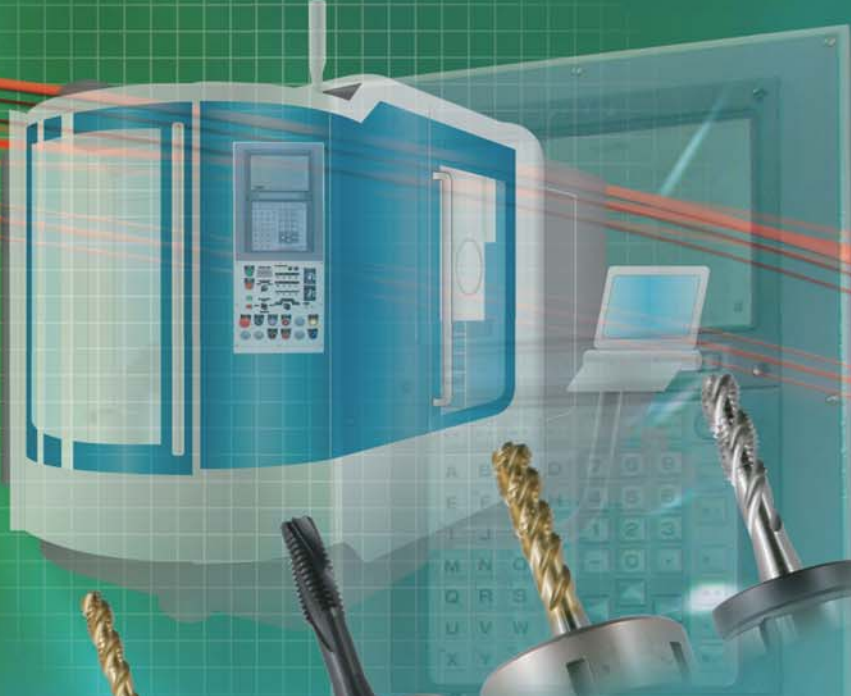


XSERIES



XSP  
AUXSP  
SUXSP  
XSL  
AUXSL  
SUXSL

Xseries maximizes the performance of high precision tapping machines and toolings.

# XSERIES

XSP / XSL / AUXSP / AUXSL / SUXSP / SUXSL

High rigidity Xseries taps

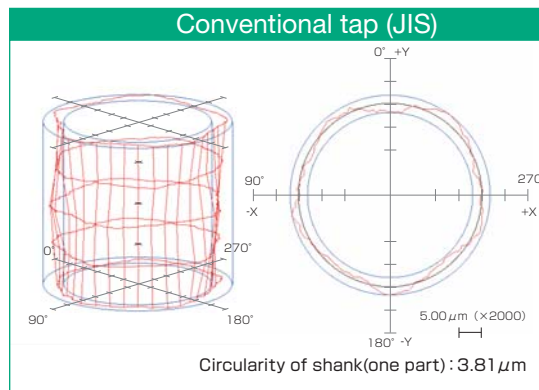
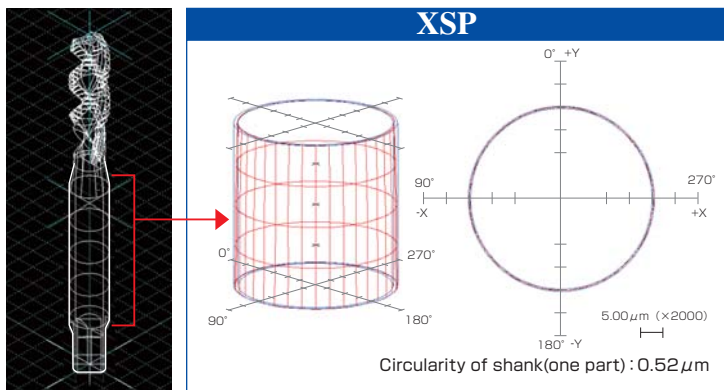
Think threads with  
**YAMAWA**

# X SERIES Features

- High level and high rigidity for next generation taps: X series enables high level machining centers and high precision toolings to perform at the maximum.
- Fully new design for shape of Tap and threads to be the most suitable for tapping.
- Furthermore, by improving tap's run-out accuracy and circularity of shank, X series has realized the stable and high quality tapping even by high speed tapping.



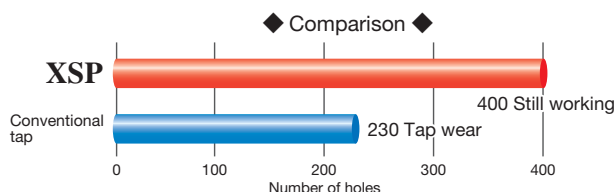
## Circularity of shank Stable tapping



## Tool life Long tool life

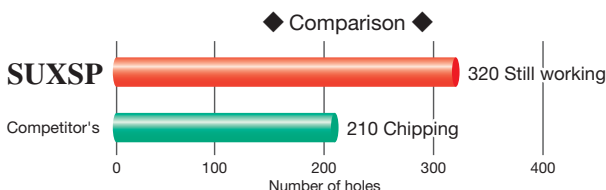
**XSP** tapping condition : Tap XSP M10x1.5

Material	S50C 16HRC
Cutting speed	15m/min
Hole diameter	φ 8.5mm
Tapping length	Blind hole 20mm long
Machine	Machining center vertical type (Synchronous feed)
Oil	Water soluble oil



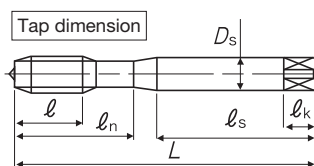
**SUXSP** tapping condition : TAP SUXSP M12x1.75

Material	SUS304 85~90HRB
Cutting speed	15m/min
Hole diameter	φ 10.3mm
Tapping length	Blind hole 18mm long
Machine	Machining center vertical type (Synchronous feed)
Oil	Non water soluble oil (chlorine-free)



## Dimension

**XSP / XSL**  
**AUXSP / AUXSL**  
**SUXSP / SUXSL**



Nominal size	Overall length <i>L</i>	Thread length <i>l</i>	Neck length <i>l<sub>n</sub></i>	Shank length ※ ( <i>l<sub>s</sub></i> )	Shank diameter <i>D<sub>s</sub></i>	Width of square <i>K</i>	Square length <i>l<sub>k</sub></i>
M6 x1	80	15	30	(45)	6	4.9	8
M8 x1.25	90	19	35	(48)	8	6.2	9
M10 x1.5	100	23	40	(53)	10	8.0	11
M12 x1.75	110	26	45	(56)	12	9.0	12

※The dimension of (*l<sub>s</sub>*) is reference.

Please use DIN371 standard collet chuck for M6, M8 & M10, and DIN376 standard collet chuck for M12.

### Warning

- ◆ Tools may shatter if broken. The wearing of eye protection is strongly advised in the vicinity of their use.
- ◆ The correct using conditions and handling of our tools are essential in securing maximum useful tool life and hazard free operation.
- ◆ The wearing of gloves is forbidden as the gloves may entangle with turning tools.
- ◆ Tools may hurt the user's feet when falling off. The safety shoes should be put on at all time.
- ◆ While fitting the tools to machine spindles and/or sleeves, care should be taken to avoid subjecting them to shock or impact.
- ◆ Check that the workpieces are properly seated and securely held in the chuck before switching on machine power.  
Do not use a tool whose cutting edges are worn-out or chipped severely.
- ◆ Tools may generate extreme heat during use. Fire protection is strongly recommended.

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YAMAWA group for Overseas YAMAWA International Co., Ltd.

