

No.044

Symbol of Roll Tap chamfer

Roll Taps

【Question】



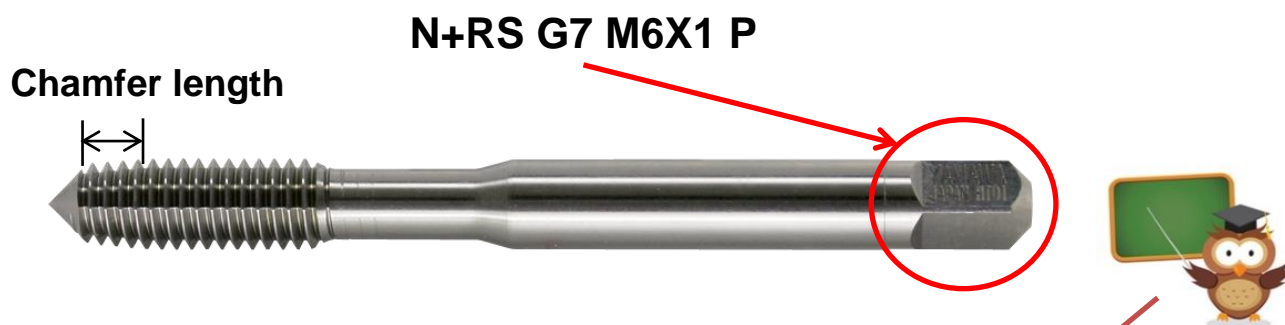
What does the letter "P" represent in the identification markings on a "N+RS G7 M6X1 P" roll tap?

【Answer】

The letter "P" represents the Plug chamfer length of a roll tap for through hole tapping applications. The letter "B" represents a Bottoming chamfer length for a blind hole roll tap.



【Guide】



"P" : Plug taps for through hole tapping, 4 pitch thread length.

"B": Bottoming taps for blind hole tapping, 2 pitch thread length.

A longer Plug chamfer length has an advantage in tapping through holes. The 4 thread chamfer produces better tool life in through hole tapping applications.

【Advice】



It is important to understand the difference between the letter "P" and the letter "B" as they represent the actual chamfer length of a "P" Plug or "B" Bottoming chamfer.

In the Yamawa catalog the letters 4P and 2P are shown without an explanation. These two figures 4P and 2P represent the chamfer length in the number of thread pitches on the tap.