

YAMAWA U.S.A. TODAY

8-TPI SERIES OF LARGE DIAMETER TAPS

Glynn Simmons, Editor

NEWSLETTER FROM YAMAWA MFG. CO., LTD.

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LARGE INVENTORIES AT EACH WHOLESALE LOCATION TO SUPPLY YOUR NEEDS.

THESE NEW 8TPI TAPS ARE IDEAL FOR OIL FIELD AND GAS EXPLORATION EQUIPMENT MANUFACTURERS, WIND TURBINE EQUIPMENT MANUFACTURERS, CONSTRUCTION EQUIPMENT, POWER PLANT MAINTAINENCE, FABRICATORS AND EQUIPMENT REPAIR.

Feature of products



SP FOR VERTICAL USE



LO-SP FOR HORIZONTAL USE



SP and LO-SP 1"-8UNC TO 1 1/2"-8UNC

Features

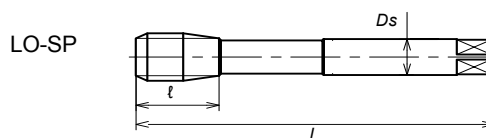
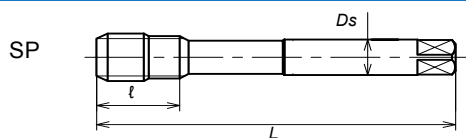
- Recommended for tapping alloy steels and high carbon steels.
- Custom blended vanadium High Speed Steel with high wear resistance.
- Ideal flute design for larger thread sizes. Produces smooth chip ejection and improved tool life.
- DIN overall length/ANSI shank diameter creates smooth chip ejection and better application of coolant for more stable tapping.
- The rear section of the threaded portion is ground off to improve chip ejection and reduce friction resistance during tapping. This grind lowers tapping torque, produces a more accurate internal thread with a better surface finish while staying engaged in the thread.
- Recommended tapping condition

Tapping speed : Up to 24SFM (8m/min)

Coolant : Non-Soluble oil

Tapping length : Up to 2 X D

Table of dimensions and sizes



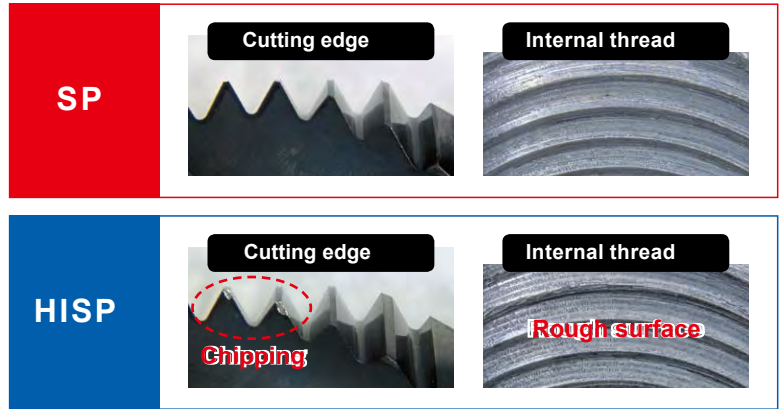
	Size	Class	Chamfer	L	l	Ds	Number of flutes	Code
SP	1"-8UNC	2BX	2.5P	6.30	1.457	0.800	4	SSU16XYEEXJ
	1 1/8"-8UN	2BX	2.5P	7.09	1.732	0.896	4	SSU18XYEEXJ
	1 1/4"-8UN	2BX	2.5P	7.09	1.929	1.021	4	SSU20XYEEXJ
	1 3/8"-8UN	2BX	2.5P	7.87	2.165	1.108	4	SSU22XYEEXJ
	1 1/2"-8UN	2BX	2.5P	7.87	2.323	1.233	4	SSU24XYEEXJ
LO-SP	1"-8UNC	2BX	2.5P	6.30	1.457	0.800	4	SSU16XYEEXHT
	1 1/8"-8UN	2BX	2.5P	7.09	1.732	0.896	4	SSU18XYEEXHT
	1 1/4"-8UN	2BX	2.5P	7.09	1.929	1.021	4	SSU20XYEEXHT
	1 3/8"-8UN	2BX	2.5P	7.87	2.165	1.108	4	SSU22XYEEXHT
	1 1/2"-8UN	2BX	2.5P	7.87	2.323	1.233	4	SSU24XYEEXHT

Tapping data

THE GEOMETRIC FLUTE DESIGN OF THE SP AND LO-SP TAPS SHOWED FAR BETTER RESULTS FOR TAPPING LARGE DIAMETER THREADS IN ALLOY STEELS THAN A CONVENTIONAL "HISP" TAP WHILE CAUSING NO DAMAGE TO THE CUTTING EDGE. THE SURFACE FINISH OF THE INTERNAL THREAD PRODUCED BY THE SP AND LO-SP TAPS IS EXCELLENT.

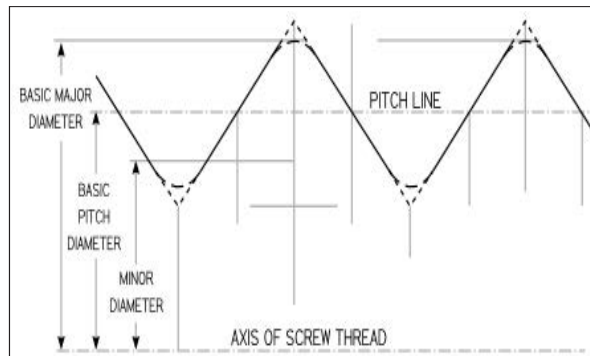
Tapping condition

Tap size	1"-8UNC
Work material	AISI 4140 (SCM440)
Tapping speed	22.6 SFM (6.9m/min)
Hole shape	Blind hole
Hole diameter	.878 (22.3mm)
Tapping length	1.500 (38mm)
Machine	Radial drilling machine
Coolant	Non-soluble oil



TECHNICAL TAP TIPS

SP 8-TPI AND LO-SP 8-TPI TAPS: THE 8UN THREAD SERIES IS THE SPECIFIED THREAD FORMING METHOD FOR SEVERAL ASTM STANDARDS INCLUDING A193 B7, A193 B8/B8M AND A320. THIS SERIES THREAD IS USED FOR DIAMETERS ONE INCH AND ABOVE.



8-TPI: THREAD SERIES - 8UN

NOMINAL THREAD SIZE AND THREADS PER IN.	BASIC PITCH DIA. IN.	MINOR BORE DIA.	% OF THREAD HEIGHT	SECTION AT MINOR DIA. SQ. IN.	TENSILE STRESS AREA SQ. IN.
1" - 8	.9188	.890	68%	0.551	0.606
1 1/8" - 8	1.0438	1.016	67%	0.728	0.790
1 1/4" - 8	1.1688	1.140	67%	0.929	1.000
1 3/8" - 8	1.2938	1.265	68%	1.155	1.233
1 1/2" - 8	1.4188	1.390	68%	1.405	1.492

CREATE THE LARGEST MINOR DIAMETER POSSIBLE. THIS WILL HELP REDUCE THE TORQUE AND CUTTING PRESSURE ON THE TAP WHILE STAYING IN THE TOLERANCE OF THE THREAD SIZE SELECTED.

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