

AUSP Rc (PT)

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

AUSP Rc (PT)



Features of products

Coated Spiral Fluted Taps for Taper Pipe Threads

AUSP Rc (PT)

HSS

Coating

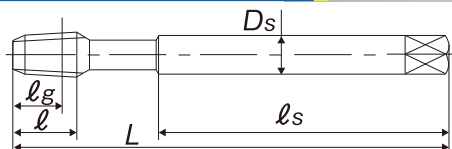


Features

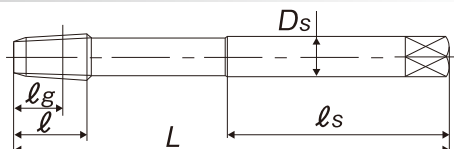
- New tap dimensions. A longer projected overall length creates a smoother chip ejection.
- A unique cutting edge geometry and a special coating produce an excellent surface finish while achieving longer tool life.

Dimensions and sizes

[1/16]



[1/8~]



Nominal Size	Chamfer	Basic major dia.	L (mm)	l (mm)	lg (mm)	ls (mm)	Ds (mm)	No. of flutes	Code	MSRP(JPY)
Rc(PT) 1/16-28	2.5P	7.723	90	14	10.1	60	8	3	SJRC010FET	6,160
Rc(PT) 1/8-28	2.5P	9.728	90	15	10.1	46	8	3	SJRC020FET	6,160
Rc(PT) 1/8-28	2.5P	9.728	150	15	10.1	40	8	3	SJRC020FETG	14,300
Rc(PT) 1/8-28	2.5P	9.728	200	15	10.1	40	8	3	SJRC020FETK	20,500
Rc(PT) 1/4-19	2.5P	13.157	100	19	15	51	11	3	SJRC040FET	9,180
Rc(PT) 1/4-19	2.5P	13.157	150	19	15	50	11	3	SJRC040FETG	16,500
Rc(PT) 1/4-19	2.5P	13.157	200	19	15	50	11	3	SJRC040FETK	23,600
Rc(PT) 3/8-19	2.5P	16.662	100	21	15.4	51	14	3	SJRC060FET	14,400
Rc(PT) 3/8-19	2.5P	16.662	150	21	15.4	50	14	3	SJRC060FETG	24,300
Rc(PT) 3/8-19	2.5P	16.662	200	21	15.4	50	14	3	SJRC060FETK	35,500
Rc(PT) 1/2-14	2.5P	20.955	125	26	20.5	64	18	4	SJRC080FET	22,800
Rc(PT) 1/2-14	2.5P	20.955	200	26	20.5	60	18	4	SJRC080FETK	42,200
Rc(PT) 3/4-14	2.5P	26.441	140	28	21.8	71	23	4	SJRC120FET	37,800
Rc(PT) 3/4-14	2.5P	26.441	200	28	21.8	70	23	4	SJRC120FETK	55,100
Rc(PT) 1-11	2.5P	33.249	160	33	26	82	26	4	SJRC160FET	67,700
Rc(PT) 1-11	2.5P	33.249	200	33	26	70	26	4	SJRC160FETK	76,700

*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 (PT) is different from Rc taps. *l_g is Basic Diameter Position.

Can be applied to various workpiece materials



AUSP Rc (PT) 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	~ 10

Process Data

Process Condition:AUSP Rc (PT) 1/4-19

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

YAMAWA	Competitor
AUSP Rc (PT) Excellent surface finish	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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