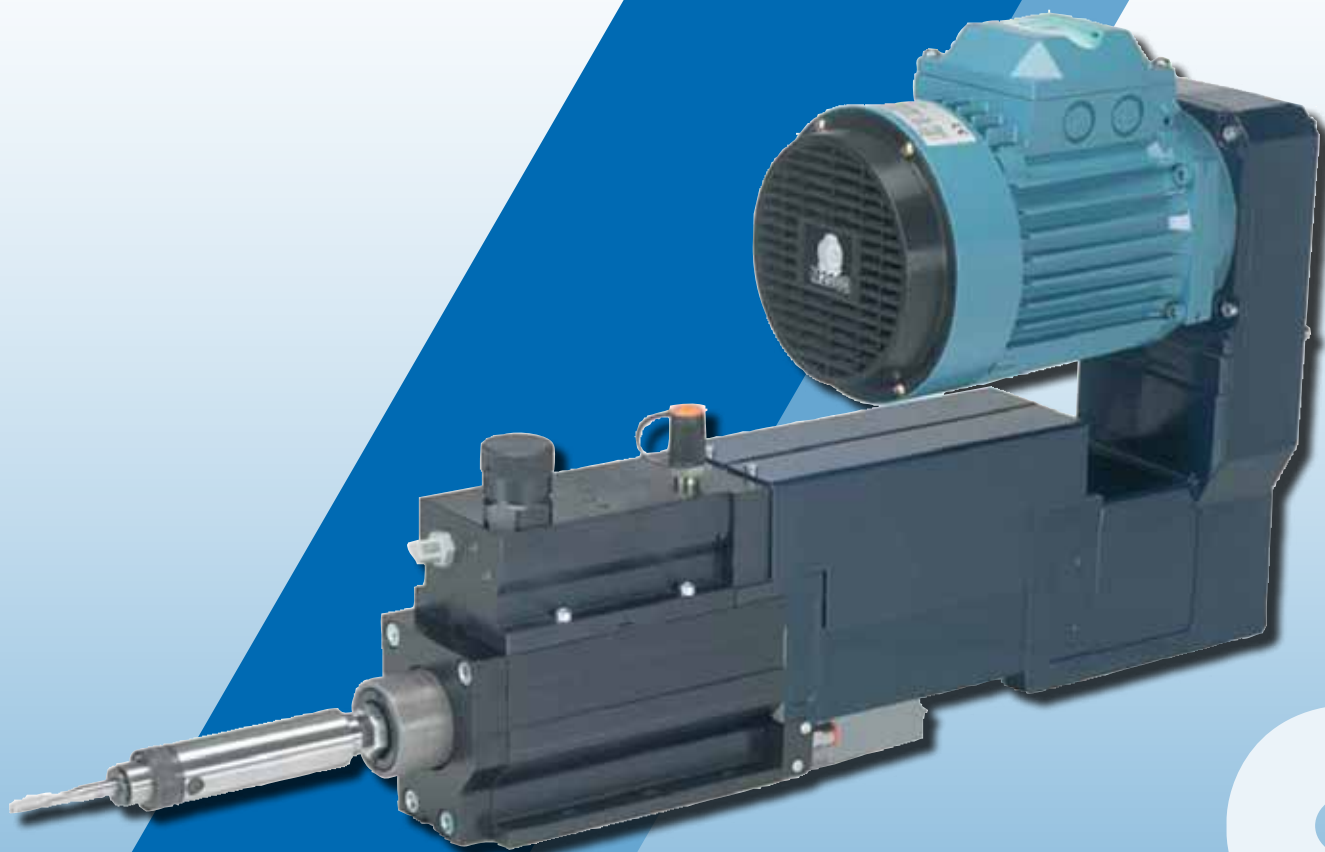


# TAPPING UNITS

**BAHCO**  
DORTMUND



**ELECTRO PNEUMATIC  
TAPPING UNIT  
SERIES BEG 48**

**BAHCO**

The BEG 48-series is a flexible electro-pneumatic unit in a modular design. The electric motor runs the spindle, while the feed is pneumatic. Hydraulic feed control makes it possible to use rapid advance and to adjust the feed rate in proportion to the pitch and the rpm. A tapping collect or a tapping spindle gives the unit the necessary length compensation.

The series is available with JT2 taper or integrated ER32 chuck as well as with multi-spindle heads.

