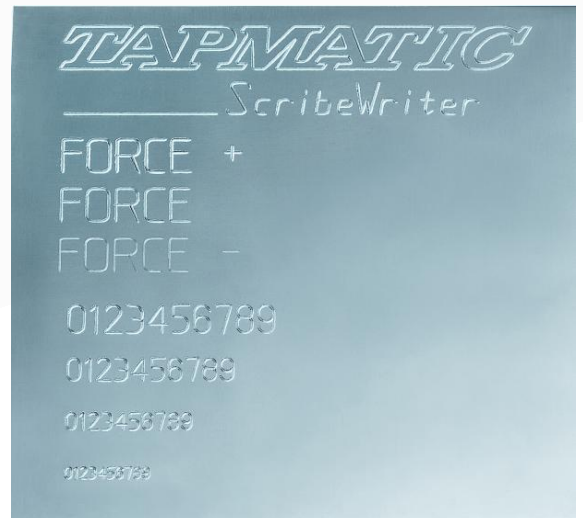


# TAPMATIC

## SCRIBEWRITER

### Operation and Safety Manual



**MARK IT WHILE YOU MAKE IT!**

At high feed rate, **without** second operations  
and **without** rotation.

# TAPMATIC

## TAPMATIC ScribeWriter® Operating Instructions and Set-up Guide

### 1. ScribeWriter All-in One Overview

#### Advantages, Function and Characteristics of the ScribeWriter

The TAPMATIC ScribeWriter marking tool was designed as a simple device for permanent marking of parts.

In addition to marking miscellaneous materials – starting with plastics, Aluminum and nonferrous metal to hardened steel (max. HRC 62) – this tool can be used on all CNC-operated machines like machining centers, lathes and robots.

Due to the deflection of the stylus (carbide marking pin), surface variations up to 5mm can be marked. The compression of the stylus against the work piece, or in feed depth, must not be deeper than 5mm, however.

Neighboring tools and collision areas in the machine's tool magazine will normally not pose a problem as there is no rotation necessary for the tool, which makes for an uncomplicated use in a tool changer.

The feed rate depends on the material, marking depth and the machine's abilities to correctly produce the desired contours. Applying a maximum of 100 RPM or lubrication of the surface of the work piece with coolant or oil *may* in individual cases improve the result (reduction of burr formation), rotation is not normally required, however using coolant or lubrication results in the longest life for the carbide stylus.

ScribeWriter permanently marks alphanumeric text, symbols, dates and serial numbers, batch codes, logos and graphics. Different fonts and sizes can be brought up in straight line, angled, concaved, circular, mirrored or reflected.

#### Advantages at a glance:

- Low cost high value marking tool for CNC machines with revolver or automatic tool changing as well as robots.
- Surface is hardly damaged; individual marking done by material compression and / or displacement
- Fast designation of tools without spindle rotation
- Available with 16mm, 20mm, 25mm and 1" straight shank, modular assembly with other various shanks like SK, CAT, BT, or HSK.
- Easy programming directly at the machine, from programmer's workplace or through commercial engraving software
- Long operating life because of high-quality tool components, for the longest life we recommend using water base coolant or minimum quantity lubrication.
- Marking depth adjustable by turning sleeve for increased spring preload.
- A smooth surface height variation of up to 5mm may be marked without adjusting the marking plane thanks to compress ability of the stylus. The recommended compression range is from less than 1 to 5mm maximum.



## 2. Set-up Guide

### Tool preparation / Adjustment of marking depth

The *ScribeWriter* with straight shank can be clamped into commercially available collet chuck holders, or Weldon collet. After identifying the tool length, the marking can begin. The marking depth is subject to work piece hardness, compression of the stylus against the work piece and initial spring load. This can be adjusted by turning the blue housing (adjustment ring) in the +/- direction in order to increase or decrease the initial load. The position can be read off the dial from 0 – 8. The adjustment of the spring force does not affect the tool length. As a possible start point you can take the spring position acc. to the dial (2) and increase or decrease it, acc. to your needs. With regards to stylus compression against the work piece, it's best to start off with 1mm, which can be increased if necessary. Please note that a max. of 5mm for stylus compression must not be exceeded.

## 3. Programming

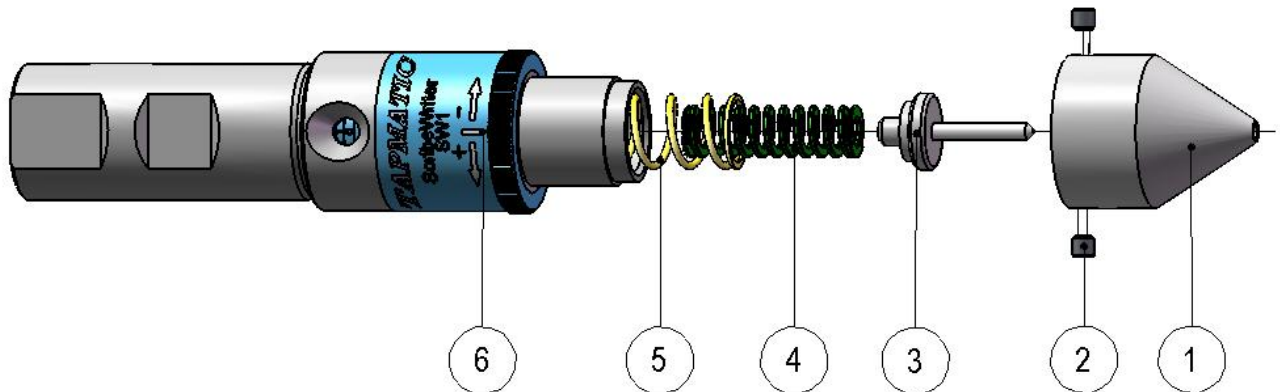
Preferably, the programming is carried out through the machine control, from a programmer's workplace with CAM or through any commercially available engraving software. Most machine manufacturers offer sub-routines to generate numbers, letters and logos. Should you use an engraving software, some minor corrections will be necessary. Please make the following changes:

- Set the RPM to „0“
- Increase of feed as long as the required marking shape is being achieved. The faster the feed, the shallower the marking depth, for a given spring preload setting and stylus compression against the work piece.
- Program immersion depth of stylus less than 1 to 2mm (max. deflection of 5mm must not be exceeded)

## 4. Maintenance

The *ScribeWriter* does not need any special maintenance. In order to protect the tool from corrosion and to guarantee Stylus suspension, the tool should be cleaned and treated with corrosion protection spray within regular intervals or if the tool will be stored for a long time.

