

【Question】



Currently, I am regrinding large size taps with various types of grinding machinery and equipment. Regrinding taps is totally different than regrinding drills and end mills and appears to be more complicated. It takes several steps to regrind a tap and its quite time consuming. Is there an easier way to regrind taps?

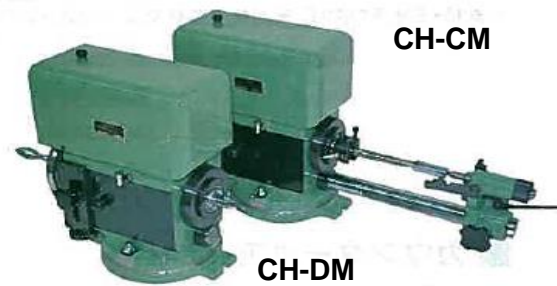
【Answer】

Yamawa is selling the CH-CM and the CH-DM tap chamfer grinders. These attachments were developed for regrinding the chamfer portion of the tap. This attachment will fit onto various types of grinding machines. The attachment makes regrinding the tap chamfer easy. Please refer to the following outline of the attachment.

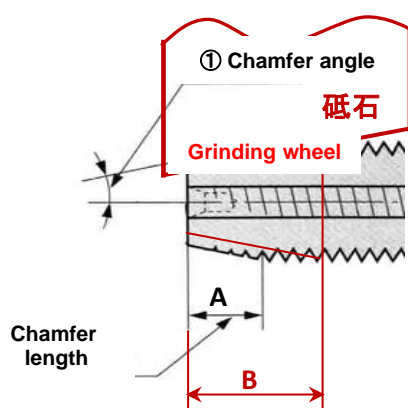


【CH-CM and CH-DM, Tap chamfer grinder】

1. The attachments are available in 2 different types, the CH-CM and the CH-DM (See pictures on the right).
2. The CH-CM is for grinding taps while the tap is held in both centers. This makes grinding possible while reducing misalignment of the tap.
3. The CH-DM is for grinding taps while the tap is held with a single center and a collet. The CH-DM is designed as a tap regrinding attachment but is rather suitable for regrinding drills and center drills.
4. Both are equipped with motors that make power rotation readily available.

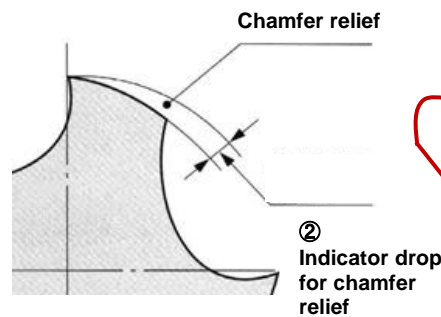


【Functions】



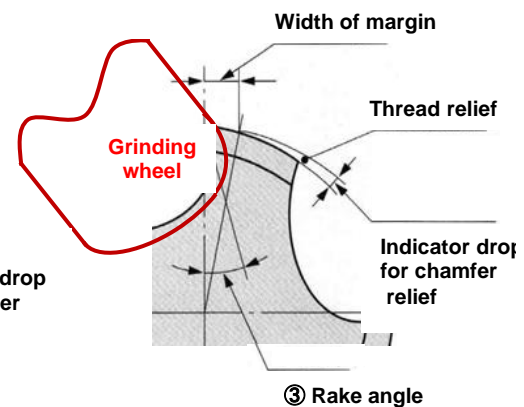
● Use the angle graduation shown on tap chamfer grinder and regrind the taps in accordance with the recommended chamfer angle.

※ After the tap is reground, the chamfer length will become longer as shown in diagram B above. Occasionally it may be necessary to cut off the end of the taps to meet with the chamfer length A.



● Use the chamfer relief graduation shown on the tap chamfer grinder and regrind the taps in accordance with the assigned chamfer relief.

※ This is the most unique function of this tap chamfer grinder.



● In the case of a straight fluted tap, use the rake angle graduation shown on the attachment and regrind the tap in accordance with the assigned cutting face angle.

※ These attachments are not available for regrinding the flute portion on the Spiral Flute and Spiral Pointed Taps.

Motorless types of CH-C and CH-D attachments are also available in our lineup!

