

## Operating Instruction Booklet

### Pneumatic Tapper

**194-431**  
**194-431-1**

**302770 A**  
**302958 B**

Dear Customer:

This tool is the result of more than 75 years of experience in the design and manufacturing of pneumatic tools for the industrial market.

We kindly ask that you read these operating instructions carefully so that you will be able to use this tool safely and for many years to come.

If you need additional information, please contact your DEPRAG Representative, one of our international support offices or us direct at DEPRAG. We will be happy to answer any questions. Please visit our web site: [www.deprag.com](http://www.deprag.com)

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## 1 Safety Tips

### 1.1. General Safety Tips



**Before operating tool make sure to carefully read and observe this operating instruction.**

Generally, the operator of the equipment and/or machinery is responsible for the equipment's perfect condition and operation, while observing all necessary safety regulations. The equipment and/or machinery has been constructed in accordance with the newest level of technology while recognizing all necessary safety-related requirements. Nevertheless, while operating the equipment and/or machinery there is a risk of bodily harm to the operator as well as damage to equipment and/or machinery and other property.

Operate the equipment and/or machinery only if equipment/machinery

- Is used for the task it was designed for
- is in perfect working condition and safe to use.


It is important to observe the technical data of the equipment, especially in regards to the environmental temperatures. The designated area of use for this equipment is clearly described in chapter *Designated Equipment Use* and those requirements have to be observed as well. Prerequisite for the safe conduct and the uninterrupted operation of the equipment, is the knowledge of the basic safety tips and the safety regulations. Additionally, all current regulations for a safe operational area, for accident-prevention guidelines of electrical and mechanical installations, as well as noise suppression demands must be observed. During any maintenance or repair work, a clean work surface is recommended. Also, it is not recommended to either eat or smoke during repair or maintenance. Arbitrary changes made to the equipment, which alters its designated use, voids the warranty and cancels the manufacturers liability.

- The tool is not insulated to protect against an electrical power surge.
- It is not recommended to use this tool in explosive hazardous environments, unless it was specifically designed for such a use.

The operating instruction booklet, especially the safety symbols and safety tips attached to the equipment or included in the documentation, must be observed at all times by all persons getting into contact with the equipment.

## 1.2. General Safety Tips for Drills and Grinders



- Use a secondary handle (side handle), if reaction torque cannot be safely supported by one hand.
  - If the machine locks-up, an increased reaction torque occurs. Reason for lock-up: Tool operates over capacity; jamming of the drill bit in material or when drill bit breaks through the material.
  - An unexpected motion of the tool or the breakage of a drill bit may cause an injury.
  - Uncomfortable or incorrect holding of tool, will not allow Operator to correctly react to an unexpected motion of the tool.
  - Disconnect tool from air supply, prior to changing inserts.
  - Prior to operating tool, make sure that collet and drill bit is securely installed.
  - Wear no loose clothing or jewelry, for movable parts [collet/bit] may seize them. Wear a hairnet if operator has long hair.
- 
- Use integrated or additionally supplied side-handles to reduce reaction torque.
  - Reduce down pressure, shortly before bit breaks through the material to be drilled.
  - Prior to operating tool, remove key from chuck.
  - If the tool is to be suspended from a Balancer, make sure it is securely attached to it.
  - Make sure to not exceed maximum operating pressure given by manufacturer. Add a pressure regulator to check operating pressure before reaching the actual tool.
  - Keep in mind that tool will continue to rotate, once it has been turned off. [inertia]
  - Turn tool off, if the airflow is suddenly disrupted.

## 1.3. Owner Obligation

The owner is obliged to only let persons operate the equipment, who

- are familiar with basic work environment safety rules and accident-preventing regulations. Also, those persons must have been instructed in the correct use of the equipment.
- have read and understood all safety and warning notifications in the Operating Instruction Booklet, as well as all other documentation pertaining to this equipment.
- check and confirm at regular intervals, that a safety oriented operation is guaranteed.

Only qualified and authorized personnel is allowed to operate, maintain and repair this equipment. A malfunction, which impairs operator safety, must be immediately removed.

