

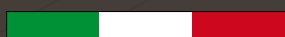
ELECTRONIC IN DIE TAPPING UNIT FOR VERY HIGH VELOCITY

SL. 2005.1 / 2



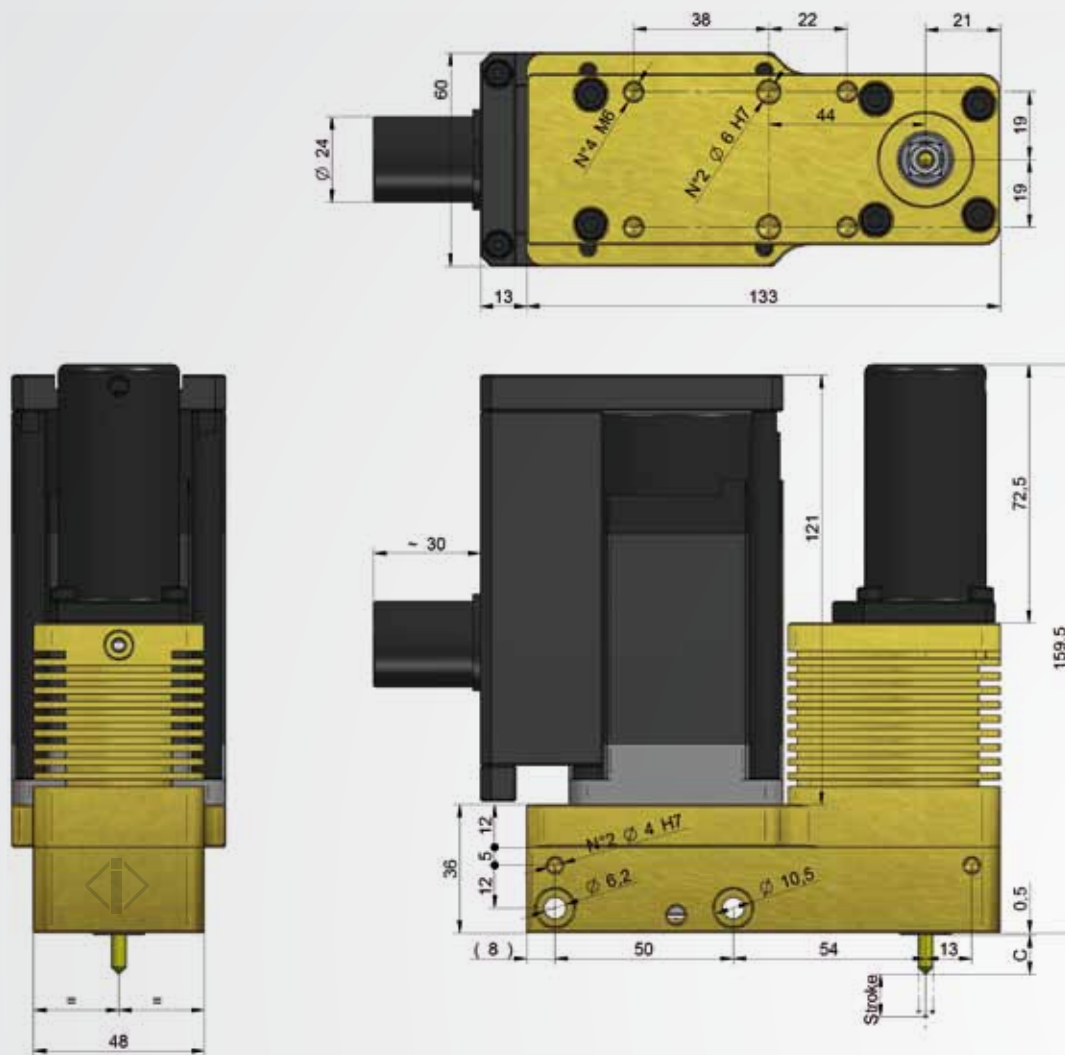
We form the quality

ITALIAN TECHNOLOGY



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SL.2005.1 400W M2 - M5



| Tapping unit type | Motorization | C | Axis Stroke |
|-------------------|--------------|--------|-------------|
| SL.2005.1 M2 | 400 W | 3 ± 1 | ~50 mm |
| SL.2005.1 M2.5 | 400 W | 5 ± 1 | ~50 mm |
| SL.2005.1 M3 | 400 W | 7 ± 1 | ~50 mm |
| SL.2005.1 M4 | 400 W | 11 ± 1 | ~50 mm |
| SL.2005.1 M5 | 400 W | 31 ± 1 | ~50 mm |

