



## ► KBM / KBU: Tapping

### Target segments

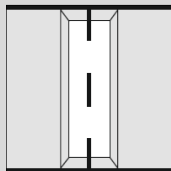
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|---|---|--|
| <input checked="" type="checkbox"/> Steel construction on-site            | <input checked="" type="checkbox"/> Vessel-, container construction | <input type="checkbox"/> Foundries       |
| <input checked="" type="checkbox"/> Steel construction industry           | <input checked="" type="checkbox"/> Machinery                       | <input type="checkbox"/> Pipe processing |
| <input checked="" type="checkbox"/> Metal construction / building fitters | <input checked="" type="checkbox"/> Ship building                   |  |

### Application: Electrical tapping

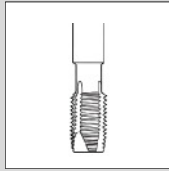
Compared with working by hand, electrical tapping is faster, requires less physical effort and produces more precise results. To fabricate an internal thread a pilot hole must be drilled in advance. Ideally the pilot hole is equipped with a counterboring. The counterboring is needed to ensure the tapper a better gate. Generally two thread types are distinguished:

#### Through hole thread

A through hole thread is one which fully pierces the workpiece and thus provides a passage into the workpiece. For through hole threads a tap drill with scalping section is needed. This geometry leads the swarf downwards out of the hole. However, through hole thread tap drills with upward swarf removal is also available.



Schematic figure of a through hole



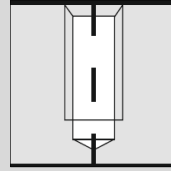
Tap drill with scalping section



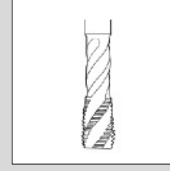
Collet for through hole thread

#### Blind hole thread

A blind hole thread is one which doesn't fully pierce the workpiece and thus provides a defined depth. For blind hole threads a tap drill with twisted swarf flutes is needed. This geometry leads the swarf upwards out of the hole.



Schematic figure of a blind hole



Tap drill with twisted swarf flutes



Collet for blind hole thread

### Solution: FEIN magnetic core drills KBM / KBU with clockwise/ counter-clockwise rotation

The clockwise/ counter-clockwise rotation enables direct and accurate tapping. The extra-large stroke range offers a large installation space for the use of very long insert tools without removing the magnetic core drill from the workpiece.



Type	Tapping- $\varnothing$ max.	Weight	Stroke range
KBU 35 Q	M14	10,6 kg	260 mm
KBU 35-2 Q	M14	11,0 kg	260 mm
KBU 35 MQ	M14	11,0 kg	260 mm
KBM 50 Q	M16	13,2 kg	315 mm
KBM 50 U	M16	13,9 kg	315 mm

Type	Tapping- $\varnothing$ max.	Weight	Stroke range
KBM 65 U	M20	16,1 kg	315 mm
KBM 80 U	M27	25,4 kg	285 mm
KBM 50 auto	M16*	16,2 kg	315 mm
KBM 80 auto	M27*	26,4 kg	285 mm

\*only in manual use

### Original FEIN accessories for tapping

FEIN offers a wide range of accessories for tapping:

- Tapping unit with reverse gear
- Fast action tapping chuck
- Collets for through hole threads [DIN 371, 374/376]
- Collets for blind hole threads [DIN 371, 374/376]



### Application video

You will find the appropriate application video with all relevant working steps here:

In German:

<https://www.youtube.com/watch?v=adKuYs90ySg>

In English:

<https://www.youtube.com/watch?v=WtgBtHPiKOW>

