

VUP

Z-PRO Series optimum tap for water soluble oil processing

Z-PRO
Ultimate Machine Tap Series



Product Features



Coated Spiral Pointed Tap VUPO



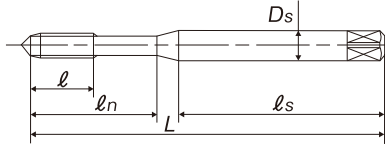
Features

- Longer Life—Improved tool life from using a high grade of powder high speed steel with a special coating!
- Flute Shape—Improved chip evacuation and cutting resistance from a unique flute shape to produce excellent internal threads!
- Longer overall Length...Allows a longer projected length out of the holder for better application of cutting fluids.

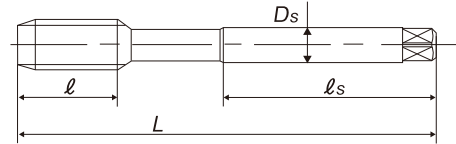
The Z-PRO VUPO is designed for use with water-soluble cutting fluid where there is a good coolant supply.

Shape and Dimensions

[M3~M6]



[M8~M16]



| Size | Class | Product Code | Chamfer | L (mm) | ℓ (mm) | ℓ _n (mm) | ℓ _s (mm) | D _s (mm) | No. of flutes | MSRP (JPY) |
|------------|-------|--------------|---------|-----------|-----------|------------------------|------------------------|------------------------|------------------|------------|
| M3 X 0.5 | P2 | 1102101035 | 5P | 56 | 9 | 18 | 32 | 4 | 3 | 2,900 |
| M3 X 0.35 | P2 | 1102101036 | 5P | 56 | 6.5 | 18 | 32 | 4 | 3 | 4,070 |
| M4 X 0.7 | P3 | 1102101042 | 5P | 63 | 13 | 21 | 36 | 5 | 3 | 2,850 |
| M4 X 0.5 | P2 | 1102101043 | 5P | 63 | 9 | 21 | 36 | 5 | 3 | 3,560 |
| M5 X 0.8 | P3 | 1102101049 | 5P | 70 | 14 | 25 | 40 | 5.5 | 3 | 2,880 |
| M5 X 0.5 | P2 | 1102101051 | 5P | 70 | 9 | 25 | 40 | 5.5 | 3 | 3,690 |
| M6 X 1 | P3 | 1102101055 | 5P | 80 | 15 | 30 | 45 | 6 | 3 | 3,180 |
| M6 X 0.75 | P2 | 1102101056 | 5P | 80 | 15 | 30 | 45 | 6 | 3 | 4,190 |
| M6 X 0.5 | P2 | 1102101057 | 5P | 80 | 9 | 30 | 45 | 6 | 3 | 4,190 |
| M8 X 1.25 | P3 | 1102101064 | 5P | 90 | 19 | — | 46 | 6.2 | 3 | 4,190 |
| M8 X 1 | P3 | 1102101065 | 5P | 90 | 19 | — | 46 | 6.2 | 3 | 4,950 |
| M10 X 1.5 | P3 | 1102101078 | 5P | 100 | 23 | — | 51 | 7 | 3 | 5,290 |
| M10 X 1.25 | P3 | 1102101079 | 5P | 100 | 23 | — | 51 | 7 | 3 | 5,290 |
| M10 X 1 | P3 | 1102101080 | 5P | 100 | 23 | — | 51 | 7 | 3 | 6,280 |
| M12 X 1.75 | P4 | 1102101088 | 5P | 110 | 26 | — | 56 | 8.5 | 3 | 6,900 |
| M12 X 1.5 | P3 | 1102101089 | 5P | 110 | 26 | — | 56 | 8.5 | 3 | 6,900 |
| M12 X 1.25 | P4 | 1102101090 | 5P | 110 | 26 | — | 56 | 8.5 | 3 | 6,900 |
| M14 X 2 | P4 | 1102101100 | 5P | 110 | 26 | — | 56 | 10.5 | 3 | 9,450 |
| M14 X 1.5 | P3 | 1102101102 | 5P | 110 | 26 | — | 56 | 10.5 | 3 | 9,450 |
| M16 X 2 | P4 | 1102101114 | 5P | 110 | 26 | — | 56 | 12.5 | 3 | 12,300 |
| M16 X 1.5 | P3 | 1102101116 | 5P | 110 | 26 | — | 56 | 12.5 | 3 | 12,300 |

Compatible with a wide range of workpiece machining

VUPO Recommended Processing Conditions

| Workpiece Material | Tapping Speed (m/min) |
|--------------------------|-----------------------|
| General Structural Steel | 10~30 |
| Carbon Steel | 10~30 |
| Alloy Steel | 10~30 |
| Stainless Steel | 5~15 |

Processing Data

Processing Conditions M10×1.5

| | |
|---------------|-----------------------------|
| Work Material | S50C |
| Thread Length | 20mm(2D) |
| Tapping Speed | 20m/min |
| Machinery | Vertical Machining center |
| Tapping Oil | Water soluble cutting fluid |

| | VUPO | Other Companies Product |
|------------------------|------|-------------------------|
| Wear After 560 Threads | | |

Warning

- ♦Tools may shatter during use. Wear safety eye cover or eye glasses to avoid injury during tapping.
- ♦Use tools under the proper tapping condition.
- ♦Never wear gloves during turning operations as the gloves may get caught in the tools.
- ♦Wear safety shoes to avoid foot injury by the falling tools.
- ♦When attaching tools to the machine, fasten firmly to avoid chatter and run-out.
- ♦Fasten the workpiece firmly so it never moves during the tapping operation. Never use worn tools or damaged tools.
- ♦Take a special care to prevent fire during machining. High temperature during tapping can cause a fire.

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JQA-QMA14664



JQA-EM3465