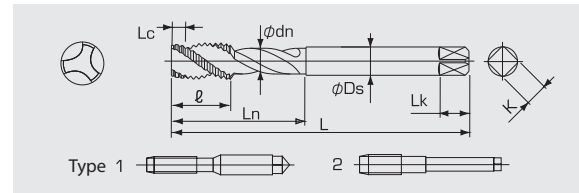


ZSP – SUS Hyper-Z Spiral Tap

Due to the sharper geometry, the **stainless steel** variant of the Z-series is a tap with high process reliability and a long tool life, also in critical materials. For blind holes.



LIST: 6870










Ø	Pitch	Pitch Chamfer	OAL	Thread Length			Shank Ø	Square Width	Square Length	Z	Type	DIN	Stock
		Lc	L	ϕ			Ln	dn	Ds				
3	0.5	2.5P	56	5.6	18	2.35	3.5	2.7	6	3	1	371	●
4	0.7	2.5P	63	8.1	21	3.15	4.5	3.4	6	3	1	371	●
5	0.8	2.5P	70	9.4	25	4.05	6.0	4.9	8	3	1	371	●
6	1	2.5P	80	12	30	4.75	6.0	4.9	8	3	1	371	●
8	1.25	2.5P	90	15.4	35	6.55	8.0	6.2	9	3	1	371	●
10	1.5	2.5P	100	18.9	39	8.25	10.0	8.0	11	3	1	371	●
12	1.75	2.5P	110	22.4	42	9.95	9.0	7.0	10	3	2	376	●
14	2	2.5P	110	25.9	49	11.65	11.0	9.0	12	3	2	376	●
16	2	2.5P	110	25.9	49	13.65	12.0	9.0	12	3	2	376	●
18	2.5	2.5P	125	32.6	55	15.15	14.0	11.0	14	4	2	376	●
20	2.5	2.5P	140	32.6	55	17.15	16.0	12.0	15	4	2	376	●
22	2.5	2.5P	140	32.6	55	19.15	18.0	14.5	17	4	2	376	●
24	3	2.5P	160	38.8	63	20.65	18.0	14.5	17	4	2	376	●

Technical Specifications

CUTTING CONDITION / RECOMMENDED CUTTING SPEED & CUTTING FLUIDS												
		Recommended Cutting Speed m/min										
Work materials	ST52(SS) Structural Steel	C15(S15C) Low Carbon Steel	C40(S40C) C < 0.45%	C50(S50C) C > 0.45%	20Cr.42CrMo (SCM.SCr) Alloy Steel		Hardened Steel	SUS Stainless Steel	GG(FC) Grey Cast Iron	GGG(FCD) Ductile Cast Iron	AC.ADC Aluminum Alloy	
	Code	~200HB	~200HB	~200HB	~200HB	~200HB	20~30HRC	30~40HRC				
Hyper-Z	ZSP	5~20	5~20	5~20	5~20	5~20	5~10	-	-	-	5~20	10~25
	ZPO	8~20	10~25	6~25	6~25	6~25	5~10	-	-	8~20	6~25	10~30
	ZSP-SUS	5~10	5~10	5~10	5~10	-	-	-	5~10	-	-	10~25
	ZPO-SUS	5~15	5~15	5~15	5~15	-	-	-	5~10	-	-	10~30
Cutting Fluids		Water-based emulsion from 7%										

1. These are general cutting recommendations and may be altered by your conditions.
2. These conditions are for thread depth of $2 \times D_c$.
3. Recommended are non-water-soluble cutting oils for Stainless Steel.

Pictogram overview

 M	Metric thread	 TOLERANCE 6H ISO CLASS 2	Thread tolerance	 DIN 371	Tap with reinforced shaft
 MF	Metric fine thread	 FORM B	Cut part. 3,5-5,5 gears	 DIN 374	Metric fine tap with overflow shaft
 HSS-E TOOL MATERIAL	High-speed steel with cobalt alloy	 FORM C	Cut part. 2-3 gears	 DIN 376	Metric tap with overflow shaft