



ROUND TOOLS ONE-STOP

GENERAL SERVICE PROVIDER

S-TAP 高效多用途涂层丝锥



苏州用朴精密科技有限公司

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一站式服务



非标定制



百余年技术加持

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www.yp-tec.com

圆柄类刀具
一站式综合服务商

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圆柄类刀具 一站式综合服务商



一站式服务



非标定制



百余年技术加持

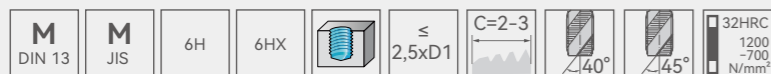
苏州用朴精密科技有限公司成立于2013年，是一家专注圆柄类精密刀具的研发生产和销售的高新技术企业，提供圆柄类棒材、精密刀具、涂层的全产业链一站式服务。现有苏州吴江和安徽滁州两处制造基地，拥有专业的技术团队，先进的生产设备和完善的质量管理体系，依托山特维克的技术支持以及完整的产业链打造客户值得信赖的圆柄类刀具一站式综合服务商。

Suzhou Yongpu Precision Technology Co., Ltd. was established in 2013 and is a high-tech enterprise specializing in the research, development, production, and sales of high precision solid carbide round tools. It provides one-stop services for the entire industry chain of round tool blanks, high precision cutting tools, and coatings. There are two production units in Wujiang, Suzhou and Chuzhou, Anhui, with professional technical teams, advanced production equipment, and a comprehensive quality control system. With Sandvik's technical support and a complete industrial chain, we aim to create a trustworthy one-stop general service provider for solid carbide round tools for our customers.



Round Tools
One-stop General
Service Provider

涂层螺旋丝锥 ST300



切削刃口精研
确保最佳的切屑形成

全新切削刃几何形状
可适用于广泛的材料种类

AICrN 纳米润滑涂层带来极佳的耐磨性
同时更小的摩擦降低了切削温度

优化的齿背几何形状
确保针对不同的材料工艺可靠地使用
以最佳方式剪断切削并使切削根部平滑

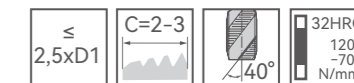
最佳排屑
得益于特殊的排屑槽几何形状

- 适合对多种类型材料加工的客户。
- 采用高性能HSS-E材料，具有耐久稳定的使用寿命。
- 采用优化的槽型设计，可适用于多种材料的加工-包括碳钢及合金钢、不锈钢、球磨铸铁。
- 优化的螺旋槽设计，可使盲孔加工中的切屑有效排出。
- 适用于同步和非同步攻丝机的螺纹加工。
- 采用适合的PVD涂层处理，具有可靠的性能。

高效多用途涂层丝锥 ST300



DIN系列-高效螺旋丝锥 DIN series high productivity spiral flute tap



	P	M	K	N	S	H	O
AICrN	●●	●	●●	●	●	●	●

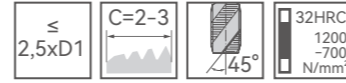
DIN371	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S335D213-M3x0.5	M3	0.5	3.5	2.7	56	10.0	18	3	6H
	S335D213-M4x0.7	M4	0.7	4.5	3.4	63	8.4	21	3	6H
	S335D213-M5x0.8	M5	0.8	6.0	4.9	70	9.6	25	3	6H
	S335D213-M6x1.0	M6	1.0	6.0	4.9	80	12.0	30	3	6H
	S335D213-M8x1.0	M8	1.0	8.0	6.2	90	15.0	35	3	6HX
	S335D213-M8x1.25	M8	1.25	8.0	6.2	90	15.0	35	3	6H
	S335D213-M10x1.0	M10	1.0	10.0	8.0	100	18.0	39	3	6HX
	S335D213-M10x1.25	M10	1.25	10.0	8.0	100	18.0	39	3	6HX
	S335D213-M10x1.5	M10	1.5	10.0	8.0	100	18.0	39	3	6H
		S335D213-M12x1.25	M12	1.25	9.0	7.0	110	18.0	--	3
S335D213-M12x1.5		M12	1.5	9.0	7.0	110	18.0	--	3	6H
S335D213-M12x1.75		M12	1.75	9.0	7.0	110	18.0	--	3	6H
S335D213-M14x1.5		M14	1.5	11.0	9.0	110	20.0	--	3	6HX
S335D213-M14x2.0		M14	2.0	11.0	9.0	110	20.0	--	3	6HX
S335D213-M16x1.5		M16	1.5	12.0	9.0	110	20.0	--	3	6HX
S335D213-M16x2.0		M16	2.0	12.0	9.0	110	20.0	--	3	6HX
S335D213-M18x1.5		M18	1.5	14.0	11.0	125	25.0	--	4	6HX
S335D213-M18x2.5		M18	2.5	14.0	11.0	125	25.0	--	4	6HX
S335D213-M20x1.5		M20	1.5	16.0	12.0	140	25.0	--	4	6HX
S335D213-M20x2.5		M20	2.5	16.0	12.0	140	25.0	--	4	6HX
S335D213-M24x3.0		M24	3.0	18.0	14.5	160	30.0	--	4	6HX

