

Hyper Z系列 被削材商品选定表

Selection chart according to work materials for Hyper Z tap series

多样化需求对应、Hyper Z系列适用于多种被削材应用

Responding to diversifying needs, the Hyper Z series are available for wide range of work materials

一般结构用钢 SS	合金钢 SCM、SCr	碳素钢 S50C	高硬度钢 30~40HRC	铸铁 FC	球墨铸铁 FCD	铝合金 AC、ADC	不锈钢 SUS
Structural Steel	Alloy Steel	Carbon Steel	Hardened Steel	Cast Iron	Ductile Cast Iron	Aluminum Alloy	Stainless Steel
HyperZ 螺旋槽丝锥 Hyper Z Spiral Tap ZSP						HyperZ 螺旋槽丝锥 Hyper Z Spiral Tap ZSP	HyperZ 螺旋槽丝锥 不锈钢专用 Hyper Z Spiral Tap For stainless steel ZSP-SUS
			HyperZ 小螺旋角丝锥 Hyper Z Low Spiral Tap ZSP-LS				

注：
*本样册中的产品图片及内容仅作参考，实物产品效果(包括但不限于外观、颜色、尺寸)可能略有差异，请以实物为准。
*本样册中的数据为理论值，均来源于不二越内部实验，于特定测试环境下所得(请见各项具体说明)，实际使用中可能因产品个体差异、使用条件和环境因素不同略有不同，请以实际使用的情况为准。
*The pictures and contents of the products in this sample book are only for illustration. The effects of the physical products (including but not limited to appearance, color and size) may vary slightly. Please refer to the physical products.
*The data in this sample book are theoretical values, which are derived from the internal experiments in NACHI. The data obtained under the specific test environment (see the specific instructions). The actual use may vary slightly according to the individual differences of the products, the use conditions and environmental factors. Please take the actual use as the criterion.

目录相关信息

Information about Catalog

有关其他丝锥系列尺寸的详细信息，请参阅此目录。
please refer to this catalog for details on the size of other tap series.



NO.T2501C-11 丝锥综合目录
Taps General Catalog



https://www.nachi.com.cn/

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高硬度钢、卧式加工中心均能实现稳定加工

HyperZ

小螺旋角丝锥

NEW
ZSP-LS



HyperZ 小螺旋角丝锥

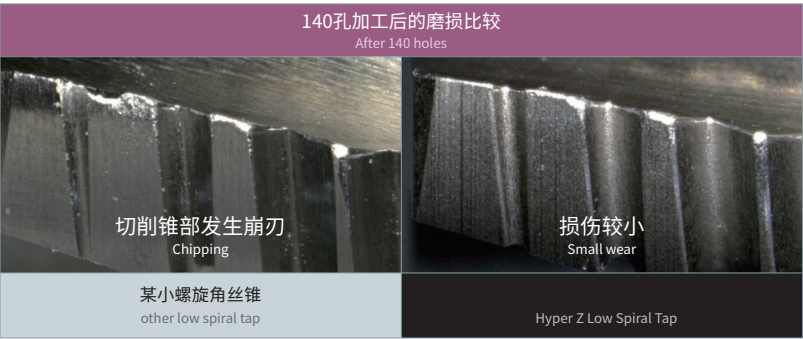
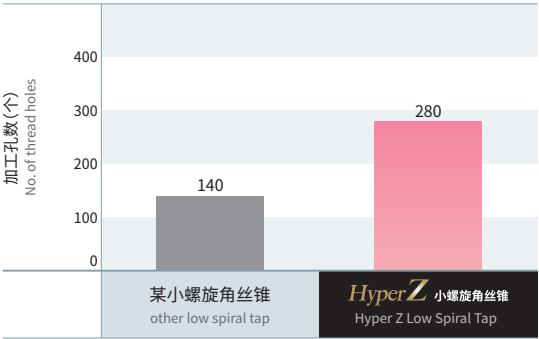
NEW ZSP-LS

高硬度钢、卧式加工中心均能实现稳定加工

Hyper Z Low Spiral Tap
Achieves stable screw threads cutting even hardened steel, even horizontal machining center

