

JIS • ANSI • DIN

LINE UP

⑤ CEMENTED CARBIDE TAP SERIES



	JIS	ANSI	DIN
N-CT LA	⑤-3		
ZELX CARB AL		⑤-6	
CT LA			⑤-9
N-CT FC	⑤-10		
ZELX CARB CI		⑤-15	
LS-N-CT	⑤-18		
N-CT-SP	⑤-20		
N-CT-PO	⑤-21		
EH-CT	⑤-23		⑤-25
UH-CT	⑤-27		⑤-29
HFACT-P	⑤-31		
HFACT-B	⑤-33		
HFICT-P	⑤-35		
HFICT-B	⑤-37		
ACHSP	⑤-39		
MC-AD-CT	⑤-41		

Selection chart of taps

Tapping conditions		Machining, in low-speed tapping area									
Product symbol		LS-N-CT	N-CT FC	N-CT LA	N-CT-SP	N-CT-PO	EH-CT	UH-CT	ACHSP	MC-AD-CT	
Tap material Surface treatment		HF	HF	HF	HF	HF	HF Coating	HF Coating	HF Coating	HF Coating	
Name		Long, for cast iron	For cast iron	For light alloys	For general use, carbide		For high-hardness steel	For ultra high-hardness steel	For tapping aluminum cast holes	With oil hole	
											
Bored Hole Shape											
For Metric Threads		⑤-18	⑤-10	⑤-3	⑤-20	⑤-21	⑤-24	⑤-28	⑤-40	⑤-42	
For Unified Threads			⑤-13								
For Whitworth Threads											
For Screw Threads used on Sewing Machines											
Pipe Threads											
American Pipe Threads											
For Miniature Threads											
For Trapezoidal Threads											
~S25C		Low carbon steels									
S25C~S45C		Medium carbon steels									
S45C~		High carbon steels									
SCM		Alloy steels									
25~35HRC		Heat treated steel									
35~45HRC		Heat treated steel									
45~55HRC		Heat treated steel									
55~63HRC		Heat treated steel									
SUS		Stainless steels (SUS)									
SKD		Tool steels									
SC		Cast steels									
FC		Cast irons									
FCD		Ductile cast irons									
Cu		Copper									
Bs		Brass									
BsC		Brass castings									
PB		Bronze									
AL		Wrought aluminum									
AC, ADC		Aluminum alloy casting									
Mg		Magnesium alloy die castings									
ZDC		Zinc alloy die castings									
		Titanium alloys									
		Nickel base alloys									
		Thermosetting plastic									
		Thermoplastic resin									

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Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Premium Thread Mills

① Dies

Center Drills
Centering Tools

Precision Machinery/
Medical Surgical Instruments

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple inspection tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

JIS

⑤-3

N-CT LA

Carbide Taps for Light Alloys



Specification

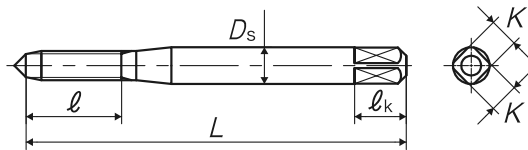


Tapping Speeds depending on Materials

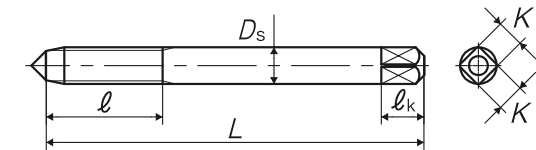
Aluminum alloy castings アルミ合金鑄物	Zinc alloy castings 亜鉛合金鑄物
10 ~ 20 (m/min)	10 ~ 20 (m/min)

■N-CT LA is the carbide tap suitable for tapping aluminum castings (AC), aluminum die castings (ADC), and zinc die castings (ZDC). For volume production.

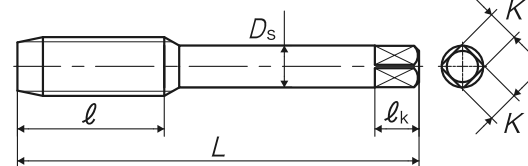
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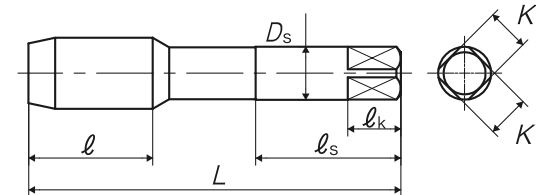
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TYPE:3