高效多用途涂层丝锥 ST300



JIS系列-高效螺旋丝锥

JIS series high productivity spiral flute tap



	P	M	K	N	S	H	O
不涂层	●	●	●	●	●	●	●
CrN+X	●●	●●	●●	●	●	●	●
AlCrN	●●	●	●●	●	●	●	●

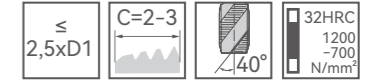
JIS	工具NO. EDP NO.	工具NO. EDP NO.CrN+X	工具NO. EDP NO.AlCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance	
	S345J215-M3x0.5	S355J215-M3x0.5	S357J215-M3x0.5	M3	0.5	4.0	3.2	46	10.0	19	3	6H	
	S345J215-M4x0.7	S355J215-M4x0.7	S357J215-M4x0.7	M4	0.7	5.0	4.0	52	8.4	20	3	6H	
	S345J215-M5x0.8	S355J215-M5x0.8	S357J215-M5x0.8	M5	0.8	5.5	4.5	60	9.6	24	3	6H	
	S345J215-M6x1.0	S355J215-M6x1.0	S357J215-M6x1.0	M6	1.0	6.0	4.5	62	12.0	29	3	6H	
	S345J215-M8x1.0	S355J215-M8x1.0	S357J215-M8x1.0	M8	1.0	6.2	5.0	70	15.0	37	3	6HX	
	S345J215-M8x1.25	S355J215-M8x1.25	S357J215-M8x1.25	M8	1.25	6.2	5.0	70	15.0	37	3	6H	
	S345J215-M10x1.0	S355J215-M10x1.0	S357J215-M10x1.0	M10	1.0	7.0	5.5	75	18.0	41	3	6HX	
	S345J215-M10x1.25	S355J215-M10x1.25	S357J215-M10x1.25	M10	1.25	7.0	5.5	75	18.0	41	3	6HX	
	S345J215-M10x1.5	S355J215-M10x1.5	S357J215-M10x1.5	M10	1.5	7.0	5.5	75	18.0	41	3	6H	
	S345J215-M12x1.25	S355J215-M12x1.25	S357J215-M12x1.25	M12	1.25	8.5	6.5	82	18.0	48	3	6H	
	S345J215-M12x1.5	S355J215-M12x1.5	S357J215-M12x1.5	M12	1.5	8.5	6.5	82	18.0	48	3	6H	
	S345J215-M12x1.75	S355J215-M12x1.75	S357J215-M12x1.75	M12	1.75	8.5	6.5	82	18.0	48	3	6H	
				S357J215-M14x1.5	M14	1.5	10.5	8.0	88	20.0	48	3	6HX
				S357J215-M14x2.0	M14	2.0	10.5	8.0	88	20.0	48	3	6HX
				S357J215-M16x1.5	M16	1.5	12.5	10.0	95	20.0	52	4	6HX
				S357J215-M16x2.0	M16	2.0	12.5	10.0	95	20.0	52	4	6HX
				S357J215-M18x1.5	M18	1.5	14.0	11.0	100	25.0	55	4	6HX
				S357J215-M18x2.5	M18	2.5	14.0	11.0	100	25.0	55	4	6HX
				S357J215-M20x1.5	M20	1.5	15.0	12.0	105	25.0	58	4	6HX
				S357J215-M20x2.5	M20	2.5	15.0	12.0	105	25.0	58	4	6HX
			S357J215-M24x3.0	M24	3.0	19.0	15.0	120	30.0	66	4	6HX	

高效多用途涂层丝锥 ST300



JIS系列-通用螺旋丝锥

JIS series general spiral flute tap



	P	M	K	N	S	H	O
ZrN	●●	●●	●●	●	●	●	●
CrN+X	●●	●●	●●	●	●	●	●
AlCrN	●●	●	●●	●	●	●	●

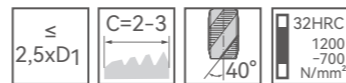
JIS	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	工具NO. EDP NO.AlCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S339J213-M3x0.5	S335J213-M3x0.5	S337J213-M3x0.5	M3	0.5	4.0	3.2	46	10.0	19	3	6H
	S339J213-M4x0.7	S335J213-M4x0.7	S337J213-M4x0.7	M4	0.7	5.0	4.0	52	8.4	20	3	6H
	S339J213-M5x0.8	S335J213-M5x0.8	S337J213-M5x0.8	M5	0.8	5.5	4.5	60	9.6	24	3	6H
	S339J213-M6x1.0	S335J213-M6x1.0	S337J213-M6x1.0	M6	1.0	6.0	4.5	62	12.0	29	3	6H
	S339J213-M8x1.0	S335J213-M8x1.0	S337J213-M8x1.0	M8	1.0	6.2	5.0	70	15.0	37	3	6HX
	S339J213-M8x1.25	S335J213-M8x1.25	S337J213-M8x1.25	M8	1.25	6.2	5.0	70	15.0	37	3	6H
	S339J213-M10x1.0	S335J213-M10x1.0	S337J213-M10x1.0	M10	1.0	7.0	5.5	75	18.0	41	3	6HX
	S339J213-M10x1.25	S335J213-M10x1.25	S337J213-M10x1.25	M10	1.25	7.0	5.5	75	18.0	41	3	6HX
	S339J213-M10x1.5	S335J213-M10x1.5	S337J213-M10x1.5	M10	1.5	7.0	5.5	75	18.0	41	3	6H
	S339J213-M12x1.25	S335J213-M12x1.25	S337J213-M12x1.25	M12	1.25	8.5	6.5	82	18.0	48	3	6H
	S339J213-M12x1.5	S335J213-M12x1.5	S337J213-M12x1.5	M12	1.5	8.5	6.5	82	18.0	48	3	6H
	S339J213-M12x1.75	S335J213-M12x1.75	S337J213-M12x1.75	M12	1.75	8.5	6.5	82	18.0	48	3	6H
	S339J213-M14x1.5		S335J213-M14x1.5	M14	1.5	10.5	8.0	88	20.0	48	3	6HX
	S339J213-M14x2.0		S335J213-M14x2.0	M14	2.0	10.5	8.0	88	20.0	48	3	6HX
	S339J213-M16x1.5		S335J213-M16x1.5	M16	1.5	12.5	10.0	95	20.0	52	3	6HX
	S339J213-M16x2.0		S335J213-M16x2.0	M16	2.0	12.5	10.0	95	20.0	52	3	6HX
	S339J213-M18x1.5		S335J213-M18x1.5	M18	1.5	14.0	11.0	100	25.0	55	4	6HX
	S339J213-M18x2.5		S335J213-M18x2.5	M18	2.5	14.0	11.0	100	25.0	55	4	6HX
	S339J213-M20x1.5		S335J213-M20x1.5	M20	1.5	15.0	12.0	105	25.0	58	4	6HX
	S339J213-M20x2.5		S335J213-M20x2.5	M20	2.5	15.0	12.0	105	25.0	58	4	6HX
S339J213-M24x3.0		S335J213-M24x3.0	M24	3.0	19.0	15.0	120	30.0	66	4	6HX	