Suggested pre-hole diameters

| M2 | M2,5 | M3 | M3,5 | M4 | M5 | M6 |
|-------|------|------|------|------|------|------|
| Ø1,85 | Ø2,3 | Ø2,8 | Ø3,3 | Ø3,7 | Ø4,7 | Ø5,6 |

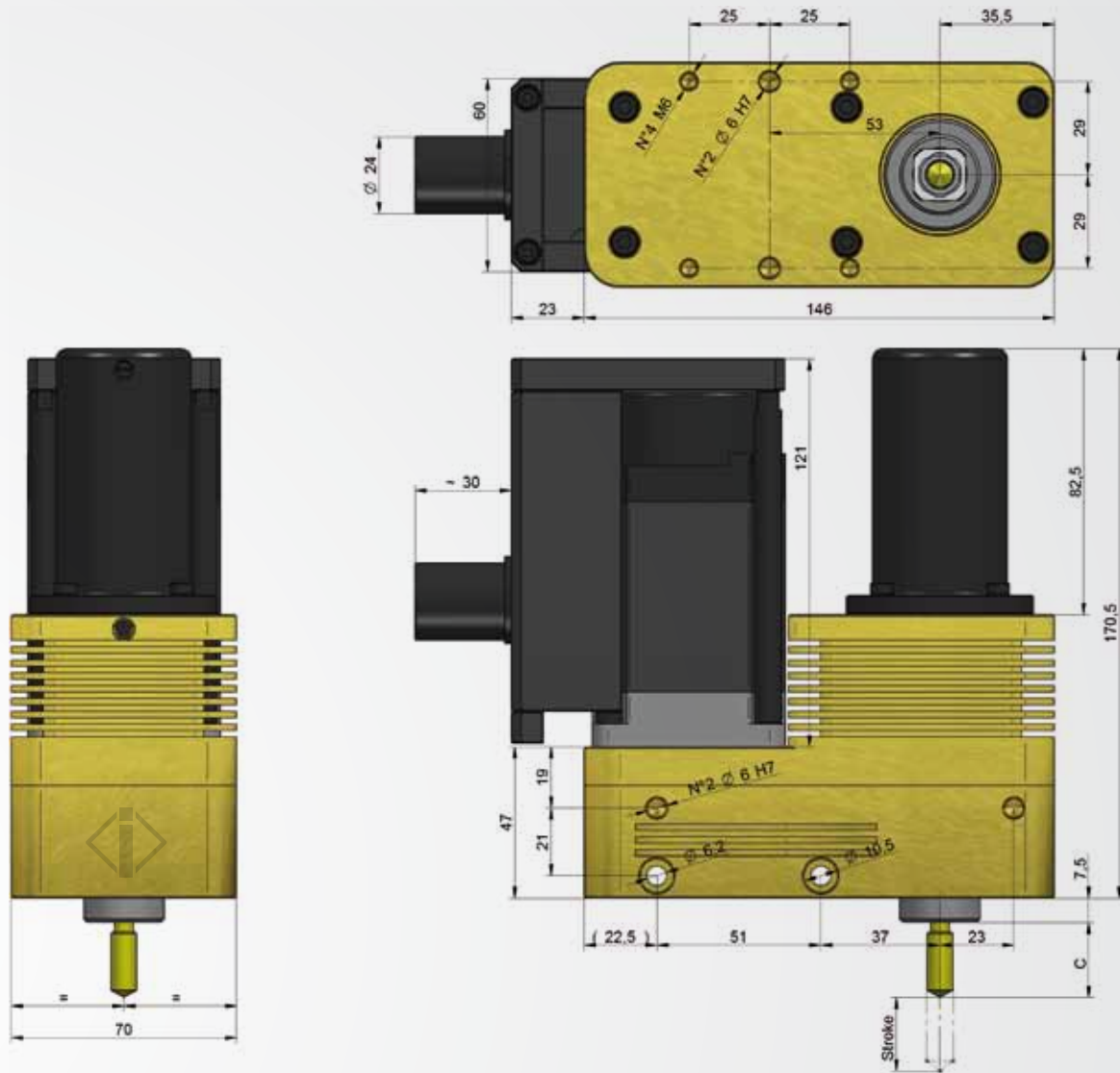
ISO 6HX pre-hole diameters

| M2 | M2,5 | M3 | M3,5 | M4 | M5 | M6 |
|-------------|--------------|--------------|-------------|--------------|-------------|------------|
| Ø1,8 - 1,85 | Ø2,27 - 2,33 | Ø2,75 - 2,81 | Ø3,2 - 3,27 | Ø3,65 - 3,73 | Ø4,6 - 4,69 | Ø5,5 - 5,6 |

ISO 6GX pre-hole diameters

| M2 | M2,5 | M3 | M3,5 | M4 | M5 | M6 |
