

## 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.

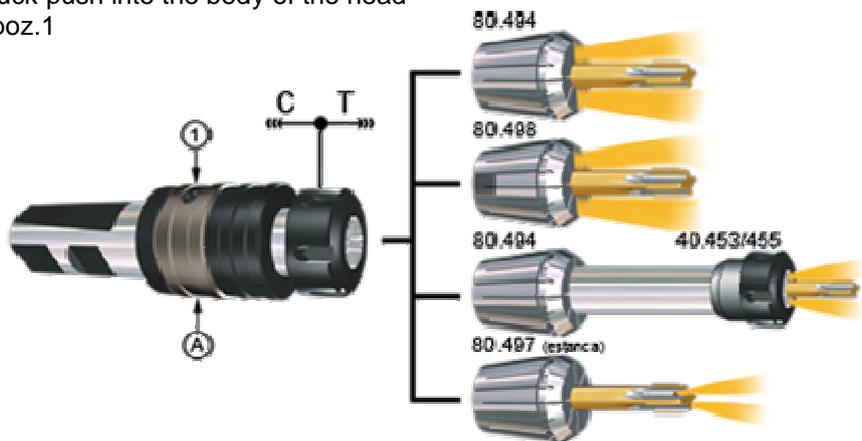
### Usage:

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).

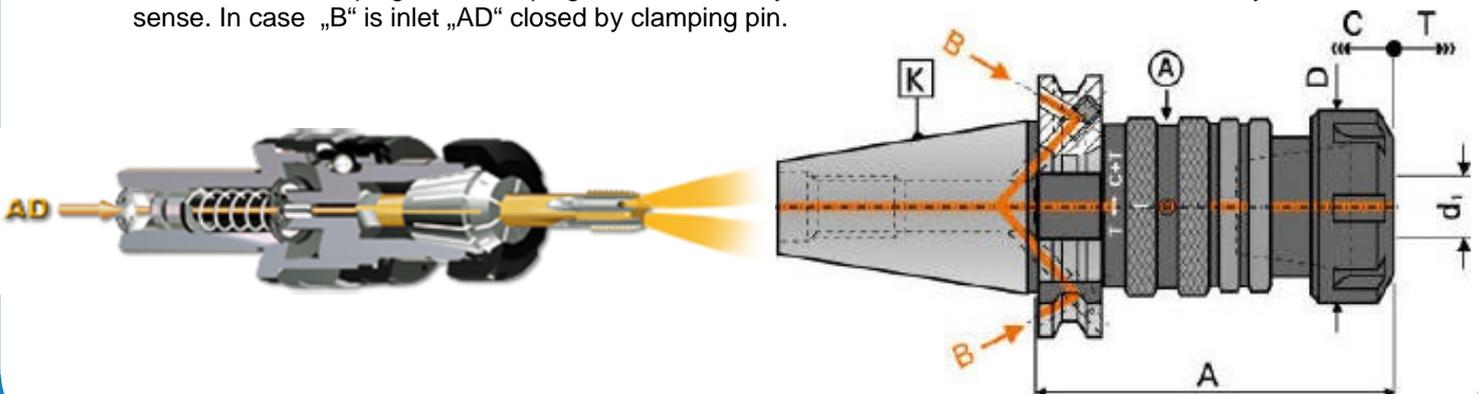
That can be done by this procedure:

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.



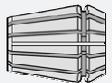
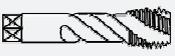
Taps are clamped to head with steel collets (ER) according to DIN 6499, there are 3 forms:

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

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