

# Tapping Tool

**For Your Punch Press Machine**



- Reduce secondary operations
- High speed productivity
- Interchangeable cartridge system  
M2~M8

## Tapping Tool

Thick Turret  
C Station



Flat Plate



Burring Hole

## Increase Productivity by Reducing Your Secondary Operations

- Fully compatible with punch press performance in terms of speed, accuracy & consistency
- Threads are interchangeable via quick change cartridge mechanism  
Standard: M3, M4, M5 (unit 1)  
M5, M6 (unit 2)  
Option: M2.5, M2.6  
UNC (up to 10-24)  
Whitworth (up to 1/4"-40)  
M2 & M8 only available in D Station tool
- Rolled thread in flat plate & burred hole

## Specification

Station Size		Thick Turret C Station					
Tool Type	Unit 1 Ball Screw Type	M2.5, M2.6, M3, M4, M5 *					
	Unit 2 Roller Screw Type	M5, M6					
Tap Specification	Tap Size	(M2.5 & M2.6 x 0.45), (M3 x 0.5), (M4 x 0.7), (M5 x 0.8), (M6 x 1.0)					
	Tap Type	UNC~4-40, 6-32, 8-32, 10-32, 10-24. Whitworth 1/4 -40					
Material Specification	Tap Type	High Speed Steel TICN Coated Forming Tap					
	Tap Size	M2.5	M2.6	M3	M4	M5	M6
	Max Mat Thick Flat Plate (mm)	2.0	2.0	2.3	3.2	3.2	3.2
	Tap Life (Estimated)	7,000	7,000	7,000	5,000	3,000	1,000
	Pre Pierce Diameter (mm)	2.27	2.37	2.75	3.65	4.6	5.55
	Max Mat Thick Upform Burr (mm)	1.0	1.0	1.2	1.6	1.6	1.6
	Min Mat Thickness for Burr (mm)	0.8	0.8	0.8	0.8	1.0	1.2
Hole Type	Flat plate, upform & downform burring						
Material	Cold & Hot Rolled Mild Steel, Aluminium & Stainless Steel **						
Programming Method	Use M08 & M09 Code. Nibbling not possible						
Tap Oil	Yushiron cut UX - 10						
Tap Oil Capacity	220cc (2000 Hits Approx)						
Tap Safety Device	Protection against missing pre-pierce hole						
Suitable m/c Type	Pega, Coma, Vipros & Vela II ***						

\* 1 off cartridge used for both M2.5 & M2.6 taps

\*\* Only able to tap stainless steel on Vipros m/c due to special PHNC setting required

\*\*\* Tapping tool not to be used on Pega King, Pega S, Apelio, Octo & cannot be changed on PDC auto-changer  
For compatibility with non-Amada machines please contact the Tooling Hotline

For further information contact the

## Tooling Hotline

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Specifications subject to change without prior notification

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