

Thread tapping technology Competition

Comparison

microtap thread tapping system

Conventional thread tapping

Torque continuously controlled

Set operating torque according to material and size of thread, and below the breakpoint of the tool
The thread is constantly controlled and analysed
This allows continuous verification of thread quality
The actual torque is shown on the display

Breakpoint is not considered

The operating torque cannot be recognised during operation. Optimisation of all parameters is not possible. The breakpoint of the tap is not considered. An automatic clutch is generally too sluggish

Tool breakage prevented

Increase of torque during operation or incident will be recognised. Thread cutting with worn tools or lack of lubrication will be prevented

Increase of scrap

Wear of tool will not be recognised and there is a danger of breakage and scrap. There is no quality control or verification of quality

Free floating spindle

The spindle exerts no opposing forces in a stress-free balance of tool and work piece. The tap pulls itself into the work piece by its own lead
The advance occurs by hand or with the automatic feed system

Increase of wear

Each tap of a different size or pitch requires its own lead screw that, when out of synchronisation, can cause increased wear. Time for retooling will add more costs. Tool breakage, especially when reversing, can often not be avoided

Precision -- from beginning to end

The measuring of depth is achieved by an electronic depth measurement system (resolution 0.05 mm). The accuracy of depth (+/- 0.1 mm) is shown on the display

Additional expenses

The true depth of the thread will have to be gauged at the end of the process, which causes additional time and expenses

Approach electronically controlled

The work piece location is also measured by the depth control system (+/- 0.1 mm). The permissible tolerance is adjustable

Verification of quality only post process

Tolerance of work piece (height, width, depth) show only after process when quality is checked

All parameters are controlled during production

...when you think thread tapping –

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...thank you for your interest