

AXE-HT

IMROBEX
Machine Tools International



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AXE-HT

Outstanding performance in tapping Aluminium Alloy Diecasting materials and others.



Features of products

AXE-HT AXE Hand Taps

HSS-P

Coating



• **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 aluminium.

• **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 wide range, from middle speed to high speed.

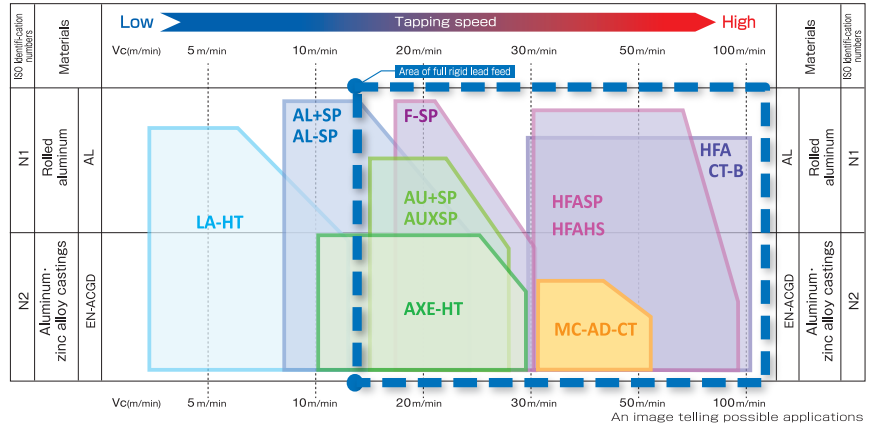
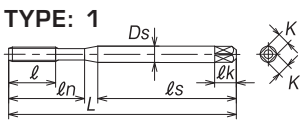
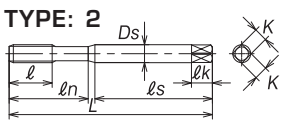


Table of dimensions and sizes

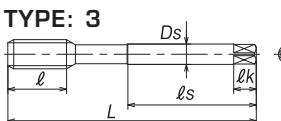
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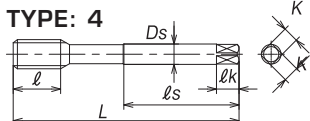
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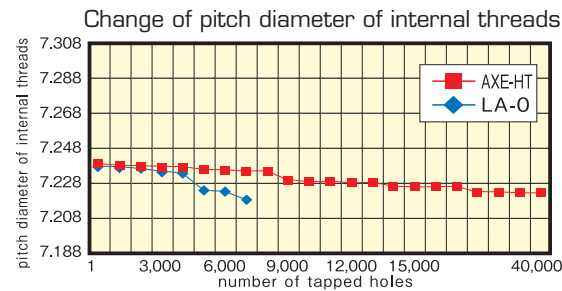
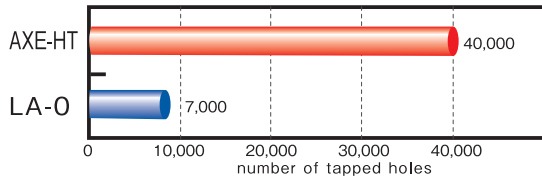


size	class	code	Chamfer	L (mm)	l (mm)	ln (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	Type
M 6×1	ISO2X	TD6.0MBLPVA	1.5P	80	15	30	45	6	4.9	8	3	1
M 8×1.25	ISO2X	TD8.0NBLPVA	1.5P	90	19	35	47	8	6.2	9	4	2
M10×1.5	ISO2X	TD010OBLPVA	1.5P	100	23	39	52	10	8	11	4	2
M10×1.25	ISO2X	TM010NBLPVA	1.5P	100	23	-	51	7	5.5	8	4	4
M10×1	ISO2X	TM010MBLPVA	1.5P	90	19	-	46	7	5.5	8	4	4
M12×1.75	ISO2X	TG012PBLPVA	1.5P	110	26	-	56	12	9	12	4	3
M12×1.5	ISO2X	TM012OBLPVA	1.5P	100	21	-	51	9	7	10	4	4
M12×1.25	ISO2X	TM012NBLPVA	1.5P	100	21	-	51	9	7	10	4	4

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

Tapping data

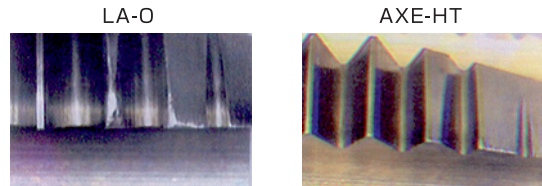
Comparison of tool life between AXE-HT and LA-O (previous product)



Tap M8 1.25

- AXE-HT: HSS-P Special coating
- LA-O: HSS-E NI
- Work material: AC4A-T6 treated
- Tapping length: 13 mm (blind hole)
- Tapping speed: 10 m/min
- Machine: Transfer machine
- Feed: Lead screw feed
- Bored hole: φ6.8
- Tapping fluid: Water soluble oil (x30)

Damage at cutting edge after 7,000 holes tapping



Warning

- Tools may shatter. Wear cover or eye glasses to avoid injury during tapping.
- Tools may be 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.



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