microtap

Thread tapping technology

Competition

... the big advantages

Free floating spindle

Drive unit is in direct line
no lead screw/guidance cartridges
Control of the cutting load
Mz torque monitoring
maximum torque Mz
Mz-cut-off moment is adjustable
current torque in Ncm is readable
minimum torque in Ncm is not reached

only necessary torque Mz is used
Programming, menu-led

- Counter balance compensation
- thread manufacturing takes place -independently
- in z-direction, only with **ZAP**
- below the static break moment of the tap
- error info.: e.g. core hole too small / tap blunt
  - tool failure & scrap are avoided
  - quality / service life monitoring
  - recognition pilot hole too large--
- *or thread-former worn out*
- cutting moment in Ncm lies below tool breaking moment
- all parameters are indicated in the display
- good/bad selection *during* the manufacturing

Supervised manufacturing

tip

Parameter settings

minimal torque
maximal torque

speed min-1
depth
control in quality
special features

- Distance-Tolerance ΔDelta-Sz - with **ZAP**
- Automatic Error STOP, seeting through **Win**PCA
- Torque control- window, min-max / depth 0,1mm
- core hole tolerance recognition
- no breakage
- *core* hole to small
  - chip clearance if nescessary
  - knowledge of service life for the taps
  - optimum speed
- exact- & *achieved depth +/- 0.1 mm*
- *optimum performance & service life of taps*
- *for depth > 1,5 d minimum power and torque for greater depth, without scrap and breakage using programmable chip-clearance*

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Quality control

PC-Software **Win**PCA and **print**tap

Speed control

Standard-Interfaces

- Online-Protocol for Quality management **QS**
- Establishing of optimal data through working-preparation
- Identifies the optimum tools, Geometry &
- Coatings as well as lubrication and from the resulting process - stand-time-evaluations / service life
- 8 bit in-/output / parallel (galvanic isolated)
- RS232 (V24) 9600 Baud (galvanic isolated) 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
- **E**lektro**M**agnetische **V**ertraeglichkeit EMV
  Norm: EN 55011/50081-2/50082-2

TÜV PRODUCT SERVICE GS CE

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