

8 Pipe Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_s	Ds	K	ℓ_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 Rp

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 Rp 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 Rp 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

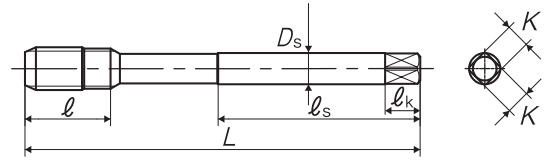
Think threads with
YAMAWA

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L	ℓ	ℓ_s	Ds	K	ℓ_k

8

JIS

TYPE: 1



Segment : 1G

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
Rp 1/8-28	SJRP020FET	C (2.5P)	9.728	90	15	46	8	6	9	3	1	¥ 5,320
Rp 1/4-19	SJRP040FET	C (2.5P)	13.157	100	19	51	11	9	12	3	1	¥ 7,910
Rp 3/8-19	SJRP060FET	C (2.5P)	16.662	100	21	51	14	11	14	3	1	¥ 12,500
Rp 1/2-14	SJRP080FET	C (2.5P)	20.955	125	26	64	18	14	17	4	1	¥ 19,700
Rp 3/4-14	SJRP120FET	C (2.5P)	26.441	140	28	71	23	17	20	4	1	¥ 32,600
Rp 1 -11	SJRP160FET	C (2.5P)	33.249	160	33	82	26	21	24	4	1	¥ 58,400

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