

MG-HT

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Ideal for blind hole tapping where there is no enough space for a preparation hole depth.

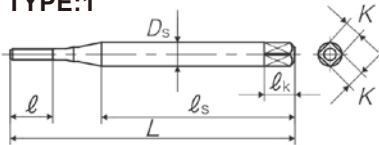




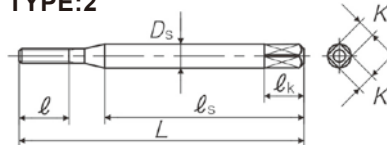
The specific gravity of magnesium is 1.7 and is extremely light compared to aluminum at 2.7 and copper at 7.9. Magnesium is a material that can meet the needs for "weight reduction." As a result, it is often used in parts for automobiles, computers, and mobile phones. Generally, these parts are thin-walled for further weight reduction. In order to produce the correct "fitting length", there is a demand for processing the screw to the final depth of the pilot hole. The **MG-HT** can be utilized for these applications because the number of threads in the chamfer area is less than one.

Dimension and sizes

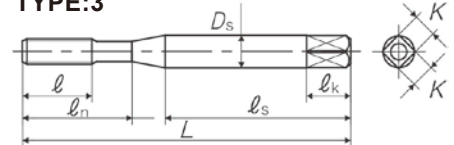
TYPE:1



TYPE:2



TYPE:3



Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	TYPE	MSRP(JPY)
M1.4X0.3	P2	TMGMQ1.4C1	1P	36	5.4	-	24	3	2.5	5	3	1	2,880
M1.6X0.35	P2	TMGMQ1.6D1	1P	36	6.3	-	24	3	2.5	5	3	2	2,740
M1.7X0.35	P2	TMGMQ1.7D1	1P	36	6.3	-	24	3	2.5	5	3	2	2,740
M2 X0.4	P2	TMGMQ2.0E1	1P	42	7.2	12	27	3	2.5	5	3	3	2,200
M2.5X0.45	P2	TMGMQ2.5F1	1P	46	8.1	14	29	3	2.5	5	3	3	1,680
M2.6X0.45	P2	TMGMQ2.6F1	1P	46	8.1	14	29	3	2.5	5	3	3	1,680
M3 X0.5	P2	TMGMQ3.0G1	1P	46	9	14	26	4	3.2	6	3	3	1,180

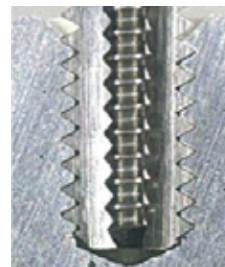
Tapping record

Size	Workpiece material	Hole size (mm)	Hole depth (mm)	Threading length (mm)	Machine	Tapping speed (m/min)	Feed	Lubrication	Number of tapped hole	Parts
M1.7X0.35	Magnesium Alloy Castings	1.40	5.5	5.0	M/C	10	Synchronized	Water soluble oil	15,000	Digital camera housing
M2 X0.4		1.65	6.0	5.5	M/C	12			15,000	
M2 X0.4		1.65	3.0	2.5	CNC	15			10,000	PC parts
M2.5X0.45		2.11	4.5	4.0	CNC	20			10,000	

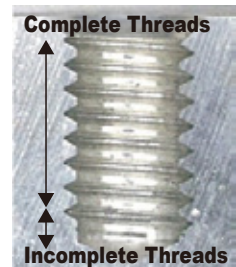
Internal thread situation

MG-HT can be machined to the bottom of the hole.

※ In magnesium alloy processing there is a risk of the chips catching on fire. Be sure to take all measures against fire prevention.



<During tapping>



<After tapping>

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.

YAMAWA MFG. Co., Ltd.

Head office Nakajima Gold bldg.13-10 Kyobashi 3chome, Chuo-ku, Tokyo 104-0031, JAPAN

Website:<http://www.yamawa.com>

YAMAWA group for Overseas

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