|--------------|--------------|--------------|--------------|--------------|--------------|--------------|
| Ø1,81 - 1,86 | Ø2,28 - 2,34 | Ø2,76 - 2,82 | Ø3,21 - 3,28 | Ø3,66 - 3,74 | Ø4,61 - 4,70 | Ø5,51 - 5,62 |

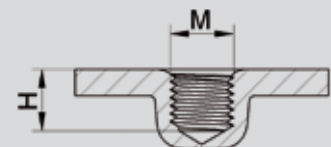
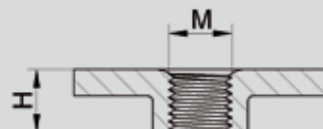
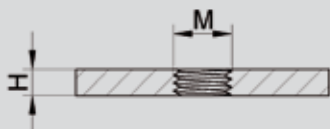
SL.2005.2 400W M6



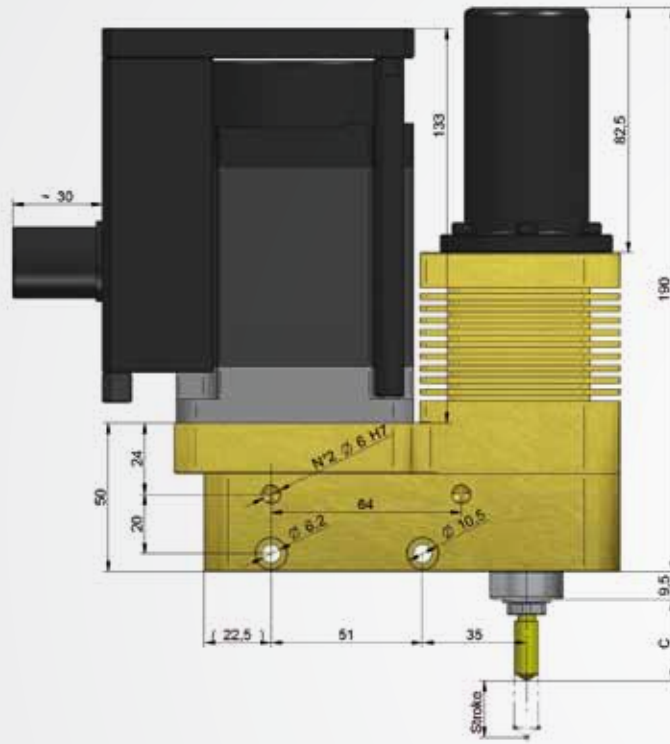
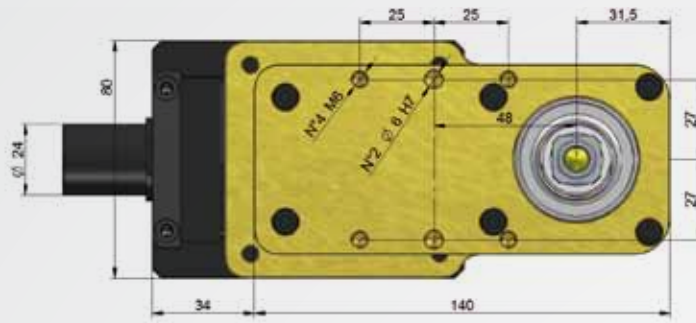
| Tapping unit type | Motorization | C | Axis Stroke |
|-------------------|--------------|--------|-------------|
| SL.2005.2 M6 | 400W | 21 ± 1 | ~50 mm |

