

Success Story **XCHANGE M8**

Application

Automotive engine block
 130.000 engine blocks per year
 engine block GG 25 (GG1025)
 41 nos. threads M 8 x 1,25



competition: HSS-E Tap
 Actual tool life:
 450 blocks → 18.450 threads

machine Heller MC 400
 tap holder Bilz WFLC/We
 blind hole 2,5 x D
 Vc = 40m/min.

Solution

XCHANGE Modular threading tap

Chamfer form E, through coolant
 Shank EDP-No. 7027434
 Indexable Nib EDP-No. 7055079



tool life:
2.870 blocks → 117.670 threads

cutting speed: Vc = 40m/min.
 Set by process; machine data could
 not be changed

Customer's benefit

Increased tool life by **XCHANGE**

Both taps had same cutting data

The difference is the much higher tool life

XCHANGE offers a **637% better tool life** than the HSS-E tap!

