

AUSP G
AUSP Rp

Coated Spiral
Fluted Taps for
Parallel Pipe
Threads

Outstanding results in improving tearing of parallel threads for pipes.
For excellent thread surface.

Z-PRO

Ultimate Machining Taps

JIS



Products Features



Coated Spiral Fluted Taps for
Parallel Pipe Threads

**AUSP G
AUSP Rp**

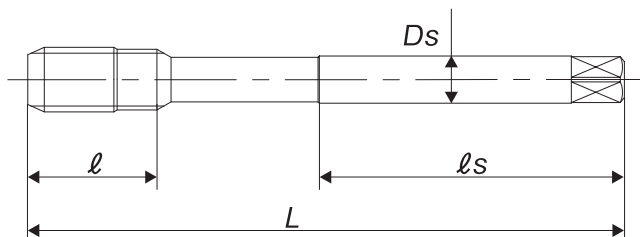


■Features

- The New geometry ensures an appropriate tool protrusion and good chip evacuation.
- The unique blade geometry and special coating provide good internal thread surface and tool life.

Shape and Dimensions

Can be used for machining a wide range of workpieces.



AUSP G/Rp Tapping Conditions

Workpiece Material		Tapping Speed (m/min)
Stainless Steels	SUS304	~ 3
Alloy Steels	SCM / SCr	5 ~ 15
High Carbon Steels	S45C~	5 ~ 15
Medium Carbon Steels	S25C~S45C	5 ~ 15
Low Carbon Steels	~S20C / SS400	5 ~ 15
Aluminum Alloy Castings/ Zinc Alloy Die Castings	AC / ADC / ZDC	5 ~ 15

Size	Class	Code	Basic major diameter	L (mm)	l (mm)	ls (mm)	Ds (mm)	Number of flutes	MSRP(JPY)
G 1/8 - 28	P3	SJG0020FET	9.728	90	15	46	8	3	5,060
G 1/4 - 19	P3.5	SJG0040FET	13.157	100	19	51	11	3	7,530
G 3/8 - 19	P3.5	SJG0060FET	16.662	100	21	51	14	3	11,900
G 1/2 - 14	P4	SJG0080FET	20.955	125	26	64	18	4	18,700
G 3/4 - 14	P4	SJG0120FET	26.441	140	28	71	23	4	31,000
G 1' - 11	P5	SJG0160FET	33.249	160	33	82	26	4	55,600
Rp 1/8 - 28	-	SJRP020FET	9.728	90	15	46	8	3	5,060
Rp 1/4 - 19	-	SJRP040FET	13.157	100	19	51	11	3	7,530
Rp 3/8 - 19	-	SJRP060FET	16.662	100	21	51	14	3	11,900
Rp 1/2 - 14	-	SJRP080FET	20.955	125	26	64	18	4	18,700
Rp 3/4 - 14	-	SJRP120FET	26.441	140	28	71	23	4	31,000
Rp 1' - 11	-	SJRP160FET	33.249	160	33	82	26	4	55,600

*Due to the adoption of a new shape, Please pay attention to L, l, and ls.

Tapping Data

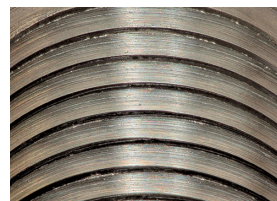
Tapping Conditions:AUSP G 1/4-19

Workpiece Material	SUS304
Tapping Speed	5m/min
Machine Used	Machining Center
Holder	Fixed
Tapping Fluid	Water soluble cutting fluid

Chips do not interfere with the holder



Good internal thread



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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