## 1.4. Operator Obligation

Personnel, who is engaged in the operation of the equipment, must always be committed to

- observe the basic safety and accident preventing regulations,
- read and observe the safety and warning notifications of this operating instruction booklet.

## 1.5. Warranty and Liability

Unless otherwise specified, our “General Sales and Delivery Conditions” apply. Warranty and liability claims in regards to persons or equipment damages are invalid, if one or several of the following causes apply:

- Use of the equipment in a non-designated application.
- Improper installation, operation, service or maintenance of the machine.
- Operation of the machine with either defective or removed safety and protection devices.
- Non-observance of the requirements stated in the operating instruction booklet, in regards to transportation, storage, mounting, installation, operation, maintenance and service of the equipment.
- Structural change or adjustment on the equipment to a non-designated use.
- Inadequate supervision of wear parts.
- Improper repair, inspection or maintenance.
- Catastrophic cases because of a war, acts of god or other reasons which are beyond our control.

## 1.6. Symbol Description



Read and observe the Operating Instruction Booklet, prior to and during operation of tool.



### DANGER

Reference to an immediate danger to a person. May lead to serious injuries or even death, if unobserved!



Properly recycle environmentally damaging grease, cooling agents or detergents.



### RECOMMENDATIONS

Important or additional information on the equipment or in the documentation.



Use eye protection or wear safety goggles.



Wear hearing protection.



Warning against hand-injuries.

Attention: Keep away your hands from areas, which are marked with this symbol!



Hands may be crushed, seized or otherwise injured.



ESD-protected area

Equipment may be damaged or destroyed by an electrostatic discharge.



Maintenance and repair on hydraulic and pneumatic equipment may only be performed by specially trained personnel!  
Disconnect equipment from air supply, prior to repair of pneumatic or hydraulic equipment.



Provide regular preventive maintenance on hoses and airlines.  
Exchange hose lines, even if there is no visible damage!  
(Observe corresponding requirements of the manufacturer!)

After repair and maintenance, check the following items:

- make sure all detached and re-attached connections are solid.
- confirm that removed covers, screens or filters were re-installed
- During disconnecting or reconnecting of an air-operated equipment, injury may occur due to a whipping air-hose

After conclusion of maintenance or repair and prior to start of operation, make sure to

- remove all materials, tools and other supplies needed for the maintenance or repair from work area of the equipment
- remove leaking liquid or oils
- make sure all safety devices on the equipment work perfectly!

## 1.7. Observe Environmental Regulations



When working on or with the equipment, it is imperative to observe all requirements in regards to waste-disposal and proper recycling.

Especially during installation, repair or maintenance, water damaging agents such as

- lubricating grease and oil
- hydraulic fluid
- cooling agents
- solvent-containing cleaning agents

must not leak into the ground or into the sewage system!

Such materials must be stored, transported, contained and recycled in suitable containers.

## 2 Designated Equipment Use

The Tapper has been designed for tapping into steel, aluminum or other materials.

## 3 Installation

- Blow out air line and pressure hose, prior to connection it to the equipment.
- The hoses must be free of bends and kinks.
- Make sure, that all air lines have a sufficient cross-section and remove possible throttle areas.
- All DEPRAG Drills resp. Tappers, may be operated either with or without lubricated air (see paragraph: Maintenance and Upkeep). Best results are achieved, when machine is lubricated with 1 – 2 drops of oil per 1m<sup>3</sup>. When operating with oilfree air, a performance reduction of up to 20% occurs!
- Connect the equipment as follows:

a) for standard operation connect equipment to a maintenance unit, consisting of Filter with condensation reservoir, Regulator and Oiler. When choosing a maintenance unit, observe air consumption of the machine (see Technical Data)

Air Consumption	Thread Size	Part No.
0,05 – 0,5 m <sup>3</sup> /min	1/4	820454 A
0,15 – 1,5 m <sup>3</sup> /min	1/2	820455 A
0,8 – 6,0 m <sup>3</sup> /min	3/4	821608 A

b) for the use with minimal lubrication connect to a filter-regulator consisting of Filter with condensation reservoir and pressure regulator

Air Consumption	Thread Size	Part No.
0,05 – 0,5 m <sup>3</sup> /min	1/4	822408 A
0,15 – 1,5 m <sup>3</sup> /min	3/8	826981 A
0,5 – 1,5 m <sup>3</sup> /min	1/2	822409 A
0,8 – 6,0 m <sup>3</sup> /min	3/4	826982 A

in connection with a Point-of-Use Oiler (Part No. 378077 A)

c) For oilfree operation, connect to Filter/Regulator, consisting of Filter with condensation reservoir and Pressure Regulator.