TYPE:4



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M1.4 × 0.3	P3	TCNR1.4C3A	3P	34	7	-	3	2.5	5	3	1	¥ 18,700 ※
M1.4 × 0.3	P3	TCNR1.4C1A	1.5P	34	7	-	3	2.5	5	3	1	¥ 18,700 ※
M1.6 × 0.35	P3	TCNR1.6D3A	3P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M1.6 × 0.35	P3	TCNR1.6D1A	1.5P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M1.7 × 0.35	P3	TCNR1.7D3A	3P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M1.7 × 0.35	P3	TCNR1.7D1A	1.5P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M2 × 0.4	P3	TCNR2.0E3A	3P	40	8	-	3	2.5	5	3	1	¥ 15,200
M2 × 0.4	P3	TCNR2.0E1A	1.5P	40	8	-	3	2.5	5	3	1	¥ 15,200
M2.2 × 0.45	P3	TCNR2.2F3A	3P	42	9.5	-	3	2.5	5	3	1	¥ 14,500 ※
M2.2 × 0.45	P3	TCNR2.2F1A	1.5P	42	9.5	-	3	2.5	5	3	1	¥ 14,500 ※
M2.3 × 0.4	P3	TCNR2.3E3A	3P	42	8	-	3	2.5	5	3	1	¥ 14,500 ※
M2.3 × 0.4	P3	TCNR2.3E1A	1.5P	42	8	-	3	2.5	5	3	1	¥ 14,500 ※
M2.5 × 0.45	P3	TCNR2.5F3A	3P	44	9.5	-	3	2.5	5	3	1	¥ 14,400 ※
M2.5 × 0.45	P3	TCNR2.5F1A	1.5P	44	9.5	-	3	2.5	5	3	1	¥ 14,400 ※
M2.6 × 0.45	P3	TCNR2.6F3A	3P	44	9.5	-	3	2.5	5	3	1	¥ 14,400 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