即使是难切削的高硬度钢，也能展现优异的工具寿命

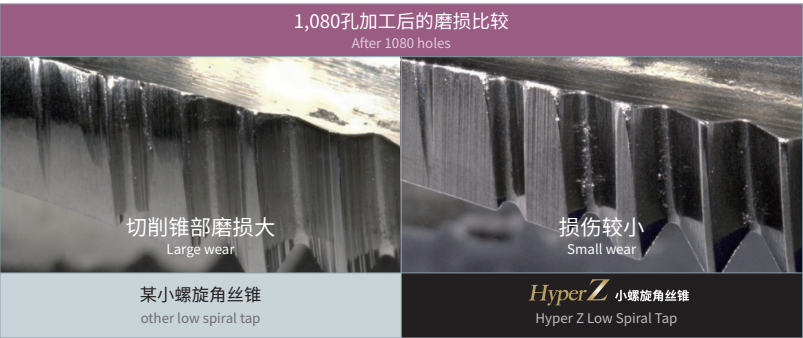
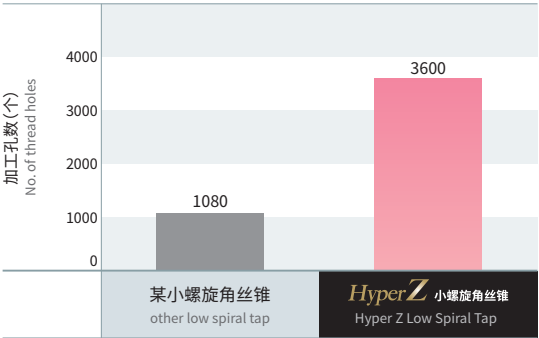
Even hardened steel that are becoming increasingly difficult to cut, the tool life surpassing other products



切削条件 Cutting conditions	规格：M6×1 Size 被削材：SCM440H (44HRC) Work Material	切削速度：5m/min Cutting speed 加工深度：7mm (盲孔) Depth(blind hole)	卧式加工中心 Horizontal machining center / Synchro tapper 攻丝油膏 Tap paste
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球墨铸铁加工数量也能超越旧款产品3倍以上

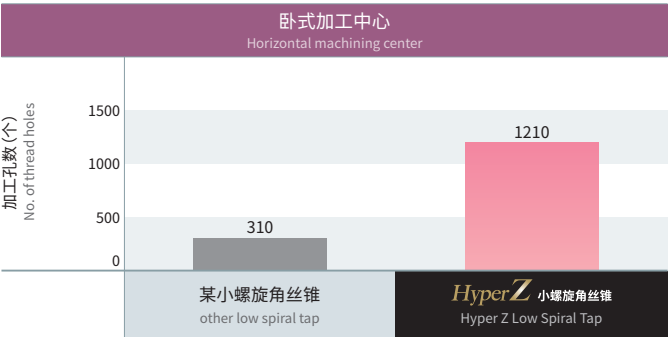
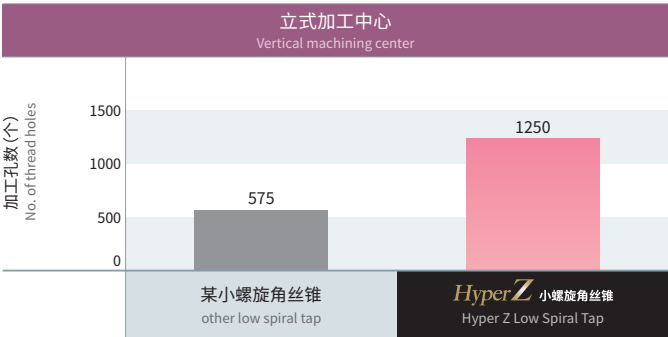
Astonishing number of processing more than three times that of old products even ductile cast iron



切削条件 Cutting conditions	规格：M6×1 Size 被削材：FCD600 Work Material	切削速度：5m/min Cutting speed 加工深度：12mm (盲孔) Depth(blind hole)	卧式加工中心 Horizontal machining center / Auto tapper 水溶性切削油剂 Water-soluble cutting fluid
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多种加工机械、均能实现稳定加工及长寿命

Achieves stable screw threads cutting and long tool life regardless of the processing machine



切削条件 Cutting conditions	规格：M12×1.75 Size 被削材：NAK55 (40HRC) Work Material	切削速度：5m/min Cutting speed 加工深度：18mm (盲孔) Depth(blind hole)	自动攻丝机 Auto tapper 水溶性切削油剂 Water-soluble cutting fluid
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■ 继承HyperZ丝锥的技术，
高硬度钢、球墨铸铁等被削材均能实现出色的性能

