

SC-TL-RZ



Low tapping torque ROLL Taps for IT industries

SC-TL-RZ

Features of product

SC-TL-RZ

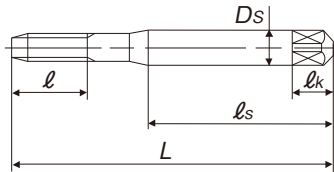


Short chamfer torqueless ROLL Taps(1 thread chamfer)

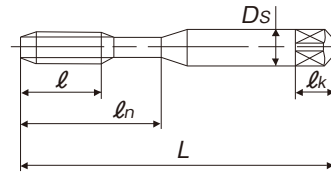
■ Features

- Producing high quality internal threads with little burrs, SC-TL-RZ results in longer tool life.
- Tapping hard-to-machine materials of lower ductility becomes possible.
- Applicable materials: SUS303, 304, 316, 440C/SCM420/S45C and higher/AC/ADC12.
- Longer tool life under water soluble oil.
- Wider tapping application range up to higher speed tapping.

Table of dimension and sizes



【M1~M2, No.2-56】



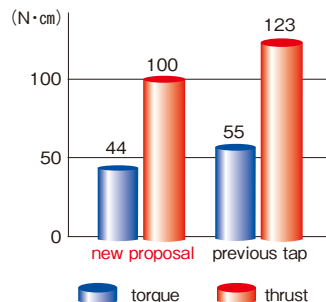
【M2.5~M6, No.4-40】

size	class	overall length	thread length	neck length	shank diameter	recommending bore hole diameter		code
						Max	Min	
M1 X0.25	G4	36	4.5	—	3	0.92	0.89	SRZ41.0B1
M1.2X0.25	G4	36	4.5	—	3	1.12	1.09	SRZ41.2B1
M1.4X0.3	G4	36	5.4	—	3	1.30	1.26	SRZ41.4C1
M1.4X0.2	G3	36	3.6	—	3	1.32	1.30	SRZ31.4A1
M1.6X0.35	G4	36	6.3	—	3	1.47	1.42	SRZ41.6D1
M1.6X0.2	G3	36	3.6	—	3	1.52	1.50	SRZ31.6A1
M1.7X0.35	G4	36	6.3	—	3	1.57	1.52	SRZ41.7D1
M2 X0.4	G4	42	7.2	—	3	1.84	1.79	SRZ42.0E1
M2.5X0.45	G5	46	8.1	14	3	2.34	2.27	SRZ52.5F1
M2.6X0.45	G5	46	8.1	14	3	2.44	2.37	SRZ52.6F1
M3 X0.5	G5	46	9	14	4	2.82	2.75	SRZ53.0G1
M4 X0.7	G6	52	11	17	5	3.72	3.65	SRZ64.0I1
M5 X0.8	G6	60	13	22	5.5	4.67	4.59	SRZ65.0K1
M6 X1	G6	62	15	26	6	5.59	5.49	SRZ66.0M1
No.2-56	G4	42	8.1	—	3	2.04	1.96	SRZ4UN2E1
No.4-40	G5	46	9	14	4	2.64	2.54	SRZ5UN4H1

Tap's accuracy classes do not always ensure the accuracy of internal threads.

Tapping data

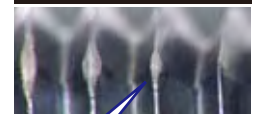
Tap	M3X0.5 G5
Coating	TiCN
material	SCM440 tempered 32HRC
threading depth	4.5mm
bored hole	φ2.8
tapping speed	5m/min
cutting oil	water soluble (x10)
machine	tapping center



new proposal
after 7000 hole tappings



previous tap
after 2800 hole tapping



There is little difference on damage between 7000 hole tapping with the new proposal and 2800 hole tapping with the previous tap.

Warning

- ◆ Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- ◆ Tools may be 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.

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