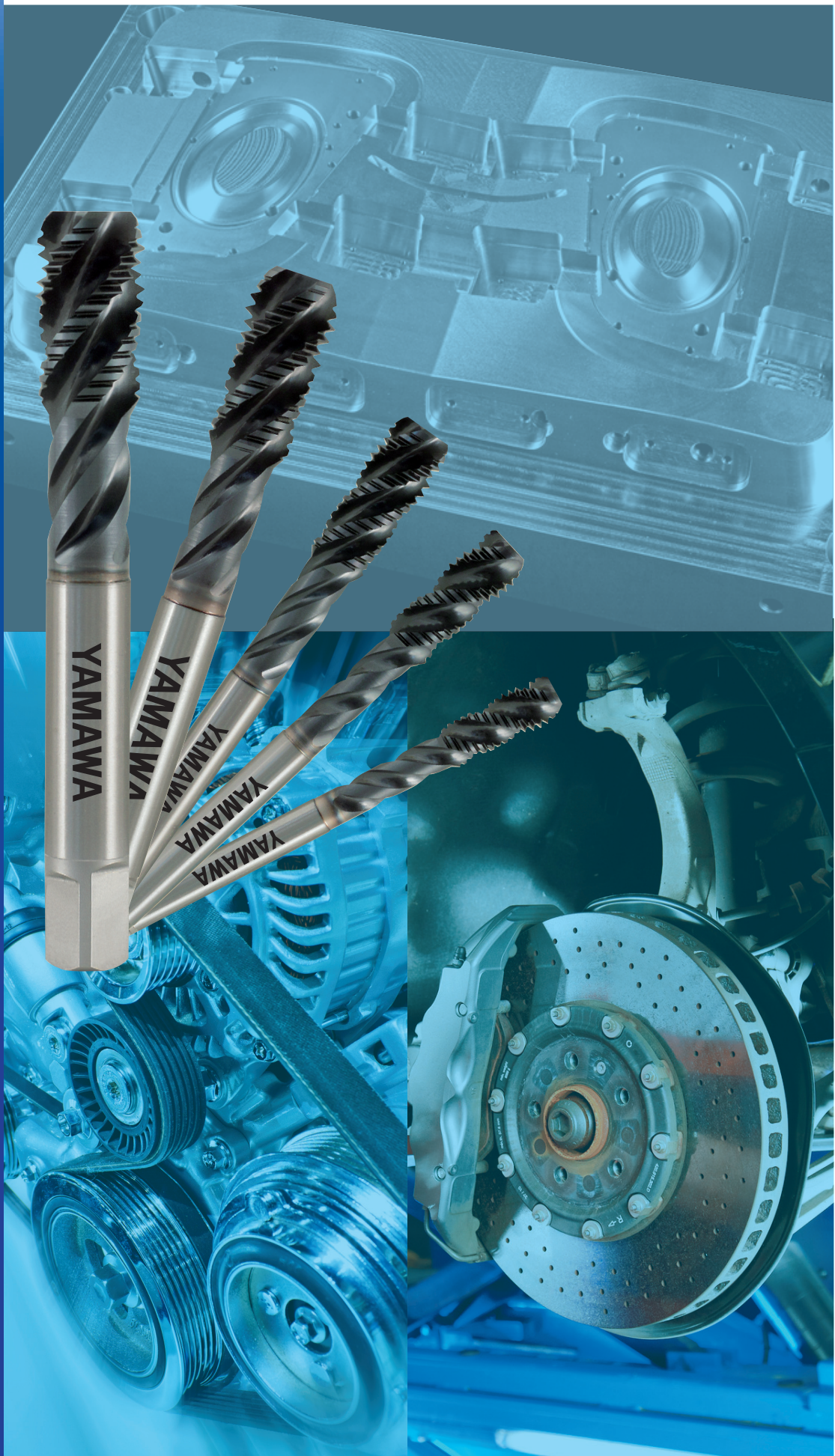


# MHSP

**Medium Hard**

# MHSP

Taps for blind hole tapping of medium hardness carbon steels.



