

Think threads with
YAMAWA

VUSP

Z-PRO Series optimum tap for water soluble oil processing

Z-PRO
Ultimate Machine Tap Series



Product Features



Coated Spiral Fluted Tap VUSP

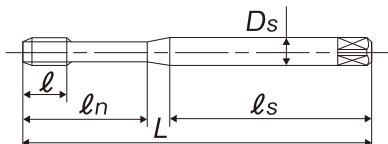


Features

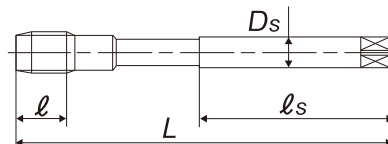
- Longer Life—Improved tool life from using a high grade of powder high speed steel with a special coating!
- Flute Shape—Improved chip evacuation and cutting resistance from a unique flute shape to produce excellent internal threads!
- The Z-PRO VUSP is designed for use with water-soluble cutting fluid where there is a good coolant supply.

Shape and Dimensions

[Typy1]



[Type2]



Size	Class	Product Code	Chamfer	L (mm)	l (mm)	ln (mm)	ls (mm)	Ds (mm)	No. of flutes	Type
M3 X 0.5	IS02X	3101101035	2.5P	56	5	18	34	3.5	3	1
M3 X 0.35	IS02X	3101101036	2.5P	56	5	18	34	3.5	3	1
M4 X 0.7	IS02X	3101101042	2.5P	63	7	21	38	4.5	3	1
M4 X 0.5	IS02X	3101101043	2.5P	63	5	21	38	4.5	3	1
M5 X 0.8	IS02X	3101101049	2.5P	70	9	25	39	6	3	1
M5 X 0.5	IS02X	3101101051	2.5P	70	6	25	39	6	3	1
M6 X 1	IS02X	3101101055	2.5P	80	11	30	45	6	3	1
M6 X 0.75	IS02X	3101101056	2.5P	80	8	30	45	6	3	1
M6 X 0.5	IS02X	3101101057	2.5P	80	8	30	45	6	3	1
M8 X 1.25	IS02X	3101101064	2.5P	90	12	35	47	8	3	1
M8 X 1	IS02X	3101101065	2.5P	90	12	44	46	6	3	2
M10 X 1.5	IS02X	3101101078	2.5P	100	13	39	52	10	3	1
M10 X 1.25	IS02X	3101101079	2.5P	100	13	49	51	7	3	2
M10 X 1	IS02X	3101101080	2.5P	90	13	-	46	7	3	2
M12 X 1.75	IS02X	3101101088	2.5P	110	15	54	56	9	3	2
M12 X 1.5	IS02X	3101101089	2.5P	100	15	49	51	9	3	2
M12 X 1.25	IS02X	3101101090	2.5P	100	15	49	51	9	3	2
M14 X 2	IS02X	3101101100	2.5P	110	18	54	56	11	3	2
M14 X 1.5	IS02X	3101101102	2.5P	100	14	49	51	11	3	2
M16 X 2	IS02X	3101101114	2.5P	110	18	54	56	12	3	2
M16 X 1.5	IS02X	3101101116	2.5P	100	14	49	51	12	3	2

Compatible with a wide range of workpiece machining

VUSP Recommended Processing Conditions

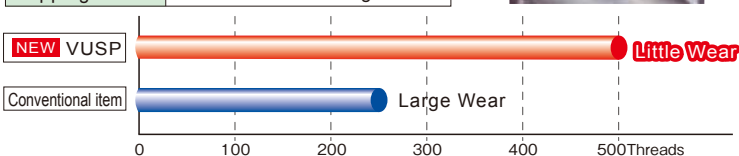
Workpiece Material	Tapping Speed (m/min)
General Structural Steel	10~20
Carbon Steel	10~25
Alloy Steel	10~20
Stainless Steel	5~10

Processing Data

Processing Conditions M3×0.5

Work Material	S50C
Thread Length	4.5mm
Tapping Speed	20m/min
Machinery	Vertical Machining center
Tapping Oil	Water soluble cutting fluid

Enlarged Photo after tapped 250 holes by VUSP



Warning

- ◆Tools may shatter during use. Wear safety eye cover or eye glasses to avoid injury during tapping.
- ◆Use tools under the proper tapping condition.
- ◆Never wear gloves during turning operations as the gloves may get caught in the tools.
- ◆Wear safety shoes to avoid foot injury by the falling tools.
- ◆When attaching tools to the machine, fasten firmly to avoid chatter and run-out.
- ◆Fasten the workpiece firmly so it never moves during the tapping operation. Never use worn tools or damaged tools.
- ◆Take a special care to prevent fire during machining. High temperature during tapping can cause a fire.



DOLINŠEK-S, d.o.o. Šempeter

Trgovina za prodajo navojnega, stružnega, rezkalnega, vrtnega orodja



JQA-QMA14664



JQA-EM3465