YAMAWA NEWS

Taps for threads for indexable milling bodies and turning holders

Suitable for through hole tapping into thermal refining steels <45HRC
(1.7225 - 42 CrMo 4, 1.6582 - 34 CrNiMo 6, 1.2344 - X 40 CrMoV 5 1)

1. Features

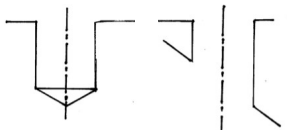
○Improved chip ejection…Special flute shape realizes smooth chip ejection!!
○Long tool life…Wear resistance improved by special coating!!
○Excellent surface finish…High cutting capability results in excellent surface finish!!

2. Tapping data

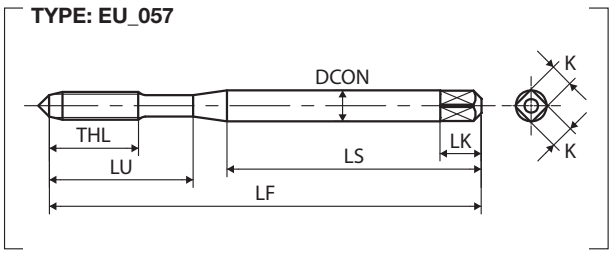
	Internal test results
Size	M2.5X0.45
Work material	1.7225 – 42 CrMo 4(45HRC)
Hole size	ϕ2.1mm, 5mm (through)
Speed	5m/min(640min−1)
Machine	M/C
Lubricant	Water soluble
No. of holes	200 holes (still usable)

User A	User B
M2.5X0.45	M4X0.7
1.7225 – 42 CrMo 4(45HRC)	1.7225 – 42 CrMo 4(45HRC)
ϕ2.1mm, 4mm (through)	Φ3.4mm, 6mm (through)
2.5m/min(320min−1)	5m/min(400min−1)
M/C	M/C
Water soluble	Water soluble
300 holes	351 holes
Reduced breakage problem	Longer life and better finishing

① Not recommended for blind hole
② Not recommended for through hole if the exit of the hole is intermittent cutting.

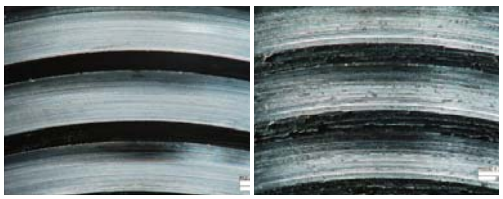


3. Dimensions - DIN371



Thread finishing
Innovative geometry combined with suitable coating result in excellent thread finishing.

MHSL **Competitor**



M-MF	TCTR (tolerance)	Ø (mm)	Hole Ø (mm)	Code	THCHT (chamfer)	LF (mm)	THL (mm)	LU (mm)	LS (mm)	DCON (mm)	K (mm)	LK (mm)	NOF	Type	Stock
DIN 371															
M2.5X0.45	ISO2X(6HX)	2.1	2.11	3109101029	5P	50	8	15	33	2.8	2.1	5	3	057	●
M3X0.5	ISO2X(6HX)	2.5	2.56	3109101035	5P	56	9	18	34	3.5	2.7	6	3	057	●
M3.5X0.6	ISO2X(6HX)	2.9	2.97	3109101038	5P	63	13	20	32	4	3	6	3	057	●
M4X0.7	ISO2X(6HX)	3.3	3.38	3109101042	5P	63	13	21	38	4.5	3.4	6	3	057	●
M4.5X0.75	ISO2X(6HX)	3.8	3.83	3109101045	5P	70	14	25	39	6	4.9	8	3	057	●
M5X0.8	ISO2X(6HX)	4.2	4.28	3109101049	5P	70	14	25	39	6	4.9	8	3	057	●
MF5X0.5	ISO2X(6HX)	4.5	4.56	3109101051	5P	70	9	-	-	6	4.9	8	3	057	●

Think threads with YAMAWA