## Features of products

For carbon steels of medium hardness,  
for blind hole tapping

# MHSP

HSS-Co

Coating



Synchro  
nized

<2D

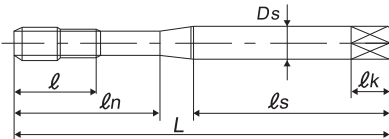


### Features

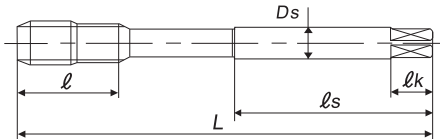
- Longer tool life: Improved tool life by utilizing a special coating.
- Thread portion: The BLF design avoids chipping problems on the full-thread portion of the tap.
- A longer overall length: Projected overall length produces smooth chip ejection and avoids interference with the tapping holder.

## Dimensions and sizes

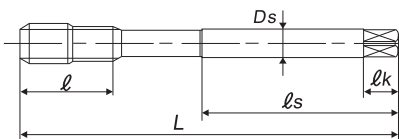
(TYPE 1) DIN371



(TYPE 2) DIN376



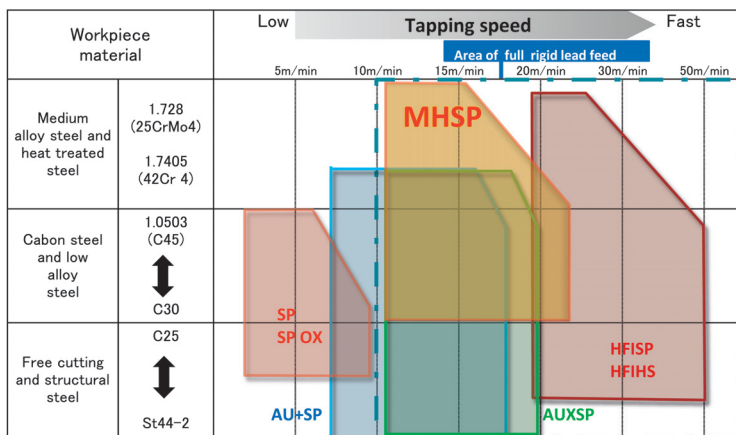
(TYPE 3) DIN374



Unit: mm

Nominal Size	Class	L	l	ln	ls	Ds	No. of flute	No. of chamfer length	Type	Code
M8X1.25	ISO2X	90	19	35	47	8	3	2.5P	1	SD8.0NBOCLJ
M10X1.5	ISO2X	100	23	39	52	10	3	2.5P	1	SD010OBOCLJ
M10X1.25	ISO2X	100	23	-	51	7	3	2.5P	3	SM010NBOCLJ
M10X1	ISO2X	90	19	-	46	7	3	2.5P	3	SM010MBOCLJ
M12X1.75	ISO2X	110	26	-	56	9	4	2.5P	2	SG012PBOCLJ
M12X1.5	ISO2X	100	21	-	51	9	4	2.5P	3	SM012OBOCLJ
M12X1.25	ISO2X	100	21	-	51	9	4	2.5P	3	SM012NBOCLJ
M14X2	ISO2X	110	26	-	56	11	4	2.5P	2	SG014QBOCLJ
M14X1.5	ISO2X	100	21	-	51	11	4	2.5P	3	SM014OBOCLJ
M16X2	ISO2X	110	26	-	56	12	4	2.5P	2	SG016QBOCLJ
M16X1.5	ISO2X	100	21	-	51	12	4	2.5P	3	SM016OBOCLJ

## System chart of MHSP

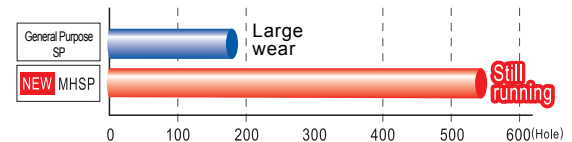


## Process Data

### Process Condition M8x1.25

Workpiece material	SCM440 35HRC
Threading Speed	12 mm
Tapping speed	15 m/min
Machine	Machining Center Vertical type
Tapping fluid	Water soluble

MHSP  
Enlarged photo tapped  
after 550 holes



## Warning

- ♦ Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- ♦ Tools may be shatter. Use tools under the proper tapping condition.
- ♦ Never wear gloves during turning operations as the gloves may get caught with the tools.
- ♦ Wear safety shoes to avoid injuring yourself by the falling tools.
- ♦ On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- ♦ Fasten the workpieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- ♦ Take a special care to fire trouble. High temperature during machining may cause fire.

Please note that specification may change without advance notice.

Think threads with  
**YAMAWA**

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