

# AUSP G/Rp

Coated Spiral  
Fluted Taps for  
Parallel Pipe  
Threads

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

## AUSP G AUSP Rp

### Z-PRO

Ultimate Machining Taps

DIN



# Products Features



Coated Spiral Fluted Taps for Parallel Pipe Threads

**AUSP G  
AUSP Rp**

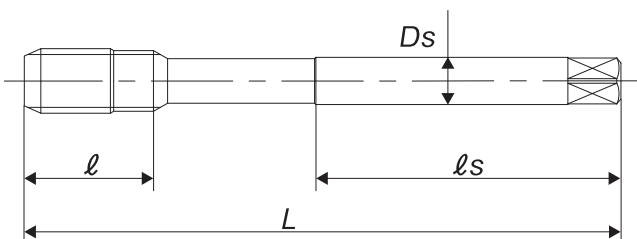


## Features

- 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
G 1/8-28	ISO228X	3119130004	9.728	90	19	46	7	4
G 1/4-19	ISO228X	3119130006	13.157	100	21	51	11	4
G 3/8-19	ISO228X	3119130008	16.662	100	21	51	12	4
G 1/2-14	ISO228X	3119130009	20.955	125	24	64	16	4
G 3/4-14	ISO228X	3119130011	26.441	140	27	71	20	4
G 1'-11	ISO228X	3119130013	33.249	160	29	82	25	5
Rp 1/8-28	-	3119026004	9.728	90	19	46	7	4
Rp 1/4-19	-	3119026006	13.157	100	21	51	11	4
Rp 3/8-19	-	3119026008	16.662	100	21	51	12	4
Rp 1/2-14	-	3119026009	20.955	125	24	64	16	4
Rp 3/4-14	-	3119026011	26.441	140	27	71	20	4
Rp 1'-11	-	3119026013	33.249	160	29	82	25	5

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

## Tapping Data

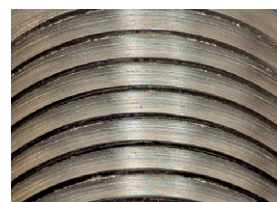
### Tapping Conditions:AUSP G 1/4-19

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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