

MHSP

Medium Hard

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Taps for blind hole tapping of medium hardness carbon steels.



Features of products

For carbon steels of medium hardness,
for blind hole tapping

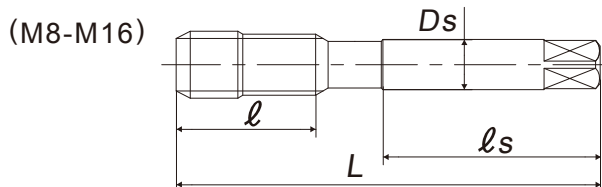
MHSP



Features

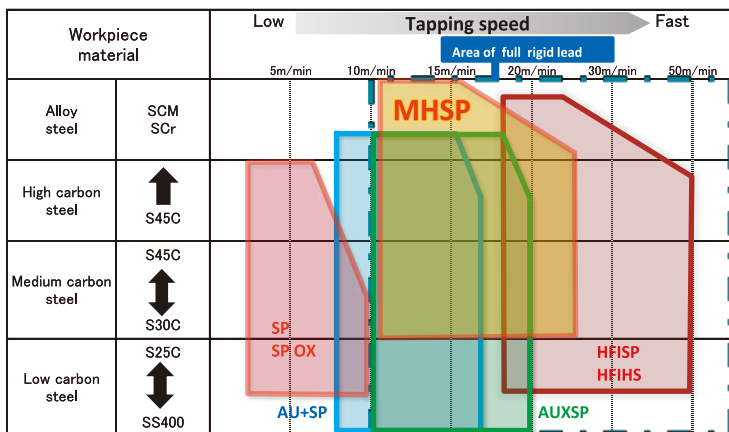
- Longer tool life : Improved tool life by utilizing a special coating.
- Thread portion : The BLF design avoids chipping problems on the full-thread portion of the tap.
- A longer overall length : Projected overall length produces smooth chip ejection and avoids interference with the tapping holder.

Dimensions and sizes



Nominal Size	Class	L (mm)	l (mm)	ls (mm)	Ds (mm)	No. of flutes	Chamfer length	Code	MSRP(JPY)
M8 X1.25	P4	90	19	46	6.2	3	2.5P	SY8.0NSOCLJ	4,580
M10X1.5	P4	100	23	51	7	3	2.5P	SY010SOCLJ	5,300
M10X1.25	P4	100	23	51	7	3	2.5P	SY010NSOCLJ	5,300
M10X1	P4	100	23	51	7	3	2.5P	SY010MSOCLJ	6,300
M12X1.75	P4	110	26	56	8.5	4	2.5P	SY012PSOCLJ	7,600
M12X1.5	P4	110	26	56	8.5	4	2.5P	SY012SOCLJ	7,600
M12X1.25	P4	110	26	56	8.5	4	2.5P	SY012NSOCLJ	7,600
M14X2	P5	110	26	56	10.5	4	2.5P	SY014QTOCLJ	10,500
M14X1.5	P4	110	26	56	10.5	4	2.5P	SY014SOCLJ	10,500
M16X2	P5	110	26	56	12.5	4	2.5P	SY016QTOCLJ	13,600
M16X1.5	P4	110	26	56	12.5	4	2.5P	SY016SOCLJ	13,600

System chart of MHSP

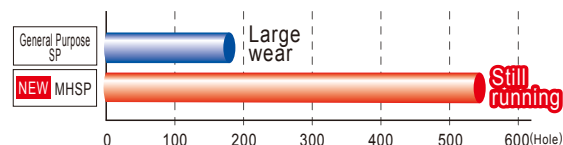


Process Data

Process Condition M8×1.25

Workpiece material	SCM440 35HRC
Threading length	12mm
Tapping speed	15m/min
Machine	Machining Center Vertical type
Tapping fluid	Water soluble

MHSP
Enlarged photo tapped
after 550 holes



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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JQA-QMA14664



JQA-EM3465