



Test

We compared 3 different types of Yamawa taps on the same tapping application

The aim of this test is to compare the performance of the new Yamawa *Version Up* 9685X to the well known and extremely reliable Yamawa taps 9644X and 9645X.



9644X

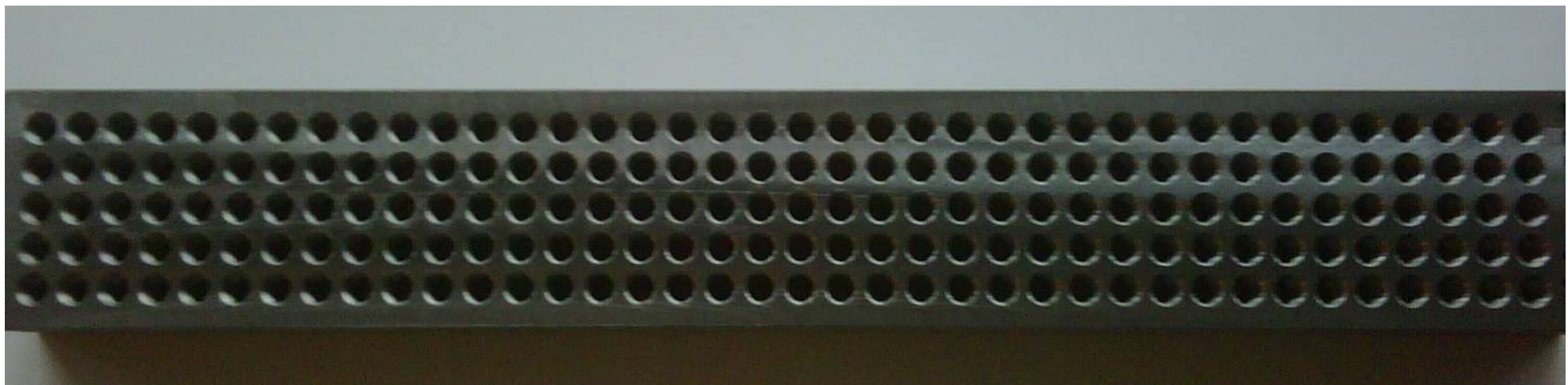


9645X



9685X **NEW** version **UP+**

Test workpiece

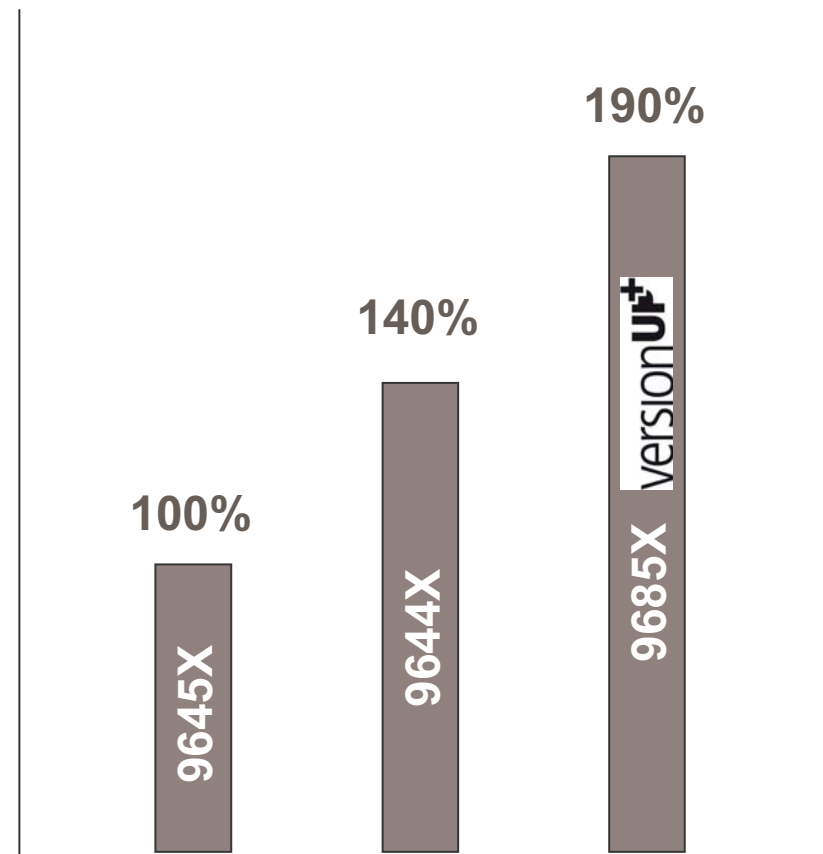




Test Report

Machine	CNC machining centre
Material	AISI 304
Coolant	Emulsion 8%
Tapping system	Synchro rigid
Direction	Vertical
Type of hole	Blind
Hole size	∅ 6,8 x 20 mm
Thread size	M8 x 16 mm
Cutting speed	8 m/min

Performance



Yamawa tap