The electronic tapping unit is a unit that can make threading operations inside the dies and in special settings, in a very easy and simple way, autonomously, and independently from the stroke of the die. It works with a brushless motor and with a servo driver that control each threading step. Just one start is enough to make the threading autonomously and quickly, always with the possibility to regulate the velocity and the threading depth. It is also possible to control that the threading has been properly done.

Types of threaded holes



SL.2005.2 750W M6 - M10



| Tapping unit type | Motorization | C | Axis Stroke |
|-------------------|--------------|--------|-------------|
| SL.2005.2 M6 | 750W | 27 ± 1 | ~50 mm |
| SL.2005.2 M8 | 750W | 27 ± 1 | ~50 mm |
| SL.2005.2 M10 | 750W | 27 ± 1 | ~50 mm |

Suggested pre-hole diameters

| M6 | M7 | M8 | M10 | M12 |
|------|------|------|------|-------|
| Ø5,6 | Ø6,6 | Ø7,6 | Ø9,4 | Ø11,5 |

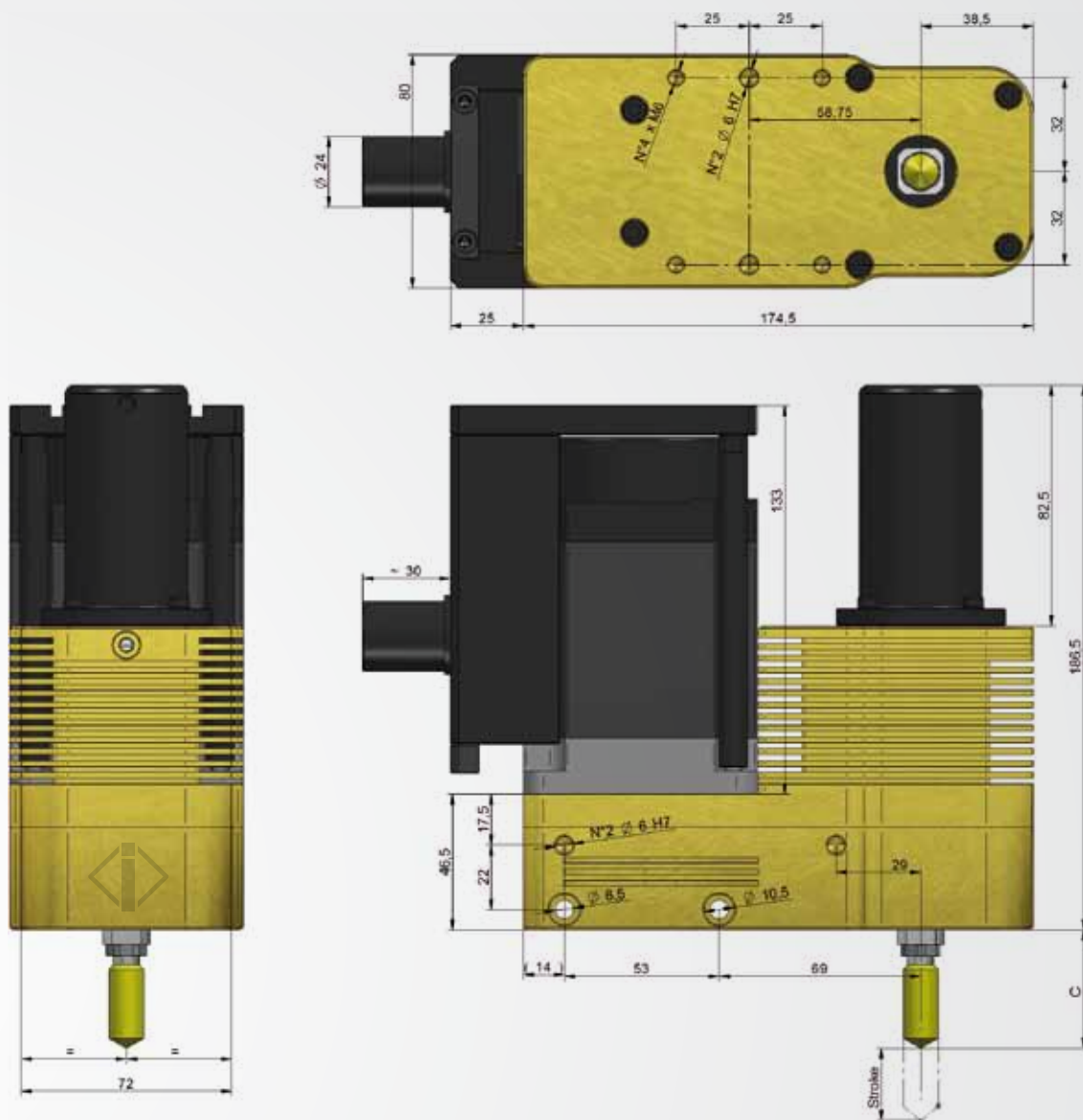
ISO 6HX pre-hole diameters

| M6 | M7 | M8 | M10 | M12 |
|------------|------------|--------------|--------------|----------------|
| Ø5,5 - 5,6 | Ø6,5 - 6,6 | Ø7,37 - 7,49 | Ø9,25 - 9,39 | Ø11,12 - 11,28 |

ISO 6GX pre-hole diameters

| M6 | M7 | M8 | M10 | M12 |
|--------------|--------------|--------------|--------------|----------------|
| Ø5,51 - 5,62 | Ø6,51 - 6,62 | Ø7,38 - 7,51 | Ø9,26 - 9,41 | Ø11,14 - 11,30 |

SL.2005.2 750W M10 S - M12



| Tapping unit type | Motorization | C | Axis Stroke |
|-------------------|--------------|--------|-------------|
| SL.2005.2 M10 | 750W | 40 ± 1 | ~50 mm |
| SL.2005.2 M12 | 750W | 40 ± 1 | ~50 mm |

ADVANTAGES:

- Threading by high velocity; up to 150 strokes/min (according to the diameter, height and material to thread)
- Easy installing and maintenance
- The unit is compact and speed, with an electrical-mechanical functioning, without any compressed air
- The threading operation is independent from any die stroke, in each position: horizontal, vertical and inclined
- Reduced spaces
