

ACHSP

Carbide taps for Aluminium
cored hole tapping

Available for tapping directly into cored holes in Aluminium!

ACHSP

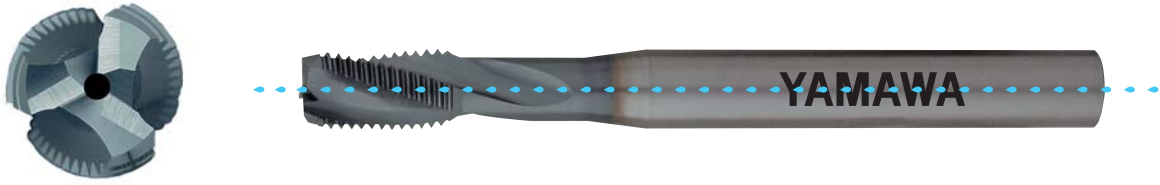


The ACHSP is ideal for tapping cored holes in a variety of Aluminium components like:
Engine Block, Cylinder Head, Transmission Case,
Manifold, Water Pump, etc.

Features

Spiral fluted taps for tapping cored holes in Aluminium

ACHSP



Features

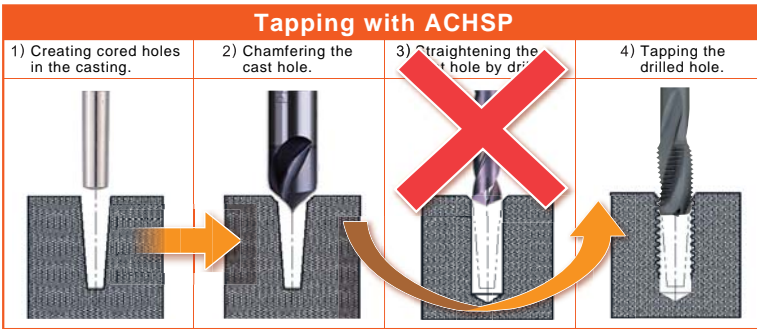
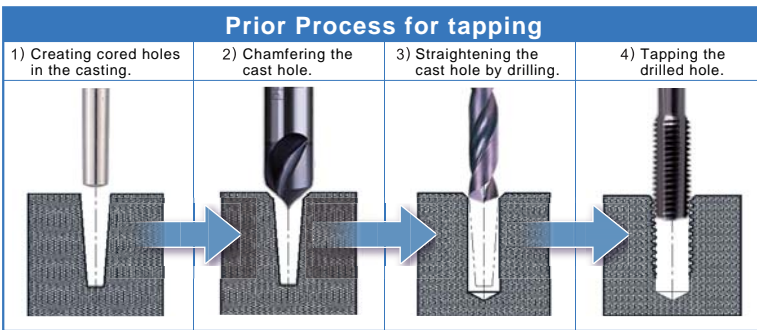
- Thanks to the frontal cutting edge, direct cored hole tapping allowing a reduction of processing time.
- Made of an ultrafine grain carbide alloy combining the correct hardness and toughness.
- The shank diameter is the same as the thread diameter of the tap which improves rigidity and makes the product more resistant to deflection and the cutting side pressure caused by misalignment. (M6, M8: 0.3 mm max, M10 0.5 mm max).
- A thin film coating offers improvements in wear resistance and a reduction of cutting edge chipping.

Recommendation

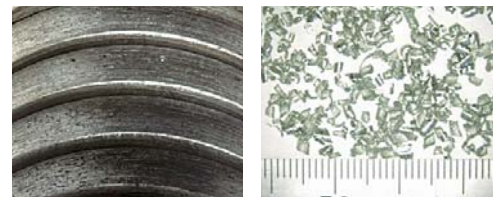
- Internal Coolant Supply is recommended to prevent the tapped holes from being blocked by the ejected chips.

Reduction of processing time

Direct tapping a cored hole results in a reduction in processing time!

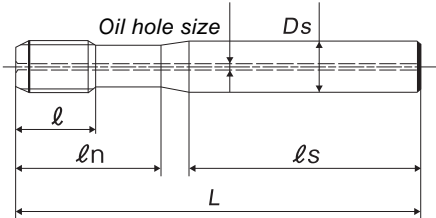


Test Data



Thread size	M8x1.25	
Workpiece material	ADC12	
Tapping speed	50 m/min	
Number of tapped holes	50	
Hole conditions	Minimum diameter size	ϕ 5.8 mm
	Taper angle	2°
	Tapping depth	22 mm
	Hole type	Blind
Internal thread length	17 mm	
Misalignment	+0.5 mm	
Feed	synchronous	
Machine	M/C (horizontal)	
Tapping fluid	Water soluble	

Dimensions and size



unit: mm

Nominal size	Class	L	l	ln	ls	Ds	Number of flutes	Oil hole size	Product code
M6x1	P3	80	12	27	48	6	3	1	SY6.0MRLXT
M8x1.25	P4	90	15	30	54	8	3	1	SY8.0NSLXT
M10x1.5	P4	100	18	36	57	10	3	1.5	SY010OSLXT
M10x1.25	P4	100	18	36	57	10	3	1.5	SY010NSLXT

Warning

- ◆ Tools may shatter. Wear cover or eye glass 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 notice.

