

Tapping - Specification of Application



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Workpiece Information

thread size	tolerance	thread direction ☐ right ☐ left
material	material standard	shape of chips ☐ long chipping ☐ short chipping ☐ brittle chipping
tensile strength [N/mm²]	elongation [%]	
material characteristics		

kind of core hole ☐ through hole ☐ blind hole	core hole-Ø (BØ)		
	depth of core hole (t_B)		
	length of thread to be cut (t)		

Machine information

machine Type	☐ without	pitch control programming of axial infeed cutting [%] reversing [%]	
	☐ leadscrew		
year when built	☐ CNC control		
machining position ☐ horizontal ☐ vertical	cutting speed $V = D \cdot \pi \cdot N / 1.000$ $N = 1.000 \cdot V / D \cdot \pi$		
type of tapping head ☐ rigid ☐ length compensation on tension ☐ length compensation on compression ☐ with overload clutch	coolant supply ☐ from outside (manually) ☐ from outside (circle) ☐ internal coolant supply ☐ minimum quantity lubrication (MMS)		coolant ☐ cutting oil ☐ emulsion % type:

Experiences

producer ☐ HAHNREITER ☐	article	specification	tool-life
reasons for end of tool-life			
remarks			

enclosures

samples of tools / workpieces / drawings of workpiece