

Zhp - M610

TAPPING HEAD WITH COMBINED AXIAL COMPENSATION COMPRESSION + TENSION / ONLY TENSION

Tapping head has been designed for being used in the most intensive threading works. M610 has really a high versatility, the tightening of the tool is made by using DIN 6499 (ER) collets.



Advantages:

1. With this model, any advancing breakdown of the spindle can be balanced during the threading operation. It has both function (Tension and Compensation) and it adapts itself to the threading size during such operation.
2. M610 provides the coolant passing through the internal part of the toolholder or directly go to the taper
3. By using cylindrical shank Collet Chucks 40.453/455, the M610 has the capacity of working in hard access working areas.

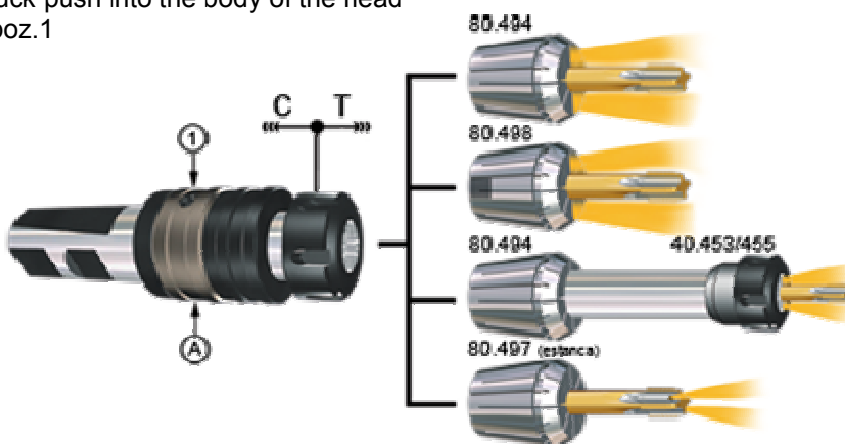
Usage:

Head is for thread cutting on NC and CNC machine tools with shank ISO40 or ISO50 DIN 69871AD+B in spindle hollow. With shank WELDON can be binded into the adaptor M307.

Head M610 has double axial compensation around central position, which is marked „C+T“, where „C“ marks Compression (length of the chuck compression from position „zero“ into the body of the head to the stopper) and „T“ marks Tension (length of tension from position „zero“ back to head to the stopper). Dimensions of both lengths are in table. If you want to hard screw tap kerf, you can very easily neutralize chuck movement into the body (Compression) and simultaneously retain only Tension (chuck is extruded).

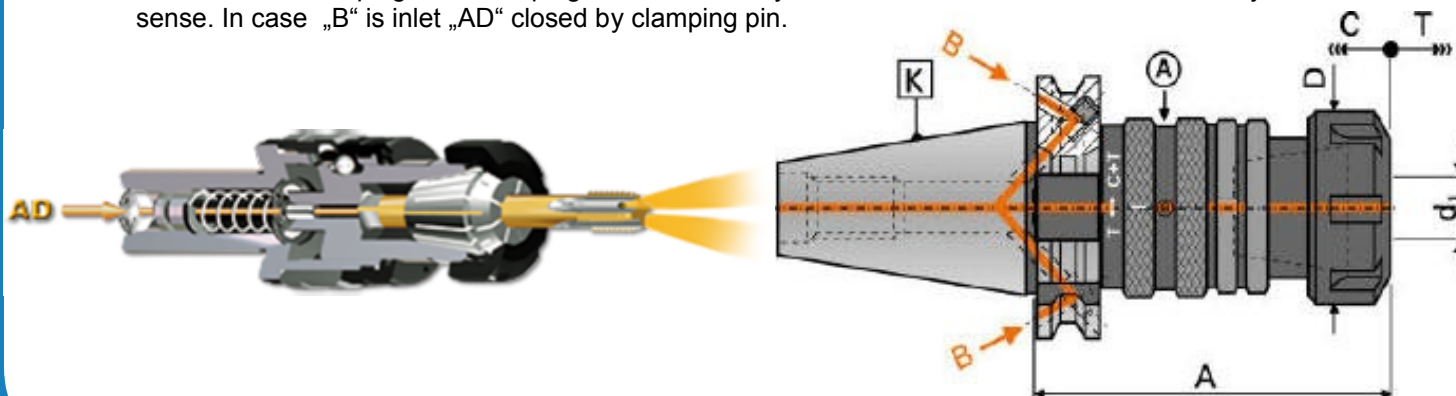
That can be done by this procedure:

