

SL BC / SL LH BC

Spiral Fluted Taps
for Bicycle
Threads, Through
Hole Use

The Ideal Tap for Machining the Pedal Attachment Threads on a Bicycle Crank has been released!

- Spiral Fluted Taps for Bicycle Threads, Through Hole Use ▪
- Spiral Fluted Taps for Left Hand Bicycle Threads, Through Hole Use ▪

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JIS



Products Features

This is a tap used for machining the crank (through-hole) of a bicycle, with the thread size "BC9/16-20". We have developed a lineup of right-hand and left-hand thread in a spiral fluted tap shape (SL) suitable for machine processing for through-holes.



BC9/16-20
(Right / Left)

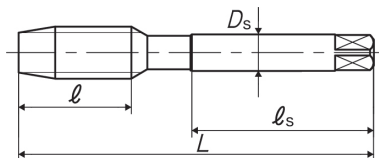
Shape and Dimensions

Spiral Fluted Taps for Bicycle Threads, Through Hole Use

SL BC

HSS

Coating



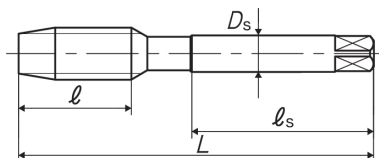
Size	Code	Chamfer	L (mm)	l (mm)	ls (mm)	Ds (mm)	Number of flutes	MSRP(JPY)
BC 9/16-20	LYBC050HEV7	7P	95	26	48	12.5	4	9,020

Spiral Fluted Taps for Left Hand Bicycle Threads, Through Hole Use

SL LH BC

HSS

Coating



Size	Code	Chamfer	L (mm)	l (mm)	ls (mm)	Ds (mm)	Number of flutes	MSRP(JPY)
BC 9/16-20	ZYBC050HEV7	7P	95	26	48	12.5	4	11,800

Tapping Data

Tapping Conditions

Workpiece Material	A6061
Tapping Length	24 mm (Through hole)
Tapping Speed	27m/min
Machine Type	Vertical Machining Center
Tapping Fluid	Water-soluble cutting fluid

Excellent Thread Surface



By utilizing a unique flute shape (SL) and designing the thread part to be suitable for the workpiece, along with surface treatment, a well-formed thread with an excellent surface finish can be achieved.

Excellent Chip Shape



The finely curled chip shape allows for excellent chip evacuation, resulting in stable tapping.

Bored Hole Size

Size	Minor Diameter of Internal Threads		Bored hole size (ref.)
	Max.	Min.	
BC 9/16-20	13.25	13.14	13.22

Unit: mm

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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