

AXE-HT

AXE-HT

Demonstrates a splendid power in tapping Aluminum Alloy Diecasting materials and others.



Feature of products

AXE-HT AXE Hand tap

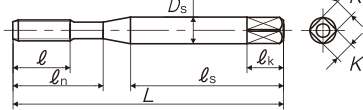


- **long tool life**...Special cutting edge design results in little damage on the cutting edge. Combination of premium powder HSS(featuring high wear resistance and heat resistance) and TiN coating brings out 5 times longer tool life than previous taps designed for aluminum.
- **Reliable screw threads**...Cutting edge with little damage restricts both the size change of internal threads and the reduction of surface roughness.
- **Wider range of application, from middle speed tapping to high speed tapping**...Most preferable combination of negative rake angle and eccentric relief enables AXE taps to be applicable in wider range, from middle speed to high speed.

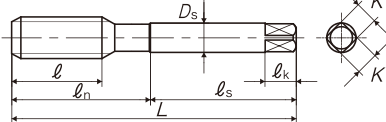
- Most preferable combination of negative rake angle and eccentric relief realizes the long tool life.
- AXE taps adopt premium powder HSS (featuring high wear resistance and heat resistance)and TiN coating.
- AXE taps are applicable to wider machines, from transfer machines to machining centers.
- Due to parted small chips, tapping operation becomes quite stable.

Table of dimensions and sizes

TYPE:1



TYPE:2

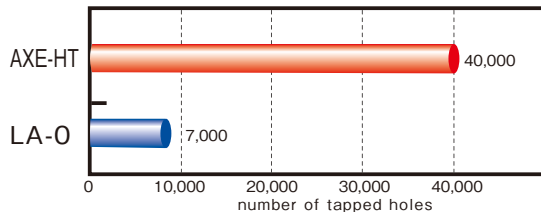


size	class	L (mm)	l (mm)	l _n (mm)	l _s (mm)	D _s (mm)	number of flutes	Type	code
M 6 × 1	P3	62	15	26	33	6	3	1	TAXEMR6.0M1
M 8 × 1.25	P3	70	19	-	36	6.2	4	2	TAXEMR8.0N1
M10 × 1.5	P3	75	23	-	38	7	4	2	TAXEMR01001
M10 × 1.25	P3	75	23	-	38	7	4	2	TAXEMR010N1
M10 × 1	P3	75	23	-	38	7	4	2	TAXEMR010M1
M12 × 1.75	P3	82	26	-	42	8.5	4	2	TAXEMR012P1
M12 × 1.5	P3	82	26	-	42	8.5	4	2	TAXEMR01201
M12 × 1.25	P3	82	26	-	42	8.5	4	2	TAXEMR012N1

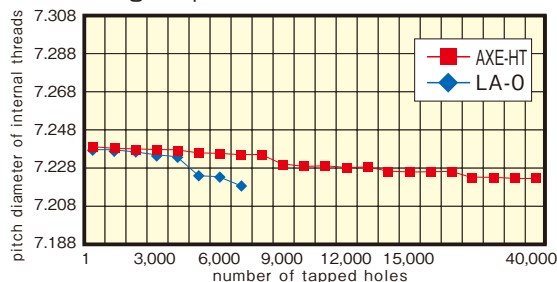
Tap's accuracy classes do not always ensure the accuracy of internal screws.

Tapping data

Comparison of tool life between AXE-HT and LA-O (previous product)



Change of pitch diameter of internal threads



tap M8×1.25

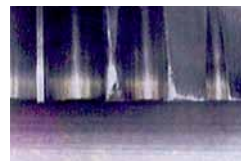
AXE-HT : HSS-P TiN

LA-O : HSS-E NI

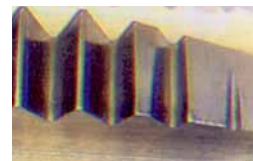
- material : AC4A- T6 treated
- thread length : 13 mm (blind hole)
- tapping speed : 10m/min
- machine : transfer machine
- feed : lead screw feed
- bored hole : φ6.8
- cutting oil : water soluble (x30)

Damage at cutting edge after 7,000 hole tapping

LA-O



AXE-HT



Warning

- ◆ Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- ◆ Tools may shatter. Use tools under the proper tapping condition.
- ◆ Never wear gloves during turning operations as the gloves may get caught with the tools.
- ◆ Wear safety shoes to avoid injuring yourself by the falling tools.
- ◆ On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- ◆ Fasten the workpieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- ◆ Take a special care to fire trouble. High temperature during machining may cause fire.

Please note that specification may change without advance notice.

YAMAWA Mfg. Co., Ltd.

Head office

Nakajima Gold bldg.13-10 Kyobashi
3chome, Chuo-ku, Tokyo 104-0031, JAPAN

Website:<http://www.yamawa.com>

YAMAWA group for Overseas

YAMAWA International Co., Ltd.



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