1. Slacken locking screw poz.1
2. Turn sleeve „A“ and chuck push into the body of the head
3. Tighten locking screw poz.1



COOLING:

Coolant inlet is through central part of the head – „form AD“ or from shoulder – „form B“. The inlet is opened or closed with two plugs. If these plugs are bolted, they closed coolant inlet and retain inlet only in head axial sense. In case „B“ is inlet „AD“ closed by clamping pin.



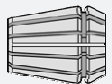
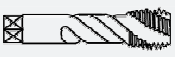


Taps are clamped to head with steel collets (ER) according to DIN 6499, there are 3 forms:

1. Standard collet without driving square - form **80.494**
2. Standard collet with driving square - form **80.498**
(At both these collets escapes coolant through all holes and this way is douched clamped tool)
3. Sealed collets without driving square - form **80.497**
(These collets are for taps clamping with central cooling).



By using cylindrical shank Collet Chucks **40.453/455** M610 has the capacity of working in hard access working areas.

Working range and technical parameters are in following table.

Ref. 13.610	K ISO			A mm	D mm	C mm	T mm		
13.610.40.12	40	ERF 16	M3-M12	102	28	5,5	6	80.493.10	89.202.10
13.610.40.20		ERF 25	M4-M20	125	42	10,5	7,5	80.493.16	89.202.16
13.610.40.33		ERF 40	M6-M33	141	63	10	10	80.493.26	89.202.26
13.610.50.12	50	ERF 16	M3-M12	102	28	5,5	6	80.493.10	89.202.10
13.610.50.20		ERF 25	M4-M20	125	42	10,5	7,5	80.493.16	89.202.16
13.610.50.33		ERF 40	M8-M33	141	63	10	10	80.493.26	89.202.26

Our further products you find on <http://www.narexmte.cz>.





KLEŠTINY DIN 6499 (ER) – TVAR MEXIN
s pojištěním čtyřhranu
COLLETS DIN 6499 - FORM MEXIN (ER)
with square locking drive

DIN 6499

80.498

80.498.10 ER 16

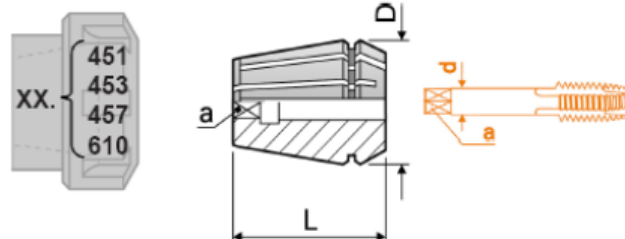
D = 17 mm L = 27,5 mm

REF.	d ₁ mm
80.498.10.05	4,5 x 3,4
80.498.10.06	5,5 x 4,3
80.498.10.07	6 x 4,9
80.498.10.08	7 x 5,5

80.498.13 ER 20

D = 21 mm L = 31,5 mm

REF.	d ₁ mm
80.498.13.05	4,5 x 3,4
80.498.13.06	5,5 x 4,3
80.498.13.07	6 x 4,9
80.498.13.08	7 x 5,5
80.498.13.09	8 x 6,2
80.498.13.10	9 x 7
80.498.13.11	10 x 8



