

# AUSP Rc (PT)

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

# AUSP Rc (PT)



## Features of products



Coated Spiral Fluted Taps  
for Taper Pipe Threads

# AUSP Rc (PT)

HSS

Coating

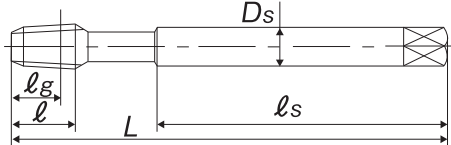


### Features

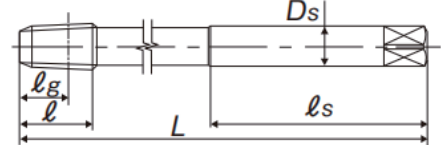
- New tap dimensions. A longer projected overall length creates a smoother chip ejection.
- A unique cutting edge geometry and a special coating produce an excellent surface finish while achieving longer tool life.

## Dimensions and sizes

[1/16]



[1/8~]



Nominal Size	Chamfer	Code	Basic major dia.	L (mm)	l (mm)	lg (mm)	ls (mm)	Ds (mm)	No. of flutes
Rc(PT)1/16-28	2.5P	3119020002	7.723	90	14	10.1	46	6	4
Rc(PT)1/8-28	2.5P	3119020004	9.728	90	15	10.1	46	7	4
Rc(PT)1/4-19	2.5P	3119020006	13.157	100	19	15	51	11	4
Rc(PT)3/8-19	2.5P	3119020008	16.662	100	21	15.4	51	12	4
Rc(PT)1/2-14	2.5P	3119020009	20.955	125	26	20.5	64	16	4
Rc(PT)3/4-14	2.5P	3119020011	26.441	140	28	21.8	71	20	4
Rc(PT)1-11	2.5P	3119020013	33.249	160	33	26	82	25	5

\*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

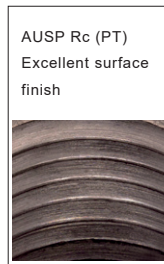
### AUSP Rc (PT) Recommended tapping conditions

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	AC/ADC/ZDC ~ 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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