

Think threads with
YAMAWA

• A USP G/Rp/Rc •

Z-PRO
Ultimate Machine Tap Series

AUSP PIPE SERIES

Outstanding thread surface for pipe threads.



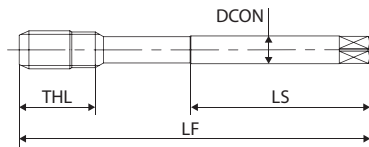
AUSP G/Rp



Coated spiral fluted taps for parallel pipe threads

- The special flute design creates smoother chip ejection.
- The unique cutting edge geometry and the special coating produce excellent surface finish while achieving longer tool life.

Dimensions and sizes



Size	TCTR (Tolerance)	Codice	THCHT (Chamfer)	LF (mm)	THL (mm)	LU (mm)	LS (mm)	DCON (mm)	K (mm)	LK (mm)	NOF (N. of flutes)
G											
1/8-28	P3	SJG0020FET	2.5P	90	15	-	46	8	6	9	3
1/4-19	P3.5	SJG0040FET	2.5P	100	19	-	51	11	9	12	3
3/8-19	P3.5	SJG0060FET	2.5P	100	21	-	51	14	11	14	3
1/2-14	P4	SJG0080FET	2.5P	125	26	-	64	18	14	17	4
3/4-14	P4	SJG0120FET	2.5P	140	28	-	71	23	17	20	4
1 -11	P5	SJG0160FET	2.5P	160	33	-	82	26	21	24	4
Rp											
1/8-28	-	SJRP020FET	2.5P	90	15	-	46	8	6	9	3
1/4-19	-	SJRP040FET	2.5P	100	19	-	51	11	9	12	3
3/8-19	-	SJRP060FET	2.5P	100	21	-	51	14	11	14	3
1/2-14	-	SJRP080FET	2.5P	125	26	-	64	18	14	17	4
3/4-14	-	SJRP120FET	2.5P	140	28	-	71	23	17	20	4
1 -11	-	SJRP160FET	2.5P	160	33	-	82	26	21	24	4

AUSP G/Rp is manufactured according to DIN overall length

Parameters

Work-materials	Vc (m/min)
Stainless steel AISi304, 1.4301	-3
Alloy steel 42CrMo4, 1.7225	5-15
High carbon steels C45, 1.0503	5-15
Middle carbon steels C25-C45, 1.1158-1.0503	5-15
Low carbon steels C22-St37-3, 1.0402-1.0037	5-15
Aluminum alloy castings Zinc alloy die castings	5-15

Process data

AUSP G 1/4-19

Work-material	St 44-2 - Fe 430B
Tapping speed	5 m/min
Machine	Machining center
Holder	Fixed holder
Tapping fluid	Water soluble

Smooth chip ejection



Excellent surface finish!



AUSP Rc (PT)



Coated spiral fluted taps for taper pipe threads

- The unique cutting edge geometry and the special coating produce excellent surface finish while achieving longer tool life.

Dimensions and sizes



Size	TCTR (Tolerance)	Codice	THCHT (Chamfer)	LF (mm)	THL (mm)	LU (mm)	LS (mm)	DCON (mm)	K (mm)	LK (mm)	NOF (N. of flutes)
Rc (PT)											
1/16-28	-	SJRC010FET	2.5P	90	14	-	60	8	6	9	3
1/8-28	-	SJRC020FET	2.5P	90	15	-	46	8	6	9	3
1/8-28	-	SJRC020FETG	2.5P	150	15	-	40	8	6	9	3
1/8-28	-	SJRC020FETK	2.5P	200	15	-	40	8	6	9	3
1/4-19	-	SJRC040FET	2.5P	100	19	-	51	11	9	12	3
1/4-19	-	SJRC040FETG	2.5P	150	19	-	50	11	9	12	3
1/4-19	-	SJRC040FETK	2.5P	200	19	-	50	11	9	12	3
3/8-19	-	SJRC060FET	2.5P	100	21	-	51	14	11	14	3
3/8-19	-	SJRC060FETG	2.5P	150	21	-	50	14	11	14	3
3/8-19	-	SJRC060FETK	2.5P	200	21	-	50	14	11	14	3
1/2-14	-	SJRC080FET	2.5P	125	26	-	64	18	14	17	4
1/2-14	-	SJRC080FETK	2.5P	200	26	-	60	18	14	17	4
3/4-14	-	SJRC120FET	2.5P	140	28	-	71	23	17	20	4
3/4-14	-	SJRC120FETK	2.5P	200	28	-	70	23	17	20	4
1 -11	-	SJRC160FET	2.5P	160	33	-	82	26	21	24	4
1 -11	-	SJRC160FETK	2.5P	200	33	-	70	26	21	24	4

AUSP Rc is manufactured according to DIN overall length

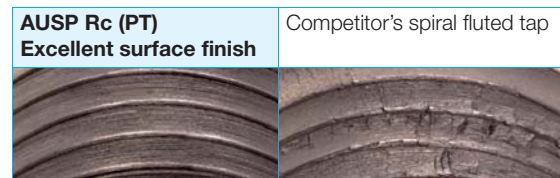
Parameters

Work-materials		Vc (m/min)
Stainless steel	AlSi304, 1.4301	-3
Alloy steel	42CrMo4, 1.7225	-5
High carbon steels	C45, 1.0503	-7
Middle carbon steels	C25-C45, 1.1158-1.0503	-7
Low carbon steels	C22-St37-3, 1.0402-1.0037	-7
Aluminum alloy castings Zinc alloy die castings	AlSi5Mg, AlSi10Mg, CuZn	-10

Process data

AUSP Rc (PT) 1/4-19

Work-material	St 44-2 - Fe 430B
Tapping speed	5 m/min
Machine	Machining center
Holder	Tap holder with tension/compression
Tapping fluid	Water soluble



WARNING

- Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- Tools may shatter. Use tools under the proper tapping condition.
- Never wear gloves during turning operations as the gloves may get caught with the tools.
- Wear safety shoes to avoid injuring yourself by the falling tools.
- On attaching tools to the machine, fasten firmly to avoid shattering and run-out.
- Fasten the workpieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- Take a special care to fire trouble. High temperature during machining may cause fire.



