

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, YAMAWA 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 Alloy Casting	Bronze	Brass Casting	Brass	Copper
		AL	AC/ADC/ZDC	PB	BsC	Bs	Cu
Tapping Speed	100m/min	HFACT-B(for Blind Holes)/HFACT-P(for Through Holes)					
	50m/min	HFASP · HFAHS(for Blind Holes) HDISL(for Through Holes)					
	30m/min						
	20m/min	F-SP(for Blind Holes) F-SL(for Through Holes)					

Fully synchronous feed

For Steels	Alloy Steel	High Carbon Steel	Middle Carbon Steel	Low Carbon Steel	Ductile Cast Iron	Cast Iron	
	SCM SCr	← S45C	S45C ↔ S30C	S25C ↔ SS400	FCD	FC	
Tapping Speed	50m/min	HFISP · HFIHS (for Blind Hole)  HDISL				HFICT-B (for Blind Holes) HFACT-P	Fully synchronous feed
	30m/min						
	20m/min					HFISP (for Blind Holes) HDISL	
	15m/min	F-SP F-SL				F-SL	

### 【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.