Air Consumption	Thread Size	Part No.
0,05 – 0,5 m <sup>3</sup> /min	1/4	822408 A
0,15 – 1,5 m <sup>3</sup> /min	3/8	826981 A
0,5 – 1,5 m <sup>3</sup> /min	1/2	822409 A
0,8 – 6,0 m <sup>3</sup> /min	3/4	826982 A

- Check air pressure at F/R/L outlet. The Regulator needs to be adjusted to an airflow of 6.3 bar (90 PSI). A higher pressure than 6.3 bar leads to increased wear and tear. Pressure below 6.3 bar leads to performance loss.

In regards to air-quality according to ISO8573-1, we recommend:

	CLASS	RESIDUE	RESIDUE OF DUST		RESIDUE OF WATER	
		OF OIL	Particle Size $\mu\text{m}$	Concentration max. $\text{mg}/\text{m}^3$	Dew Point $^{\circ}\text{C}$	Pressure Concentration max. $\text{g}/\text{m}^3$
Lubricated Air	4	5	15	8	+3	6
Dry Air	3	1	5	5	-20	0,88

## 4 Handling

The tool should only be used while observing all safety- and danger recommendations.

Machine starts by lever valve.

## 5 Assembly - Disassembly

**Disassembly:** (see Spare Parts Drawing)



**Prior to disassembly, disconnect equipment from air-supply! Only experienced maintenance personnel may assemble or disassemble this equipment.**

After repair or maintenance, verify that equipment runs to specification!

Principally, use only DEPRAG original spare parts. Otherwise, a reduction in equipment power output and an increased maintenance requirement will occur.

If NON-DEPRAG parts are installed, DEPRAG is entitled to void any existing warranty and liability obligations.



**Attention:**

Motor- and gearing parts may be damaged if dropped!

1. Knock on cylinder pin 800026 to remove it from the holder.
2. Use press bolts 460227 to push off tapping chuck.
3. Loosen cover 302764 by slightly twisting it (1-2 thread rotations).
4. Unscrew gear housing 302763.

5. Unscrew valve housing 301279 with complete lever valve (right-hand thread).
6. Remove motor and gearing parts towards connecting side.
7. Remove bearing cover and remove and check vanes.
8. Minimum width of vane should be 8 mm. Vanes, which have a smaller width or show visible damage, need to be replaced.



**NOTE**

Make sure to replace complete sets of vanes (5 pcs) only.