- Automatical approach of the tap to the hole
- Automatical tap lubrication at each stroke
- Torque controlled
- Control that each thread has been properly done
- Thread on dead holes
- Left threading (on request)
- Multiple threading are possible



PresSpray Pumps

They spray lubricant under command as an instant spray, without air, so they are suitable instruments to lubricate a precise zone, just an example a very precise point like a threading, or a wider area like a sheet. At each spray the oil is so heavy that it doesn't generate any fog. The particularity of these pumps is that they can dose the lubricating volume that is necessary to each press cycle and they can direction its way out through apposite nozzles, that create an homogeneous spray without air.

They are simple to install, to configure and to use. According to the different types of nozzles there can be rectilinear, conical or fan type spray.

An automatic lubrication in the dies and, in case of threading, directly on the taps, is a guarantee of long life and high performances. The operator won't have to take care of the lubricating process, paying his whole attention to the quality of the production. Pressspray pumps are available in different types, according to the volume of oil required.

Oils

Pressspray pumps can work with different kinds of lubricants, high viscosity oils and light oils, which can be carefully controlled.

NTR-300 BE (Integral oil)

It's suitable for cold steel deformation processes. It gives high performances in the fine blanking, traditional blanking, drawing, bending, minting and by the use of rolling taps, for both steels and stainless steels.

STR-800 E (Emulsible oil)

It's a universal oil suitable for scrap removing and cold deforming. It guaranties more high performances and longer life time to the parts of the die.

Both oils are excluded to prescriptions for inflammable oils.



Rolling taps

Rolling taps guarantee very high performances if compared to the conventional screw taps, avoiding the problems of scraps in the dies.