5

JIS

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M2.6 × 0.45	P3	TCNR2.6F1A	1.5P	44	9.5	-	3	2.5	5	3	1	¥ 14,400 ※
M3 × 0.5	P3	TCNR3.0G3A	3P	46	11	-	4	3.2	6	3	1	¥ 14,000
M3 × 0.5	P3	TCNR3.0G1A	1.5P	46	11	-	4	3.2	6	3	1	¥ 14,000
M3.5 × 0.6	P3	TCNR3.5H3A	3P	48	11	-	4	3.2	6	3	1	¥ 14,700 ※
M3.5 × 0.6	P3	TCNR3.5H1A	1.5P	48	11	-	4	3.2	6	3	1	¥ 14,700 ※
M4 × 0.7	P3	TCNR4.0I3A	3P	52	13	-	5	4	7	3	1	¥ 14,700
M4 × 0.7	P3	TCNR4.0I1A	1.5P	52	13	-	5	4	7	3	1	¥ 14,700
M4 × 0.5	P3	TCNR4.0G3A	3P	52	11	-	5	4	7	3	1	¥ 16,400 ※
M4 × 0.5	P3	TCNR4.0G1A	1.5P	52	11	-	5	4	7	3	1	¥ 16,400 ※
M5 × 0.8	P3	TCNR5.0K3A	3P	60	16	-	5.5	4.5	7	3	1	¥ 15,500
M5 × 0.8	P3	TCNR5.0K1A	1.5P	60	16	-	5.5	4.5	7	3	1	¥ 15,500
M5 × 0.5	P3	TCNR5.0G3A	3P	52	11	-	5.5	4.5	7	3	1	¥ 16,700 ※
M5 × 0.5	P3	TCNR5.0G1A	1.5P	52	11	-	5.5	4.5	7	3	1	¥ 16,700 ※
M6 × 1	P3	TCNR6.0M3A	3P	62	19	-	6	4.5	7	3	2	¥ 16,600
M6 × 1	P3	TCNR6.0M1A	1.5P	62	19	-	6	4.5	7	3	2	¥ 16,600
M6 × 0.75	P3	TCNR6.0J3A	3P	62	13	-	6	4.5	7	3	2	¥ 18,300 ※
M6 × 0.75	P3	TCNR6.0J1A	1.5P	62	13	-	6	4.5	7	3	2	¥ 18,300 ※
M6 × 0.5	P3	TCNR6.0G3A	3P	55	11	-	6	4.5	7	3	2	¥ 21,400 ※
M6 × 0.5	P3	TCNR6.0G1A	1.5P	55	11	-	6	4.5	7	3	2	¥ 21,400 ※
M7 × 1	P3	TCNR7.0M3A	3P	65	19	-	6.2	5	8	3	3	¥ 21,600 ※
M7 × 1	P3	TCNR7.0M1A	1.5P	65	19	-	6.2	5	8	3	3	¥ 21,600 ※
M7 × 0.75	P3	TCNR7.0J3A	3P	62	13	-	6.2	5	8	3	3	¥ 23,400 ※
M7 × 0.75	P3	TCNR7.0J1A	1.5P	62	13	-	6.2	5	8	3	3	¥ 23,400 ※
M8 × 1.25	P3	TCNR8.0N3A	3P	70	22	-	6.2	5	8	3	3	¥ 21,600
M8 × 1.25	P3	TCNR8.0N1A	1.5P	70	22	-	6.2	5	8	3	3	¥ 21,600
M8 × 1.25	P4	TCNS8.0N3A	3P	70	22	-	6.2	5	8	3	3	¥ 21,600 ※
M8 × 1.25	P4	TCNS8.0N1A	1.5P	70	22	-	6.2	5	8	3	3	¥ 21,600 ※
M8 × 1	P3	TCNR8.0M3A	3P	70	19	-	6.2	5	8	3	3	¥ 21,600
M8 × 1	P3	TCNR8.0M1A	1.5P	70	19	-	6.2	5	8	3	3	¥ 21,600
M8 × 0.75	P3	TCNR8.0J3A	3P	62	13	-	6.2	5	8	3	3	¥ 23,400 ※
M8 × 0.75	P3	TCNR8.0J1A	1.5P	62	13	-	6.2	5	8	3	3	¥ 23,400 ※
M10 × 1.5	P3	TCNR010O3A	3P	75	24	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1.5	P3	TCNR010O1A	1.5P	75	24	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1.5	P4	TCNS010O3A	3P	75	24	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1.5	P4	TCNS010O1A	1.5P	75	24	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1.25	P3	TCNR010N3A	3P	75	22	-	7	5.5	8	3	3	¥ 29,300
M10 × 1.25	P3	TCNR010N1A	1.5P	75	22	-	7	5.5	8	3	3	¥ 29,300
M10 × 1.25	P4	TCNS010N3A	3P	75	22	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1.25	P4	TCNS010N1A	1.5P	75	22	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1	P3	TCNR010M3A	3P	70	19	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1	P3	TCNR010M1A	1.5P	70	19	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1	P4	TCNS010M3A	3P	70	19	-	7	5.5	8	3	3	¥ 29,300 ※
M10 × 1	P4	TCNS010M1A	1.5P	70	19	-	7	5.5	8	3	3	¥ 29,300 ※
M12 × 1.75	P3	TCNR012P3A	3P	82	30	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.75	P3	TCNR012P1A	1.5P	82	30	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.75	P4	TCNS012P3A	3P	82	30	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.75	P4	TCNS012P1A	1.5P	82	30	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.5	P3	TCNR012O3A	3P	82	24	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.5	P3	TCNR012O1A	1.5P	82	24	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.5	P4	TCNS012O3A	3P	82	24	-	8.5	6.5	9	3	3	¥ 38,900 ※

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

JIS

⑤-4

※ = Specified Distribution Items. Made to order products.

