

# TAPPER

INSTRUCTION MANUAL

# GSM PRO M18

## ORIGINAL INSTRUCTIONS

For your personal safety,  
READ and UNDERSTAND before  
using.

SAVE THESE INSTRUCTIONS FOR  
FUTURE REFERENCE.

### Warning:

Only tools equipped with over load protection, when motor has been cut off due to over load, always switch on machine with no load for at least 3 minutes to reduce temperature before switch on again to avoid burn out to the motor.



Version:20151201

## EC-Declaration of Conformity

We,

**Jepson Power GmbH**  
Ernst-Abbe-Str. 5  
52249 Eschweiler  
Germany

As the manufacturer declare herewith under our responsibility that our products:

Machine description: (Function) Tapper

Type/Serial number: GSMPRO M18  
110-120V, 220-240V 50-60Hz, 450W, Class II

Year: 2019

Complies with the following standards, directives and referenced standard documents:

2006/42/EC	Machinery Directive
2014/30/EU	EMC Directive
2011/65/EC	RoHS Directive

EN 62841-1:2005

EN 62841-2-9:2015

EN 55014-1:2006+A1:2009+A2:2001

EN 55014-1:2017

EN 55014-2:2015

EN 61000-3-2:2014

EN 61000-3-3:2013

Pierre Michiels, Jepson Power GmbH, Ernst-Abbe-Str. 5, 52249 Eschweiler, Germany

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(Name and address of the person, which is authorized to compile the relevant technical documentation)