80.498.16 ER 25

D = 26 mm L = 34 mm

REF.	d ₁ mm
80.498.16.05	4,5 x 3,4
80.498.16.06	5,5 x 4,3
80.498.16.07	6 x 4,9
80.498.16.08	7 x 5,5
80.498.16.09	8 x 6,2
80.498.16.10	9 x 7
80.498.16.11	10 x 8
80.498.16.12	11 x 9
80.498.16.13	12 x 9

80.498.20 ER 32

D = 33 mm L = 40 mm

REF.	d ₁ mm
80.498.20.05	4,5 x 3,4
80.498.20.06	5,5 x 4,3
80.498.20.07	6 x 4,9
80.498.20.08	7 x 5,5
80.498.20.09	8 x 6,2
80.498.20.10	9 x 7
80.498.20.11	10 x 8
80.498.20.12	11 x 9
80.498.20.13	12 x 9
80.498.20.14	14 x 11
80.498.20.15	16 x 12

80.498.26 ER 40

D = 41 mm L = 46 mm

REF.	d ₁ mm
80.498.26.08	7 x 5,5
80.498.26.09	8 x 6,2
80.498.26.10	9 x 7
80.498.26.11	10 x 8
80.498.26.12	11 x 9
80.498.26.13	12 x 9
80.498.26.14	14 x 11
80.498.26.15	16 x 12
80.498.26.16	18 x 14,5
80.498.26.17	20 x 16

80.498.34 ER 50

D = 52 mm L = 60 mm

REF.	d ₁ mm
80.498.34.13	12 x 9
80.498.34.14	14 x 11
80.498.34.15	16 x 12
80.498.34.16	18 x 14,5
80.498.34.17	20 x 16
80.498.34.18	22 x 18
80.498.34.19	25 x 20
80.498.34.20	28 x 22
80.498.34.21	32 x 24

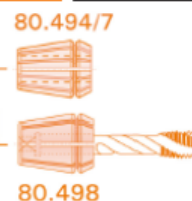
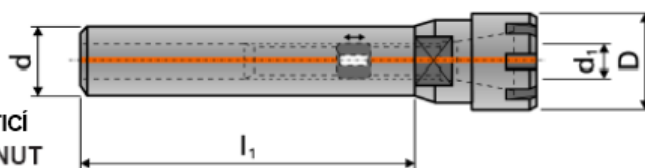


DLOUHÉ KLEŠTINOVÉ UPÍNAČE PRO ER KLEŠTINY DIN 6499
pro nástroje s válcovou stopkou
LONG COLLET CHUCKS FOR DIN 6499 (ER) COLLETS
for tools with cylindrical shank

DIN 1835-A

40.455

S «MINI» KLEŠTINOU MATICÍ
WITH «MINI» COLLET NUT



REF.	d mm		d ₁ mm	A mm	l ₁ mm	D mm	MINI		
40.455.12.10/080	12	ER 16	0,5-10	40,5	80	22	80.495.10	89.205.10	89.190.21
40.455.16.10/050	16	ER 16	0,5-10	36,5	50	22	80.495.10	89.205.10	89.192.10
40.455.16.10/100		ER 16	0,5-10	36,5	100	22	80.495.10	89.205.10	89.192.10
40.455.16.10/150		ER 16	0,5-10	36,5	150	22	80.495.10	89.205.10	89.192.10
40.455.16.13/050		ER 20	1-13	33,5	50	28	80.495.13	89.205.13	89.192.10
40.455.16.13/100		ER 20	1-13	33,5	100	28	80.495.13	89.205.13	89.192.10
40.455.16.13/150		ER 20	1-13	33,5	150	28	80.495.13	89.205.13	89.192.10
40.455.20.10/050	20	ER 16	0,5-10	30,5	50	22	80.495.10	89.205.10	89.192.10
40.455.20.10/100		ER 16	0,5-10	30,5	100	22	80.495.10	89.205.10	89.192.10
40.455.20.10/150		ER 16	0,5-10	30,5	150	22	80.495.10	89.205.10	89.192.10
40.455.20.13/050		ER 20	1-13	33,5	50	28	80.495.13	89.205.13	89.192.13
40.455.20.13/100		ER 20	1-13	33,5	100	28	80.495.13	89.205.13	89.192.13
40.455.20.13/150		ER 20	1-13	33,5	150	28	80.495.13	89.205.13	89.192.13