 Think threads with
YAMAWA

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

JIS

N-CT LA Carbide Taps for Light Alloys

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M12 × 1.5	P4	TCNS012O1A	1.5P	82	24	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.25	P3	TCNR012N3A	3P	80	22	-	8.5	6.5	9	3	3	¥ 38,900
M12 × 1.25	P3	TCNR012N1A	1.5P	80	22	-	8.5	6.5	9	3	3	¥ 38,900
M12 × 1.25	P4	TCNS012N3A	3P	80	22	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1.25	P4	TCNS012N1A	1.5P	80	22	-	8.5	6.5	9	3	3	¥ 38,900 ※
M12 × 1	P3	TCNR012M3A	3P	70	19	-	8.5	6.5	9	3	3	¥ 42,900 ※
M12 × 1	P3	TCNR012M1A	1.5P	70	19	-	8.5	6.5	9	3	3	¥ 42,900 ※
M14 × 2	P3	TCNR014Q3A	3P	88	30	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 2	P3	TCNR014Q1A	1.5P	88	30	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 2	P4	TCNS014Q3A	3P	88	30	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 2	P4	TCNS014Q1A	1.5P	88	30	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 1.5	P3	TCNR014O3A	3P	88	24	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 1.5	P3	TCNR014O1A	1.5P	88	24	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 1.5	P4	TCNS014O3A	3P	88	24	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 1.5	P4	TCNS014O1A	1.5P	88	24	34	10.5	8	11	4	4	¥ 40,200 ※
M14 × 1.25	P3	TCNR014N3A	3P	88	22	34	10.5	8	11	4	4	¥ 43,900 ※
M14 × 1.25	P3	TCNR014N1A	1.5P	88	22	34	10.5	8	11	4	4	¥ 43,900 ※
M14 × 1	P3	TCNR014M3A	3P	70	19	37	10.5	8	11	4	4	¥ 43,900 ※
M14 × 1	P3	TCNR014M1A	1.5P	70	19	37	10.5	8	11	4	4	¥ 43,900 ※
M14 × 1	P4	TCNS014M3A	3P	70	19	37	10.5	8	11	4	4	¥ 43,900 ※
M14 × 1	P4	TCNS014M1A	1.5P	70	19	37	10.5	8	11	4	4	¥ 43,900 ※
M16 × 2	P4	TCNS016Q3A	3P	95	30	37	12.5	10	13	4	4	¥ 48,900 ※
M16 × 2	P4	TCNS016Q1A	1.5P	95	30	37	12.5	10	13	4	4	¥ 48,900 ※
M16 × 1.5	P3	TCNR016O3A	3P	95	24	37	12.5	10	13	4	4	¥ 48,900 ※
M16 × 1.5	P3	TCNR016O1A	1.5P	95	24	37	12.5	10	13	4	4	¥ 48,900 ※
M16 × 1.5	P4	TCNS016O3A	3P	95	24	37	12.5	10	13	4	4	¥ 48,900 ※
M16 × 1.5	P4	TCNS016O1A	1.5P	95	24	37	12.5	10	13	4	4	¥ 48,900 ※
M16 × 1	P3	TCNR016M3A	3P	75	19	41	12.5	10	13	4	4	¥ 52,200 ※
M16 × 1	P3	TCNR016M1A	1.5P	75	19	41	12.5	10	13	4	4	¥ 52,200 ※
M18 × 2.5	P4	TCNS018R3A	3P	100	35	38	14	11	14	4	4	¥ 57,600 ※
M18 × 2.5	P4	TCNS018R1A	1.5P	100	35	38	14	11	14	4	4	¥ 57,600 ※
M18 × 1.5	P4	TCNS018O3A	3P	95	24	43	14	11	14	4	4	¥ 57,600 ※
M18 × 1.5	P4	TCNS018O1A	1.5P	95	24	43	14	11	14	4	4	¥ 57,600 ※
M20 × 2.5	P4	TCNS020R3A	3P	105	35	41	15	12	15	4	4	¥ 67,900 ※
M20 × 2.5	P4	TCNS020R1A	1.5P	105	35	41	15	12	15	4	4	¥ 67,900 ※
M20 × 1.5	P4	TCNS020O3A	3P	95	24	43	15	12	15	4	4	¥ 67,900 ※
M20 × 1.5	P4	TCNS020O1A	1.5P	95	24	43	15	12	15	4	4	¥ 67,900 ※

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

JIS

⑤-5

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

5

ANSI

ANSI

ZELX CARB AL

Carbide Taps for Light Alloys



Specification



■ZELX CARB AL is the carbide tap suitable for tapping aluminum castings (AC), aluminum die castings (ADC), and zinc die castings(ZDC). For volume production.

Tapping Speed depending on Materials

Aluminum alloy castings アルミ合金鑄物	Zinc alloy castings 亜鉛合金鑄物
10 ~ 20 (m/min)	10 ~ 20 (m/min)

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

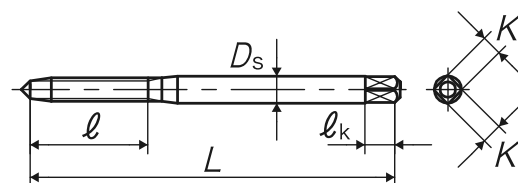
Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

