No. 018

Cutting Taps

How to distinguish between SU-PO and SU+SL taps

【Question】

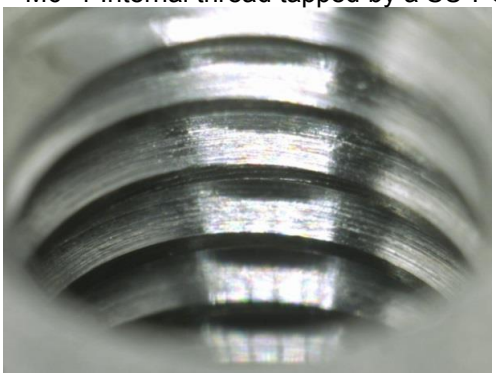
For tapping through holes in Stainless Steel material,
I wonder how I can make good use of a SU-PO tap and a
SU+SL tap. Can you please advise?

【Answer】 You can distinguish them according to the tapping speed required.
The SU-PO is recommended for the lower tapping speed around 5m/min in stainless steel while the SU+SL is recommended for higher speeds up to 18m/min.

【Guide】 In the past the only option for tapping Stainless Steels in through holes was a SU-PO tap. Now the SU+SL tap is also available and you can choose either one to fit the tapping speed required. Use the SU-PO tap for less than 5m/min and the SU+SL for tapping speeds of 6m/min to 18m/min. Tapping with a fully synchronous feed is recommended for tapping speeds of more than 8m/min.

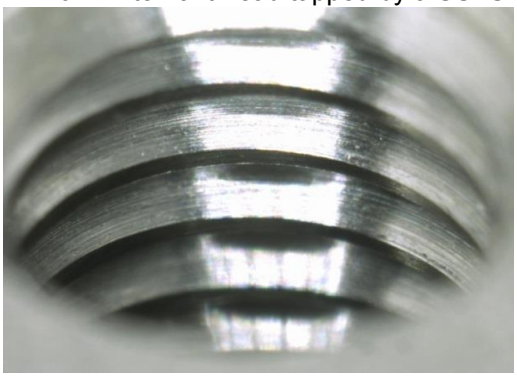
Distribution Stock: SU+SL is available from M3 to M6 in size range

M6×1 Internal thread tapped by a SU-PO



SUS304 Internal threads tapped at 7m/min speed

M6×1 Internal thread tapped by a SU+SL



SUS304 Internal thread tapped at 15m/min speed

The SU+SL taps are suitable for tapping through holes in work hardening and stringy materials like Stainless Steels, Chrome Steels, and Molybdenum Steels.

System Table for tapping Stainless Steel through holes