

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.
L	ℓ	ℓn	ℓs	Ds

JIS

①

Spiral Fluted Taps
(for blind hole)

②

Spiral Fluted Taps
(for through hole)

③

Spiral Pointed Taps
(for through hole)

④

Hand Taps

⑤

Cemented Carbide Taps

⑥

Roll Taps

⑦

Special Thread Taps
Simple Inspection Tools

⑧

Pipe Taps

⑨

Thread Mills
Premium Thread Mills

⑩

Dies

⑪

Center Drills
Centering Tools

⑫

Precision Machinery/
Medical Surgical Instruments



ACHSP

Spiral Fluted Tap for Aluminum Casting



Specification



Tapping Speeds depending on Materials

Aluminum alloy castings
アルミ合金鋳物
30~50
(m/min)

Features

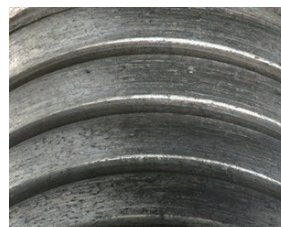
- Direct tapping of cored holes without drilling first, results in reducing the manufacturing time.
- Made from an ultrafine grain carbide alloy combining the hardness and toughness.
- The shank diameter is the same as the major diameter of the tap which improves rigidity and makes the ACHSP more resistant to deflection and the cutting side pressure caused from misalignment. (Maximum displacement of core hole: M6 · M8 within 0.3 mm, M 10 within 0.5 mm)
- A thin film coating offers improvements in wear resistance and a reduction of cutting edge chipping.

Tapping Data

Tapping Conditions [M8×1.25]

Workpiece Material		ADC12
Tapping Speed		50m/min
Number of Holes Tapped		50 hole
Bored Hole Shape	Bore Diameter	φ5.8
	Taper Angle	2°
	Depth	22mm
	Condition	Blind hole
Tapping Length		17mm
Misalignment Amount		X direction + 0.5 mm
Feed Type		Synchronous feed
Machine Type		M / C machine (horizontal type)
Tapping Fluid		Water soluble cutting fluid

Condition of Internal Threads

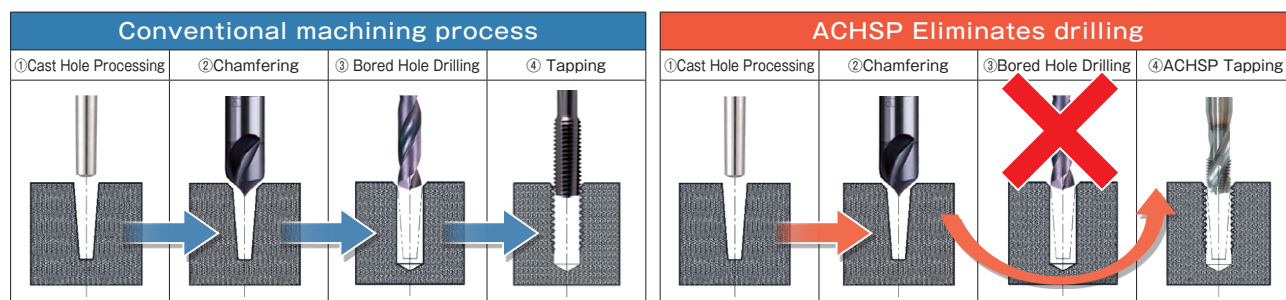


Chip Shape



Reduction of machining time

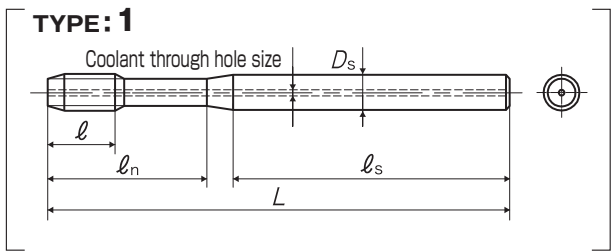
Correcting misaligned cast pilot holes is unnecessary shortening the tapping process time!



Recommendation

Internal coolant supply is recommended to prevent the tapped holes from being blocked by the ejected chips.

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Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Coolant hole size (mm)	TYPE	MSRP
For Metric Threads														
M6 × 1	P3	SY6.0MRLXT	2.5P	80	12	27	48	6	-	-	3	1	1	¥ 42,500
M8 × 1.25	P4	SY8.0NSLXT	2.5P	90	15	30	54	8	-	-	3	1	1	¥ 53,200
M10 × 1.5	P4	SY010OSLXT	2.5P	100	18	36	57	10	-	-	3	1.5	1	¥ 69,500
M10 × 1.25	P4	SY010NSLXT	2.5P	100	18	36	57	10	-	-	3	1.5	1	¥ 69,500

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⑤-40