

TAPS DRILL-OUT TOOLS

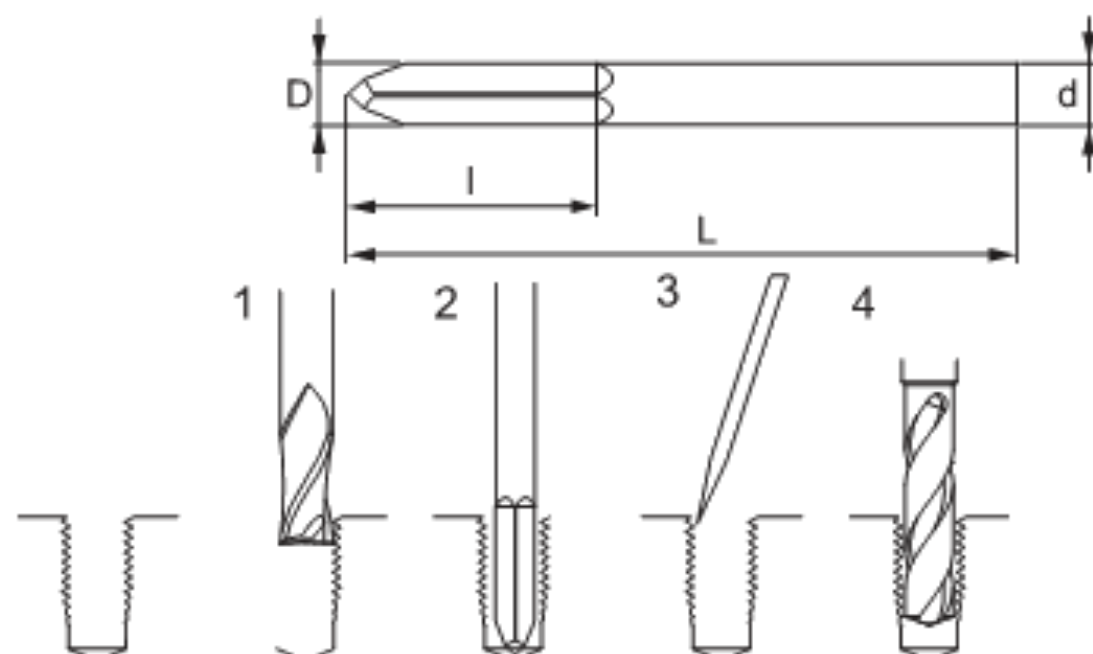


ITEM: A1810

This solid carbide tool was designed to extract broken taps from holes. Machining is normally run dry.

For best centring, follow the procedure below:

- (1) Flatten the broken tap, using a larger tool or a same-sized hand mill.
- (2) Select a suitable tap destroying tool and execute the work being careful that the processed rigidity is the maximum. Recommended cutting speed not greater than 45 m/mm and feed rate from 0.03 to 0.05 mm.
- (3) Remove the tap pieces left along the walls using a sharp tool.
- (4) When finished, we recommend reprocessing the hole with a drill of the same size as the pre-tapping hole.



Tech. Code		D mm	TAP	L1 mm	L mm	d mm
A18103		3	M4 - M5	15	50	3
A18104		4	M6	20		4
A18104,5		4,5	M8	25		4,5
A18105		5	M10	30	60	5
A18106		6	M12	30	80	6
A18108		8	M14 - M16	35	100	8
A181010		10	M18 - M20			10
A181012		12	M22 - M24			12

TAPS DRILL-OUT KIT



ITEM: A1811

A1811	Tech. Code		Composition
	A1811KIT		5-piece set Ø 3-6 mm