

# AUSP Rc

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Improvements in the surface condition of taper pipe threads.  
Outstanding thread surface !!



# Features of products

Coated Spiral Fluted Taps for Taper Pipe Threads

AUSP Rc

HSS

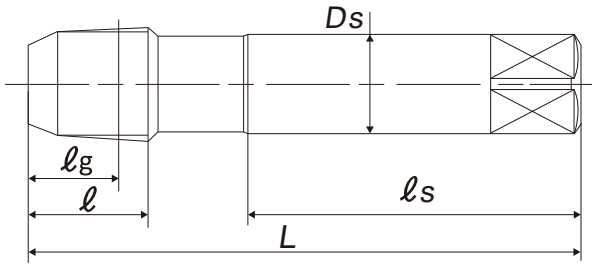
Coating



## Features

- New tap dimensions. A longer projected overall length creates a smoother chip ejection.
- A unique cutting edge geometry and a special coating produce an excellent surface finish while achieving longer tool life.

## Dimensions and sizes



## Can be applied to various workpiece materials

### AUSP Rc Recommended process conditions

Workpiece materials		Recommended tapping speed(m/min)
Stainless steels	SUS304	~ 3
Alloy steels	SCM/SCr	~ 5
High carbon steels	S45C~	~ 7
Middle carbon steels	S25C~S45C	~ 7
Low carbon steels	~S20C/SS400	~ 7
Aluminum alloy castings Zinc alloy die castings	AC/ADC/ZDC	~ 10

Nominal Size	Basic major dia.	L (mm)	l (mm)	lg (mm)	ls (mm)	Ds (mm)	No. of flutes	Code	MSRP(JPY)
Rc 1/16-28	7.723	90	14	10.1	60	8	3	SJRC010FET	5,700
Rc 1/8-28	9.728	90	15	10.1	46	8	3	SJRC020FET	5,700
Rc 1/4-19	13.157	100	19	15	51	11	3	SJRC040FET	8,500
Rc 3/8-19	16.662	100	21	15.4	51	14	3	SJRC060FET	13,300
Rc 1/2-14	20.955	125	26	20.5	64	18	4	SJRC080FET	20,700
Rc 3/4-14	26.441	140	28	21.8	71	23	4	SJRC120FET	34,300
Rc 1-11	33.249	160	33	26	82	26	4	SJRC160FET	61,500

\*Please check new tap dimension of  $L/l/l_g$ .

\*Length of  $L/l/l_g$  of AUSP Rc is different from PT taps. \*Length of L of AUSP Rc is different from Rc taps. \*  $l_g$  is Basic Diameter Position.

## Process Data

### Process Condition:AUSP Rc 1/4-19

Workpiece material	SS400
Tapping speed	5m/min
Machine	Machining Center
Holder	Tap holder with tension/compression
Tapping fluid	Water soluble

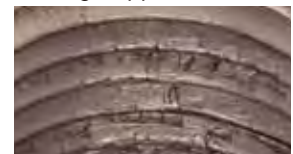
### YAMAWA

AUSP Rc  
Excellent surface finish



### Competitor

Competitor's spiral fluted tap for taper pipe threads  
Galling happened.



## 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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