

SURZ

SURZ can control Seam Part of internal threads.

■ SU Roll Taps ■

SURZ



To respond to the increasing demand for tapping stainless steel parts in IT industries, Yamawa developed SU Roll Taps(SURZ) by harmonizing with Seamless and torqueless Roll tap.

Feature of product

SURZ



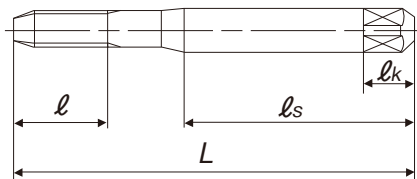
SU Roll tap (2 thread chamfer)

Feature

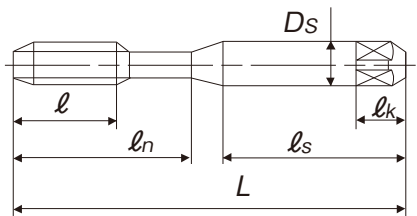
Applying the special form to tap's root, SURZ controls the minor diameter geometry of internal threads.

- Special lobe shape realizes low tapping torque.
- SURZ controls Seam Part which is produced by thread forming operation.
- High efficiency can be obtained in thread forming stainless steel parts.
- By adjusting bored hole size, you can adjust the minor diameter geometry of internal threads.

Table of dimension and size



【M1~M2.3, No.2-56】



【M2.5~M3, No.4-40, No.6-32】

size	class	overall length	thread length	neck length	shank diameter code	code
M1 X0.25	G4	36	4.5	—	3	SUR41.0BB
M1.2X0.25	G4	36	4.5	—	3	SUR41.2BB
M1.4X0.3	G4	36	5.4	—	3	SUR41.4CB
M1.6X0.35	G4	36	6.3	—	3	SUR41.6DB
M1.6X0.2	G3	36	3.6	—	3	SUR31.6AB
M1.7X0.35	G4	36	6.3	—	3	SUR41.7DB
M2 X0.4	G4	42	7.2	—	3	SUR42.0EB
M2.3X0.4	G4	42	7.2	—	3	SUR42.3EB
M2.5X0.45	G4	46	8.1	14	3	SUR42.5FB
M2.6X0.45	G5	46	8.1	14	3	SUR52.6FB
M3 X0.5	G5	46	9	14	4	SUR53.0GB
No.2-56	G4	42	8.1	—	3	SUR4UN2EB
No.4-40	G5	46	9	14	4	SUR5UN4HB
No.6-32	G5	52	11	16	5	SUR5UN6JB

Tap's class does not always ensure the accuracy of internal threads.

Tapping data

tap size	SURZ E=G4 M2X0.4 B
material	SUS304
thread length	5.2mm(Blind hole)
bored hole size	ϕ 1.85~ ϕ 1.82
tapping speed	5m/min
feed	rigid
tapping direction	vertical
lubricant	water soluble (x20)
test machine	machining center

bored hole size	ϕ 1.85	ϕ 1.84
cross section of internal threads		
Seam shape	normal	semi top-roll
minor diameter	ϕ 1.62	ϕ 1.61
bored hole size	ϕ 1.83	ϕ 1.82
cross section of internal threads		
Seam shape	full top-roll	full top-roll
minor diameter	ϕ 1.60	ϕ 1.59

M2x0.4 6H internal thread minor diameter and tolerance	
max	1.679
min	1.567
tolerance	0.112



POINT!!

Please select the suitable bored hole size.

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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