

versionUP⁺

Moving into the future.

VERSION UP BLANK

- lower grinding allowance
- shorter time required for the grinding process
- closer tolerance tanks to innovative grinding process

VERSION UP SHANK

The shank tolerance of the VERSION UP taps is much closer than conventional taps, allowing a dramatic reduction of run-out and a consequently longer tool life.

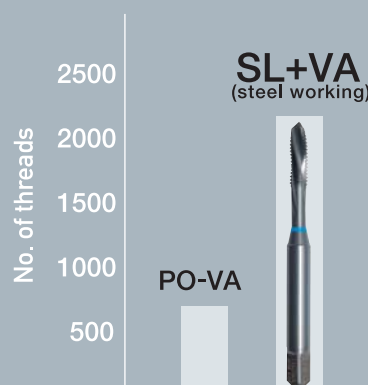
VERSION UP GEOMETRIES

The VERSION UP range presents highly innovative cutting geometries.

VERSION UP is the answer that Yamawa gives to the new requests of the market. Ensures longer tool life and higher cutting speed, for a dramatic productivity increase.



The VERSION UP range for blind holes features a 45° spiral fluted geometry, as well as optimized front and rake angles and margin for better chip ejection, lower torque and higher thread finishing.





The VERSION UP range for through holes, has been replaced by a 15° left hand spiral, able to push and eject the chips in the feed direction. This new geometry definitely ensures a more efficient chip ejection compared to traditional spiral pointed taps, allowing a 50% higher cutting speed.

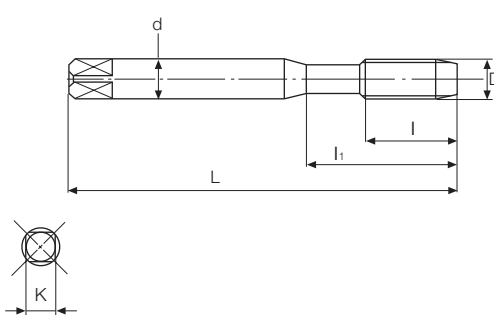








PLUS INCREASE IN TOOL LIFE, UP TO 100%

PLUS DRAMATIC REDUCTION IN THE COST PER HOLE

M
YMW
NORM

MATERIAL GROUP	Vc (m/min)	
		
1 - 2 - 3 - 4 - 5	8-20	5-15
9 - 10 - 11	8-20	5-15



GRUPPI MATERIALE / MATERIAL GROUPS WERKSTOFFEGRUPPE / GROUPES MATIÈRE									1-5	9-11	1-5	9-11	1-5	9-11	1-5	9-11
																
									HSSE	HSSE	HSSE	HSSE				
									OX	OX	OX	OX				
									ISO2X (6HX)	ISO2X (6HX)	ISO2 (6H)	ISO2 (6H)				
																
D	p	Ø	L	l	l1	d	k		Stock	Stock	Stock	Stock				
M	3	0.5	2.5	56	6,5	18	4		●		●					
	4	0.7	3.3	63	9	21	6		●		●					
	5	0.8	4.2	70	10,5	25	6		●		●					
	3	0.5	2.5	56	6,5	18	4	3		●		●				
	4	0.7	3.3	63	9	21	6	4,9		●		●				
	5	0.8	4.2	70	10,5	25	6	4,9		●		●				
	6	1	5	80	15	30	6	4,9		●		●				
	8	1.25	6.8	90	19	35	8	6,2		●		●				
	10	1.5	8.5	100	23	40	10	8		●		●				
	12	1.75	10.3	110	26	45	12	9		●		●				



M	3	~10	3	3	3	3
	12			3		4



VPM



VP



VPM



VP



Marcatura laser sul quadro per preservare la precisione del gambo.
Laser marking on the square to protect shank accuracy.
Lase Markierung auf der Vierkant um der Präzision der Schaft zu halten.
Marquage laser sur le carré pour préserver la précision de la queue.

SHANK TOLERANCE
CUTTING GEOMETRY
CUTTING SPEED
TOOL LIFE

PLUS