

# 8 Pipe Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	$\ell$	$\ell_s$	Ds	K	$\ell_k$

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

JIS

Z-PRO

## AUSP G

Z-PRO

Coated Spiral Fluted Taps for Parallel Pipe Threads



Specification



Tapping Speeds depending on Materials

Low carbon steels  
低炭素鋼  
**5~15**  
(m/min)

Medium carbon steels  
中炭素鋼  
**5~15**  
(m/min)

High carbon steels  
高炭素鋼  
**5~15**  
(m/min)

Alloy steels  
合金鋼  
**5~15**  
(m/min)

Stainless steels  
ステンレス鋼  
**~3**  
(m/min)

Aluminum alloy castings  
アルミ合金鋳物  
**5~15**  
(m/min)

Zinc alloy castings  
亜鉛合金鋳物  
**5~15**  
(m/min)

### Product Features

- New shape is adopted. Proper tool projection length is secured, achieving a good chip ejection efficiency.
- Good internal thread surface and long tool life are achieved by the adoption of the unique cutting edge shape and special coating.

### Tapping Data

#### Tapping conditions [AUSP G 1/4-19]

Workpiece Materials	SUS304
Tapping Speed	5m/min
Machine	Machining center
Holder	Fixed
Tapping Fluid	Water soluble cutting fluid

#### Chips Do Not Interfere with the Holder.



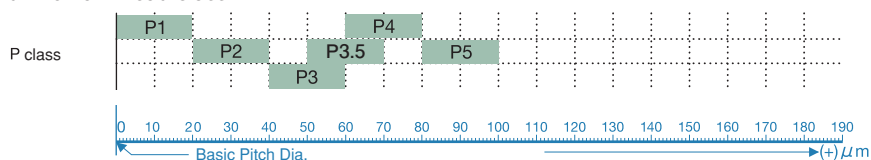
#### Good Internal Thread



- Compatible with tapping of a wide range of work materials
- AUSP G Standard tapping conditions**

Workpiece Materials		Standard Tapping Speed (m/min)
Stainless Steels	SUS304	~ 3
Alloy Steels	SCM/SCr	5 ~ 15
High Carbon Steels	S45C ~	5 ~ 15
Medium Carbon Steels	S25C ~ S45C	5 ~ 15
Low Carbon Steels	~ S20C/SS400	5 ~ 15
Aluminum Alloy Casting/ Zinc Alloy Casting	AC/ADC/ZDC	5 ~ 15

- Tap class and internal thread class



Nominal size	Basic Major Dia.	
G 1/8-28	9.147	P3 107
G 1/4-19	12.301	P3.5 125
G 3/8-19	15.806	P3.5 125
G 1/2-14	19.793	P4 142
G 3/4-14	25.279	P4 142
G 1-11	31.770	P5 180

Pitch diameter tolerance zone of  
JIS (ISO) internal thread (JIS B 0202)

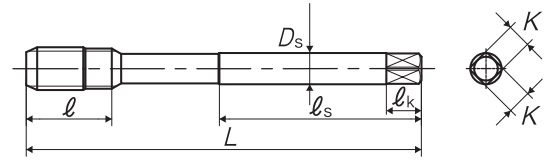
Think threads with  
**YAMAWA**

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	$\ell$	$\ell_s$	Ds	K	$\ell_k$

8

JIS

TYPE: 1

Spiral Fluted Taps  
(for blind hole)

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Thread Mills  
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Dies

⑩

Center Drills  
Centering Tools

⑪

Precision Machinery/  
Medical Surgical Instruments

⑫

JIS

⑧-24

Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	$\ell$ (mm)	$\ell_s$ (mm)	Ds (mm)	K (mm)	$\ell_k$ (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
G 1/8-28	P3	SJG0020FET	C (2.5P)	9.728	90	15	46	8	6	9	3	1	¥ 5,320
G 1/4-19	P3.5	SJG0040FET	C (2.5P)	13.157	100	19	51	11	9	12	3	1	¥ 7,910
G 3/8-19	P3.5	SJG0060FET	C (2.5P)	16.662	100	21	51	14	11	14	3	1	¥ 12,500
G 1/2-14	P4	SJG0080FET	C (2.5P)	20.955	125	26	64	18	14	17	4	1	¥ 19,700
G 3/4-14	P4	SJG0120FET	C (2.5P)	26.441	140	28	71	23	17	20	4	1	¥ 32,600
G 1 -11	P5	SJG0160FET	C (2.5P)	33.249	160	33	82	26	21	24	4	1	¥ 58,400