**Assembly:**



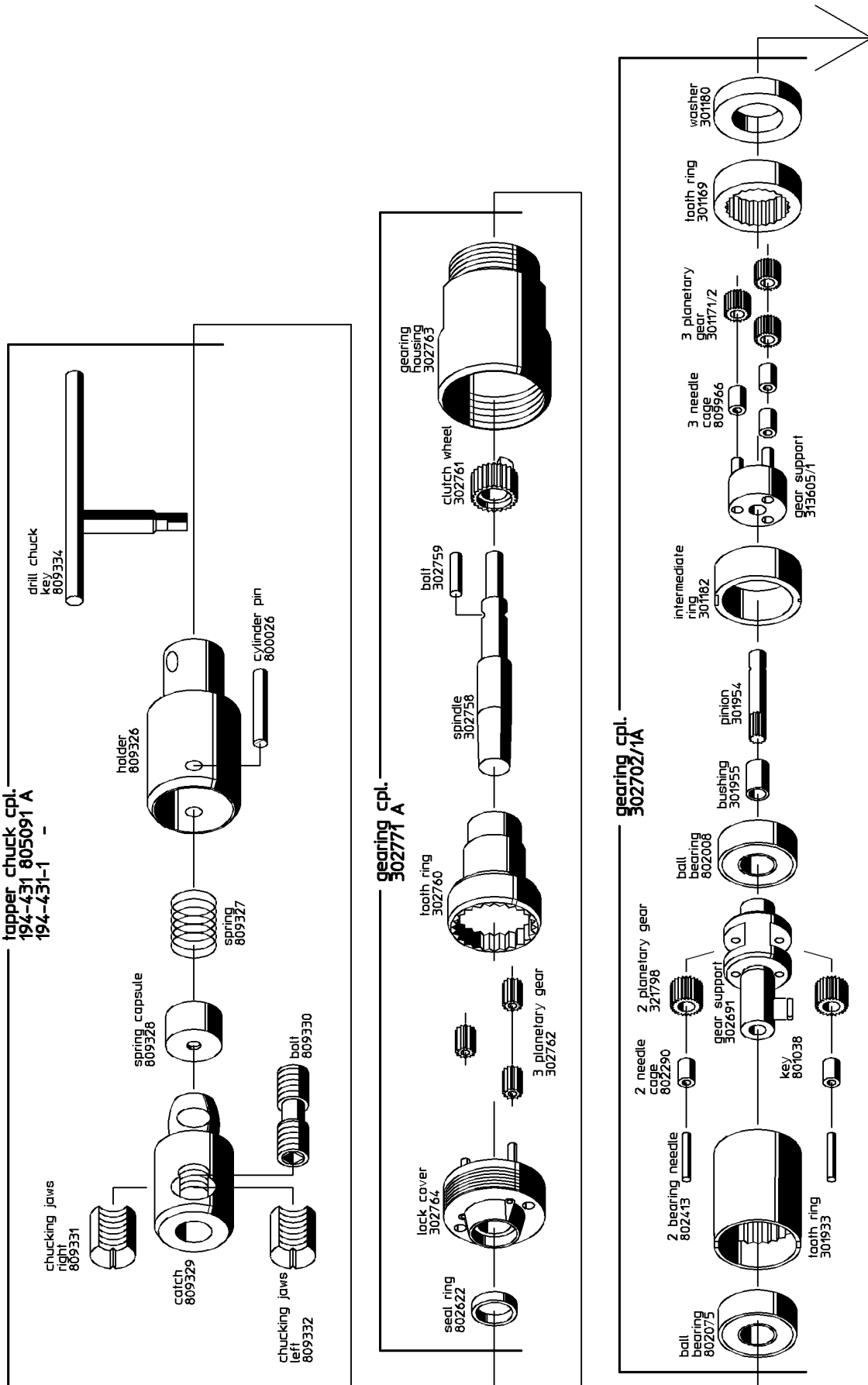
**Use the DEPRAG Grease 807293 (100-g tube) to grease the ball bearing, needle bearing and gearing parts prior to reassembly.**