Identification of the signatory

Name: Michiels

Surname: Pierre

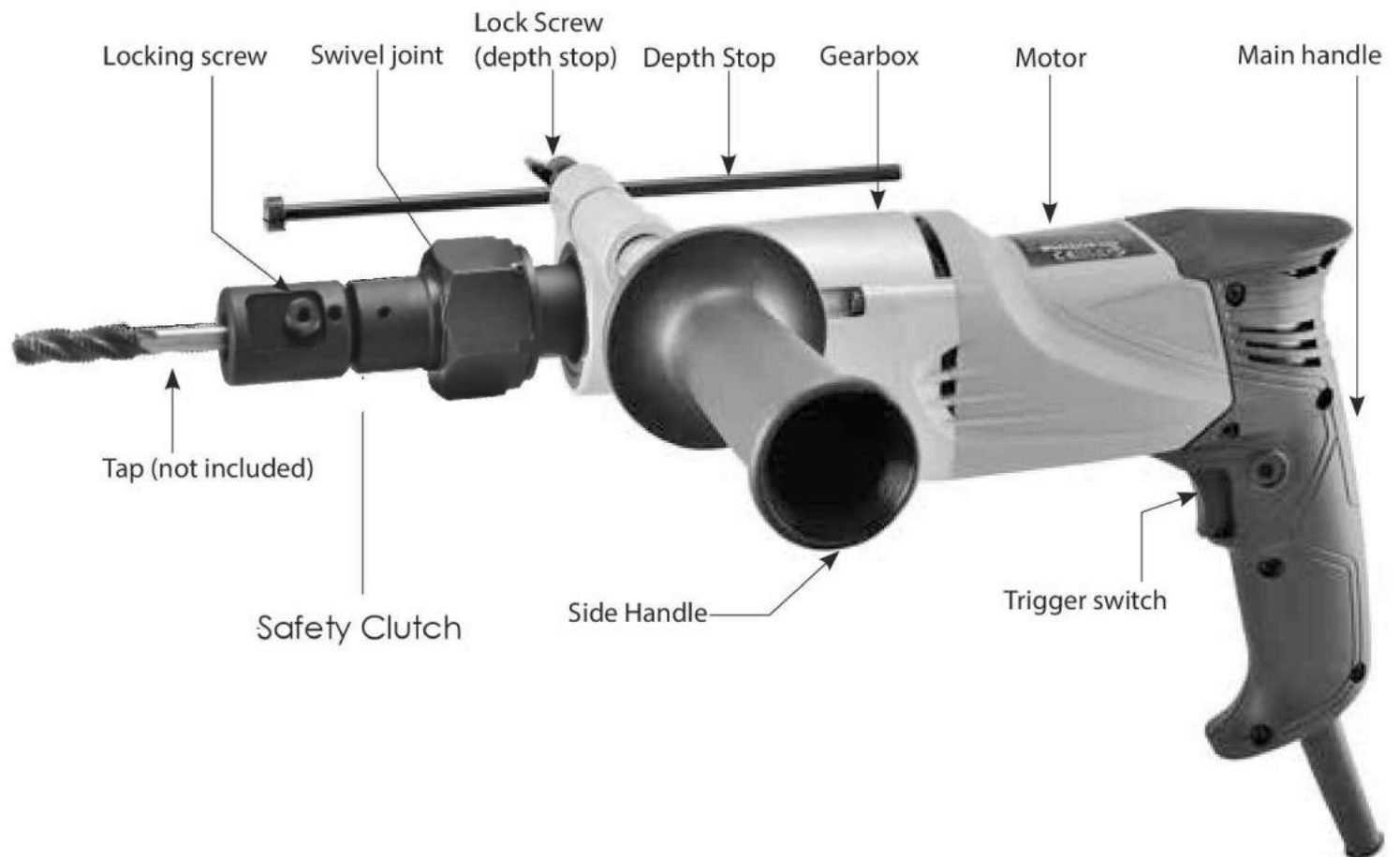
Position: CEO

Germany Eschweiler,  
6.01.2019

Place + Date

  
Signature

Power Input	North America: 4A, Other regions: 450W	
Voltage	North America: 115V, 60Hz, Other regions: See machine nameplate	
No Load min <sup>-1</sup>	Forward	280
	Reverse	680
Tapping Capacity	Steel	18mm (9/16")
	Aluminum	16mm (5/8")
Dimensions	400mm x 80mm x 200mm	
Net Weight	2.7 Kg (Not including side handle 0.45 Kg)	



## User Instructions

### Notes for the customer

The instruction manual includes important instructions as to how to operate the plant safely, correctly and economically. Observing these instructions helps to avoid risks, repair costs and downtimes and to increase the reliability and lifetime of the machine.

The instruction manual must be read and used by each person who works with the electrical equipment. This applies in particular to the "Safety Instructions" chapter. It is too late to read the manual and safety instructions when work is actually being carried out at the machine.

Always keep one copy of this manual next to the machine so that it is at hand ready to be consulted!

In case of any doubt or questions, always contact the machine manufacturer.

In addition to the instruction manual, the accident prevention regulations which apply in the country of use and the user location must be adhered to. In addition, the recognised technical rules regarding accident prevention must be observed.

### Liability and warranty

All the information contained in this instruction manual has been drawn up to the best of our knowledge and belief, taking our experience to date into consideration.

The original version of this instruction manual was drawn up in the German language and was checked by us for accuracy of content. The translation into the respective national/contractual language was carried out by a recognised translation agency.

This instruction manual has been put together with the greatest of care. However, if you should discover any incomplete items or mistakes, please inform us in writing. Your suggestions for improvement will help us to create a user-friendly manual.

### Subsequent Orders and Copyright

Further copies of this instruction manual can be ordered from the address below. We ask for your understanding that further copies are subject to charge.

Jepson Elektrowerkzeuge

Ernst-Abbe-Straße 5

D-52249 Eschweiler

Phone: +49 (0)2403 – 6455-0

Fax: +49 (0)2403 – 6455-15

Mail: info@jepson.de

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### Abbreviations

V	Volt
Hz	Hertz
W	Watt
~	AC
/min	Revolutions per minute rpm
N	Newton

## Safety Instructions

The basic prerequisite for safe handling and disturbance-free operation of this electric tool is knowledge of the basic safety instructions. In addition, the accident prevention rules and regulations which apply in the user location must be adhered to, as well as the

recognised rules of the trade with regard to safety and correct working methods.

It is not permitted to use the electric tool for other purposes than those intended by the manufacturer. Such use could give rise to unforeseeable risks.

Local working and safety rules and laws must always be followed. The same applies to regulations which apply to the environment.

Safety equipment must never be removed or bridged over.

When using oils, greases and other chemical substances, the safety regulations which apply to the particular product must always be observed! Contact with chemicals should be avoided as far as possible. Before it is permissible to work with these substances the instructions for use on the packaging must be read and followed. This applies for all chemicals, therefore also for cleaning media.

All notes and signs regarding safety and possible risks must be kept in a fully legible condition.

## Illustration of Safety Instructions

The following symbols are used in the instruction manual:

**Warning against possible danger of injury or danger to life for persons**



Warning

**Warning against possible damage to property or the environment**



Caution

**Warning against dangerous electrical voltage**



**Warning against hot surfaces**



**Ignoring these instructions can lead to serious damage to health, up to life-threatening injuries!**

**This symbol indicates important information**



**Hazardous to the environment**



## General Safety Instructions

**This electric tool fulfils the basic EC safety and health regulations. Nevertheless, dangerous situations can arise.**



Warning



All safety equipment must be maintained in perfect condition.



Warning

Always pay attention to moving parts. These can cause injury because of their movement or by sudden movement.



Warning

Only use the electric tool when it is in perfect condition from the technical point of view, and only use it for intended purpose while being aware of safety issues and risks, and paying attention to the instruction manual! In particular, have any disturbances which could have a negative effect on safety corrected immediately!



**WARNING!** It is essential to read all the instructions. Mistakes which are made while attempting to follow the below instructions can cause electric shock, fire and/or serious injury. The following term "Electric tool", refers to mains-powered electric tools (with mains cable) and battery-powered electric tools (without mains cable).



