

PARADUR SHORT CHIP soft: Blind hole threads up to 3.5xd in long-chipping materials with utmost process reliability

THE TOOL:

- HSS-E taps with axial internal cooling for the production of deep blind hole threads up to 3.5xd in long-chipping materials with utmost process reliability
- Special geometry and small helix create perfect chip breaking even in the case of long-chipping, soft materials
- Long flutes and axial internal cooling guarantee optimum chip transportation and utmost process reliability
- TiN coating and additional steam treatment for outstanding tool life with no cold welding
- Short thread for reduced friction

THE APPLICATION:

- Deep hole threads up to 3.5xd
- Materials up to $R_m = 850 \text{ N/mm}^2$
- Long-chipping materials, e.g. construction steels, cementation steels or heat-treatable steels
- Globular cast iron GGG
- Short-chipping materials, e.g. grey cast iron GG or AlSi alloys

Condition:

- Machine tools with internal cooling
- Conventional tapping attachments (floating chuck, selfreversing tapping attachments etc.) or synchronized tapping (rigid tapping) are possible

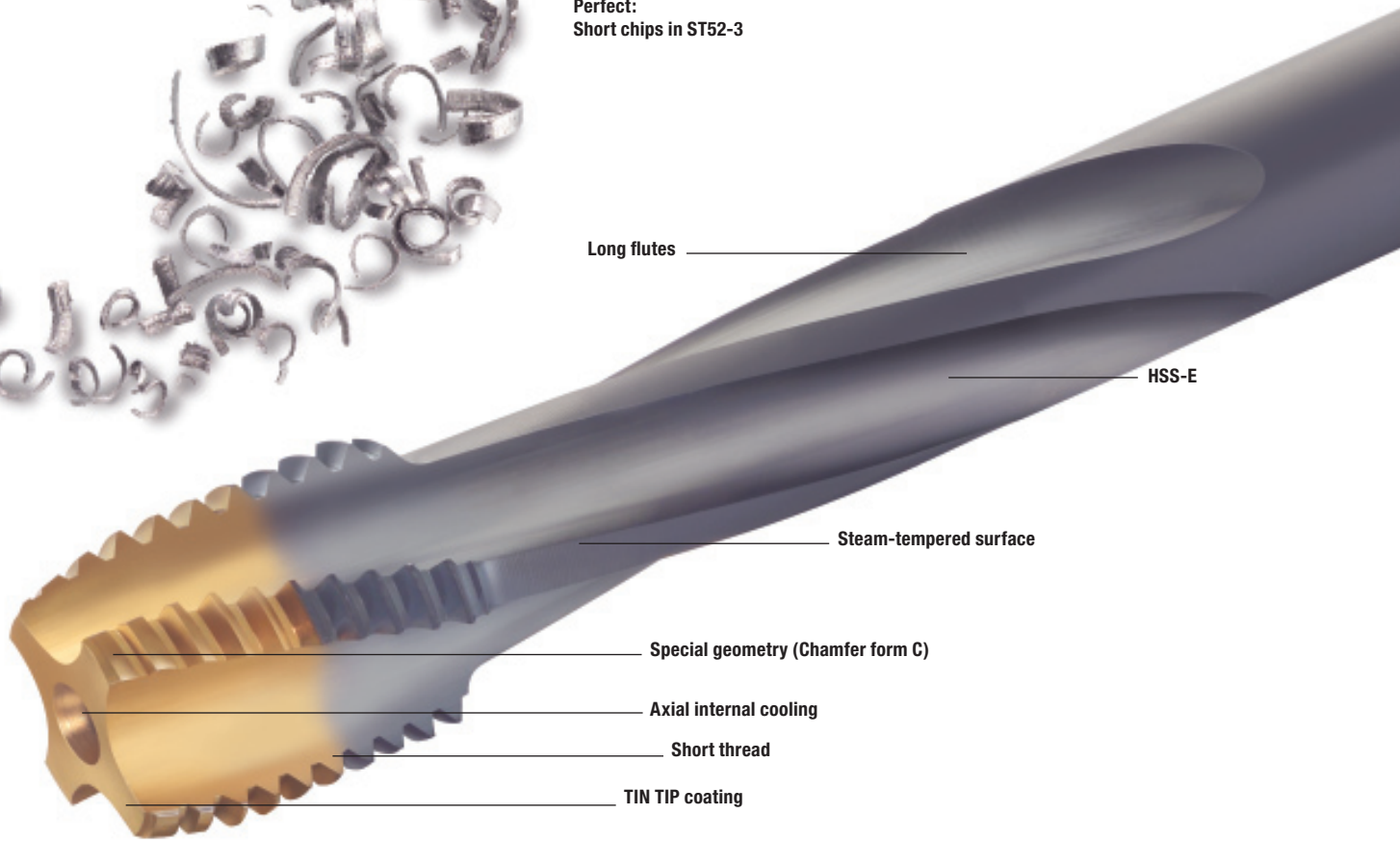
Dimension range:
M: M5 - M20
MF: M8x1 - M16x1.5

YOUR ADVANTAGES:

- *Utmost process reliability thanks to perfect chip breakage*
- *No bird nesting*
- *Optimum machine output*
- *High productivity due to multi-machine operation*
- *Broad application spectrum and long tool life thanks to TiN coating*



Perfect:
Short chips in ST52-3



Long flutes

HSS-E

Steam-tempered surface

Special geometry (Chamfer form C)

Axial internal cooling

Short thread

TIN TIP coating

Example

Material	St52-3
Thread	M10
Deep hole threads	2.5xd
Thread depth	25 mm
Number of threads	25.000
Free machine capacity	53 h

Result:

- Considerable time gained thanks to greater cutting speeds
- Optimum chip formation and chip transport without bird nesting
- Greater productivity with simultaneously longer tool life