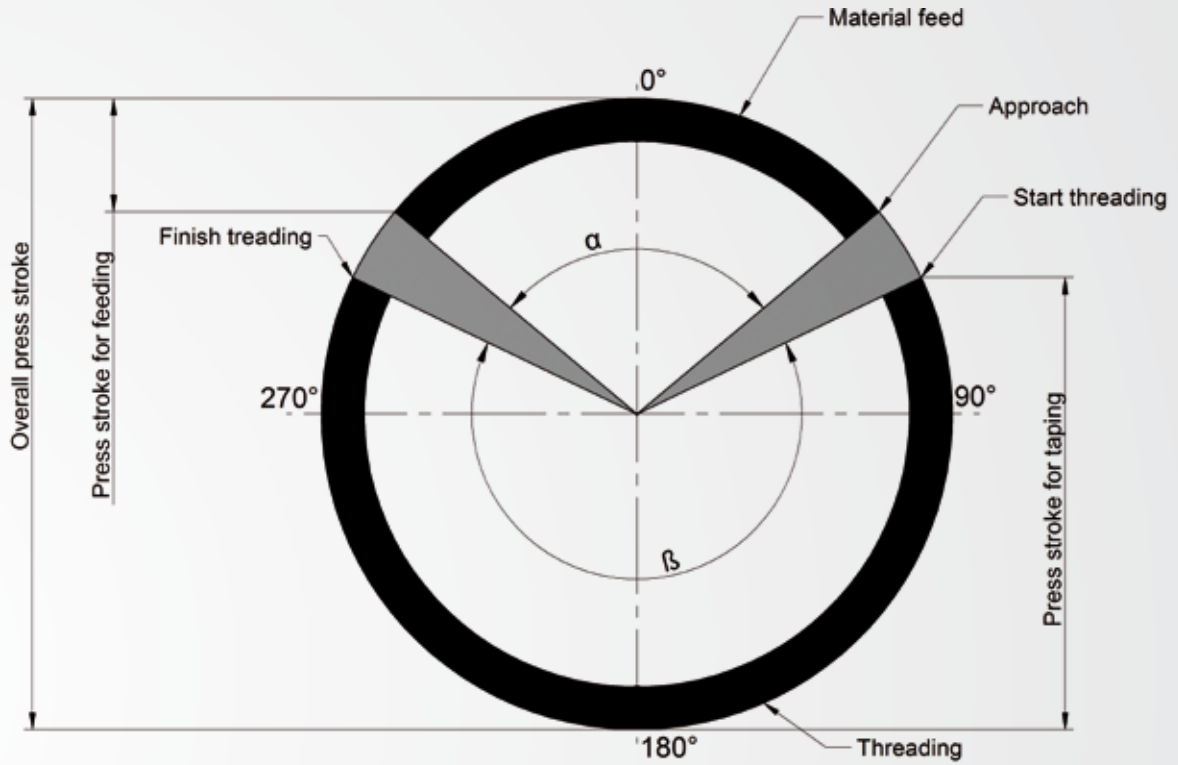
Rolling taps can even work at higher velocity than other taps and give more quality to the surfaces that they generate (less roughness).

They guarantee more resistance to the thread splitting, allowing shorter executions, with shorter die strokes and longer tap life.

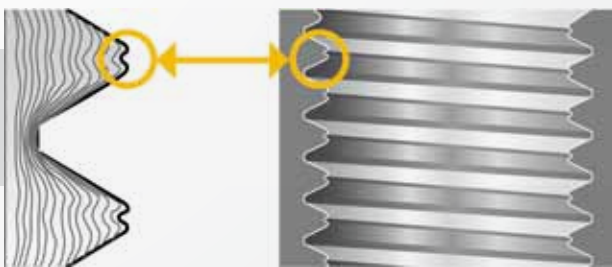
There is a wide range of taps' types like TiN or TiCn coated, metric threading ISO (with 6HX, 6GX, 7GX tolerances) and UNC or UNF.

Our technical office is always at your disposal for further questions or any suggestion on the best way to use our products.

