

AU+SL

TiN coated Left hand spiral fluted
taps(right hand cutting)
for through hole

AU+SL enables the tapping at medium and high speed
tapping for wide range of work materials.

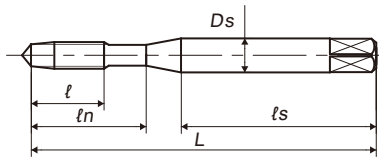
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*We are expanding size range of
AU+SL up to M20, both metric
coarse and metric fine.*



Dimension

[M3~M6]

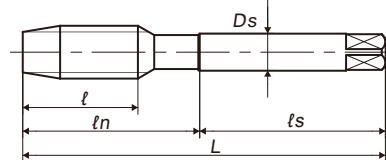


unit mm

Size	Class	No. of flutes	Chamfer	L	l	ln	ls	Ds	Code
M3X0.5	P2	3	5P	46	9	14	26	4	VSAPQ3.0GL
M4X0.7	P3	3	5P	52	11	17	29	5	VSAPR4.0IL
M5X0.8	P3	3	5P	60	13	22	33	5.5	VSAPR5.0KL
M6X1	P3	3	5P	62	15	26	33	6	VSAPR6.0ML
M8X1.25	P3	3	5P	70	19	-	36	6.2	VSAPR8.0NL
M8X1	P3	3	5P	70	19	-	36	6.2	VSAPR8.0ML
M10X1.5	P3	3	5P	75	23	-	38	7	VSAPR010OL
M10X1.25	P3	3	5P	75	23	-	38	7	VSAPR010NL
M10X1	P3	3	5P	75	23	-	38	7	VSAPR010ML
M12X1.75	P4	3	5P	82	26	-	42	8.5	VSAPS012PL

*Tap class is only the target for the limit of internal threads.

[M8~]



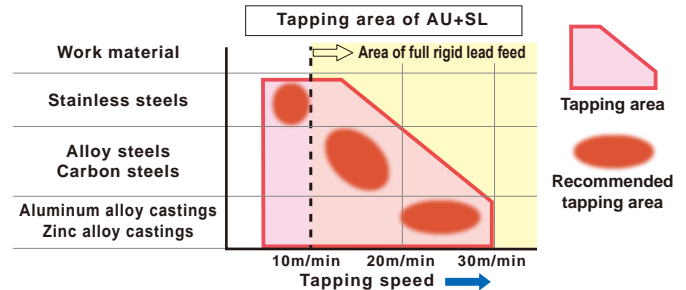
unit mm

Size	Class	No. of flutes	Chamfer	L	l	ln	ls	Ds	Code
M12X1.5	P3	3	5P	82	26	-	42	8.5	VSAPR012OL
M12X1.25	P3	3	5P	82	26	-	42	8.5	VSAPR012NL
NEW M14X2	P4	3	5P	88	26	-	45	10.5	VSAPS014QL
NEW M14X1.5	P3	3	5P	88	26	-	45	10.5	VSAPR014OL
NEW M16X2	P4	3	5P	95	26	-	48	12.5	VSAPS016QL
NEW M16X1.5	P3	3	5P	95	26	-	48	12.5	VSAPR016OL
NEW M18X2.5	P4	4	5P	100	33	-	51	14	VSAPS018RL
NEW M18X1.5	P4	4	5P	100	33	-	51	14	VSAPS018OL
NEW M20X2.5	P4	4	5P	105	33	-	50	15	VSAPS020RL
NEW M20X1.5	P4	4	5P	105	33	-	50	15	VSAPS020OL

Applicable to wide range of materials

Recommended tapping condition

Work material	Recommended tapping speed (m/min)
Stainless steels SUS304	5~10
Alloy steels SCM/SCr	10~20
High carbon steels S45C~	10~20
Medium carbon steels S25C~S45C	10~20
Low carbon steels ~S20C/SS400	10~20
Aluminium alloy castings AC·ADC Zinc alloy castings ZDC	20~30



Longer tool life

Condition[M6X1]

Work material	SCM440
Tapping speed	15m/min
Bored hole diameter	φ 5.0
Threading length	9mm Through hole
Machine	Machining centers vertical type
Tapping oil	Water soluble oil

Edge condition after tapping 3000 hole



Improvement in chip ejection efficiency

- Left hand spiral flute design enables the smooth chip ejection even by high speed tapping.
- AU+SL enable to eject chip smoothly for wide range of work materials from steels to stainless steels.

Good chip ejection



Warning

- ◆Tools may shatter. Wear cover or eye glasses 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 work pieces 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.

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