

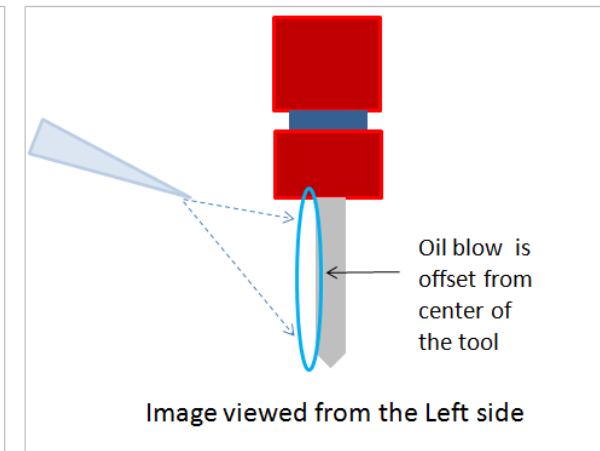
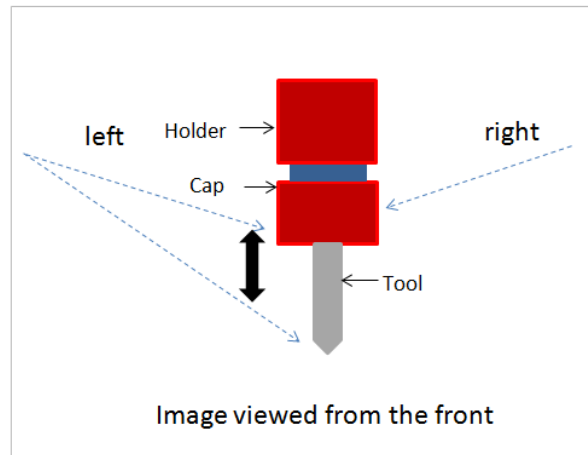
# Tapping

- Model :  $\alpha$ -D21MiA5
- Coolant : Synthetic soluble type
- Coolant pump :  
460W  
96 L/min  
6.5m(60Hz)
- Material : SS400  
(Steel for general structure )
- Tool :  
Spiral Fluted Tap M3 x 0.5
- Prepared hole size  
Diameter 2.52mm Depth 11.5mm




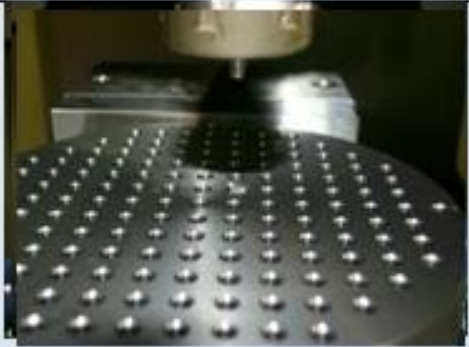
- Condition  
Tapping Speed : 13m/min(S1380)  
Feed : 690mm/min  
Valid tap depth : 9.0mm (ap)  
Width: 5mm (D)  
Step process : No

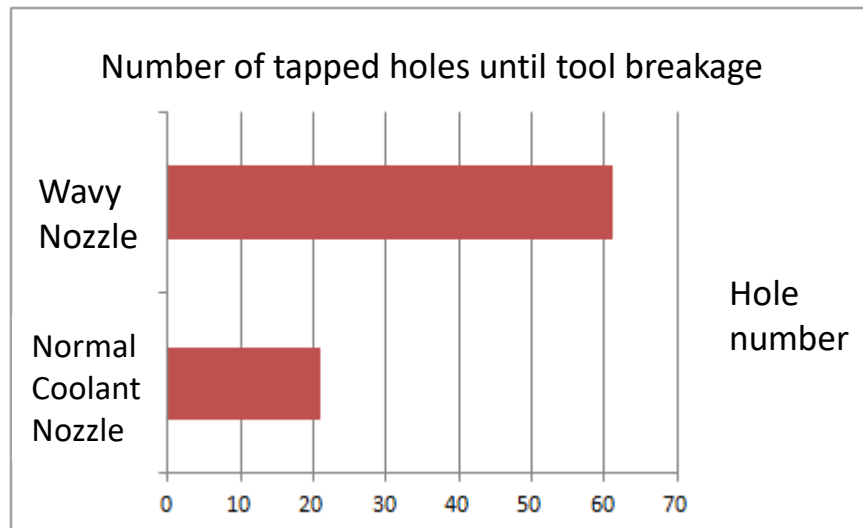
- Case of Wavy Nozzle use (Two Wavy Nozzle are used)  
Left Side Mode : SWEEP Right Side Mode : FIX  
Swing Angle : 2 Count  
Nozzle Speed : 100 Count



- Case of fixed nozzle  
Two 1/2 inch Round nozzle are used.

# Tapping

|               | Normal coolant nozzle   | Wavy Nozzle  |
|---------------|---|--|
| Tool Breakage |  <p>Tool Broken during 22nd hole processing</p> |  <p>Tool Broken during 62nd hole processing</p> |



Number of tapped holes until tool breakage

Normal coolant nozzle : 21  
 Wavy Nozzle : 61

**Tool life is 2.9 times**