Warning

Caution

KEEP THESE INSTRUCTIONS IN A SAFE PLACE.



## Work Area Safety

Keep your work area clean and well lit. Cluttered benches and dark areas invite accidents.

Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquid, gases, or dust. Power tools create sparks, which may ignite the dust or fumes.

Keep bystanders, children, and visitors away while operating a power tool. Distractions can cause you to lose control.

## Electrical Safety



Warning

Caution

Earthed tools must be plugged into an outlet properly installed and earthed in accordance with all codes and ordinances. Never remove the earthing prong or modify the plug in any way. Do not use any adaptor plugs. Check with a qualified electrician if you are in doubt as to whether the outlet is properly earthed. If the tools should electrically malfunction or break down, earthing provides a low resistance path to carry electricity away from the user.

Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.

Don't expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.

Don't abuse the cord. Never use the cord to carry the tools or pull the plug from an outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged or entangled cords increase the risk of electric shock.

When operating a power tool outside, only use authorized cords for out door work. These cords are rated for outdoor use and reduce the risk of electric shock.

## Personal Safety

Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

Use safety equipment. Always wear eye protection. Safety equipment such as dust mask, non-skid safety shoes, hardhat, or hearing protection used for appropriate conditions will reduce personal injuries.



Avoid accidental starting. Be sure switch is off before plugging in. Carrying tools with your finger on the switch or plugging in tools that have the switch on invites accidents..



Warning

Caution

Remove any adjusting key or wrenches before turning the tool on. A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.

Do not overreach. Keep a proper footing and balance at all times. Proper footing and balance enables better control of the tool in unexpected situations.

Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.

## Tool use and care

Do not force tool. Use the correct tool for your application. The correct tool will do the job better and safer at the rate for which it is designed.

Do not use tool if switch does not turn it on and off. Any tool that cannot be controlled with the switch is dangerous and must be repaired.

Disconnect the plug from the power source before making any adjustments, changing accessories, or storing the tool. Such preventive safety measures reduce the risk of starting the tool accidentally.

Store idle tools out of reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool. Tools are dangerous in the hands of untrained users.

Maintain tools with care. Keep cutting tools sharp and clean. Properly maintained tools, with sharp cutting edges are less likely to bind and are easier to control.

Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tools operation. If damaged, have the tool serviced before using. Poorly maintained tools cause many accidents.

Use the power tool, accessories and blades etc., in accordance with these instructions and in the manner intended for the particular type of power tool, taking into account the working conditions and the work to be performed. Use of the power tool for operations different from those intended could result in a hazardous situation.



Use clamps or other practical way to secure and support the work piece to a stable platform. Holding the work by hand r against your body is unstable and may lead to loss of control.

Use only accessories that are recommended by the manufacturer for your model. Accessories that may be suitable for one tool may become hazardous when used on another tool.



Warning Caution

**Service**

Only qualified repair personnel must perform tool service. Service or maintenance performed by unqualified personnel could result in a risk of injury.

When servicing tool, use only identical replacement parts. Follow instructions in the Maintenance section of this manual. Use of unauthorized parts or failure to follow Maintenance Instructions may create a risk of electric shock or injury.

**Specific Safety Rules**



Warning Caution

**Take care to avoid the magnet releasing.** Ensure that the magnet has properly adhered to the work piece before beginning drilling.

**Metal swarf and other debris will dangerously lower magnets adhesion force.** Always ensure that the magnet is clean and free of rust or other foreign matter.

**Employ safety chain at all times.** Magnet can release unexpectedly at any time- especially due to power failure.

**Power supply socket must be kept easily accessible.** In an emergency you may need to quickly unplug the machine.

**Never exceed an angle of 90 degrees.** Overhead (upside down) drilling is very dangerous and should never be attempted.

**The magnets adhesion depends on the thickness of the work piece. Always ensure that the work piece is a minimum of 12mm (7/16 in.) thick.** If not, then a minimum 10mm thick piece of iron or steel must be placed under the workpiece to ensure adequate adhesion.

**Other electric machines used on the same receptacle will cause uneven voltage, which could lead to the magnet releasing.** Always use this machine alone on the receptacle.

**Avoid operating annular cutters without coolant fluid. Always check coolant level before operating.**

**Do not operate with blunt or damaged cutting tools.** This will easily overload the motor.

**Protect the motor.** Never allow cutting fluid, water, or other foreign contaminants enter the motor.

**Metal swarf are often very sharp and hot. Never touch them with bare hands.** Clean up with a magnetic swarf collector and a chip hook or other appropriate tool.