* DODÁVKA BEZ KLÍČE

* SUPPLIED WITHOUT WRENCH



KLEŠTINY S TĚSNĚNÍM DIN 6499 (ER)
 pro nástroje s válcovou stopkou dle DIN 1835-A a chlazením středem
SEALED COLLETS DIN 6499 (ER)
 for tools with cylindrical shank DIN 1835-A and coolant channel

DIN 6499-B

80.497

80.490.10 ER 16

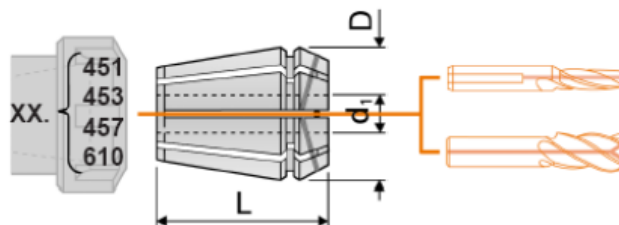
D = 17 mm L = 27,5 mm

REF.	d ₁ mm
80.497.10.040	4
80.497.10.050	5
80.497.10.060	6
80.497.10.070	7
80.497.10.080	8
80.497.10.090	9
80.497.10.100	10

80.490.13 ER 20

D = 21 mm L = 31,5 mm

REF.	d ₁ mm
80.497.13.040	4
80.497.13.050	5
80.497.13.060	6
80.497.13.070	7
80.497.13.080	8
80.497.13.090	9
80.497.13.100	10
80.497.13.110	11
80.497.13.120	12
80.497.13.130	13



80.490.16 ER 25

D = 26 mm L = 34 mm

REF.	d ₁ mm
80.497.16.040	4
80.497.16.050	5
80.497.16.060	6
80.497.16.070	7
80.497.16.080	8
80.497.16.090	9
80.497.16.100	10
80.497.16.110	11
80.497.16.120	12
80.497.16.130	13
80.497.16.140	14
80.497.16.150	15
80.497.16.160	16

80.490.20 ER 32

D = 33 mm L = 40 mm

REF.	d ₁ mm
80.497.20.040	4
80.497.20.050	5
80.497.20.060	6
80.497.20.070	7
80.497.20.080	8
80.497.20.090	9
80.497.20.100	10
80.497.20.110	11
80.497.20.120	12
80.497.20.130	13
80.497.20.140	14
80.497.20.150	15
80.497.20.160	16
80.497.20.170	17
80.497.20.180	18
80.497.20.190	19
80.497.20.200	20

80.490.26 ER 40

D = 41 mm L = 46 mm

REF.	d ₁ mm
80.497.26.040	4
80.497.26.050	5
80.497.26.060	6
80.497.26.070	7
80.497.26.080	8
80.497.26.090	9
80.497.26.100	10
80.497.26.110	11
80.497.26.120	12
80.497.26.130	13
80.497.26.140	14
80.497.26.150	15
80.497.26.160	16
80.497.26.170	17
80.497.26.180	18
80.497.26.190	19
80.497.26.200	20
80.497.26.210	21

80.497.26.220	22
80.497.26.230	23
80.497.26.240	24
80.497.26.250	25
80.497.26.260	26

80.490.34 ER 50

D = 52 mm L = 50 mm

REF.	d ₁ mm
80.497.34.120	12
80.497.34.140	14
80.497.34.160	16
80.497.34.180	18
80.497.34.200	20
80.497.34.220	22
80.497.34.240	24
80.497.34.260	26
80.497.34.280	28
80.497.34.300	30
80.497.34.320	32
80.497.34.340	34



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