

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	ℓs	Ds	K	ℓk

- 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



Z-PRO AUSP Rc



Z-PRO
Coated Spiral Fluted Taps for Taper Pipe Threads

Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~7 (m/min)	Medium carbon steels 中炭素鋼 ~7 (m/min)	High carbon steels 高炭素鋼 ~7 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~3 (m/min)	Aluminum alloy castings アルミ合金鑄物 ~10 (m/min)	Zinc alloy castings 亜鉛合金鑄物 ~10 (m/min)
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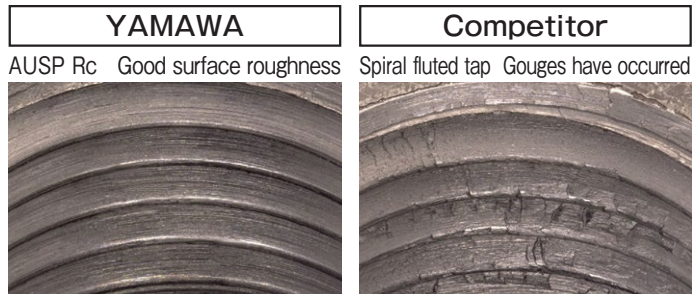
Product Features

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

Tapping Data

Tapping conditions [AUSP Rc 1/4-19]

Workpiece Materials	SS400
Tapping Speed	5m/min
Machine	Machining center
Holder	With tension and compression
Tapping Fluid	Water soluble cutting fluid



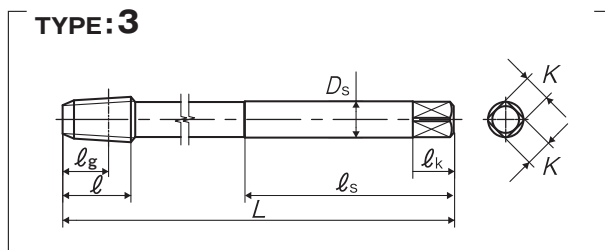
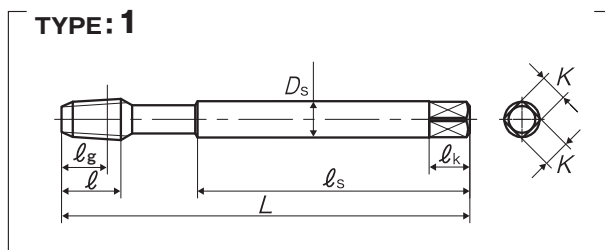
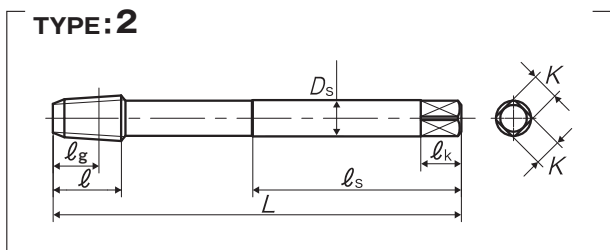
- Compatible with tapping of a wide range of work materials

AUSP Rc Standard tapping conditions

Workpiece Materials		Standard Tapping Speed (m/min)
Stainless Steels	SUS304	~3
Alloy Steels	SCM/SCr	~5
High Carbon Steels	S45C ~	~7
Medium Carbon Steels	S25C ~ S45C	~7
Low Carbon Steels	~S20C/SS400	~7
Aluminum Alloy Casting/ Zinc Alloy Casting	AC/ADC/ZDC	~10

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	l	lg	ls	Ds	K	lk

- ① Spiral Fluted Taps (for blind hole)
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- 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/Metal Surgical Instruments



Segment : 1G

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	l (mm)	lg (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
Rc 1/16-28	SJRC010FET	2.5P	7.723	90	14	10.1	60	8	6	9	3	1	¥ 6,160
Rc 1/8-28	SJRC020FET	2.5P	9.728	90	15	10.1	46	8	6	9	3	2	¥ 6,160
Rc 1/4-19	SJRC040FET	2.5P	13.157	100	19	15	51	11	9	12	3	2	¥ 9,180
Rc 3/8-19	SJRC060FET	2.5P	16.662	100	21	15.4	51	14	11	14	3	2	¥ 14,400
Rc 1/2-14	SJRC080FET	2.5P	20.955	125	26	20.5	64	18	14	17	4	2	¥ 22,800
Rc 3/4-14	SJRC120FET	2.5P	26.441	140	28	21.8	71	23	17	20	4	2	¥ 37,800
Rc 1 -11	SJRC160FET	2.5P	33.249	160	33	26	82	26	21	24	4	2	¥ 67,700
Long shank, for Pipe Threads													
Rc 1/8-28	SJRC020FETG	2.5P	9.728	150	15	10.1	40	8	6	9	3	3	¥ 14,300
Rc 1/8-28	SJRC020FETK	2.5P	9.728	200	15	10.1	40	8	6	9	3	3	¥ 20,500 ^{**}
Rc 1/4-19	SJRC040FETG	2.5P	13.157	150	19	15	50	11	9	12	3	3	¥ 16,500
Rc 1/4-19	SJRC040FETK	2.5P	13.157	200	19	15	50	11	9	12	3	3	¥ 23,600 ^{**}
Rc 3/8-19	SJRC060FETG	2.5P	16.662	150	21	15.4	50	14	11	14	3	3	¥ 24,300
Rc 3/8-19	SJRC060FETK	2.5P	16.662	200	21	15.4	50	14	11	14	3	3	¥ 35,500 ^{**}
Rc 1/2-14	SJRC080FETK	2.5P	20.955	200	26	20.5	60	18	14	17	4	3	¥ 42,200 ^{**}
Rc 3/4-14	SJRC120FETK	2.5P	26.441	200	28	21.8	70	23	17	20	4	3	¥ 55,100 ^{**}
Rc 1 -11	SJRC160FETK	2.5P	33.249	200	33	26	70	26	21	24	4	3	¥ 76,700 ^{**}

** = Specified Distribution Items. Made to order products.