**CAUTION: NEVER position machine on a workpiece between the electrode and the earth an arc type welder. Damage to the machine will result, as the welder will earth through the machines earthing cable.**



Warning Caution

**WARNING: NEVER attempt to use machine with incorrect current or abnormally low voltage. Check machine nameplate to ensure that correct voltage and Hz are used.**

Extension cable should be selected after ensuring the diameter is sufficient for the length. Follow the chart below:

Max length:

10m (32 ft.)	1.25 square mm (16 ga.)
15m (50 ft.)	2.0 square mm (14 ga.)
30m (100 ft.)	3.50 square mm (12 ga.)

(Over 30m NOT RECOMMENDED)

**Never touch the rotating cutter or swarf with your bare hands, body, gloves, hair or clothing.**

**When replacing cutters never touch the sharp cutting surfaces with bare hands**

**Use a pilot pin, which matches the cutter. A mismatched cutter and pilot pin will cause a dangerous situation.**

**Non-ferrous metals and other materials may not be used, since the magnet will not be able to adhere to it magnetically.**

**Do not use excessive feed pressure when drilling.**

**Symbols on the Electric Tool**

Warning against dangerous electrical voltage



Warning against high surface temperature



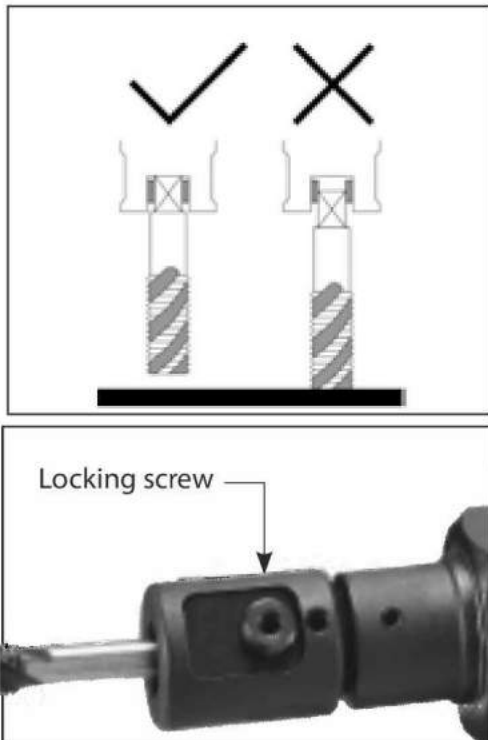
## SETTING UP FOR TAPPING

**CAUTION:** Never use a cutting tool which is larger than the maximum rated capacity of the machine.

**CAUTION:** Always follow the tap manufacturer's recommendation for selecting the correct size hole for tapping.

Using the universal tap chuck, use the key to turn it to open its jaws enough to fit the square of the tap. Ensure that the corners of the square are properly located in the jaws. Then use the key to securely tighten the chuck.

**NOTE:** Make sure that the tap is inserted as deeply as possible into the jaws. An improperly seated tap will run off center and could result in damage to the jaws or tap.



**ALWAYS ENSURE THAT THE HOLE ISN'T OVER TAPPED. THE HOLE'S DEPTH MUST BE LONGER THAN THE NEEDED THREADING DEPTH!!**

**ALWAYS HOLD THE TOOL AS STRAIGHT AS POSSIBLE TO AVOID BREAKING THE TAP OR CREATING TOO MUCH TORQUE**

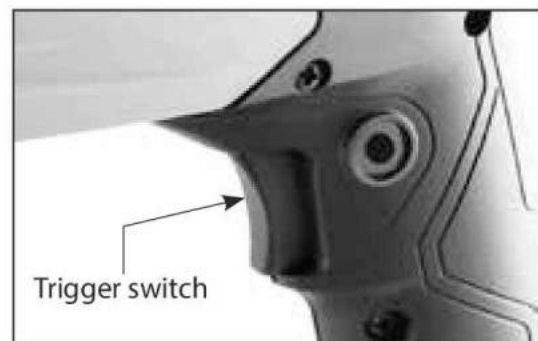
## THE SWITCH

### To Switch On:

Squeeze the trigger switch and hold to turn the motor on.

### To switch off:

Release the trigger switch.



