

No.033 How to select Taps for Ultra High Speed Tapping?

Cutting Taps

【Question】 Does YAMAWA offer taps for ultra high speed tapping with fully synchronous feed up to 5,000 RPM. Do the YAMAWA taps correspond with high-performance machining practices?

【Answer】 Yes, YAMAWA offers an excellent offering of taps for Ultra High Speed Tapping. Please refer to the table below to select the best product that meets your tapping conditions.

YAMAWA's full lineup for Ultra High Speed corresponds with every application of blind holes and through holes in vertical and horizontal processing. High speed RPM is defined as 20 to 30m/min. Normal speed is defined as 5 to 10m/min. The Ultra High Speed RPM is defined as 50 to 100m/min.

Non-ferrous materials	Aluminum Rolling Stock	Aluminum/Zinc	Bronze	Brass Casting	Brass	Copper	
	AL	AC/ADC /ZDC	PB	BsC	Bs	Cu	
Tapping Speed 100m/ 50m/mi 30m/mi 20m/m	HFACT-B(for Blind Holes)/HFACT-P(for Through Holes)						Fully synchronous feed
	HFASP·HFAHS(for Blind Holes) HDISL(for Through Holes)						
	F-SP(for Blind Holes) F-SL(for Through Holes)						

Ferrous materials	Alloy Steel	High Carbon Steel	Middle Carbon Steel	Low Carbon Steel	Ductile Cast Iron	Cast Iron	
	SCM SCr	← S45C	S45C ↔ S30C	S25C ↔ SS400	FCD	FC	
Tapping Speed 50m/min 30m/min 20m/min 15m/min	HFISP·HFIHS(for Blind Holes) HDISL(for Through Holes)				HFICT-B (for Blind Holes) HFACT-P (for Through Holes)		Fully synchronous feed
	F-SP(for Blind Holes) F-SL(for Through Holes)				HFISP(for Blind Holes) HDISL(for Through Holes)		
					F-SL(for Through Holes)		

【Note】 These products should be used with machines that have a full synchronous feed and a solid type holder that has high rigidity, high accuracy, and high pressure capabilities. Improper use will cause a feeding error that will develop a pitch enlargement problem on internal screw threads.