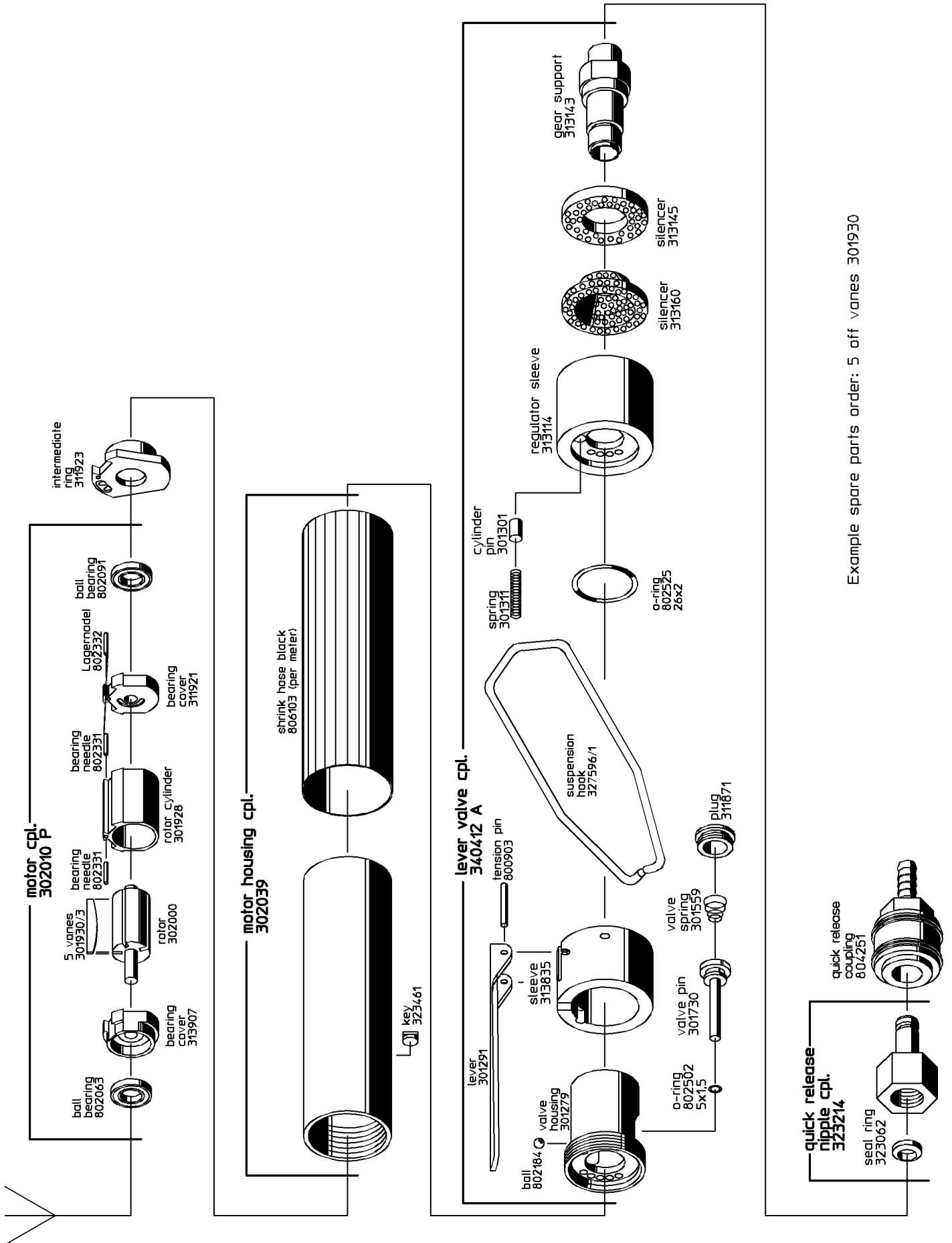
1. Insert the five vanes into the rotor und assembly the bearing cover and the ball bearing.
2. Insert motor parts and gear parts into motor housing.
3. Assembly valve housing 302887/1 with lever valve (right hand thread).
4. Install the gear housing 302763 and tighten the lock cover 302764.
5. Tighten quick-change chuck using cylinder pin 800026.

**Special Repair Tools (Optional Equipment)**

<b>PART No.</b>	<b>NAME</b>	<b>USAGE</b>
461618	Wrench	For orientation inside the housing
460227	Press Bolt	For disassembly the drill chuck

## 5.1. Spare Parts Drawing





Example spare parts order: 5 off vanes 301930

## 6 Maintenance and Upkeep

Operator can perform inspection and maintenance. Only specialized personnel may perform assembly or disassembly of this equipment. Faulty assembly may lead to danger for the operator and to permanent damage of the equipment

This drill spindle requires little maintenance. If the following rules are observed, the tool reaches its promised high life span and remains in a safe condition to use.

- Regularly check equipment for external damage.
- Check the air filter (bleed water condensation on a regular basis) and the oil reservoir, as well as the oiler adjustment [if operated with lubricated air]. We recommend DEPRAG-Oil, Part No. 790081 E (250 cm<sup>3</sup>).
- After repair and prior to assembly, grease gearing parts with DEPRAG grease Part No. 807293 (tube: 100 g).
- After assembly, drip 2 – 3 drops of oil into the drill's air intake.
- The gearing, balls and needle bearing, as well as the seal rings, must be greased every 500 operating hours or at least once a year.
- If operated in an oilfree environment, this maintenance is necessary every 250 hours.
- If machine has not been operated for some time, drip a couple drops of oil into the air inlet and let drill run for 5 – 10 seconds.
- If drill malfunctions, we recommend to send the machine to DEPRAG.