## TAPPING OPERATION

**NOTE:** It is recommended to always use cutting oil on the tap to give longer tap life and better results.

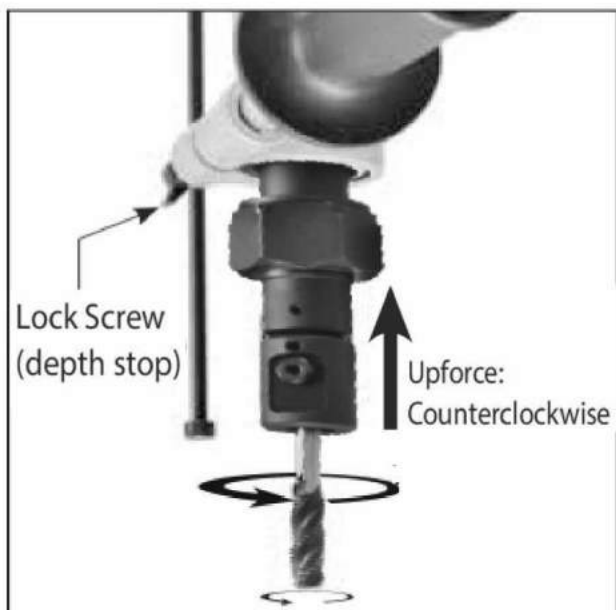
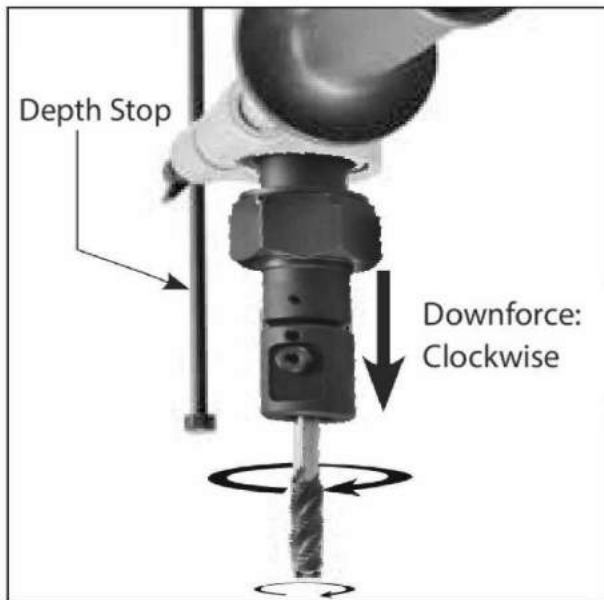
1. Before tapping begins, there must be a proper sized hole. Make sure that the hole is the correct size for the tap.

To begin tapping, start the machine by squeezing the trigger switch. When there is no feed pressure on the tap, the spindle will be in neutral and will not spin. When there is downward feed pressure, the spindle will automatically spin in the right hand (clockwise) direction at low speed. Hold the

machine as square as possible with the hole. (The swivel joint will take up small amounts of misalignment)

3. Once the hole is tapped, release the downward feed pressure and the spindle will stop.
4. When the machine is pulled back, the spindle will automatically spin in the left hand (counterclockwise) direction at high speed (in order to more quickly remove the tap).

**CAUTION: Do not pull too hard when backing out or the tap could pull out of the chuck. This could lead to premature wear of the chuck.**



## THE DEPTH STOP

The depth stop is useful when tapping blind holes to avoid bottoming out the tap. It may be moved back out of the way (or removed entirely) when not needed.

### To set the depth stop:

1. Loosen the locking screw and adjust the bar so that it is flush with the end of the tap. This will be the zero position.
2. Take the intended tapping depth and subtract 4mm. Then back off the bar by this amount. (4mm must be subtracted because of the internal mechanism)
3. Once the desired position is set, retighten the lock screw.

**Example:** If the desired tapping depth is 14mm, then the depth stop bar should be set to 10mm back from the end of the tap. (14mm minus 4mm = 10mm)

**NOTE: It is not possible to tap left-hand threads with this machine**

**WARNING: Always hold tightly to both handles to resist the torque forces created during the tapping operation.**

**WARNING: Never attempt to tap without using the side handle and always ensure that the handle is tight before operating.**

## THE OPTIONAL SAFETY CLUTCH

The optional safety clutch is designed to slip when the maximum torque value is exceeded. It is pre-set at the factory to the standard value. If the clutch slips many times and its torque value decreases, it may be reset at an authorized service center.



## MAINTENANCE

Every 50 hours of operation blow compressed air through the motor while running at no load to clean out accumulated dust. (If operating in especially dusty conditions, perform this operation more often.)

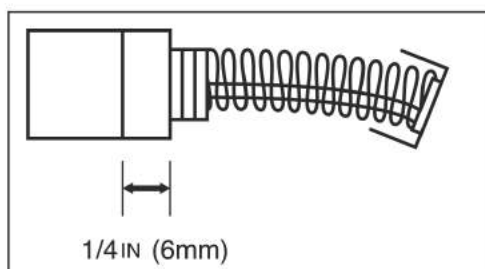
Keep the machine clean and free of chips.

Check for loose fittings and tighten as needed.

Ensure that the ventilation slots are clear so that motor can be cooled normally. Blow low pressure compressed air through the ventilation slots with the motor running to keep motor clean.

## THE CARBON BRUSHES

The carbon brushes are a normal wearing part and must be replaced when they reach their wear limit.