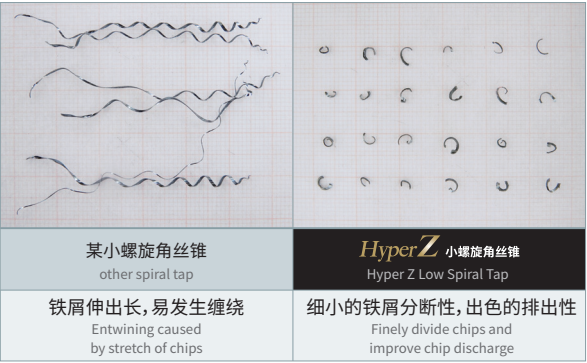
■ 小螺旋角槽型的采用，
提升了铁屑分断性

■ 即使在卧式加工中心，
也能降低加工中缠绕铁屑的困扰。

- Inherit the technology of Hyper Z tap, also compatible with high hardness steel, ductile cast iron and other work materials
- Adopts low spiral flute shape and improves chip evacuation
- Even with a horizontal machining center, reduce chip clogging and entanglement problems

卧式加工中心的铁屑比较

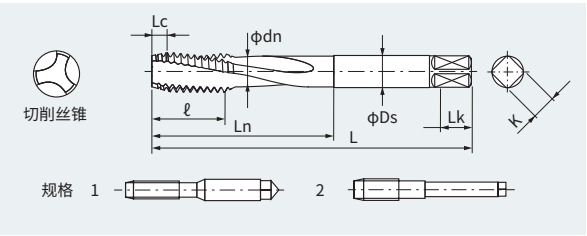
Compare chip by horizontal machining center



ZSP-LS HyperZ 小螺旋角丝锥

Hyper Z Low Spiral Tap

FAX 工具材料
特殊 涂层
12° 螺旋角



LIST 7962	订货方法 Order	ZSP-LS	编码 Code No.	单位 (Unit) : mm							
编码 Code No.	螺纹尺寸 Thread Size	等级 TAP Limit	切削锥部 (P) Lc(P)	全长 L	螺纹长 ℓ	槽数 Flutes	柄径 Ds	钻颈长 Ln	首径 dn	规格 Type	库存 Stock
3M0.5R	M3 × 0.5	REG	P3	3	46	5.6	3	4.0	20.0	2.35	1 ●
4M0.7R	M4 × 0.7	REG	P3	3	52	8.1	3	5.0	23.0	3.15	1 ●
5M0.8R	M5 × 0.8	REG	P3	3	60	9.4	3	5.5	26.0	4.05	1 ●
6M1R	M6 × 1	REG	P3	3	62	12.0	3	6.0	29.0	4.75	1 ●
8M1.25R	M8 × 1.25	REG	P3	3	70	15.4	3	6.2	33.0	6.55	2 ●
10M1.5R	M10 × 1.5	REG	P3	3	75	18.9	3	7.0	37.0	8.25	2 ●
10M1.25R	M10 × 1.25	REG	P3	3	75	15.7	3	7.0	33.0	8.55	2 ●
12M1.75R	M12 × 1.75	REG	P3	3	82	22.4	3	8.5	42.0	9.95	2 ●
12M1.5R	M12 × 1.5	REG	P3	3	82	20.9	3	8.5	40.0	10.25	2 ●
12M1.25R	M12 × 1.25	REG	P4	3	82	17.2	3	8.5	35.0	10.55	2 ●

●：标准在库品 Stocked items

被削材选定基准表和切削速度

Selection chart according to work material and recommended cutting speed

被削材 Work materials	一般 结构用钢 SS Structural Steel	低碳素钢 S15C Low Carbon Steel	中碳素钢 S40C Medium Carbon Steel	高碳素钢 S50C High Carbon Steel	合金钢 SCM, SCr Alloy Steel	高硬度钢 30~40HRC Hardened Steel	不锈钢 SUS Stainless Steel	铸铁 FC Cast Iron	球墨铸铁 FCD Ductile Cast Iron	铝合金 AC, ADC Aluminum Alloy
选定表 Selection chart	-	-	-	○	-	◎	-	○	○	-
切削速度(m/min) Cutting speed	-	-	-	5~15	-	3~15	-	3~15	3~15	-
推荐切削油剂 Cutting Fluids	油性非水溶性油剂 Sulfochlorinated Oil			水溶性油剂 Water soluble Oil				水溶性油剂 Water soluble Oil		

注) 1.表中的数值是一般基准值，切削条件会根据使用状态不同而变化。
2.表中的数值为攻丝深度2Dc(攻丝深度是直径的2D)的基准。
3.高硬度钢加工时使用攻丝油膏效果较佳。

1.These are general Cutting condition, and may be altered by your conditions.
2.These conditions are for thread depth of 2 × Dc.
3.Tap paste is effective for Hardened Steel cutting.