高效多用途涂层丝锥 ST300



JIS系列-通用长柄螺旋丝锥

JIS series general purpose long shank spiral flute tap



	P	M	K	N	S	H	O
不涂层	•	•	•	•	•	•	•
CrN+X	••	••	••	••	••	••	••

JIS-L100	工具NO. EDP NO.	工具NO. EDP NO.CrN+X	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S325JL213-M3x0.5	S335JL213-M3x0.5	M3	0.5	4.0	3.2	100	10.0	19	3	6H
	S325JL213-M4x0.7	S335JL213-M4x0.7	M4	0.7	5.0	4.0	100	8.4	21	3	6H
	S325JL213-M5x0.8	S335JL213-M5x0.8	M5	0.8	5.5	4.5	100	9.6	25	3	6H
	S325JL213-M6x1.0	S335JL213-M6x1.0	M6	1.0	6.0	4.5	100	12.0	29	3	6H
	S325JL213-M8x1.0	S335JL213-M8x1.0	M8	1.0	6.2	5.0	100	15.0	40	3	6HX
	S325JL213-M8x1.25	S335JL213-M8x1.25	M8	1.25	6.2	5.0	100	15.0	40	3	6H
	S325JL213-M10x1.0	S335JL213-M10x1.0	M10	1.0	7.0	5.5	100	18.0	41	3	6HX
	S325JL213-M10x1.25	S335JL213-M10x1.25	M10	1.25	7.0	5.5	100	18.0	41	3	6HX
	S325JL213-M10x1.5	S335JL213-M10x1.5	M10	1.5	7.0	5.5	100	18.0	41	3	6H

■ YONGPUPRECISION

涂层先端丝锥 ST200



- 适合对多种类型材料加工的客户。
- 采用高性能HSS-E材料，具有耐久稳定的使用寿命。
- 采用优化的槽型设计，可适用于多种材料的加工-包括碳钢及合金钢、不锈钢、球磨铸铁以及铸铝材料。
- 优化的直槽刃倾角设计，可使通孔加工中的切屑有效排出。
- 适用于同步和非同步攻丝机的螺纹加工。
- 采用适合的PVD涂层处理，具有可靠的性能。

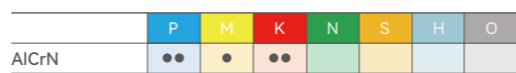
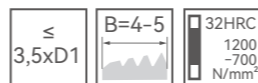


高效多用途涂层丝锥 ST200



DIN系列-高效先端丝锥

DIN series high productivity spiral point tap



DIN371	工具NO. EDP NO.AiCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S330HD215-M3x0.5	M3	0.5	3.5	2.7	56	10.0	18	3	6HX
	S330HD215-M4x0.7	M4	0.7	4.5	3.4	63	13.0	21	3	6HX
	S330HD215-M5x0.8	M5	0.8	6.0	4.9	70	16.0	25	3	6HX
	S330HD215-M6x1.0	M6	1.0	6.0	4.9	80	18.0	30	3	6HX
	S330HD215-M8x1.0	M8	1.0	8.0	6.2	90	20.0	35	4	6HX
	S330HD215-M8x1.25	M8	1.25	8.0	6.2	90	20.0	35	4	6HX
	S330HD215-M10x1.0	M10	1.0	10.0	8.0	100	20.0	39	4	6HX
	S330HD215-M10x1.25	M10	1.25	10.0	8.0	100	20.0	39	4	6HX
	S330HD215-M10x1.5	M10	1.5	10.0	8.0	100	20.0	39	4	6HX
DIN376	工具NO. EDP NO.AiCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of slots	精度 TAP tolerance
	S330HD215-M12x1.25	M12	1.25	9.0	7.0	110	25.0	--	5	6HX
	S330HD215-M12x1.5	M12	1.5	9.0	7.0	110	25.0	--	5	6HX
	S330HD215-M12x1.75	M12	1.75	9.0	7.0	110	25.0	--	5	6HX
	S330HD215-M14x1.5	M14	1.5	11.0	9.0	110	25.0	--	5	6HX
	S330HD215-M14x2.0	M14	2.0	11.0	9.0	110	25.0	--	4	6HX
	S330HD215-M16x1.5	M16	1.5	12.0	9.0	110	25.0	--	4	6HX
	S330HD215-M16x2.0	M16	2.0	12.0	9.0	110	25.0	--	4	6HX
	S330HD215-M18x1.5	M18	1.5	14.0	11.0	125	25.0	--	4	6HX
	S330HD215-M18x2.5	M18	2.5	14.0	11.0	125	25.0	--	4	6HX
	S330HD215-M20x1.5	M20	1.5	16.0	12.0	140	28.0	--	4	6HX
	S330HD215-M20x2.5	M20	2.5	16.0	12.0	140	28.0	--	4	6HX
	S330HD215-M24x3.0	M24	3.0	18.0	14.5	160	32.0	--	4	6HX

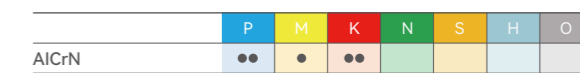
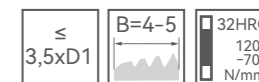


高效多用途涂层丝锥 ST200



JIS系列-高效先端丝锥

JIS series high productivity spiral point tap



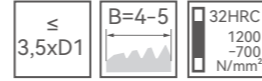
JIS	工具NO. EDP NO.AiCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S330HJ215-M6x1.0	M6	1.0	6.0	4.5	62	16.0	29	3	6H
	S330HJ215-M8x1.0	M8	1.0	6.2	5.0	70	21.0	37	4	6HX
	S330HJ215-M8x1.25	M8	1.25	6.2	5.0	70	21.0	37	4	6H
	S330HJ215-M10x1.0	M10	1.0	7.0	5.5	75	23.0	41	4	6HX
	S330HJ215-M10x1.25	M10	1.25	7.0	5.5	75	23.0	41	4	6HX
	S330HJ215-M10x1.5	M10	1.5	7.0	5.5	75	23.0	41	4	6H
	S330HJ215-M12x1.25	M12	1.25	8.5	6.5	82	24.0	48	5	6H
	S330HJ215-M12x1.5	M12	1.5	8.5	6.5	82	24.0	48	5	6H
	S330HJ215-M12x1.75	M12	1.75	8.5	6.5	82	24.0	48	5	6H
	S330HJ215-M14x1.5	M14	1.5	10.5	8.0	88	24.0	48	5	6HX
	S330HJ215-M14x2.0	M14	2.0	10.5	8.0	88	24.0	48	4	6HX
	S330HJ215-M16x1.5	M16	1.5	12.5	10.0	95	24.0	52	4	6HX
	S330HJ215-M16x2.0	M16	2.0	12.5	10.0	95	24.0	52	4	6HX
	S330HJ215-M18x1.5	M18	1.5	14.0	11.0	100	24.0	55	4	6HX
	S330HJ215-M18x2.5	M18	2.5	14.0	11.0	100	24.0	55	4	6HX
	S330HJ215-M20x1.5	M20	1.5	15.0	12.0	105	26.0	58	4	6HX
	S330HJ215-M20x2.5	M20	2.5	15.0	12.0	105	26.0	58	4	6HX
	S330HJ215-M24x3.0	M24	3.0	19.0	15.0	120	32.0	66	4	6HX