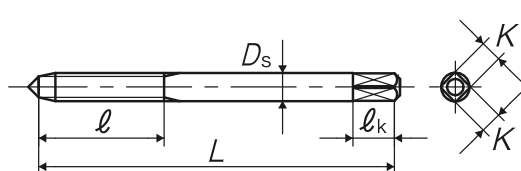
ANSI

⑤-6

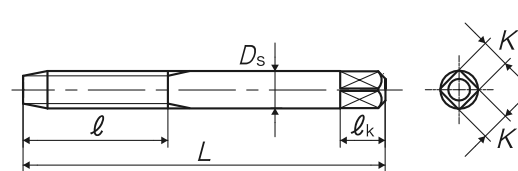
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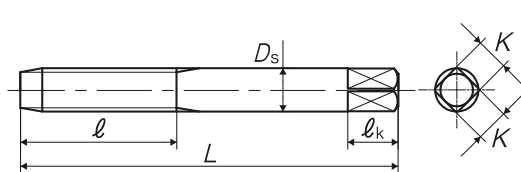
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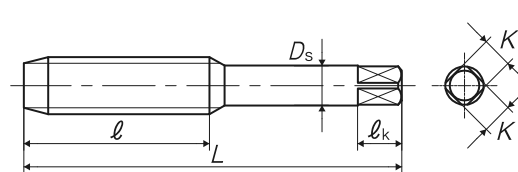
TYPE: 3



TYPE: 4



TYPE: 5



Segment : 1L

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Metric Threads										
M3 × 0.5	D3	Y71000	4P	1.937	0.625	0.141	0.11	0.187	3	1
M3 × 0.5	D3	Y71001	1.5P	1.937	0.625	0.141	0.11	0.187	3	1
M4 × 0.7	D4	Y71002	4P	2.125	0.75	0.168	0.131	0.25	3	2
M4 × 0.7	D4	Y71003	1.5P	2.125	0.75	0.168	0.131	0.25	3	2
M5 × 0.8	D4	Y71004	4P	2.375	0.875	0.194	0.152	0.25	3	2
M5 × 0.8	D4	Y71005	1.5P	2.375	0.875	0.194	0.152	0.25	3	2
M6 × 1	D5	Y71006	4P	2.5	1	0.255	0.191	0.312	3	3
M6 × 1	D5	Y71007	1.5P	2.5	1	0.255	0.191	0.312	3	3
M8 × 1.25	D5	Y71010	4P	2.718	1.125	0.318	0.238	0.375	3	4

