

Tapping – Specification of Application

„Hahnreiter“

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customer	phone		
name	fax	e-mail	date

Workpiece Information

thread size	tolerance	thread direction <input type="radio"/> right <input type="radio"/> left
material	material standard	shape of chips <input type="radio"/> long chipping <input type="radio"/> short chipping <input type="radio"/> brittle chipping
tensile strength [N/mm ²]	elongation [%]	
material characteristics		

kind of core hole <input type="radio"/> through hole <input type="radio"/> blind hole	core hole- \varnothing ($B\varnothing$)	
	depth of core hole (t_B)	
	length of thread to be cut (t)	

Machine Information

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

Experiences

producer <input type="radio"/> HAHNREITER <input type="radio"/>	article	specification	tool-life
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reasons for end of tool-life

remarks

enclosures

samples of tools / workpieces / drawings of workpiece