

XSERIES
X series

Taps for pipe taper threads.

Straight flute type

PT-X

Spiral flute type

SP-PT-X

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S

New pipe taps specialized for tapping on machine operation.



PT-X

SP-PT-X

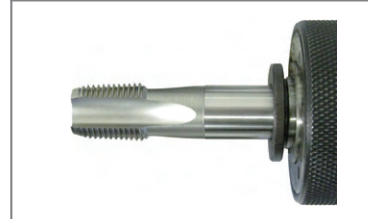
Feature of product

Adopting new geometry, PT-X and SP-PT-X can ensure properly long ejecting length of tap.

previous dimension



new dimension



Feature of product

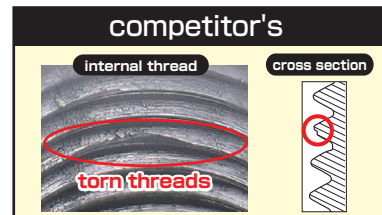
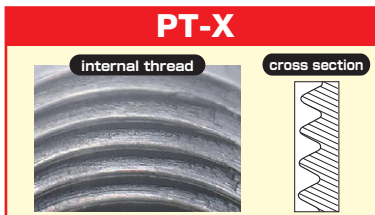
- By adopting new blank dimension, X series ensure the proper ejecting length.
- With short thread length type, X series are suitable for tapping such machine components as have limit in their width.
- X series can run 2 times faster than previous taps.

Tapping performance

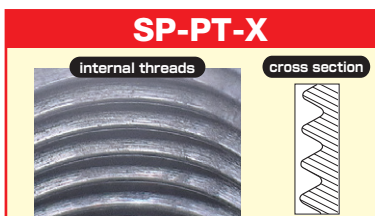
Suitable design of cutting edge and proper ejecting length of X series guarantee the reliable internal thread tapping.

Tapping condition

size	1/8-28
material	S45C
tapping speed	3m/min
bored hole size	φ8.2
threaded length	10.5mm
machine	vertical machining center (non-rigid)
lubricant	water soluble oil(without chlorine,x20)



size	1/8-28
material	SS400
tapping speed	5m/min
bored hole size	φ8.2
threaded length	10.5mm
machine	vertical machining center (non-rigid)
lubricant	water soluble oil(no chroline,x 20)



Dimensions

PT-X

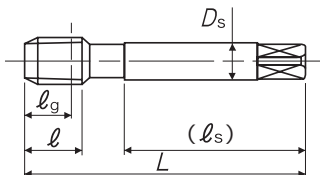


straight flute type

SP-PT-X



spiral flute type



size	OD basic size	overall length L	thread length ℓ	distance to basic diameter Lg	shank length (Ls)	shank diameter Ds	code	
							PT-X	SP-PT-X
PT 1/16-28	7.723	75	13.5	10.5	(47)	8	THX2T01K-8	SHX2T01K-8
PT 1/8-28	9.728	75	13.5	10.5	(48)	8	THX2T02K	SHX2T02K
PT 1/4-19	13.157	85	16.5	12.5	(54)	11	THX2T04-	SHX2T04-
PT 3/8-19	16.662	95	18	14	(60)	14	THX2T06-	SHX2T06-
PT 1/2-14	20.955	105	22.5	17	(64)	18	THX2T08Q	SHX2T08Q

tapping condition

	tapping speed(m/min.)	
material	PT-X	SP-PT-X
low carbon steel ~S25C	~ 3	~ 7
high carbon steel S45C~	~ 5	~ 7
alloy steel SCM	—	~ 5
cast iron FC250	~10	—
aluminum cast iron ADC12	~10	~10

recommendation

※When there is collapsed thread trouble, please use tappers.

※Class is 2nd class. Distance to basic diameter is that for short pipe thread type.

Warning

- ◆Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- ◆Tools may shatter. Use tools under the proper tapping condition.
- ◆Never wear gloves during turning operations as the gloves may get caught with the tools.
- ◆Wear safety shoes to avoid injuring yourself by the falling tools.
- ◆On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- ◆Fasten the workpieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- ◆Take a special care to fire trouble. High temperature during machining may cause fire.

※Please note that specification may change without advance notice.