

MHSL

MHSL

Taps for through hole of medium hardness carbon steel.



Feature of products

For carbon steel of middle class hardness, for through hole tapping

MHSL M6~M16×1.5



■ Features

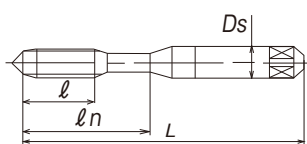
- **Long tool life**...Combination of CO-HSS(featuring wear resistance) and special coating realizes high durability.
- **Improved chip ejection**...Having Yamawa's special flute design, MHSL accomplishes splendid chip ejection performance.
- **Good surface roughness**...Superior cutting performance results in preferable surface roughness.

[Example of tapping]

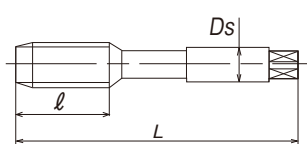


MHSL has attained very high durability in through hole tapplings of steel product of middle hardness class, such as automobile component-Hub bearings.

Table of dimensions and sizes



【M6】



【M8~M16】

pitch (P)	class	overall length	thread length	neck length	shank diameter	number of flutes	codes
M6 X1	P3	62	15	26	6	3	MHSLR6.0M7
M8 X1.25	P4	70	19	-	6.2	3	MHSLS8.0N7
M10X1.25	P4	75	23	-	7	3	MHSLS010N7
M12X1.25	P5	82	26	-	8.5	4	MHSLT012N7
M14X1.5	P5	88	26	-	10.5	4	MHSLT01407
M16X1.5	P5	95	26	-	12.5	4	MHSLT01607



Flute Form

To improve chip ejection, MHSL have 2-step-flute taper.



2-step-flute taper pushes out chips smoothly.
Cross section of 2-step-flute taper.

Tapping data

Improved wear resistance feature

Due to wear, tap having old design caused noise at 1239 tapping



SL + TiCN
1239
holes
NG

tapping condition

size	M12×1.25
material	S53C (25HRC)
thread length	13mm
tapping speed	30m/min
machine	machining center
cutting oil	water soluble (external)

Good!

MHSL
2800
holes
still
running



Improved surface roughness



PO no surface treatment
first tapping internal screw thread



SL + TIN coating
first tapping internal screw thread

Good!

MHSL first tapping internal screw thread

As a result of high cutting performance, MHSL produces far better internal screws with good surface roughness.



Warning

- ◆ Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- ◆ Tools may 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.

YAMAWA Mfg. CO., Ltd.

Head office

Nakajima Gold bldg.13-10 Kyobashi
3chome, Chuo-ku, Tokyo 104-0031, JAPAN

Website: <http://www.yamawa.com>

YAMAWA group for Overseas

YAMAWA International Co., Ltd.



JQA-QMA14664



JQA-EM3465