高效多用途涂层丝锥 ST200



JIS系列-通用先端丝锥

JIS series general purpose spiral point tap



	P	M	K	N	S	H	O
ZrN	●●	●●	●●	●	●	●	●
CrN+X	●●	●●	●●	●	●	●	●
AlCrN	●●	●	●●	●	●	●	●

JIS	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	工具NO. EDP NO.AlCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S336J213-M3x0.5	S330J213-M3x0.5	S332J213-M3x0.5	M3	0.5	4.0	3.2	46	10.0	19	3	6H
	S336J213-M4x0.7	S330J213-M4x0.7	S332J213-M4x0.7	M4	0.7	5.0	4.0	52	12.0	20	3	6H
	S336J213-M5x0.8	S330J213-M5x0.8	S332J213-M5x0.8	M5	0.8	5.5	4.5	60	14.0	24	3	6H
	S336J213-M6x1.0	S330J213-M6x1.0	S332J213-M6x1.0	M6	1.0	6.0	4.5	62	16.0	29	3	6H
	S336J213-M8x1.0	S330J213-M8x1.0	S332J213-M8x1.0	M8	1.0	6.2	5.0	70	21.0	37	3	6HX
	S336J213-M8x1.25	S330J213-M8x1.25	S332J213-M8x1.25	M8	1.25	6.2	5.0	70	21.0	37	3	6H
	S336J213-M10x1.0	S330J213-M10x1.0	S332J213-M10x1.0	M10	1.0	7.0	5.5	75	23.0	41	3	6HX
	S336J213-M10x1.25	S330J213-M10x1.25	S332J213-M10x1.25	M10	1.25	7.0	5.5	75	23.0	41	3	6HX
	S336J213-M10x1.5	S330J213-M10x1.5	S332J213-M10x1.5	M10	1.5	7.0	5.5	75	23.0	41	3	6H
	S336J213-M12x1.25	S330J213-M12x1.25	S332J213-M12x1.25	M12	1.25	8.5	6.5	82	24.0	48	3	6H
	S336J213-M12x1.5	S330J213-M12x1.5	S332J213-M12x1.5	M12	1.5	8.5	6.5	82	24.0	48	3	6H
	S336J213-M12x1.75	S330J213-M12x1.75	S332J213-M12x1.75	M12	1.75	8.5	6.5	82	24.0	48	3	6H
	S336J215-M14x1.5			M14	1.5	10.5	8.0	88	24.0	48	4	6HX
	S336J215-M14x2.0			M14	2.0	10.5	8.0	88	24.0	48	4	6HX
	S336J215-M16x1.5			M16	1.5	12.5	10.0	95	24.0	52	4	6HX
	S336J215-M16x2.0			M16	2.0	12.5	10.0	95	24.0	52	4	6HX
	S336J215-M18x1.5			M18	1.5	14.0	11.0	100	24.0	55	4	6HX
	S336J215-M18x2.5			M18	2.5	14.0	11.0	100	24.0	55	4	6HX
	S336J215-M20x1.5			M20	1.5	15.0	12.0	105	26.0	58	4	6HX
	S336J215-M20x2.5			M20	2.5	15.0	12.0	105	26.0	58	4	6HX
	S336J215-M24x3.0			M24	3.0	19.0	15.0	120	32.0	66	4	6HX

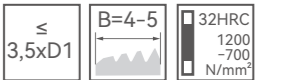
■ YONGPUPRECISION

高效多用途涂层丝锥 ST200



JIS系列通用长柄先端丝锥

JIS series general purpose tap with long shank



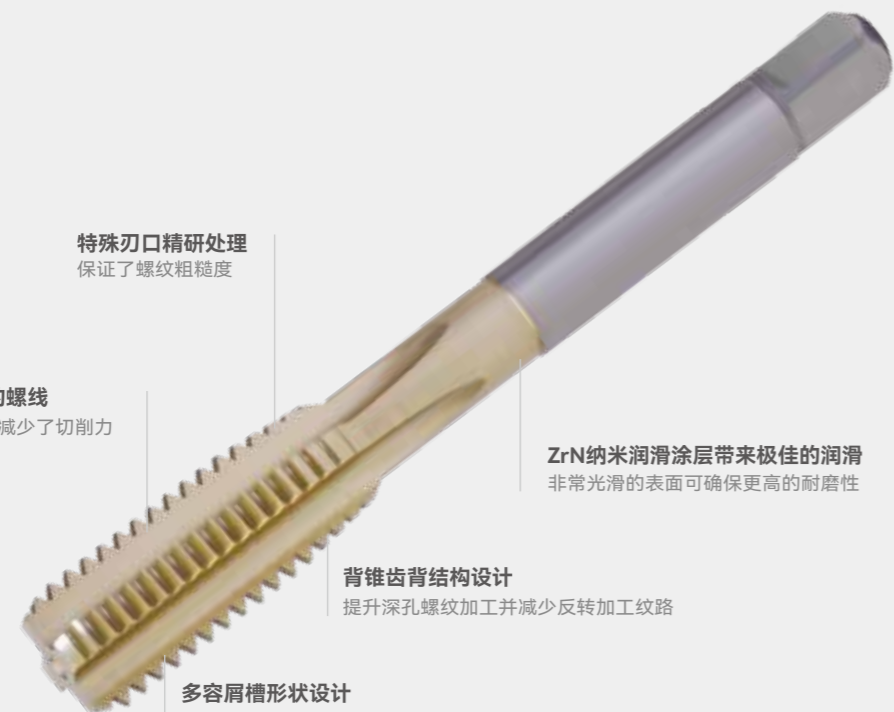
	P	M	K	N	S	H	O
不涂层	●	●	●	●	●	●	●
CrN+X	●●	●●	●●	●	●	●	●

JIS-L100	工具NO. EDP NO	工具NO. EDP NO.CrN+X	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S320JL213-M3x0.5	S330JL213-M3x0.5	M3	0.5	4.0	3.2	100	10.0	20	3	6H
	S320JL213-M4x0.7	S330JL213-M4x0.7	M4	0.7	5.0	4.0	100	13.0	27	3	6H
	S320JL213-M5x0.8	S330JL213-M5x0.8	M5	0.8	5.5	4.5	100	16.0	33	3	6H
	S320JL213-M6x1.0	S330JL213-M6x1.0	M6	1.0	6.0	4.5	100	19.0	40	3	6H
	S320JL213-M8x1.0	S330JL213-M8x1.0	M8	1.0	6.2	5.0	100	22.0	40	3	6HX
	S320JL213-M8x1.25	S330JL213-M8x1.25	M8	1.25	6.2	5.0	100	22.0	40	3	6H
	S320JL213-M10x1.0	S330JL213-M10x1.0	M10	1.0	7.0	5.5	100	24.0	41	3	6HX
	S320JL213-M10x1.25	S330JL213-M10x1.25	M10	1.25	7.0	5.5	100	24.0	41	3	6HX
	S320JL213-M10x1.5	S330JL213-M10x1.5	M10	1.5	7.0	5.5	100	24.0	41	3	6H

