

Think threads with  
**YAMAWA**

# VUSP

Z-PRO Series optimum tap for water soluble oil processing

**Z-PRO**  
*Ultimate Machine Tap Series*



# Product Features



# Coated Spiral Fluted Tap VUSP

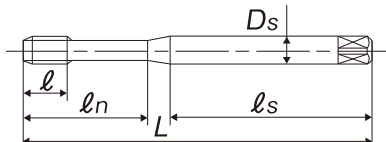


## Features

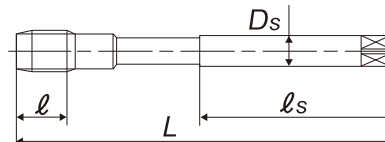
- Longer Life—Improved tool life from using a high grade of powder high speed steel with a special coating!
  - Flute Shape—Improved chip evacuation and cutting resistance from a unique flute shape to produce excellent internal threads!
  - Total Length—Utilizing a longer overall length to avoid the chips interfering with the holder!
- The Z-PRO VUSP 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)	ln (mm)	ls (mm)	Ds (mm)	No. of flutes	MSRP (JPY)
M3 X 0.5	P2	1101101035	2.5P	56	5	18	32	4	3	2,900
M3 X 0.35	P2	1101101036	2.5P	56	5	18	32	4	3	4,070
M4 X 0.7	P2	1101101042	2.5P	63	7	21	36	5	3	2,850
M4 X 0.5	P2	1101101043	2.5P	63	5	21	36	5	3	3,560
M5 X 0.8	P2	1101101049	2.5P	70	9	25	40	5.5	3	2,880
M5 X 0.5	P2	1101101051	2.5P	70	6	25	40	5.5	3	3,690
M6 X 1	P2	1101101055	2.5P	80	11	30	45	6	3	3,180
M6 X 0.75	P2	1101101056	2.5P	80	8	30	45	6	3	4,190
M6 X 0.5	P2	1101101057	2.5P	80	8	30	45	6	3	4,190
M8 X 1.25	P3	1101101064	2.5P	90	12	-	46	6.2	3	4,190
M8 X 1	P3	1101101065	2.5P	90	12	-	46	6.2	3	4,950
M10 X 1.5	P3	1101101078	2.5P	100	13	-	51	7	3	5,290
M10 X 1.25	P3	1101101079	2.5P	100	13	-	51	7	3	5,290
M10 X 1	P3	1101101080	2.5P	100	13	-	51	7	3	6,280
M12 X 1.75	P4	1101101088	2.5P	110	15	-	56	8.5	3	6,900
M12 X 1.5	P3	1101101089	2.5P	110	15	-	56	8.5	3	6,900
M12 X 1.25	P3	1101101090	2.5P	110	15	-	56	8.5	3	6,900
M14 X 2	P4	1101101100	2.5P	110	18	-	56	10.5	3	9,450
M14 X 1.5	P3	1101101102	2.5P	110	14	-	56	10.5	3	9,450
M16 X 2	P4	1101101114	2.5P	110	18	-	56	12.5	3	12,300
M16 X 1.5	P3	1101101116	2.5P	110	14	-	56	12.5	3	12,300

## Compatible with a wide range of workpiece machining

### VUSP Recommended Processing Conditions

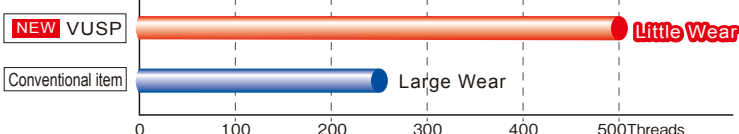
Workpiece Material	Tapping Speed (m/min)
General Structural Steel	10~20
Carbon Steel	10~25
Alloy Steel	10~20
Stainless Steel	5~10

## Processing Data

### Processing Conditions M3×0.5

Work Material	S50C
Thread Length	4.5mm
Tapping Speed	20m/min
Machinery	Vertical Machining center
Tapping Oil	Water soluble cutting fluid

Enlarged Photo after tapped 250 holes by VUSP



## 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