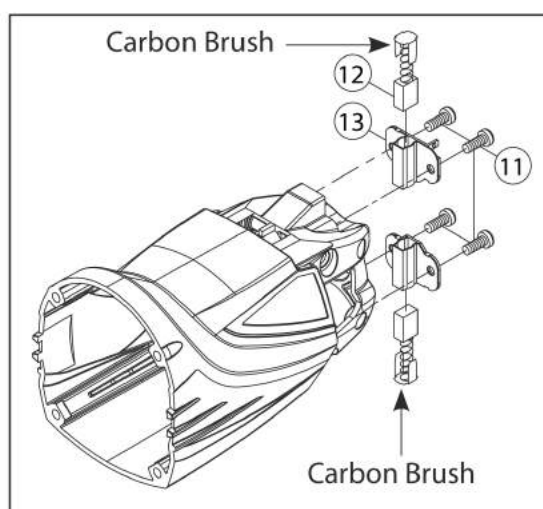


## TO REPLACE BRUSHES

1. Remove the 5 long screws and 2 short screws to remove the left handle housing. (The two screws closest to the motor are the short screws).
2. Remove the 2 short screws to remove the right handle housing. There will be wires which will remain attached. Take care not to strain the wires.
3. Unplug the female spade terminal from the brush.
4. Unscrew the 2 screws to remove the brush holder. The brush will come away together with the holder.
5. Install the new brush into the brush holder

with the male spade end pointing toward the rear of the motor then screw the brush holder in place.

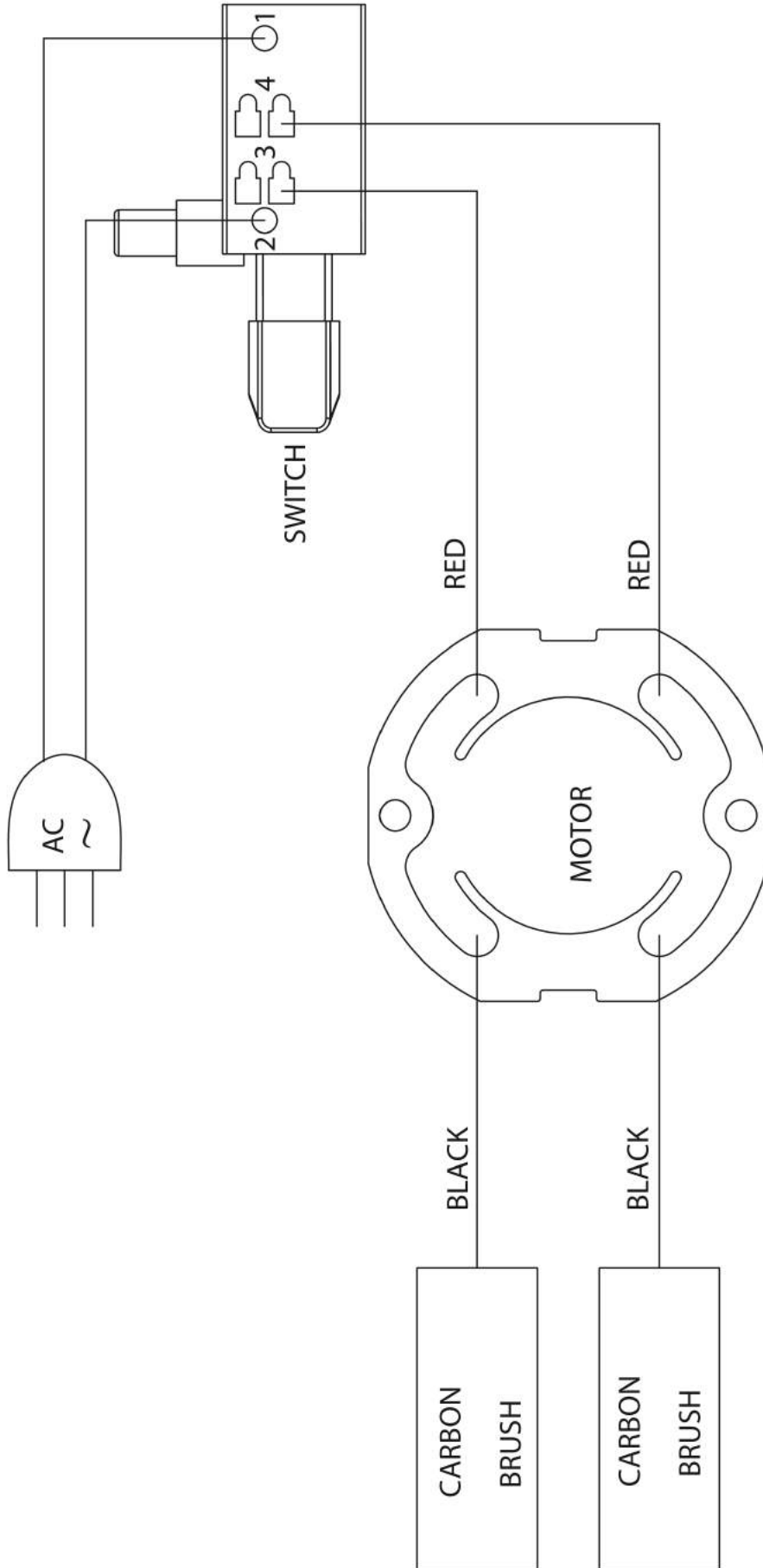
6. Reconnect the female spade terminal to the brush. Then repeat for the other brush.
  7. Replace the right handle housing, then carefully place the switch in the correct position and arrange the wires so that they will not be pinched.
  8. Replace the left handle housing, taking care to avoid pinching any wires and tighten the screws.
- Always entrust all repairs to an authorized service agent.