■ YONGPUPRECISION



涂层直槽丝锥 ST100



特殊刃口精研处理
保证了螺纹粗糙度

经过优化的螺线
攻丝进给时减少了切削力

ZrN纳米润滑涂层带来极佳的润滑
非常光滑的表面可确保更高的耐磨性

背锥齿背结构设计
提升深孔螺纹加工并减少反转加工纹路

多容屑槽形状设计
可降低切削扭矩并产生小且薄的切屑

- 采用优化的槽型设计，适用铸铁、球墨铸铁、合金钢及碳钢的加工。
- 优化的多槽设计，可使短切屑材料在通孔和盲孔攻丝中的切屑有效排出。
- 适用于同步和非同步攻丝机的螺纹加工。
- 高性能HSS-E材料和PVD涂层处理，具有耐久稳定的使用寿命和可靠的性能。

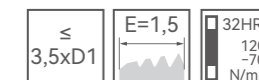
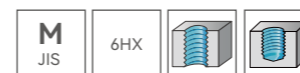


高效多用途涂层丝锥 ST100



JIS系列-高效直槽丝锥

JIS series high productivity straight flute tap



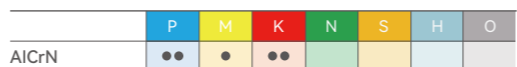
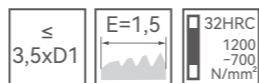
JIS	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺线长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S336JJ215-M6x1.0	M6	1.0	6.0	4.5	62	16.0	29	4	6HX
	S336JJ215-M8x1.0	M8	1.0	6.2	5.0	70	21.0	37	4	6HX
	S336JJ215-M8x1.25	M8	1.25	6.2	5.0	70	21.0	37	4	6HX
	S336JJ215-M10x1.0	M10	1.0	7.0	5.5	75	23.0	41	4	6HX
	S336JJ215-M10x1.25	M10	1.25	7.0	5.5	75	23.0	41	4	6HX
	S336JJ215-M10x1.5	M10	1.5	7.0	5.5	75	23.0	41	4	6HX
	S336JJ215-M12x1.25	M12	1.25	8.5	6.5	82	24.0	48	4	6HX
	S336JJ215-M12x1.5	M12	1.5	8.5	6.5	82	24.0	48	4	6HX
	S336JJ215-M12x1.75	M12	1.75	8.5	6.5	82	24.0	48	4	6HX
	S336JJ215-M14x1.5	M14	1.5	10.5	8.0	88	24.0	48	4	6HX
	S336JJ215-M14x2.0	M14	2.0	10.5	8.0	88	24.0	48	4	6HX
	S336JJ215-M16x1.5	M16	1.5	12.5	10.0	95	24.0	52	4	6HX
	S336JJ215-M16x2.0	M16	2.0	12.5	10.0	95	24.0	52	4	6HX
	S336JJ215-M18x1.5	M18	1.5	14.0	11.0	100	24.0	55	4	6HX
	S336JJ215-M18x2.5	M18	2.5	14.0	11.0	100	24.0	55	4	6HX
	S336JJ215-M20x1.5	M20	1.5	15.0	12.0	105	26.0	58	4	6HX
	S336JJ215-M20x2.5	M20	2.5	15.0	12.0	105	26.0	58	4	6HX
	S336JJ215-M24x3.0	M24	3.0	19.0	15.0	120	32.0	66	4	6HX

高效多用途涂层丝锥 ST100



DIN系列-高效直槽丝锥

DIN series high productivity straight flute tap

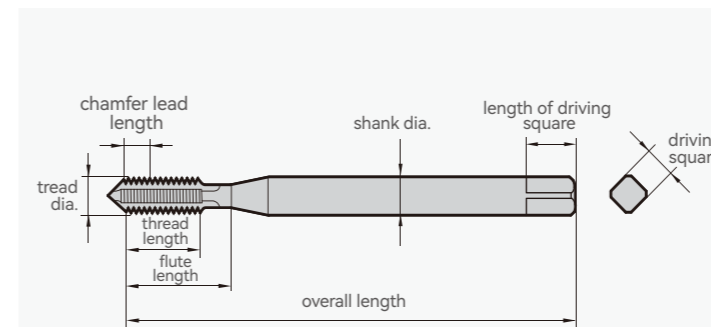


DIN371	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S332ID215-M3x0.5	M3	0.5	3.5	2.7	56	10.0	18	3	6HX
	S332ID215-M4x0.7	M4	0.7	4.5	3.4	63	13.0	21	3	6HX
	S332ID215-M5x0.8	M5	0.8	6.0	4.9	70	16.0	25	3	6HX
	S332ID215-M6x1.0	M6	1.0	6.0	4.9	80	18.0	30	4	6HX
	S332ID215-M8x1.0	M8	1.0	8.0	6.2	90	20.0	35	4	6HX
	S332ID215-M8x1.25	M8	1.25	8.0	6.2	90	20.0	35	4	6HX
	S332ID215-M10x1.0	M10	1.0	10.0	8.0	100	20.0	39	4	6HX
	S332ID215-M10x1.25	M10	1.25	10.0	8.0	100	20.0	39	4	6HX
	S332ID215-M10x1.5	M10	1.5	10.0	8.0	100	20.0	39	4	6HX

