List 5172

SPEED FEED 328 | CARBIDE | BR | SHANK h7 | PACKED 1 PIECE

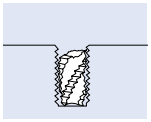
EXOCARB® EX-H-DRL, Tap Extractor

EDP Number		Diameter	Flute Length	Overall Length	Shank Diameter	Tap Types					
						Straight Fluted		Spiral Pointed		Spiral Fluted	
		D (mm)	FL (mm)	L (mm)	d (mm)	Metric	ANSI	Metric	ANSI	Metric	ANSI
87700	●	2-6 Set	-	-	-	-	-	-	-	-	-
87702	●	2.000	10.00	30.00	2.00	M3	#4, #5, #6	M3	#4, #5	M3	#4, #5, #6
87703	●	3.000	15.00	40.00	3.00	M4, M5	#8, #10	M4	#8, #10	M4, M5	#8, #10
87704	●	4.000	20.00	45.00	4.00	M6	1/4, 5/16	M5, M6	1/4	M6	1/4, 5/16
87705	●	5.000	25.00	50.00	5.00	M8, M10	3/8	-	5/16	M8, M10	5/8
87706	●	6.000	30.00	60.00	6.00	M12	7/16, 1/2	M8	3/8	M12	7/16, 1/2
87707	●	7.000	35.00	80.00	7.00	M14	9/16	M10	7/16	M14	9/16
87708	●	8.000	40.00	80.00	8.00	M16	5/8	M12	1/2	M16	5/8
87709	●	9.000	45.00	100.00	9.00	M18	3/4	M14	9/16	M18	3/4
87781	●	11.000	55.00	110.00	11.00	M22	7/8	M18	-	M22	7/8
87782	●	12.000	60.00	110.00	12.00	M24	1	M20	3/4	M24	1
87710	●	10.000	50.00	100.00	10.00	M20	-	M16	5/8	M20	-

● Stocked ○ Available Upon Request; MOQ May Apply ▲ Globally Stocked

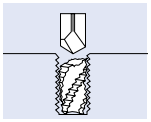
Note: For drill diameter selection, use the method outlined below. Straight Fluted & Spiral Fluted Taps: 0.46 (TapØ) < (DrillØ) < 0.75 (TapØ). Spiral Pointed Taps: 0.6 (TapØ) < (DrillØ) < 0.75 (TapØ).

HTE



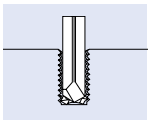
1. Broken Tap

Check how tap is broken. If any portion of the tap is protruding, grind the damaged surface of the tap flush with the workpiece. This will allow the damaged tap to be drilled easier.



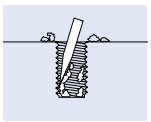
2. Centering of Drill

Position the drill over the center of the tap. Please make sure both the workpiece and drill are properly secured. Make an initial light drill approach, and then quickly retract the drill. For this step, do not use lubrication.



3. Hole Processing

Drill the hole at a fixed feed and speed, stopping the operation occasionally to remove broken chips. In addition, use plenty of high quality cutting oil.



4. Chip Removal

Once the tap has been broken up, the remaining portions of the tap can be removed. For best results, use a scriber. Once the hole is cleaned, tapping can be resumed.

Cutting Conditions and Procedures to Note

1. Use a drilling speed of 65-80SFM.
2. Hand feed of 0.0005~0.001 in/rev is normal.
3. Use a rigid holder.
4. Select a high quality cutting oil and apply in sufficient amounts.
5. This tool should not be used to drill soft steels, aluminum alloys or other soft materials.
6. Resharpening should be done periodically.
7. For through hole processing of heat treated steels, use a spare piece of material underneath the material being drilled as this will prevent breakage caused by sudden torque.
8. **Cannot be used to remove forming taps.**

P					M			K	N		S		H			
Steel					Stainless Steel			Cast Iron	Non-Ferrous		HRSA		Hardened Steel			
Carbon Steel			Alloy Steel	Die Steel					Aluminum		Nickel Alloy	Titanium				
Low	Medium	High			300	400	17-4 PH		6061 7075	Casting	Inconel	6Al4V (30 HRC)	~35 HRC	35-45 HRC	45-50 HRC	50-70 HRC
1010 1018	1035 1045	1065	4140 4340													◎

○ Good ◎ Best