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

ANSI

ZELX CARB AL Carbide Taps for Light Alloys

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M8 × 1.25	D5	Y71011	1.5P	2.718	1.125	0.318	0.238	0.375	3	4
M8 × 1	D5	Y71008	4P	2.718	1.125	0.318	0.238	0.375	3	4
M8 × 1	D5	Y71009	1.5P	2.718	1.125	0.318	0.238	0.375	3	4
M10 × 1.5	D6	Y71014	4P	2.937	1.25	0.381	0.286	0.437	3	4
M10 × 1.5	D6	Y71015	1.5P	2.937	1.25	0.381	0.286	0.437	3	4
M10 × 1.25	D5	Y71012	4P	2.937	1.25	0.381	0.286	0.437	3	4
M10 × 1.25	D5	Y71013	1.5P	2.937	1.25	0.381	0.286	0.437	3	4
M12 × 1.75	D6	Y71020	4P	3.375	1.656	0.367	0.275	0.437	3	5
M12 × 1.75	D6	Y71021	1.5P	3.375	1.656	0.367	0.275	0.437	3	5
M12 × 1.5	D6	Y71018	4P	3.375	1.656	0.367	0.275	0.437	3	5
M12 × 1.5	D6	Y71019	1.5P	3.375	1.656	0.367	0.275	0.437	3	5
M12 × 1.25	D5	Y71016	4P	3.375	1.656	0.367	0.275	0.437	3	5
M12 × 1.25	D5	Y71017	1.5P	3.375	1.656	0.367	0.275	0.437	3	5
For Unified Threads										
No.5-40UNC	GH3	Y84800	4P	1.937	0.625	0.141	0.11	0.187	3	1
No.5-40UNC	GH3	Y84801	1.5P	1.937	0.625	0.141	0.11	0.187	3	1
No.6-32UNC	GH3	Y84802	4P	2	0.687	0.141	0.11	0.187	3	2
No.6-32UNC	GH3	Y84803	1.5P	2	0.687	0.141	0.11	0.187	3	2
No.8-32UNC	GH3	Y84804	4P	2.125	0.75	0.168	0.131	0.25	3	2
No.8-32UNC	GH3	Y84805	1.5P	2.125	0.75	0.168	0.131	0.25	3	2
No.10-24UNC	GH3	Y84806	4P	2.375	0.875	0.194	0.152	0.25	3	2
No.10-24UNC	GH3	Y84807	1.5P	2.375	0.875	0.194	0.152	0.25	3	2
No.10-32UNF	GH3	Y84808	4P	2.375	0.875	0.194	0.152	0.25	3	2
No.10-32UNF	GH3	Y84809	1.5P	2.375	0.875	0.194	0.152	0.25	3	2
1/4-20UNC	GH3	Y84810	4P	2.5	1	0.255	0.191	0.312	3	3
1/4-20UNC	GH3	Y84811	1.5P	2.5	1	0.255	0.191	0.312	3	3
1/4-20UNC	GH5	Y84860	4P	2.5	1	0.255	0.191	0.312	3	3
1/4-20UNC	GH5	Y84861	1.5P	2.5	1	0.255	0.191	0.312	3	3
1/4-28UNF	GH3	Y84812	4P	2.5	1	0.255	0.191	0.312	3	3
1/4-28UNF	GH3	Y84813	1.5P	2.5	1	0.255	0.191	0.312	3	3
1/4-28UNF	GH5	Y84862	4P	2.5	1	0.255	0.191	0.312	3	3
1/4-28UNF	GH5	Y84863	1.5P	2.5	1	0.255	0.191	0.312	3	3
5/16-18UNC	GH3	Y84814	4P	2.718	1.125	0.318	0.238	0.375	3	4
5/16-18UNC	GH3	Y84815	1.5P	2.718	1.125	0.318	0.238	0.375	3	4
5/16-18UNC	GH5	Y84864	4P	2.718	1.125	0.318	0.238	0.375	3	4
5/16-18UNC	GH5	Y84865	1.5P	2.718	1.125	0.318	0.238	0.375	3	4
5/16-24UNF	GH3	Y84816	4P	2.718	1.125	0.318	0.238	0.375	3	4
5/16-24UNF	GH3	Y84817	1.5P	2.718	1.125	0.318	0.238	0.375	3	4
5/16-24UNF	GH5	Y84866	4P	2.718	1.125	0.318	0.238	0.375	3	4
5/16-24UNF	GH5	Y84867	1.5P	2.718	1.125	0.318	0.238	0.375	3	4
3/8-16UNC	GH3	Y84818	4P	2.937	1.25	0.381	0.286	0.437	3	4
3/8-16UNC	GH3	Y84819	1.5P	2.937	1.25	0.381	0.286	0.437	3	4
3/8-16UNC	GH5	Y84868	4P	2.937	1.25	0.381	0.286	0.437	3	4
3/8-16UNC	GH5	Y84869	1.5P	2.937	1.25	0.381	0.286	0.437	3	4
3/8-24UNF	GH3	Y84820	4P	2.937	1.25	0.381	0.286	0.437	3	4
3/8-24UNF	GH3	Y84821	1.5P	2.937	1.25	0.381	0.286	0.437	3	4
3/8-24UNF	GH5	Y84870	4P	2.937	1.25	0.381	0.286	0.437	3	4
3/8-24UNF	GH5	Y84871	1.5P	2.937	1.25	0.381	0.286	0.437	3	4
7/16-14UNC	GH3	Y84822	4P	3.156	1.437	0.323	0.242	0.406	3	5
7/16-14UNC	GH3	Y84823	1.5P	3.156	1.437	0.323	0.242	0.406	3	5

ANSI

⑤-7

Think threads with
YAMAWA

· This product is different from JIS products in shape and dimensions, please be careful when using.

①
Spiral Fluted Taps
(for blind hole)

②
Spiral Fluted Taps
(for through hole)

③
Spiral Pointed Taps
(for through hole)

④
Hand Taps

⑤
Cemented Carbide Taps

⑥
Roll Taps

⑦
Special Thread Taps
Simple Inspection tools

⑧
Pipe Taps

⑨
Thread Mills
Premium Thread Mills

⑩
Dies

⑪
Center Drills
Centering Tools

⑫
Precision Machinery/
Medical Surgical Instruments

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

5

ANSI

ZELX CARB AL Carbide Taps for Light Alloys

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
7/16-14UNC	GH5	Y84872	4P	3.156	1.437	0.323	0.242	0.406	3	5
7/16-14UNC	GH5	Y84873	1.5P	3.156	1.437	0.323	0.242	0.406	3	5
7/16-20UNF	GH3	Y84824	4P	3.156	1.437	0.323	0.242	0.406	3	5
7/16-20UNF	GH3	Y84825	1.5P	3.156	1.437	0.323	0.242	0.406	3	5
7/16-20UNF	GH5	Y84874	4P	3.156	1.437	0.323	0.242	0.406	3	5
7/16-20UNF	GH5	Y84875	1.5P	3.156	1.437	0.323	0.242	0.406	3	5
1/2-13UNC	GH3	Y84826	4P	3.375	1.656	0.367	0.275	0.437	3	5
1/2-13UNC	GH3	Y84827	1.5P	3.375	1.656	0.367	0.275	0.437	3	5
1/2-13UNC	GH5	Y84876	4P	3.375	1.656	0.367	0.275	0.437	3	5
1/2-13UNC	GH5	Y84877	1.5P	3.375	1.656	0.367	0.275	0.437	3	5
1/2-20UNF	GH3	Y84828	4P	3.375	1.656	0.367	0.275	0.437	3	5
1/2-20UNF	GH3	Y84829	1.5P	3.375	1.656	0.367	0.275	0.437	3	5
1/2-20UNF	GH5	Y84878	4P	3.375	1.656	0.367	0.275	0.437	3	5
1/2-20UNF	GH5	Y84879	1.5P	3.375	1.656	0.367	0.275	0.437	3	5