Should the carbide pin be damaged or worn, it can be easily replaced. In order to exchange the Stylus or change from the standard to the higher strength spring set version, please follow these steps:



**Spring set version**

Standard: **blue** + **violet**  
heavy (H): **uncoated** + **violet**

1. Eliminate initial spring load by turning the adjustment ring (**Pos. 6**) in the (-) direction into the end position
2. Loosen the set screws (**Pos. 2**)
3. Remove the cone end (**Pos. 1**) by means of a spanner wrench
4. Exchange the carbide pin / Stylus (**Pos. 3**) or spring (**Pos. 5**)
5. Cleaning and corrosion protection of parts
6. check correct position of springs (**Pos. 4 + 5**) inside of tool
7. Insert Stylus into cone end (**Pos. 1**) and assemble tool by means of spanner wrench, so that the adjustment ring can still be turned
8. Secure cone end (**Pos. 1**) by tightening the set screws (**Pos. 2**)



***Do not use force when assembling the tool.***  
***In order to avoid damage, do not tighten screws excessively!***



# TAPMATIC



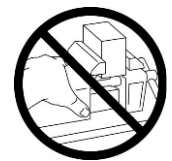
**To avoid serious injury and ensure best results for your application, please read carefully all operation and safety instructions for your *ScribeWriter* marking head, as well as all other safety instructions that are applicable, especially those for your machine tool.**

▶ **1. Proper Clothing:** Rotating and protruding machine components can snag loose fitting clothing, jewelry, or long hair. Never wear jewelry, long sleeves, neckties, gloves or anything else that could become caught when operating a machine tool. Long hair must be restrained or netted to prevent it from becoming entangled in rotating spindle. Steel-toed boots should also be worn in any machine environment.

▶ **2. Proper Eye Protection:** Always wear safety glasses with side shields to protect your eyes from flying particles.



▶ **3. Proper Work Piece Fixturing:** Never hold the work piece or the vise it is held in by hand. The work piece must be clamped firmly to the table of the machine so that it cannot move, rotate or lift.



▶ **4. Always be aware of the Potential Hazards of a Machining Operation:** Sometimes working with your machine can seem routine. You may find that you are no longer concentrating on the operation. A feeling of false security can lead to serious injury. Always be alert to the dangers of the machines with which you work. Always keep hands, body parts, clothing, jewelry, and hair out of the areas of operation when the machine is operating. Areas of operation include the immediate point of machining and all transmission components including the marking tool. Never bring your hand, other body parts or anything attached to your body into any of these areas until the machine is completely stopped.

▶ **5. Be aware of any other applicable safety instructions or requirements.**

## Check-list for good marking

1. **Never** use this marking tool before reading carefully all safety instructions for this tool, as well as the machine's instructions.
2. Is the tool correctly inserted into the holder / collet and secured?
3. Is the spring tension correctly adjusted? (If in doubt: better too weak than too strong.)
4. Is the feed correct?
5. Has the tool length been correctly defined?
6. Is the work piece securely fastened and supported against rotation and upward motion?
7. Were possible collision areas checked and eliminated?

# TAPMATIC

**Repair Service:** Through your local distributor or directly to

TAPMATIC Corporation  
802 Clearwater Loop  
Post Falls, Idaho 83854

**To Expedite Repair:** Return tool direct to Tapmatic Corporation, by United Parcel Service and enclose the following statement with your purchase order: "Authorization given to repair and return tool if total repair cost does not exceed 40% of the cost of a new tool." Tapmatic will still send you cost notification for the actual charges prior to repairing the tool, and we will call to request credit card # for invoicing.

**Important:** Be sure to return complete tool because any missing parts will be replaced.

**Cost Notification:** Tapmatic will FAX a cost notification to you, soliciting your approval before repairs are completed. If it is determined that the tool cannot be repaired, at customer's request, Tapmatic will return the disassembled parts. We are not able to reassemble tapping attachments using damaged or worn out parts.

**Optional Return Procedure:** The *ScribeWriter* may also be returned for repair through your local Tapmatic Distributor. They will ship the tool to us and include instructions for the repair and return. You may already have an open account with them which will facilitate the handling of invoicing.

**Priority Service:** Tapmatic services tools returned for repair in the order in which they are received. All tools will be evaluated and repaired within three weeks from the date they arrive subject to receiving the customer's approval to proceed with the repair.

Priority is given to tools shipped to us by overnight or second day.

If a repair is sent to us by UPS ground or similar service it can also be given priority. Just call and let us know you need priority service and advise if you would like the tool returned to you by overnight or second day. In the interest of fairness, to all our customers we ask that you approve return shipment by overnight or second day before we agree to upgrade your repair order to priority service. Typical turn around, not including shipping time, for priority repairs is 5-7 days subject to receiving the customer's approval to proceed with the repair. Should you have any more questions, please do not hesitate to contact us. We are pleased to answer your questions: **Please call... 800 854-6019 or email us at... info@tapmatic.com.**