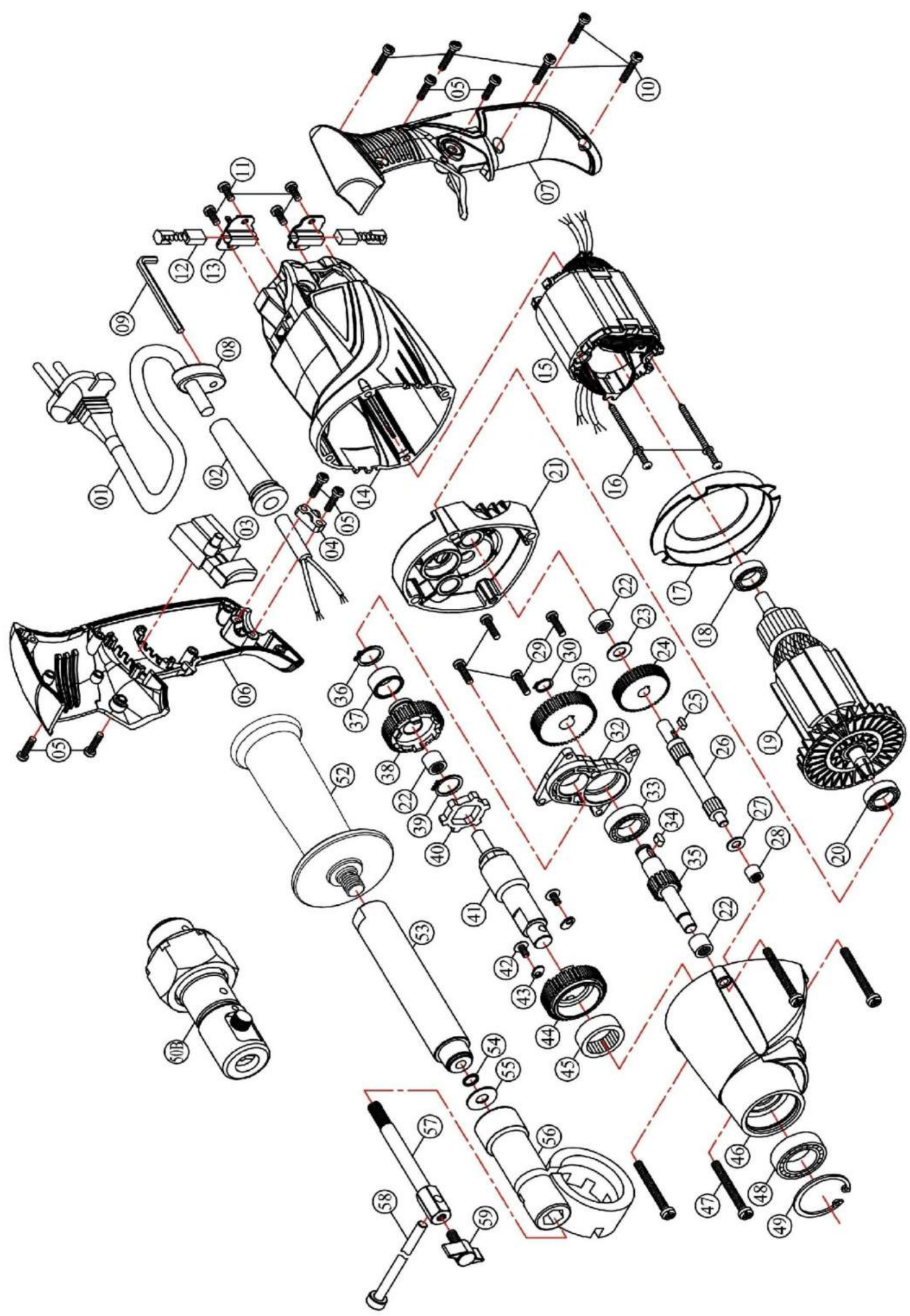
**If the replacement of the power supply cord is necessary, this has to be done by the manufacturer or their agent in order to avoid a safety hazard.**

**WARNING: All repairs must be entrusted to an authorized service center.** Incorrectly performed repairs could lead to injury or death.