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

ANSI

⑤-8

⑤ Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_s	Ds	K	ℓ_k

DIN

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

DIN

CT LA

Carbide Taps for Light Alloys



Specification



■CT LA is the carbide tap suitable for tapping aluminum castings (AC), aluminum die castings (ADC), and zinc die castings (ZDC). For volume production.

Tapping Speeds depending on Materials

Aluminum alloy castings アルミ合金鑄物	Zinc alloy castings 亜鉛合金鑄物
10 ~ 20 (m/min)	10 ~ 20 (m/min)

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection tools

⑧ Pipe Taps

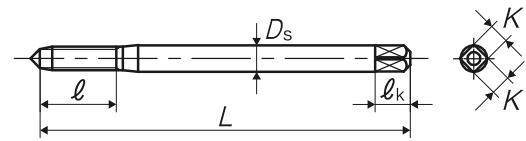
⑨ Thread Mills
Premium Thread Mills

⑩ Dies

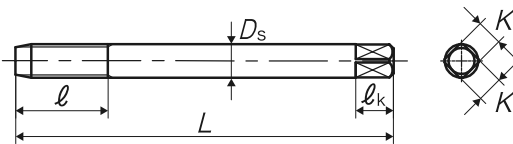
⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

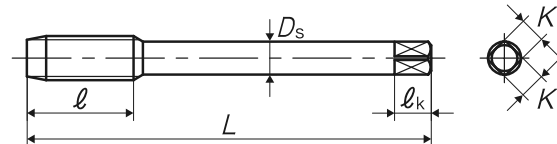
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TYPE: 2



TYPE: 3



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads											
M3 × 0.5	ISO2X	TD3.0GBLWB3	3P	56	11	-	3.5	2.7	6	3	1
M4 × 0.7	ISO2X	TD4.0IBLWB3	3P	63	13	-	4.5	3.4	6	3	1
M5 × 0.8	ISO2X	TD5.0KBLWB3	3P	70	16	-	6	4.9	8	3	1
M6 × 1	ISO2X	TD6.0MBLWB3	3P	80	19	-	6	4.9	8	3	1
M8 × 1.25	ISO2X	TD8.0KBLWB3	3P	90	22	-	8	6.2	9	3	2
M10 × 1.5	ISO2X	TD10.0OBLWB3	3P	100	24	-	10	8	11	3	2
M12 × 1.75	ISO2X	TG012PBLWB3	3P	110	29	-	9	7	10	3	3

DIN

⑤-9

Think threads with
YAMAWA

・ This product is different from JIS products in shape and dimensions, please be careful when using.

Cemented Carbide Tap Series

JIS

N-CT FC

Carbide Taps for Cast Irons

Specification

HF



■N-CT FC is the carbide tap suitable for hard and abrasive materials such as cast irons. For volume production.

Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~15
(m/min)

Ductile cast irons
強靱鑄鉄
5~15
(m/min)

Brass castings
黄銅鑄物
5~15
(m/min)

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk



5

JIS

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

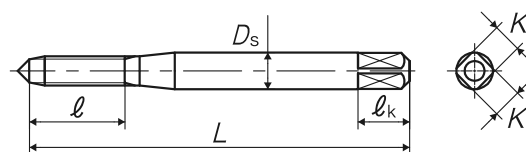
Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