Threading process



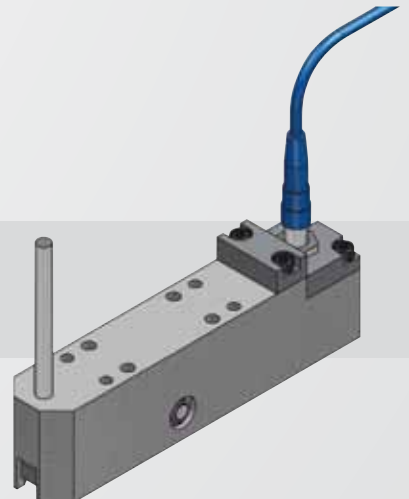
The smaller is the angle of material feed (α), the greater will be the time for threading, (more strokes / min.)

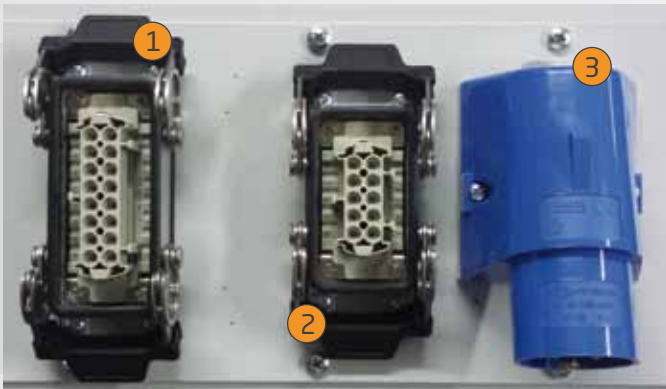


Rolling thread example

End threading controller

To check the production at 100% properly done





- ① SIGNALS CABLE
- ② MOTOR CABLE (MOTOR+ENCODER)
- ③ FEEDING



- ① MASTER ON
- ② CONTROL PANEL

ELECTRICAL CHARACTERISTICS:

Feeding:
monophasic (trifasic on request) from 200 Vac to 230 Vac (+10%, -15%) 50 / 60 Hz (± 3 Hz)

Maximum current of the control panel: 30 Amp

Dimensions of the electronic box including connectors: Height 500, Width 400, Depth 230 (dimensions in mm)



NEW WHEEL CONSOLE WITH TOUCH SCREEN

New



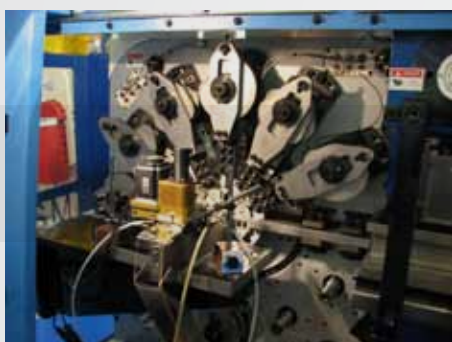
NEW TOUCH SCREEN

New

APPLICATIONS



Example of application by high-speed tools



Example of application by presses like Bihler or similar



Example of application with 6 tapping units by components for automotive industry



150 STROKES/MIN



BLIND HOLES THREADINGS



EASY INSTALLATION



THREADINGS IN SECURITY



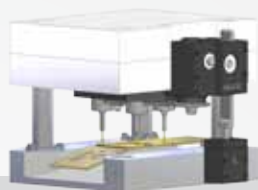
HIGH PERFORMANCE



UP TO 8 THREADINGS WITH ONE CONSOLE

INTERCOM IS ALSO

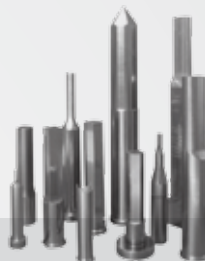
PRODUCTS



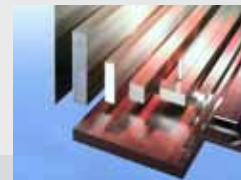
Mechanical in die tapping units



Standard components



Special parts according to drawing



teels and ground steel plates

SERVICE



TECHNICAL SUPPORT
BY QUALIFIED PERSONNEL



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IN SPECIFIC SOLUTION FOR EVERY SITUATION



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VIA C. CATTANEO 18/22 - 20064 GORGONZOLA (MILANO)
TEL. +39 02 95300202 FAX +39 02 95300023
WWW.INTERCOMONLINE.IT - INTERCOM@INTERCOMONLINE.IT