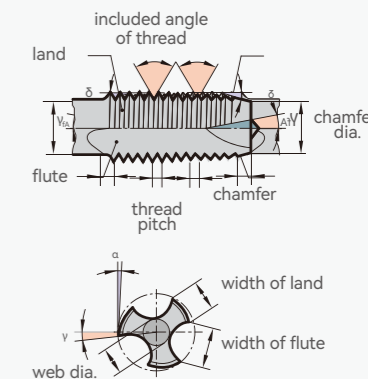
DIN376	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of slots	精度 TAP tolerance
	S332ID215-M12x1.25	M12	1.25	9.0	7.0	110	25.0	--	4	6HX
	S332ID215-M12x1.5	M12	1.5	9.0	7.0	110	25.0	--	4	6HX
	S332ID215-M12x1.75	M12	1.75	9.0	7.0	110	25.0	--	4	6HX
	S332ID215-M14x1.5	M14	1.5	11.0	9.0	110	25.0	--	4	6HX
	S332ID215-M14x2.0	M14	2.0	11.0	9.0	110	25.0	--	4	6HX
	S332ID215-M16x1.5	M16	1.5	12.0	9.0	110	25.0	--	4	6HX
	S332ID215-M16x2.0	M16	2.0	12.0	9.0	110	25.0	--	4	6HX
	S332ID215-M18x1.5	M18	1.5	14.0	11.0	125	25.0	--	4	6HX
	S332ID215-M18x2.5	M18	2.5	14.0	11.0	125	25.0	--	4	6HX
	S332ID215-M20x1.5	M20	1.5	16.0	12.0	140	28.0	--	4	6HX
	S332ID215-M20x2.5	M20	2.5	16.0	12.0	140	28.0	--	4	6HX
	S332ID215-M24x3.0	M24	3.0	18.0	14.5	160	32.0	--	4	6HX

■ YONGPUPRECISION

丝锥产品信息 General information



δ = chamfer angle
 V_s = spiral point angle
 α = clearance angle
 γ = rake angle



刃型 Flute forms



straight fluted, form C
without spiral point



helix angle
15°

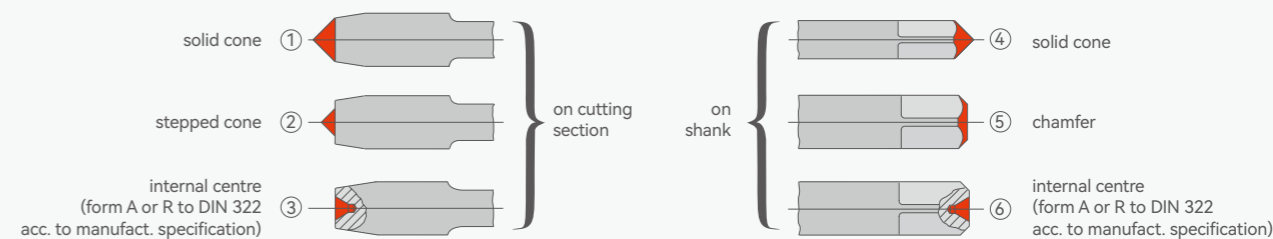


straight fluted, form B
with spiral point



helix angle
40°

中心形式标准 Types of centres (standard, to DIN 2197/DIN 2175)



Thread dia. range mm	Centre on cutting section		Centre on shank
	with chamfer forms A, C, D, E	with chamfer form B	
≤ 4.2	①	①	④ ⑤ ⑥
> 4.2 ... 5.6	① ②	①	④ ⑤ ⑥
> 5.6 ... 10.0	① ② ③	① ② ③	④ ⑤ ⑥
> 10.0	③	③	⑥

槽型冷却形式 Coolant duct geometries

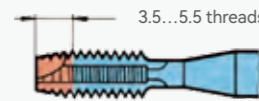
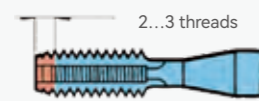
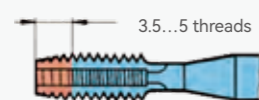
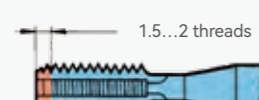


axial coolant
delivery
with axial coolant
duct exit



axial coolant
delivery with radial
coolant duct exit in the flutes
at the chamfer

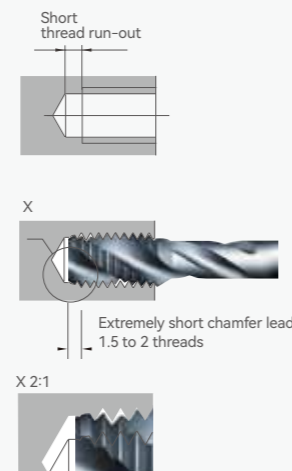
切削锥类型 Threading chamfer type

Form B		medium, 3.5 - 5.5 threads, with spiral point, for all through holes and deep tapping holes in medium and long-chipping materials
Form C		short, 2 - 3 threads for blind holes and generally for aluminium, grey cast iron and brass
Form D		medium, 3.5 - 5 threads for short through holes
Form E		extremely short, 1.5-2 threads, for blind holes with little run-out depth.

E型 切削锥选择 Selection of E-type Cutting Cone

除了传统的B型和C型丝锥外，我们越来越多地将E型工具纳入我们的标准范围。因此，在加工盲孔时，我们考虑到对丝锥的需求日益增长，在加工盲孔时，丝锥的螺纹应尽可能靠近孔底，在加工通孔时，丝锥的螺纹应尽可能深。

In addition to the conventional Form B and C for machine taps we are increasingly including Form E tools in our standard range. Thus, we are taking into account the increasing demand for taps with which threads can be produced as close as possible to the bottom of the bore when machining blind holes and to produce deepest threads as possible when machining through holes.

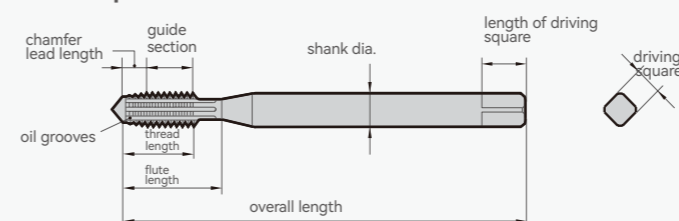


E型丝锥具有非常短的倒角引线，只有1.5到2个螺纹。在加工中心和攻丝夹头上，与B型和C型相比，刀具导向较短切削扭矩降低。采用了刚性工具夹持。E型丝锥在生产应用中，完全覆盖螺纹加工具有显著优势。

Type E taps have very short chamfered leads, with only 1.5 to 2 threads. In the machining center and tapping chuck, compared with B and C, the tool steering is shorter and the cutting torque is lower. Rigid tool clamping is adopted. In the production and application of E-type taps, the processing of fully covered threads has significant advantages.

