

ACHSP

Spiral Taps for Aluminum
Cored Hole tapping

Available for tapping directly into cored holes in aluminum!!

▪ Spiral Fluted Taps for tapping Cored Holes in Aluminum ▪

ACHSP



The ACHSP is ideal for tapping Cored Holes in a variety of Aluminum components like;
Engine Block, Cylinder Head, Mission Case, Manifold, Water Pump, etc.

Characteristics

Spiral Fluted Taps for Tapping Cored Holes in Aluminum

ACHSP



Characteristics

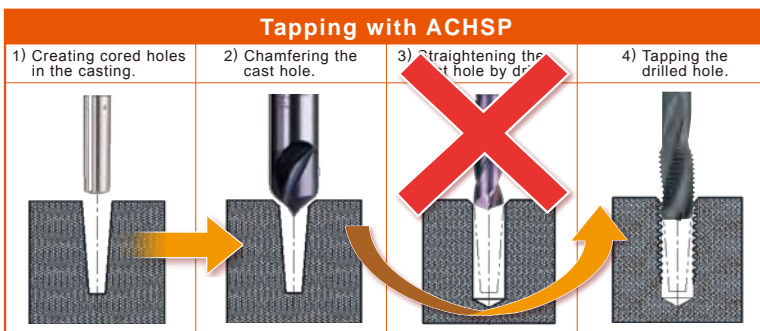
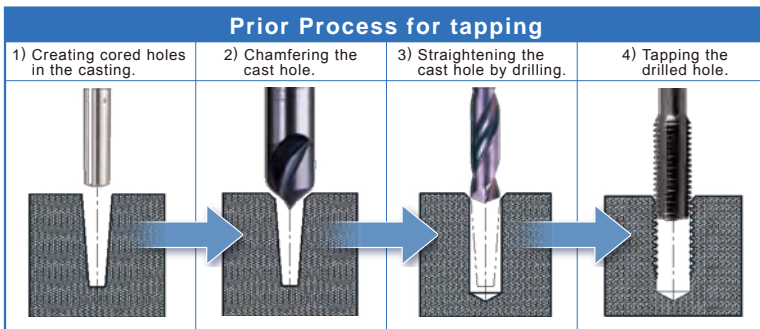
- Direct Cored Hole tapping results in a reduction of processing time.
- Made of an ultrafine grain carbide alloy combining the correct hardness and toughness.
- The shank diameter is the same as the thread diameter of the tap which improves rigidity and makes the product more resistant to deflection and the cutting side pressure caused from misalignment. (M6, M8: 0.3mm max, M10 0.5mm max)
- A thin film coating offers improvements in wear resistance and a reduction of cutting edge chipping.

Recommendation

- Internal Coolant Supply is recommended to prevent the tapped holes from being blocked by the ejected chips.

Reduction of processing time

Direct tapping a cored hole results in a reduction in processing time!!

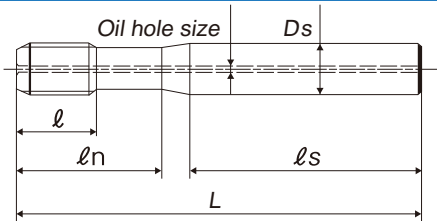


Test Data



Thread size	M8x1.25	
Workpiece material	ADC12	
Tapping speed	50m/min	
Number of tapped holes	50	
Hole conditions	Minimum diameter size	φ 5.8mm
	Taper angle	2°
	Tapping depth	22mm
	Hole Type	Blind
Internal thread length	17mm	
Misalignment	+0.5mm	
Feed	synchronous	
Machine	M/C(horizontal)	
Tapping fluid	Water soluble	

Dimension and size



Nominal Size	Class	L	l	ln	ls	Ds	Number of flutes	Oil hole size	Product code
M6x1	P3	80	12	27	48	6	3	1	SY6.0MRLXT
M8x1.25	P4	90	15	30	54	8	3	1	SY8.0NSLXT
M10x1.5	P4	100	18	36	57	10	3	1.5	SY010OSLXT
M10x1.25	P4	100	18	36	57	10	3	1.5	SY010NSLXT

unit mm

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.

YAMAWA Mfg. Co., Ltd.

Head office

Nakajima Gold bldg.13-10 Kyobashi
3chome, Chuo-ku, Tokyo 104-0031, JAPAN

Website: <http://www.yamawa.com>

YAMAWA group for Overseas

YAMAWA International Co., Ltd.



JQA-QMA14664



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