

AXE

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

AXE



Feature of products

AXE AXE tap

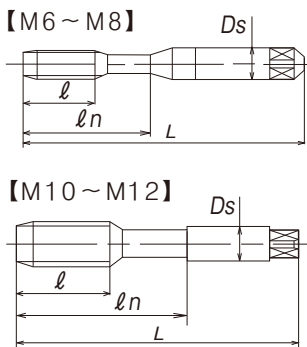


- **long tool life**...Special cutting edge design results in little damage on the cutting edge. Combination of premium powder HSS(featuring high wear resistance and heat resistance) and TiN coating brings out 5 times longer tool life than previous taps designed for aluminum.
- **Reliable screw threads**...Cutting 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

DIN lengths with ANSI shank dimensions (Unit: inch)

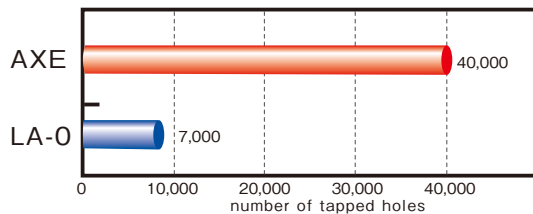


size	class	L	l	ln	Ds	number of flutes	code
M6 X1	D5	3.150	0.591	1.181	0.255	3	TS6.0MELPVA
M8 X1.25	D5	3.543	0.748	1.382	0.318	4	TS8.0NELPVA
M10X1.5	D6	3.937	0.906	1.929	0.323	4	TS010OFLPVA
M10X1.25	D6	3.937	0.906	1.929	0.323	4	TS010NFLPVA
M10X1	D6	3.937	0.906	1.929	0.323	4	TS010MFLPVA
M12X1.75	D6	4.331	1.024	2.126	0.367	4	TS012PFLPVA
M12X1.5	D6	4.331	1.024	2.126	0.367	4	TS012OFLPVA
M12X1.25	D6	4.331	1.024	2.126	0.367	4	TS012NFLPVA

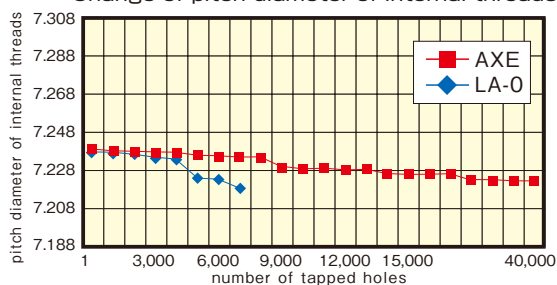
Tap's accuracy classes do not always ensure the accuracy of internal screws.

Tapping data

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



Change of pitch diameter of internal threads



tap M8×1.25

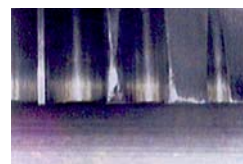
AXE : HSS-P TiN

LA-O : HSS-E NI

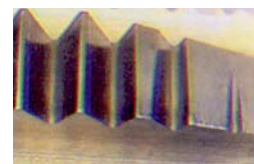
- material : AC4A- T6 treated
- thread length : 13 mm (blind hole)
- tapping speed : 10m/min
- machine : transfer machine
- feed : lead screw feed
- bored hole : $\phi 6.8$
- cutting oil : water soluble (x30)

Damage at cutting edge after 7000 hole tapping

LA-O



AXE



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 advance notice.

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