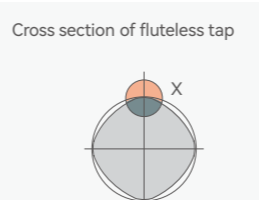
螺纹加工信息 Threading hole making

**螺纹部分
Thread portion**



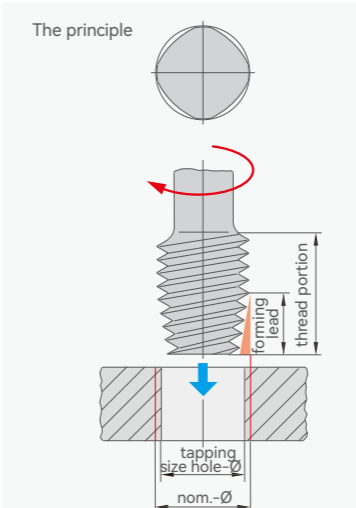
chamfer lead length, guide section, shank dia., length of driving square, oil grooves, thread length, flute length, overall length, driving square

Cross section of fluteless tap






detail x
D1 = flank diameter
D = nominal diameter

The principle

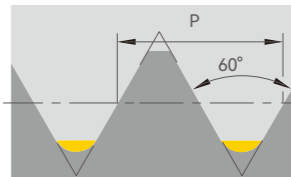
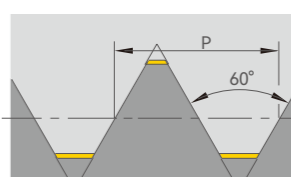
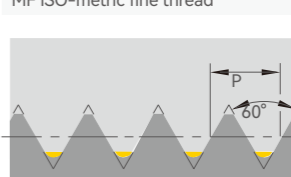
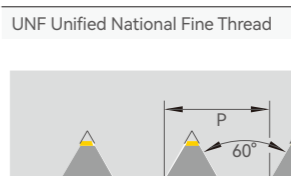
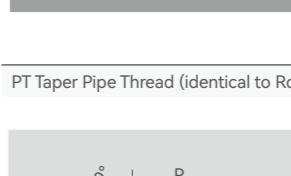


forming lead, thread portion, tapping size hole - Ø, nom.-Ø

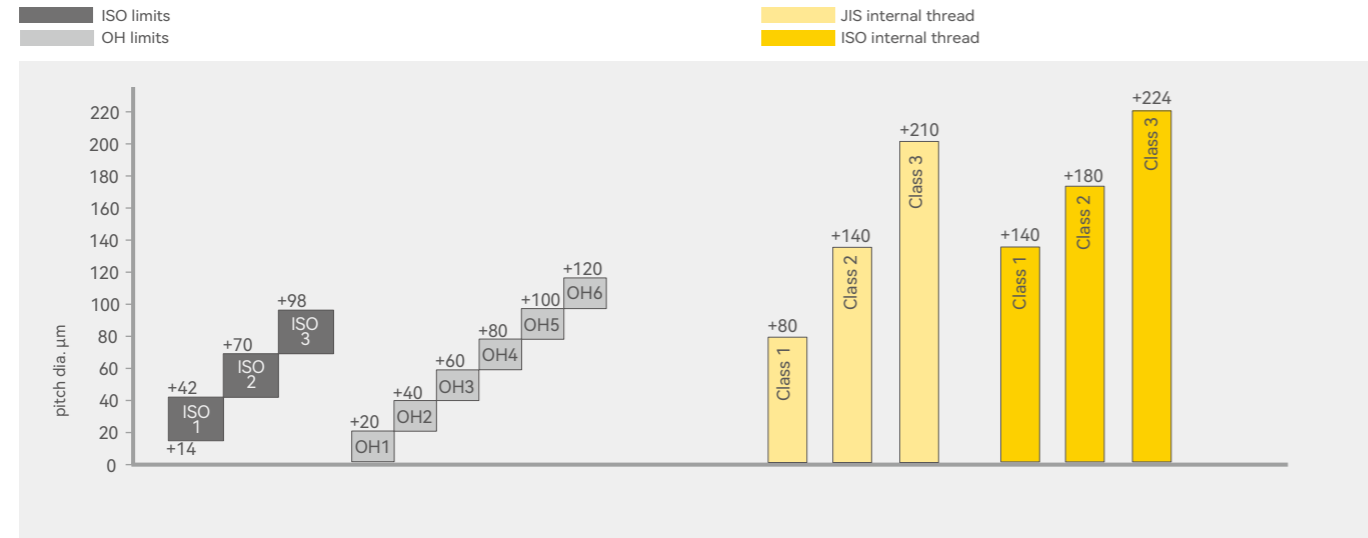
Types of tapping size hole

-  with fluteless taps without oil grooves for thread depth $\leq 1 \times D$
-  for thread depth $\geq 1 \times D$
-  with fluteless taps with oil grooves for all thread depths

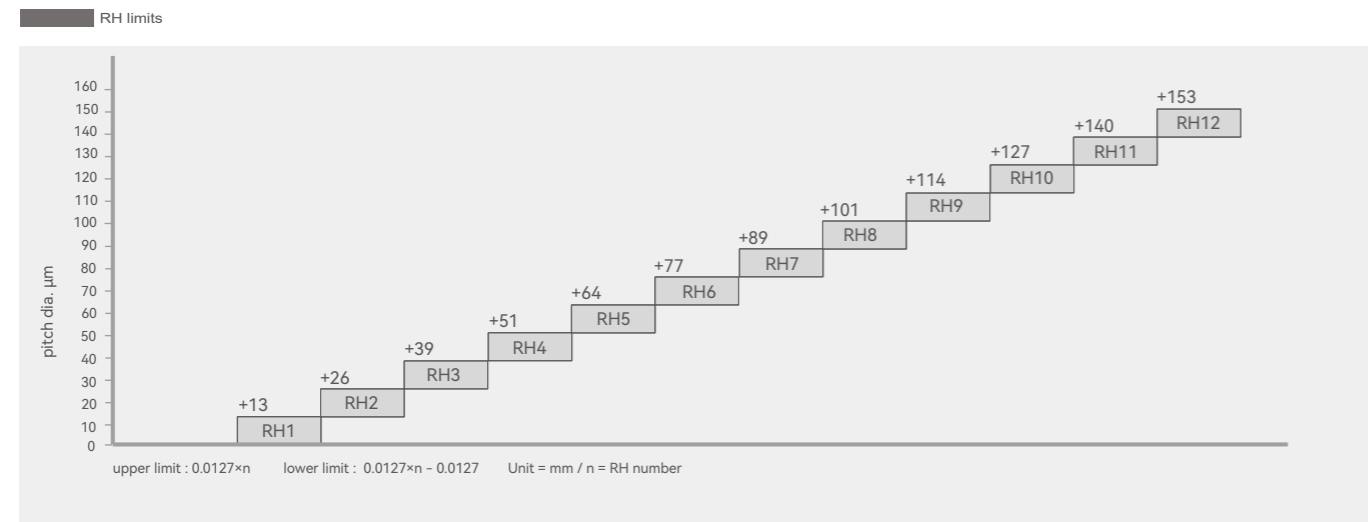
螺纹类型及特点 Types and characteristics

Geometry drawing	Standard	Application
	M ISO-metric thread	DIN 13-1 General standard thread
	UNC Unified National Coarse Thread	ASME B1.1 General UN standard thread
	MF ISO-metric fine thread	DIN 13-2 to DIN 13-11 General fine thread
	UNF Unified National Fine Thread	ASME B1.1 ISO-metric trapezoidal thread
	PT Taper Pipe Thread (identical to Rc and BSPT)	JIS B 0203 Japanese Industrial Standard Internal thread for pipe threads and fittings