### 6.1. Wear Parts

QUANTITY	NAME	PART No.
5	Vanes	301930/3

## 7 Trouble Shooting

In the case of a malfunction, check and observe all instructions contained in this technical documentation. If necessary, adjust equipment as needed.

Possible faults and their causes are shown below:

FAULT	CAUSE	SOLUTION
Insufficient Power	Restriction in air hose	Remove bends or other restrictions
	Air pressure too low	Minimum air pressure should be 90 PSI for maximum performance
	Screen Support or silencers are clogged	Clean or replace screen support or silencers.
	Hose I.D. is too small	Use required hose I.D.
	Insufficient lubrication	Provide the required air-quality
Machine does not start	No air; shut-off valve is closed.	Open shut-off valve
	Worn vanes or vanes are jammed	Exchange vanes

If necessary, send the equipment to DEPRAG.

## 8 Delivery Capacity

Please check the delivery capacity in regards to its completeness.

QUANTITY	NAME	PART No.
1	Operating Instruction Booklet	012168 EN
1	Tapper	302770 A / B

## 9 Accessories are optional equipment

NAME	PART No.
Exhaust hose	314544 A
Silencer (for exhaust hose)	313773
drill chuck (Range 0,5 – 8 mm)	804650
quick change chuck	805094

## 10 Storage

Unused machines should be stored in a dry, locked area.

## 11 Technical Data

**Manufacturer** DEPRAG SCHULZ GMBH u. CO.  
**Address** Kurfürstenring 12 - 18 Postfach 1352  
D-92224 Amberg D-92203 Amberg  
**Phone** 09621/371-0  
**Fax** 09621/371-120

### Technical Data:

<b>MODEL No.</b>	<b>194-431</b>	<b>194-431-1</b>
<b>PART NO.</b>	<b>302770 A</b>	<b>302770 B</b>
<b>Drilling into Aluminum up to (mm)</b>	M8	
<b>Drilling into Steel up to (mm)</b>	M6	
<b>chucking range for square drive of the tapping chuck, mm</b>	3-9	
<b>Air consumption (m<sup>3</sup>/min / cfm)</b>	0,4	
<b>Speed, unloaded right (rpm)</b>	650	
<b>Speed, unloaded left (rpm)</b>	1120	
<b>Power , kW</b>	0,25	
<b>Weight (kg)</b>	1,5	
<b>Required Hose I.D. (mm)</b>	6	
<b>Connecting thread</b>	G 1/4 "	
<b>Noise level (dB(A))</b>	74	
<b>Vibration m/s<sup>2</sup></b>	< 2,5	

## 12 Disposal

Unused machines should be stored in a dry, locked area. Disassemble the machine for the required disposal complete. Observe local and environmental regulations for the separation and recycling of materials.



**Recycle waste oil to avoid environmental contamination!**

## 13 Conformity Declaration

### EC-Conformity Declaration according to the EC-Machine-Guidelines 98/37/EC, Amendment IIA

We,

DEPRAG SCHULZ GMBH & CO.  
PO Box 1352  
D-92203 Amberg

hereby confirm, that the design of the  
Tapper

**194-431**  
**194-431-1**

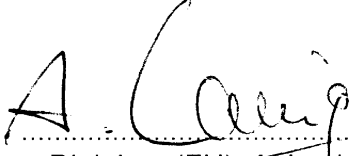
conforms to the following, relevant regulation:

- EC-Machine-Guidelines, Version 98/37/EC, Amendment No. 1 and No. 2.2.

Applicable Standard:

- EN ISO 12100-1 und 12100-2

Amberg, 05.12. 2006

  
Dipl. Ing. (FH) A. Langig  
Mr. Design Dept.

## 14 Service Locations and Authorized Partners

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