

# MHRZ

Medium Hard

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Now, the worries have gone, about tapping carbon steels and alloy steels of medium hardness.



# Product features

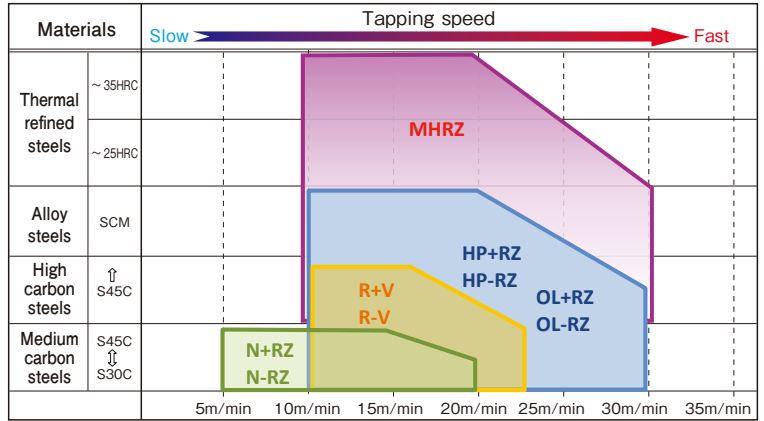
Roll Taps for Carbon Steels of Medium Hardness

**MHRZ** M6~M14

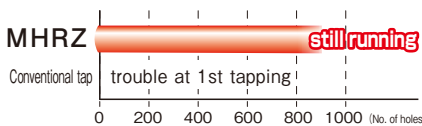


## Features

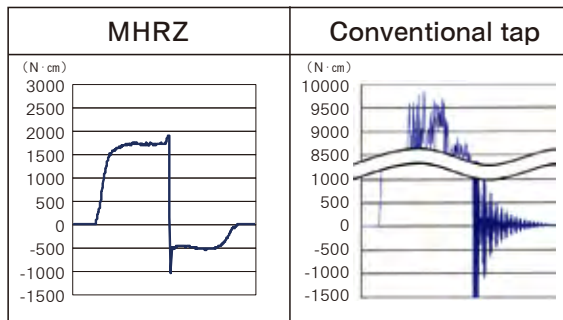
- Due to Yamawa's proprietary design, the tapping torque decreases.
- With a combination of wear-resistant tool material and a unique coating, the tool's durability improves tremendously.
- Consistent tapping of thermal refined materials (~35HRC) is ensured.
- Tapping with water soluble tapping fluid is possible.



## Tapping Data / Comparison of tapping torque

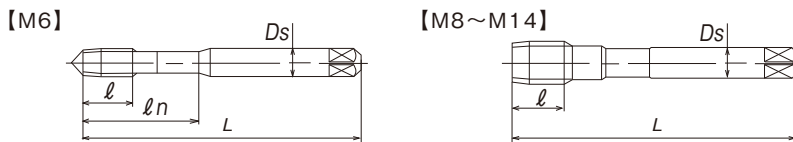


Size	M12X1.5
Material	SCM440(thermal refined)/35HRC
Tapping speed	20m/min
Bored hole size	φ11.3mm
Threading length	18mm(Through hole)
Machine	MC(Synchronous feed)
Tapping fluid	Water soluble
No. of holes	800hole(still running)



Consistent tapping in SCM440(thermal refined) at 35HRC becomes possible. Before the MHRZ, this material was thought to be difficult for thread forming.

## Dimension and Sizes



Size	Class	Chamfer	L	ℓ	ℓn	Ds	Code
M6 X1	G8	4P	62	11	26	6	RY6.0M8DCTP
		2P					RY6.0M8DCTB
M8 X1.25	G8	4P	70	12	-	6.2	RY8.0N8DCTP
		2P					RY8.0N8DCTB
M10X1.5	G8	4P	75	13	-	7	RY01008DCTP
		2P					RY01008DCTB
M10X1.25	G8	4P	75	13	-	7	RY010N8DCTP
		2P					RY010N8DCTB
M12X1.5	G9	4P	82	15	-	8.5	RY01209DCTP
		2P					RY01209DCTB
M12X1.25	G9	4P	82	15	-	8.5	RY012N9DCTP
		2P					RY012N9DCTB
M14X1.5	G10	4P	88	18	-	10.5	RY01400DCTP
		2P					RY01400DCTB

External centers of M 6 x 1 (B) are to be removed.

**No more worries!!**

(Cutting tap) entangled chips

internal thread by roll tap

internal thread by cutting tap

◆ By adopting roll taps, the worries about the problems caused by chips are completely solved.

◆ A great improvement in surface finish of internal threads

### 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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