

No.033

## **How to select Taps for Ultra High Speed Tapping?**

Cutting Taps

## [Question]



Does YAMAWA offer taps for ultra high speed tapping with fully synchronous feed up to 5,000 RPM.

Do the YAMAWA taps correspond with high performance machining practices?

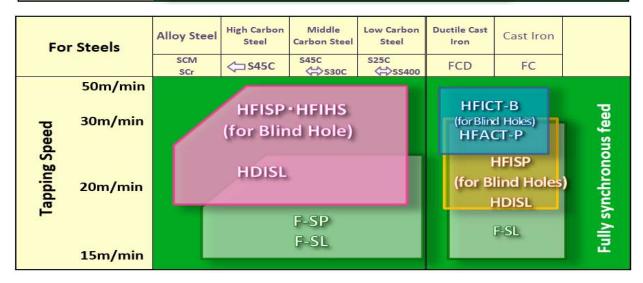
[Answer]

Yes, YAWAMA offers an excellent offering of taps for Ultra High Speed Tapping.
Please refer to the table below to select the best product that meets your tapping conditions.



YAMAWA's full lineup for Ultra High Speed corresponds with every application of blind holes and through holes in vertical and horizontal processing. General tapping speed is defined as 5 to 10m/min, but the Ultra High Speed Tapping is defined as 50 to 100m/min.

For Non-ferrous materials	Aluminum Rolling Stock	Aluminum Zinc	Bronze	Brass Casting	Brass	Cupper	
	AL	AC/ADC/ZDC	РВ	BsC	Bs	Cu	
100111/111111	HFACT-B(for Blind Holes)/HFACT-P(for Through Holes)						pee
Speed 50m/min	HFASP • HFAHS(for Blind Holes) HDISL(for Through Holes)						Fully synchronous feed
apping 30m/min							/nch
20m/min	F-SP(for Blind Holes)						



## [Note]



These products should be used with machines that have a full synchronous feed and a solid type holder that has high rigidity, high accuracy, and high pressure capabilities. Improper use will cause a feeding error that will develop a pitch enlargement problem on internal screw threads.