

ELECTRO HYDRAULIC TAPPING UNIT BEG 55

BEG 55 is a powerful yet compact electro-hydraulic series of units. The electric motor runs the spindle, while the feed is hydraulically powered and controlled. 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 spindle gives the unit the necessary length compensation. The series is available in two different taper options as well as with multi-spindle heads.



- COMPACT DESIGN YET POWERFUL
- INTEGRATED HYDRALIC SYSTEM
- LONG STROKE – 120 MM
- HIGH PRECISION
- LOW NOISE LEVEL

| Guidlines for choice of unit | | | | | | | | | | | [M-Thread] | | |
|------------------------------|-------------------|-----|-----|----|-----------------------------|-----|-----|-----|----------------------|-----|------------|-----|--|
| TAPPING UNIT | CAPACITY IN STEEL | | | | CAPACITY IN ALUMINIUM/BRASS | | | | CAPACITY IN PLASTICS | | | | |
| No of Spindles | 1 | 2 | 3 | 4 | 1 | 2 | 3 | 4 | 1 | 2 | 3 | 4 | |
| BEG55 | M16 | M10 | M10 | M8 | M24 | M16 | M16 | M14 | M30 | M20 | M20 | M16 | |

| Performance specifications | | | |
|-------------------------------|---------|---------------------------|-----------------|
| Thrust (max.) | 6 000 N | Depth accuracy +/- | 0.01 mm |
| Stroke (max. 100% controlled) | 120 mm | Rapid advance rate (max.) | 6 m/min |
| Min. Center to Center Spacing | | Controlled feed rate | 0.04–0.65 m/min |
| Single Spindle | 140 mm | Sound level | <80 dB(A) |
| Double-Spindle Head | 17 mm | | |

| Motor and Transmission specifications | |
|---------------------------------------|---|
| No of Poles | TAPPING UNIT/MOTOR AT V380-420(Y)/220-240(Δ)50HZ [kW] |
| 2 | 2.2 |
| 4 | 1.5 |
| 6 | 1.1 |
| 8 | 0.55 |

| No of Poles | SPINDEL RPM AT GEAR RATIO AT 50HZ | | | | | | | |
|-------------|-----------------------------------|-------|-------|-------|------|-------|-------|-------|
| | 2.7:1 | 2.1:1 | 1.7:1 | 1.4:1 | 1:1 | 1:1.4 | 1:1.7 | 1:2.1 |
| 2 | 1040 | 1370 | 1690 | | | | | |
| 4 | 500 | 640 | 830 | 1070 | 1390 | 1810 | | |
| 6 | 330 | 420 | 550 | 700 | 910 | 1180 | 1520 | 1980 |
| 8 | 250 | 310 | 410 | 520 | 680 | 880 | 1130 | 1480 |

• Motor specifications shown in the tables are valid for 380–420V(Y) /220–240V(Δ) (±5%), 50 Hz. These motors can also be used at 440–480 V(Y) (±5%), 60 Hz. If so the rpm will increase by ~20% and the power by ~15% relative to the data for 50Hz. E2 also offers 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:
 $M = (P_{[kW]} \times 9500) / \text{rpm}$

E2 does not recommend tapping with a floating holding at higher speeds than 2000 rpm. Maximum speed is lower when tapping a deep or blind hole and/or using a large thread.

