

# 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)

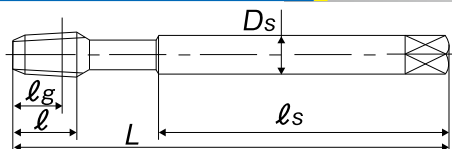


### Features

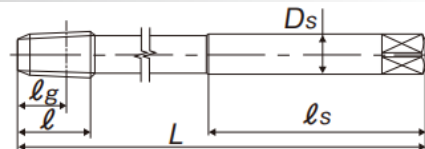
- New tap dimensions. A longer projected overall length creates a smoother chip ejection.
- A unique cutting edge geometry and a special coating produce an excellent surface finish while achieving longer tool life.

## Dimensions and sizes

[1/16]



[1/8~]



| Nominal Size   | Chamfer | Basic major dia. | L (mm) | ℓ (mm) | ℓ <sub>g</sub> (mm) | ℓ <sub>s</sub> (mm) | D <sub>s</sub> (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<sub>g</sub>.

\*Length of L/ℓ/ℓ<sub>g</sub> of AUSP Rc is different from PT taps. \*Length of L of AUSP Rc (PT) is different from Rc taps. \*ℓ<sub>g</sub> is Basic Diameter Position.

## Can be applied to various workpiece materials

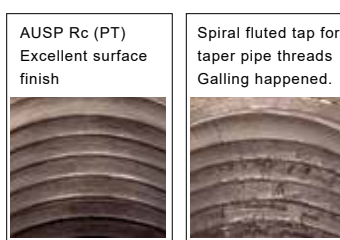
### AUSP Rc (PT) Recommended tapping conditions

| 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<br>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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