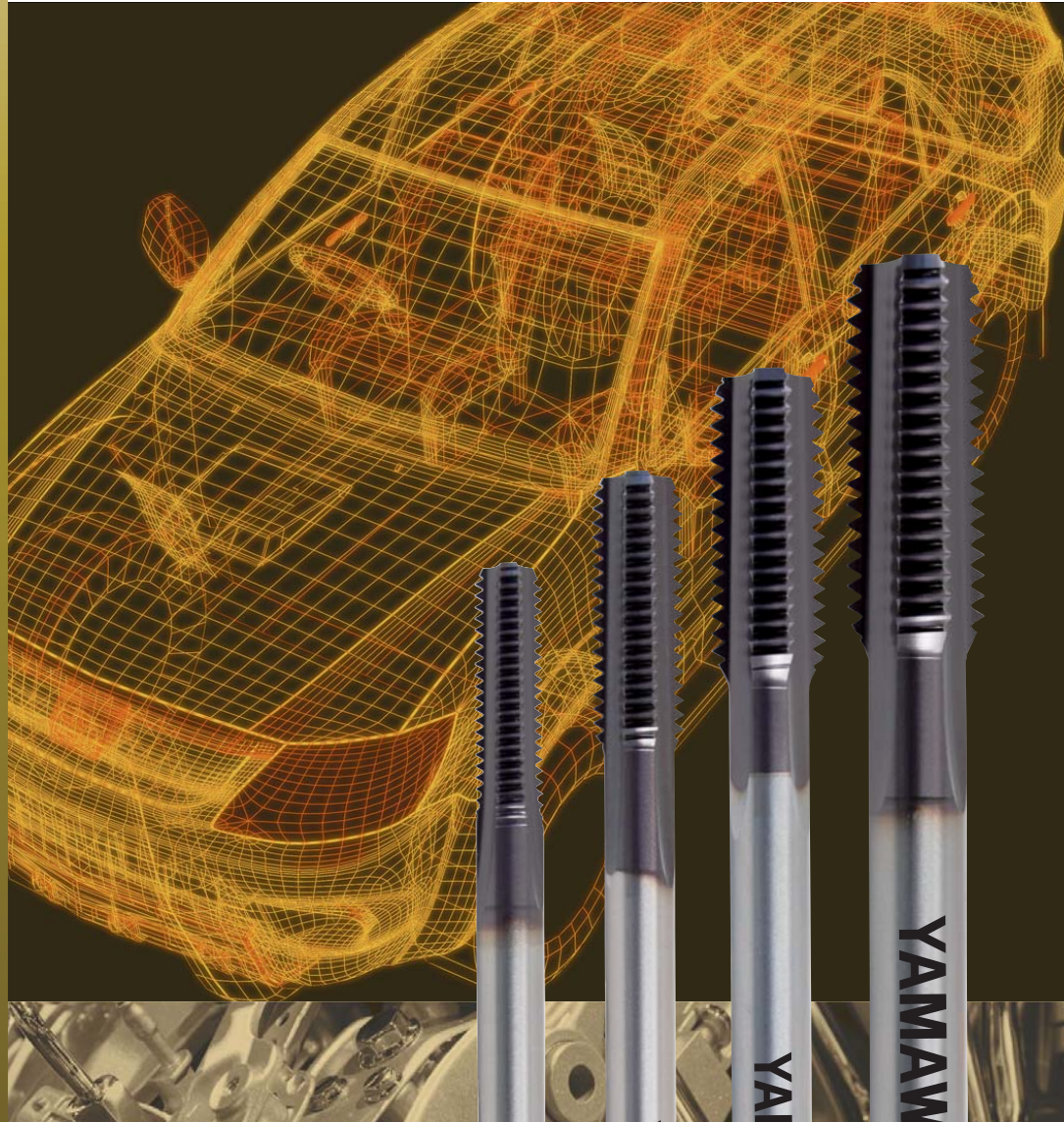


# MC-AD-CT

Better efficiency on blind hole tapping in such materials as aluminium die castings and aluminium alloy castings!  
YAMAWA introduces carbide tap with oil hole!

■ Carbide tap with oil hole ■

## MC-AD-CT



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Suitable for mass production on alluminium die-cast workpieces such as cylinder blockhead, transmission case and manifold water-pump.

## Tap features

### MC-AD-CT Carbide tap with oil hole



- Longer tool life at medium and high speed tapping

Combination of following 3 factors:

- ① special edge design to reduce chipping problems
- ② ultra fine grain carbide material for higher wear resistance
- ③ TiAlN coating for 5 times longer tool life than the previous taps designed for aluminium.

- Oil hole

Having center through hole design to correspond with such cutting conditions as inner coolant supply, mist coolant supply and cryogenic dry, oil hole taps work quite well removing remaining chips after boring and during tapping and avoiding welding trouble.

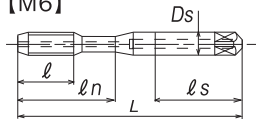
- The tap adopts ultra fine grain carbide with high wear resistance feature and TiAlN coating.
- MC-AD-CT taps are designed with chamfer length 1.5P to meet application's requirements.
- Due to long shank, MC-AD-CT taps are applicable for deep hole tapping.

Please use the machine which has synchronized tapping feed.

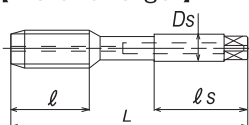
## Table of dimensions and sizes

### Dimensions

#### [M6]



#### [M8 and larger]



size	class	L	l	ln	ls	Ds	number of flutes	code
M6 X1	P3	100	19	28	50	6	3	MCADR6.0M1
M8 X1.25	P3	100	22	—	50	6.2	3	MCADR8.0N1
M10X1.5	P4	100	24	—	50	7	3	MCADS01001
M10X1.25	P4	100	22	—	50	7	3	MCADS010N1
M10X1	P4	100	19	—	50	7	3	MCADS010M1
M12X1.75	P4	100	30	—	50	8.5	3	MCADS012P1
M12X1.5	P4	100	24	—	50	8.5	3	MCADS012O1
M12X1.25	P4	100	22	—	50	8.5	3	MCADS012N1

Taps' accuracy classes do not always ensure the accuracy of internal screws.

## Tapping data



- part name : cylinder block
- material : ADC12
- size : M6×1
- hole shape : blind
- hole depth : 14 mm
- thread length : 12 mm
- machine : MC
- direction : horizontal
- feed : Synchronized feed
- tapping speed : 57 m/min
- cutting oil : water soluble oil
- tool life : 240,000 hole~

### Warning

- ◆ Tools may shatter. Wear cover or eye glasses 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.