

8 Pipe Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	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 Rp



Z-PRO
Coated Spiral Fluted Taps for Parallel Pipe Threads

Specification



Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	~3 (m/min)	5~15 (m/min)	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



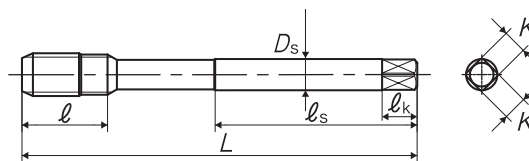
- Compatible with tapping of a wide range of work materials

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

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

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	2.5P	9.728	90	15	46	8	6	9	3	1	¥ 5,060
Rp 1/4-19	SJRP040FET	2.5P	13.157	100	19	51	11	9	12	3	1	¥ 7,530
Rp 3/8-19	SJRP060FET	2.5P	16.662	100	21	51	14	11	14	3	1	¥ 11,900
Rp 1/2-14	SJRP080FET	2.5P	20.955	125	26	64	18	14	17	4	1	¥ 18,700
Rp 3/4-14	SJRP120FET	2.5P	26.441	140	28	71	23	17	20	4	1	¥ 31,000
Rp 1 -11	SJRP160FET	2.5P	33.249	160	33	82	26	21	24	4	1	¥ 55,600

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Metal Surgical Instruments ⑫