

Thread tapping technology

Competitive

... the big advantages

Free floating spindle

Spindle is directly driven
 No lead screw
 Control of the cutting load
Torque monitoring
 Maximum torque
 Torque set-point is adjustable
 Current torque in Ncm is readable
 Minimum torque in Ncm is not reached

 Only necessary torque is used
 Programming, menu driven

- Counter balance compensation
- Threading takes place with the pitch of the tap
- in Z-direction, only with **ZAP**
- below the static breaking point of the tap
- error info when pilot hole too small or dull tap
- tool failure and scrap are avoided
- quality and service life monitoring
- pilot hole is too large
- or thread pitch is worn out
- cutting action in Ncm lies below tool breaking point
- all parameters are indicated in the display
- good/bad are indicated *during* the manufacturing

Supervised manufacturing



Parameter settings

minimum torque
 maximum torque

speed RPM
 depth

control in quality
 special features

- part position tolerance Δ Delta-Sz - with **ZAP**
- Torque control window, min-max
- Depth setting to 0,1mm
- pilot hole tolerance recognition
- no breakage
- pilot hole to small
- automatic chip clearance
- observe service life for the taps
- optimum speed
- exact *depth is achieved +/- 0.1 mm*
- *optimum performance and service life of taps*
- *for depth > 1,5 d minimum power and torque for greater depth, without scrap and breakage using programmable chip-clearance*

Quality control

PC-Software **WinPCA** and **printtap**

Speed control

Standard-Interfaces

- Online-Protocol for Quality management
- Develop optimum performance with feedback
- Identifies the best tools
- Tool geometry, coatings, and lubrication are evaluated in the process for the best service life.
- 8 bit input / output parallel interfaces
- RS232 (V24) 9600 Baud for Automation and communication

CE- / GS-Sign, incl. EMV

- **CE-Certificated, TÜV Certification**
 Norm: EN 60 204-1; 1992;
 DIN EN 292 T1,T2; DIN EN 294; DIN EN 349; DIN 8418
- **ElektroMagnetische Vertraeglichkeit EMV**
 Norm: EN 55011/50081-2/50082-2



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Competitive Advantage

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