- Compact yet flexible design
- Modular hydraulic feed control for the whole stroke
- Smart depth control
- Linear transducer for total control of the complete cycle (optional)

Guidelines for choice of unit [M-Thread]												
Tapping unit	Capacity in Steel				Capacity in Aluminium/Brass				Capacity in wood/plastics			
No. of spindles	1	2	3	4	1	2	3	4	1	2	3	4
<b>BEG 481</b>	M6	M5	M4	M3	M10	M8	M8	M6	M14	M8	M8	M8
<b>BEG 482</b>	M8	M6	M5	M3	M14	M10	M8	M8	M16	M14	M12	M10
<b>BEG 487</b>	M12	M8	M6	M6	M20	M14	M12	M10	M30	M20	M20	M16

Performance specifications at 6.3 bar				
Thrust (max.)	1650-2000 N		depth accuracy +/-	0.01 mm
Stroke (max. 100% controlled)	100 mm		rapid advance rate (max.)	10 m/min
Min. center to center spacing			controlled feed rate	>0.04 m/min
Single spindle	90 mm		air consumption	2.8 l/100 mm
Double spindle head	12 mm		sound level	<85 dB(A)

Motor and transmission specifications			
No. of Poles	Tapping unit / Motor at V380-420 (Y) /220-240 (Δ) 50Hz [kW]		
	BEG481	BEG482	BEG487
2	0,55	1.1	2.2
4	0.37	0.75	1.5
6	0.25	0.55	1.1
8			0.55

We do not recommend floating tapping at turns over 2000 U / min. use. In addition, we point out that the max. speed when cutting reduced in deep holes, blind holes or the use of larger threaded heads.

- Motor specifications shown in the tables are valid for 380-420V (Y)/220-240V (Δ) (±5%), 50Hz. These motors can also be used at 440-480V (Y) (±5%), 60 Hz. If so the rpm will increase by ~20% and the power by 15% relative to the data for 50Hz. We also offer motors for other voltages and frequencies. Please state voltage and frequency when requesting a quote or ordering.

- the torque at the spindle for a specific rpm is calculated as:

$$M = (P_{[kW]} \times 9500) / \text{rpm}$$

# TAPPING UNIT BEG48

Technical data										
No. of Poles	Spindle rpm with gear ratio and 50Hz									
	2.5:1	2.1:1	1.8:1	1.6:1	1.4:1	1.2:1	1:1	1:1.2	1:1.4	1:1.6
2	1130*	1350	1580	1750						
4	560*	670	780	860	1030	1190	1390	1620	1880	
6	360*	440	510	560	670	780	910	1060	1230	1470
8	270*	330	380	420	500	580	680	790	920	1100

No. of Poles	Spindle rpm with gear ratio and 50Hz		
	1:1.8	1:2.1	1:2.5
2			
4			
6	1630	1900	
8	1210	1420	1730*

\*Not available for BEG487


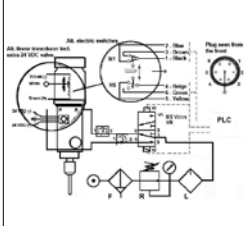
**Dimensions in mm**

	BEG 481	BEG 484	BEG 487
A	210	250	311
D	140	160	175

optional orientation of the transmission housing (in 90° steps)

Weight 29-40 kgs

Necessary components	
Tapping attachments	Type
	<b>Length compensations up to 10 mm</b> Integrated ER32 chuck with length comp. collets M4-M12
	<b>Length compensations up to: 25 mm</b> Tapping spindle GS12E M4-M16 (JT2) 40 mm Tapping spindle GS24E M8-M30 (ER32+B18/Ø16 taper shank)
Tap holders	Type
	<b>ER32 collets with compensation</b> M4-M12
	<b>T12 for GS12E</b> <b>T24 for GS24E</b>
Limit Switches	Type
	<b>Electric switches</b> <b>Pneumatic switches</b> <b>Inductive switches</b> <b>or Linear Transducer</b>

Accessories	
Multi-Spindle-Heads	Type
	<b>Adjustable heads</b> VH04, VH06, VH08, VH10, MBKV 40
Controls	Type
	<b>Controls for BEG48-units with:</b> Electric switches Pneumatic Switches Inductive Switches or Linear Transducer



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All information subject to change without further notice.  
No responsibility is taken for the correctness of the named specifications.