | Plastic Bowl |
| 48 | BL-17 | Adjusting Ring |
| 49 | BL-18 | O-Ring |
| 50 | BL-19 | Drip pipe |
| 51 | BL-20 | O-Ring |
| 52 | BL-21 | Visi-Dome |
| 53 | BL-22 | O-Ring |
| 54 | BL-23 | Filling plug |
| 55 | BL-25 | Spring |
| 56 | BL-26 | O-Ring |
| 57 | BL-27 | Enjeter Pin |
| 58 | BFC-01 | Mounting Bracket |
| 59 | BC-02 | Anchor Block |
| 60 | BC-03 | Screw |
| 61 | BC-04 | Packing |

Specify Air Inlet 1/4" or 3/8" when ordering BFR-01, BC-04 and BL-01

F.R.L Unit Operation manual

1. Installation

- Install F.R.L. as close as possible to the pneumatic equipment for which they are used.
- Make sure the air flows from IN direction (the end marked with ►).
- The FRL unit is pre- assembled except pressure gauge. It is recommended to wrap pipe thread tape (not supplied) on all threaded fittings.
- If there is a need to relocate the FRL. Please make sure the FRL units are aligned and joined tightly after reconfiguration.
- Remove filling plug and add Wespro Air Motor Oil. Do not fill more to than 80% capacity of lubricator's bowl. To prevent oil over-flow when air pressure is applied.
- Make sure the service pressure does not exceed 135 p.s.i.

2. Regulator (pressure regulation)

- To increase the pressure by pulling up the pressure governor and turning clockwise. By turning counterclockwise will decrease pressure. Push the pressure governor down to lock position after air pressure is set.

Note: Attempting to turn the pressure governor in the lock position will cause air leakage and/or damage the pressure regulator.

3. Filter (drain discharge)

- Filter should be checked regularly for water accumulation.
- Discharge and drain water before it reaches the baffle plate.
- Turn the drain nut counter-clockwise for discharging the drain.

Note: Do not over-tighten drain nut. It may cause damage.

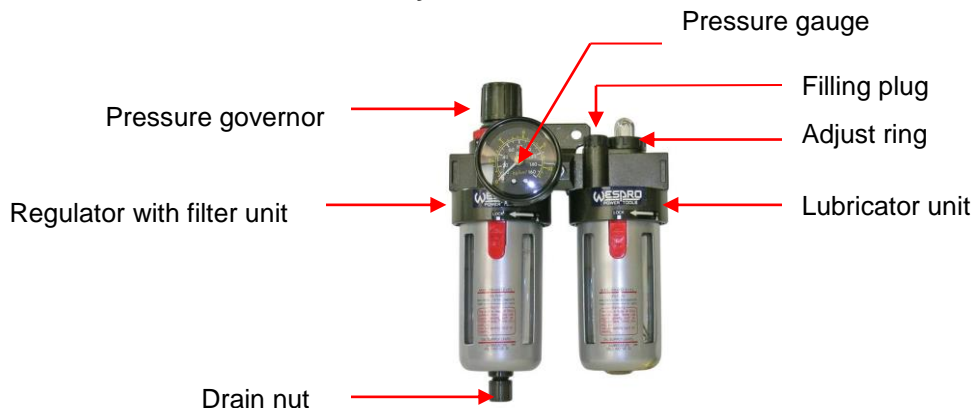
4. Lubricator (oil flow)

- For oil supply volume regulation, turn the adjust ring counter-clockwise to increase oil flow speed. Clockwise to decrease oil flow speed. 0 is for minimum and 9 is for maximum flow speed.

Note: Oil volume per drop is approx. 0.02 ml. Recommend 2 drops/per min for tools' air consumption 10 cfm.

5. Maintenance

- Disconnect the air supply and depressurize the units prior to servicing.
- Use neutral cleanser when cleaning polycarbonate bowls.
- Check oil level. Refill if necessary.
- Drain the water from bowl if necessary.



Picture shown BFC300H

WARNINGS AND CAUTIONS FOR SAFE OPERATION

- **WEAR EYE PROTECTION WHEN OPERATING THIS UNIT**
- **HEARING PROTECTION IS RECOMMEND**
- **TURN OFF THE AIR SUPPLY PRIOR ADDING OIL TO THE LUBRICATOR**
- **DISCONNECT THE AIR SUPPLY AND DEPRESSURIZE THE UNITS PRIOR SERVICING**
- **DO NOT WEAR JEWELRY, LOOSE CLOTHING OR LONG HAIR WHILE OPERATING THIS UNIT**
- **KEEP HANDS CLEAR OF TAP CHUCK, TAP AND ARMS WHILE ACTUATING THE MOTOR**
- **PERIODICALLY INSPECT UNITS FOR DAMAGE, LOOSE HARDWARE AND ANYTHING IRREGULAR**

TROUBLESHOOTING

| INDEX | PROBLEM | CAUSE AND REMEDY |
|-------|--|--|
| 1 | Loss of power | Dynamic pressure must be in between 90 to 100 p.s.i.. Check the air pressure gauge when lever is depressed. Adjust air pressure if necessary. Refer to enclosed F.R.L Unit Operation manual. Excessive air pressure will wear parts prematurely and void the warranty. |
| | | Lack of lubrication. Recommend 2 to 3 drops per minute on TR400S and 700S series. Refer to enclosed F.R.L Unit Operation manual for adjustment. Use only air motor oil. Recommend Wespro AMO or NFO series air motor oil. |
| | | Check the built-in air regulator is proper set at max. speed on TR400S or TR700S. |
| | | Air leaks from hose connections. Check all connections and re-tighten all fittings if necessary. |
| 2 | Tap is jammed | The tapper is not in perpendicular position. Adjust tool's holder, which is held by 4 cap screws on articular arm. |
| | | Workpiece is not flat and leveled. Adjust workpiece if necessary. |
| | | Tap must be well lubricated or oiled prior tapping. |
| | | Tap might be worn out. Use a new tap to verify. |
| | | Check the run out of tap chuck, tap holder and tap. They might have been damaged. Replace them if necessary. |
| | | Improper tap. Use spiral point for through-hole applications. Spiral flute for bottoming (blind-hole) applications. Also see Fig.1 for proper torque setting on clutch tap collet. |
| | | Drilled hole diameter is under size. Refer to correct tap drill sizes. |
| 3 | Broken taps | Too much downward pressure to start the tapping process. Apply ONLY sufficient downward pressure. The tap will engage itself and follow the drilled hole. |
| | | Tap is dull. Replace a new tap. |
| | | The clutch tap collet is over-torque. Adjust to proper torque setting. Refer to Fig. 1. |
| 4 | Excessive air motor oil comes out from exhaust | Refer to enclosed F.R.L Unit Operation manual. Adjust to proper oil drop per minute. |
| 5 | RPM is slow | Refer to INDEX 1. |
| 6 | Watery air motor oil comes out from exhaust | Too much water traps in filter cup. Discharge and drain water from air filter. Refer to enclosed F.R.L Unit Operation manual. |
| 7 | Articulating arm can not support air motor | Gas cylinder worn out. Replace the gas cylinder. |
| 8 | Motor seize | Disconnect air supplier and check the tap chuck can be turned by hand. If it is turntable, refer to INDEX 1 & 2. If not, contact Tap-Rite service centres for repair process. |

05/10/18



To adjust the clutch tap collet

- Use a small flathead screwdriver to prop circlip out from circlip's tail
- Use pin spanner to adjust torque ring
Clockwise---increase torque
Counter-clockwise---decrease torque
- Re-install circlip back and make sure the tail of circlip is in the notch of torque setting ring