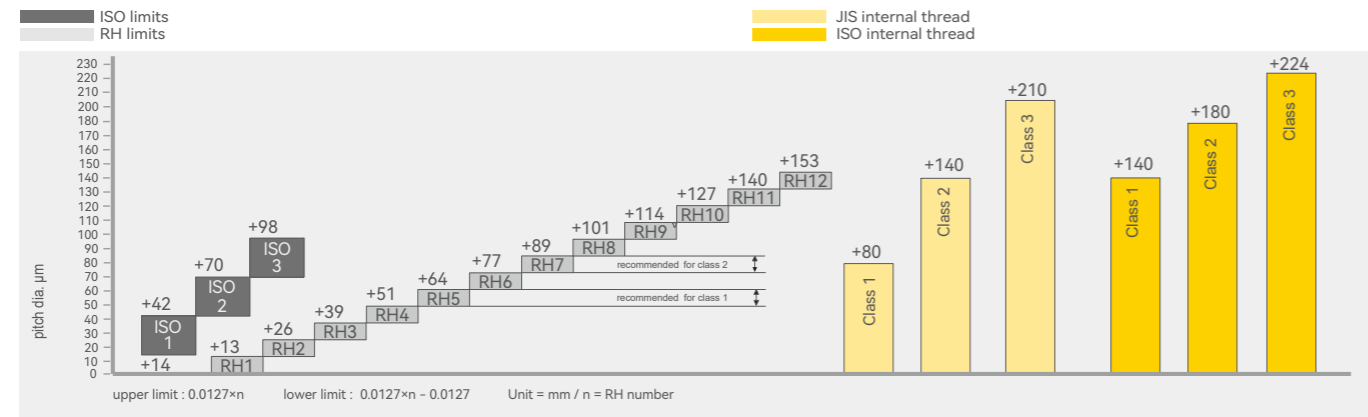
Example M10 (x 1.5)



挤压丝锥公差标准 RH limits for fluteless taps



Example M10 (x 1.5)



丝锥使用测试报告 Tap test report

丝锥类型 Tap type		<input type="checkbox"/> 螺旋槽 Spiral flute	<input type="checkbox"/> 直槽 Straight flute	<input type="checkbox"/> 涂层 coating	<input type="checkbox"/> 无涂层 uncoated
规格型号 Ordering code					
加工条件 Machining conditions	机床类型、制造商及功率大小: Machine, manufacturer and power:	<input type="checkbox"/> MK	<input type="checkbox"/> SK	<input type="checkbox"/> HSK	<input type="checkbox"/> TR <input type="checkbox"/> 其他
	主轴连接方式 Spindle connection mode	<input type="checkbox"/> DIN	<input type="checkbox"/> ANSI	<input type="checkbox"/> JIS	<input type="checkbox"/> 其他
	工作名称 Process	工件材料/描述 workpiece material / description			
	热处理方式 Heat treatment	抗拉强度 Tensile strength N/mm ²			
硬度 Hardness	延伸率 Elongation %				
加工工艺要求 Process requirements	加工方式选择 Processing mode	<input type="checkbox"/> 水平切削 Horizontal cutting	<input type="checkbox"/> 垂直切削 Vertical cutting	<input type="checkbox"/> 刀具旋转 Tool rotation	<input type="checkbox"/> 刀具静止 Tool stationary
	刀具寿命 Tool life	新品寿命 New product life _____	修磨重涂寿命 Service life of grinding and repainting _____		
	寿命判断 Tool change reason	<input type="checkbox"/> 负载 Load	<input type="checkbox"/> 表面质量 Surface quality	<input type="checkbox"/> 尺寸 Size	<input type="checkbox"/> 其他 Other
	切削参数 Cutting parameters	转速n Speed _____ min ⁻¹	线速度V _c Cutting speed _____ m/min		
进给方式 Feed mode	<input type="checkbox"/> 凸轮式 Cam-type	<input type="checkbox"/> 液压推动式 Sydraulic	<input type="checkbox"/> 丝杠式 Screw	<input type="checkbox"/> NC控制式 CNC	
	<input type="checkbox"/> 同步式 Synchronous	<input type="checkbox"/> 齿轮式 Gear type	<input type="checkbox"/> 其他 Other		
刀具夹紧方式 Tool clamping mode	<input type="checkbox"/> 弹簧夹头方式 ER collet	<input type="checkbox"/> 丝锥夹头方式 Tap collet mode	<input type="checkbox"/> 自动换向夹头方式 Automatic reversing collet mode	<input type="checkbox"/> 过载保护装置方式 Overload protection device mode	
	<input type="checkbox"/> 带长度补偿装置方式 With length compensation device	<input type="checkbox"/> 带轴向调整方式 With axial adjustment mode	<input type="checkbox"/> 带内冷传输方式 In band cooling transmission mode _____ bar		
润滑条件 Lubrication conditions	<input type="checkbox"/> 油 Oil	<input type="checkbox"/> 乳化液 Emulsion _____ %	<input type="checkbox"/> 干切削 Dry cutting	<input type="checkbox"/> 循环 Loop	
	<input type="checkbox"/> 润滑脂 Grease	<input type="checkbox"/> 少量润滑 Little lubrication	<input type="checkbox"/> 其他 Other		
加工过程 Processing	刀具品牌 Tool brand			零件或加工部位草图 Sketch of parts or machining parts	
	切削参数 cutting parameters	切削速度-v _m /min Cutting speed			
		转速-nr/min Rotating speed			
	进给量-v _f mm/min Feed rate				
结果 result	加工状态及质量 Processing state and quality	注: 加工失效时, 请注明加工失效时的 加工数量: <input type="checkbox"/> 件/ <input type="checkbox"/> 米			
	刀具使用寿命 Tool life				
结论及建议 Conclusion and advise					

