

AUSP Rc (PT)

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

AUSP Rc (PT)



Z-PRO
Ultimate Machining Taps

Features of products



Coated Spiral Fluted Taps
for Taper Pipe Threads

AUSP Rc (PT)

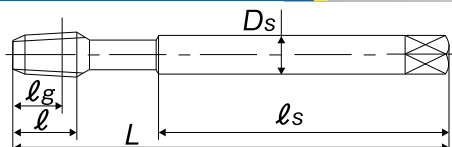


Features

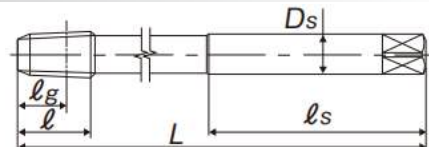
- New tap dimensions. A longer projected overall length creates a smoother chip ejection.
- A unique cutting edge geometry and a special coating produce an excellent surface finish while achieving longer tool life.

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/lg.

*Length of L/l/lg. of AUSP Rc is different from PT taps. *Length of L of AUSP Rc (PT) is different from Rc taps. *lg is Basic Diameter Position.

Can be applied to various workpiece materials

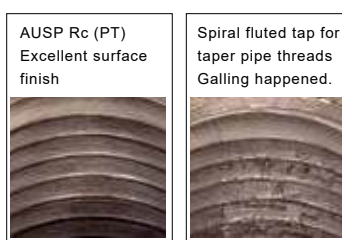
AUSP Rc (PT) Recommended tapping conditions

Workpiece materials	Recommended tapping speed(m/min)
Stainless steels SUS304	~ 3
Alloy steels SCM/SCr	~ 5
High carbon steels S45C~	~ 7
Medium carbon steels S25C~S45C	~ 7
Low carbon steels ~S20C/SS400	~ 7
Aluminum alloy castings Zinc alloy die castings	~ 10

Tapping Data

Tapping 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



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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