# WIRING



MODEL : GSMPRO Art. 495090





## PARTS LIST

NO.	Parts Name	Q'TY	NO.	Parts Name	Q'TY
1	POWER SUPPLY CABLE	1	44	REVERSING DRIVE GEAR M0.9x44T	1
2	CORD ARMOR	1	45	NEEDLE BEARING TA 2210	1
3	TRIGGER SWITCH	1	46	GEAR CASE	1
4	CABLE CLIP	1	47	SCREW M5 x 45	4
5	SCREW M4 x 14	6	48	BALL BEARING 6003-2NSE	1
6	HANDLE HOUSING-RIGHT	1	49	INTERNAL CIRCLIP R-35	1
7	HANDLE HOUSING-LEFT	1	50A	UNIVERSAL TAP CHUCK	1
8	HEX KEY HOLDER	1	50A-1	SWIVEL BARREL	1
9	L-HEX WRENCH-M4 M4	1	50A-2	COIL SPRING $\varnothing 1.6 \times \varnothing 13 \times \varnothing 16.2 \times 18L \times 5T$	1
10	SCREW M4 x 16	5	50A-3	SPACER	1
11	SCREW M4 x 8	4	50A-4	ROLL PIN $\varnothing 5 \times 30$	1
12	CARBON BRUSH 7 x 8 x 12	2	50A-5	CHUCK BODY	1
13	CARBON BRUSH HOLDER	2	50A-6	JAW-LEFT HAND THREAD	1
14	MOTOR HOUSING	1	50A-7	SOCKET SET SCREW M5 x 12	2
15	STATOR	1	50A-8	OPERATING SCREW	1
16	STATOR SCREW M4 x 60	2	50A-9	JAW-RIGHT HAND THREAD	1
17	FAN BAFFLE	1	50B	UNIVERSAL TAP CHUCK w/ CLUTCH	1
18	BALL BEARING 608 ZZ	1	50B-1	HUB	1
19	ARMATURE M0.7 x 7T	1	50B-2	DISC SPRING $\varnothing 20.4 \times \varnothing 40 \times 2.25$	1
20	BALL BEARING 609-2RS	1	50B-3	FRICTION DISC $\varnothing 20.4 \times \varnothing 40 \times 2$	1
21	GEAR PLATE	1	50B-4	SWIVEL BARREL	1
22	NEEDLE BEARING HK 0810	3	50B-5	ROLL PIN $\varnothing 5 \times 30$	1
23	THRUST RING 816	1	50B-6	FRICTION COLLAR	1
24	INPUT GEAR M0.7 x 46T	1	50B-7	SOCKET SET SCREW M4 x 6	1
25	PARALLEL KEY 3 x 3 x 8	1	50B-8	ADJUSTOR NUT	1
26	INPUT GEAR SPINDLE M0.9 x 10T	1	50B-9	COIL SPRING $\varnothing 1.7 \times \varnothing 13 \times \varnothing 16.4 \times 18.5L \times 4T$	1
27	THRUST RING $\varnothing 6 \times \varnothing 13 \times 1$	1	50B-10	SPACER	1
28	NEEDLE BEARING HK0608	1	50B-11	CHUCK BODY	1
29	SCREW M4 x 14	4	50B-12	JAW-LEFT HAND THREAD M12 x P1.25	1
30	EXTERNAL CIRCLIP S-10	1	50B-13	SOCKET SET SCREW M5 x 12	2
31	IDLER GEAR M0.9 x 44T	1	50B-14	OPERATING SCREW M12 x P1.25	1
32	INNER GEAR PLATE	1	50B-15	JAW-RIGHT HAND THREAD M12 x P1.25	1
33	BALL BEARING 6001 zz	1	51	ROLL PIN $\varnothing 5 \times 30$	1
34	PARALLEL KEY 4 x 4 x 8	1	52	SIDE HANDLE GRIP M12	1
35	IDLER PINION M1.0 x 14T	1	53A	SIDE HANDLE SHAFT-LONG	1
36	EXTERNAL CIRCLIP S-16	1	53B	SIDE HANDLE SHAFT-SHORT	1
37	BUSHING $\varnothing 16 \times \varnothing 20 \times 10$	1	54	SPRING WASHER M10	1
38	FORWARD DRIVE GEAR M1.0 x 38T	1	55	FLAT WASHER $\varnothing 10 \times \varnothing 18 \times 2$	1
39	EXTERNAL CIRCLIP S-17	1	56	SIDE HANDLE BRACKET	1
40	DOG CLUTCH	1	57	BOLT M8	1
41	SPINDLE	1	58	DEPTH STOP	1
42	TRUSS HEAD SCREW M4 x 8	2	59	THUMB SCREW M6 x L12	1
43	TAB	2			

