

Thread cutting heads and threading

Type: Zhr, Zhb, Zho, Zhp M610, M620 and M630, RTH

1.	What thread cutting heads does firm NAREX MTE produce?	Just now only 2 types - reversible thread cutting heads RTH and safety thread-cutting heads Zhb
2.	What difference is between heads RTH and Zhb?	Head RTH is designed only for right hand threads, it has own speed reversal and skidding clutch that defendes screwing tap against torsion failure. Further it has off position which is exploited during threading noncontinuous threads. Head Zhb is designed for right hand and left hand threads and has skidding clutch and possibility of axial compensation for case when machine spindle feed is different from the value of pitch. ATTENTION! Head RTH must everytime revolve, head Zhb not. Type Zhp is designed for machining centres. It consists of holder and exchangeable taper shank which can be with or without skidding clutch. Up to the type of head Zhp enables axial compensation.
3.	Original reversible heads were named ZHR. What is main difference between ZHR and RTH?	Head ZHR were applicable on left hand and right hand threads but they had some defects: length, volume, lower service speed. Heads RTH are shorter, there can be exchanged shank, lower weight, more sensitive gofer and higher service speed.
4.	Which older thread cutting heads does NAREX MTE repair?	Heads ZHR20, ZHR30 and heads Zhb2, Zhb2A, Zhb3 and Zhb3A are repaired if are spare parts on the stock.
5.	Does firm NAREX MTE repair heads GSA 2, GSA 3, GB 2 a GB 3?	Because there are heads from import (NDR), these heads are not repaired by firm NAREX MTE. Only for heads GB2 and GB3 are delivered plastic collet chucks.
6.	Is for screw tap clamping to the head better collet RUBBER FLEX or plastic collet?	Collet RUBBER FLEX simultaneously centralizes and clamp screw tap. Plastic collet only centralizes screw tap and with worse accuracy. Anyway collet RUBBER FLEX is more favourable though it is more expensive.
7.	Are plastic collets used on now produced thread cutting heads?	They are used only on exchangeable chucks NVH 2 and NVH 3, which are designed for thread cutting heads type "A" for fast tools exchange.
8.	What collets are used on head Zhb 51?	On this thread cutting head are not used any collets. Screw tap is centralized and clamped by adapter bush and is ensured against turn 360 degrees by two opposite setscrew like in all other heads. In basic head accessories is set of 8 pieces of adapters. The biggest diameter which can be clamped is 40mm.
9.	Is it possible to use heads RTH and Zhb to forming screwing taps clamping?	It is possible, but ATTENTION! Especially by heads RTH can not be diameter of forming screwing tap bigger than is half of head work range. For example: we do not clamp forming screwing tap to head RTH 22 but to RTH 32. It is because of the big beats during reverse revolutions what makes for premature attrition or head destruction.
10.	What revolutions are suitable for thread cutting heads?	Revolutions are chosen according to recommended cutting speed which is given by producer or supplier of screwing taps. Each thread cutting head has only narrow maximum revolutions.

11.	Is it possible to cut threads in impassable slots to the bottom with these heads?	YES it is possible, both types RTH and Zhb have skidding clutch, so if it is correct adjusted, the screwing tap can not be break off. But WE DO NOT RECOMMEND this way of using, it is too fierce and not safe everytime. Especially by bigger diameters of screwing taps.
12.	What is the best way of adjusting the skidding clutch of thread cutting head?	Procedure is described in instructions for use. The best way is experimentally. Stepwise is torsion moment increasing to the time when screwing tap is fluently cutting thread and can be easily screw out from the thread.
13.	What use is scale on the sleeve by which is torsion moment adjusted?	Scale does not say anything about torsion moment. It identifies place of sleeve on the body of the head.
14.	Can be these thread cutting heads used on lathe?	Heads Zhb - YES, heads reversible RTH - NOT.
15.	Slip on the skidding clutch is fluent or fitful?	In all cases except head Zhr 21 is slip fitful.
16.	Is produced type RTH-L for left hand thread?	It is not on the stock but you can demand it and delivery term is about 4 - 6 weeks.
17.	Is produced type RTH-A for quick tool exchange?	Not now, but if customers will be interest in it we start with its production.
18.	Can be quick change tapping heads M610, M620 and M630 used for bottom holes cutting?	For bottom holes cutting can be used head M620 with switched-on axial compensation and with skidding clutch. M610, M620 and M630 can be used for cutting without axial compensation only with accurate programme (there is defined accurate number of spindle revolutions to achieve head stopping in required position).
19.	Must be quick-change adaptors with skidding clutch type RK-M622 adjusted or they are already adjusted from producer?	Quick change adaptors are adjusted for given range of threads for which is skidding clutch designed.
20.	How to adjust quick-change adaptors M622 with skidding clutch?	If you need there is possible to adjust torsion moment on skidding clutch this way: 1. Slacken lock ring in top part of adaptor. 2. By torque wrench and by turning nut with slots in top part of adaptor is skidding clutch adjusted on requirement torsion moment.
21.	Can be quick-change tapping heads delivered with taper shank MORSE?	NAREX MTE is able to produce these these tapping heads up to the concrete requirement as special production or there could be used heads Zhb.
22.	With which taper shanks NAREX are delivered quick-change tapping heads?	Quick-change tapping heads M610, M620 and M630 can be delivered with taper shank ISO 30, ISO 40 and ISO 50 up to the norm DIN 2080 or up to the norm DIN 69871. By head M610 is possible combined coolant supply up to the norm DIN 69871 AD+B. Type M630 for automatic exchange is up to the norm DIN 69871 AD.