

TTT Tapping-Torque-Testsystem

Laboratory Evaluation & Analysis System

Terms of Reference / Approach

The Temperature-Sensor-Equipment TSE collects Temperature Data for Application of Temperature Delta T

At the time of the greatest heat build-up the exact temperature at the tip of the tool can be measured only with an enormous effort

Solution / DeltaT Method

When determining the temperature at the tip of the tool right before the measurement and again right after the measurement however, and compare both data, the difference results in the temperature value Delta T (ΔT)

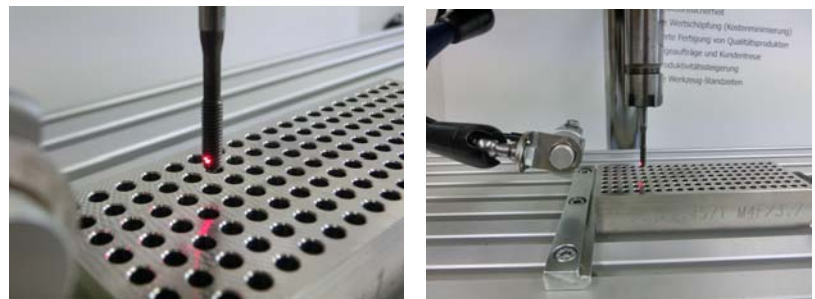
Realisation

The Temperature-Sensor-Equipment TSE is furnished with a temperature measurement device incl. optics, fixation handle and accessories

Features

The ΔT data are fed into the Analyser of the „Evaluation & Analysis Software“ and directed towards a parameterisation (graphic and numerical display of the temperature value ΔT) and subsequently amalgamated and evaluated with the torque data of the work spindle

The TSE in combination with the TTT-System has specially been developed for laboratory requirements of the Water-Mixable-Fluids (MWF's) industry and manufacturers of threading tools and tool coatings



Temperature Assessment

...right before and right after measurement

From „ ΔT “ we gain meaningful evidence for the interpretation of temperature influences. The computed ΔT mean value of a series of measurement, interacting with the torque values, is able to deliver plausible conclusions in regard of the effective power of an additive respectively EPs in dependence on temperatures (friction*) occurring in a work process

* At determination of the friction coefficient the physical load parameters in a wear process are defined in four quantities:

- Normal Force F_N (Torque)
 - Velocity V (Cutting Speed)
 - Temperature T (Delta T)
 - Time of Load t_B (Depth of Thread / Time)
- (GFT, Tribologie from 2002, sheet 7, page 8)

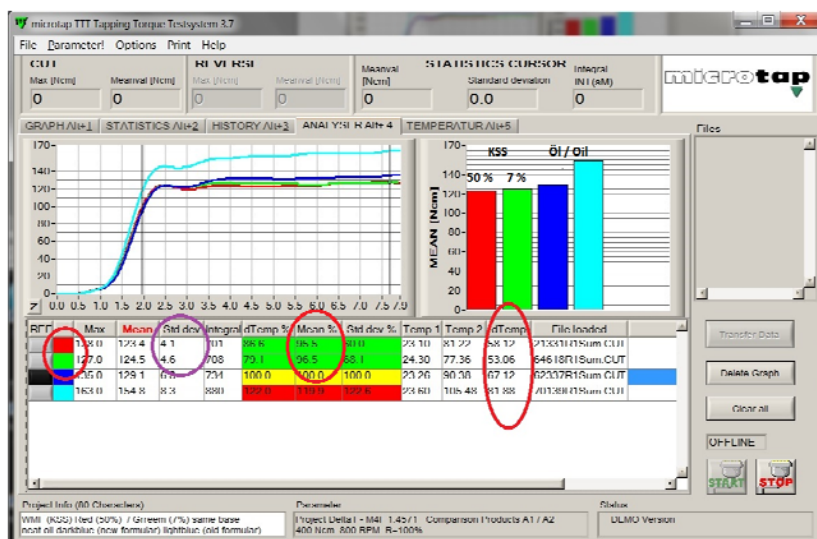
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Benefit / Advantage

Retrofitting TSE Temperatur-Sensor-Equipment and WinPCA3.7 Upgrade

Temperature, which has a decisive influence on the activity and functionality – in other words: the potency and limitation of tribologic performance of lubricants and their additives, is a factor for friction with essential effects on a durable existence and the quality of a factually operative lubrication film, and its limits as well



Analyser / Bar Chart

Price
Retrofitting

Requirement

Upgrades
V2.5 – 2.6V3
V2.7 – 2.7V6

Updates
V3.0 – V3.36

TTT Instruction & Training on-site
Incl. TSE Installation, TTT Standard & Method, WinPCA Evaluation-Analysis
WinPCA SW for further PCs

3.000 €
Incl. Firmware-Update at microtap GmbH
and authorised partner excluding shipping costs

The TSE System is available and applicable only in junction with WinPCA3.7, Firmware > V.4.99

WinPCA3.7 (Compatible MS-XP / Win7+8 32/64)
3.500 €
2.700 €

1.500 €
1.600 € (1 day)
2.800 € (2 days)
foreign countries plus expenses
300 € per workstation / computer

microtap GmbH
Rotwandweg 4
82024 Taufkirchen / München (Munich – GERMANY)
Tel +49-89-6128051 / Fax +49-89 -6127488
<http://www.tapping-torque-test.com>