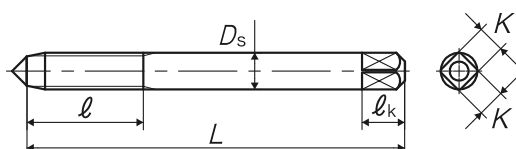
JIS

⑤-10

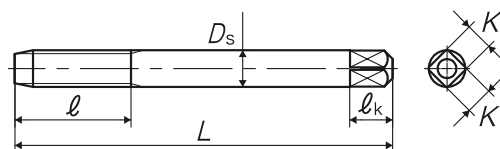
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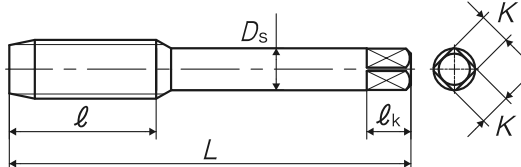
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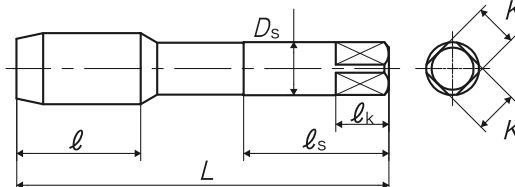
TYPE: 3



TYPE: 4



TYPE: 5



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M1.4 × 0.3	P3	TCNR1.4C3	3P	34	7	-	3	2.5	5	3	1	¥ 18,700 ※
M1.4 × 0.3	P3	TCNR1.4C1	1.5P	34	7	-	3	2.5	5	3	1	¥ 18,700 ※
M1.6 × 0.35	P3	TCNR1.6D3	3P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M1.6 × 0.35	P3	TCNR1.6D1	1.5P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M1.7 × 0.35	P3	TCNR1.7D3	3P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M1.7 × 0.35	P3	TCNR1.7D1	1.5P	36	8	-	3	2.5	5	3	1	¥ 16,600 ※
M2 × 0.4	P3	TCNR2.0E3	3P	40	8	-	3	2.5	5	3	1	¥ 15,200
M2 × 0.4	P3	TCNR2.0E1	1.5P	40	8	-	3	2.5	5	3	1	¥ 15,200
M2.2 × 0.45	P3	TCNR2.2F3	3P	42	9.5	-	3	2.5	5	3	1	¥ 14,500 ※

※ = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

JIS

N-CT FC Carbide Taps for Cast Irons

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
① Spiral Fluted Taps (for blind hole)	M2.2 × 0.45	P3	TCNR2.2F1	1.5P	42	9.5	-	3	2.5	5	3	1	¥ 14,500 ※
	M2.3 × 0.4	P3	TCNR2.3E3	3P	42	8	-	3	2.5	5	3	1	¥ 14,500 ※
	M2.3 × 0.4	P3	TCNR2.3E1	1.5P	42	8	-	3	2.5	5	3	1	¥ 14,500 ※
② Spiral Fluted Taps (for through hole)	M2.5 × 0.45	P3	TCNR2.5F3	3P	44	9.5	-	3	2.5	5	3	1	¥ 14,400 ※
	M2.5 × 0.45	P3	TCNR2.5F1	1.5P	44	9.5	-	3	2.5	5	3	1	¥ 14,400 ※
	M2.6 × 0.45	P3	TCNR2.6F3	3P	44	9.5	-	3	2.5	5	3	1	¥ 14,400
③ Spiral Pointed Taps (for through hole)	M2.6 × 0.45	P3	TCNR2.6F1	1.5P	44	9.5	-	3	2.5	5	3	1	¥ 14,400
	M3 × 0.5	P3	TCNR3.0G3	3P	46	11	-	4	3.2	6	3	1	¥ 14,000
	M3 × 0.5	P3	TCNR3.0G1	1.5P	46	11	-	4	3.2	6	3	1	¥ 14,000
④ Hand Taps	M3 × 0.35	P3	TCNR3.0D3	3P	46	8	-	4	3.2	6	3	1	¥ 16,400 ※
	M3 × 0.35	P3	TCNR3.0D1	1.5P	46	8	-	4	3.2	6	3	1	¥ 16,400 ※
	M3.5 × 0.6	P3	TCNR3.5H3	3P	48	11	-	4	3.2	6	3	1	¥ 14,700
⑤ Cemented Carbide Taps	M3.5 × 0.6	P3	TCNR3.5H1	1.5P	48	11	-	4	3.2	6	3	1	¥ 14,700
	M4 × 0.7	P3	TCNR4.0I3	3P	52	13	-	5	4	7	4	1	¥ 14,700
	M4 × 0.7	P3	TCNR4.0I1	1.5P	52	13	-	5	4	7	4	1	¥ 14,700
⑥ Roll Taps	M4 × 0.5	P3	TCNR4.0G3	3P	52	11	-	5	4	7	4	1	¥ 16,400 ※
	M4 × 0.5	P3	TCNR4.0G1	1.5P	52	11	-	5	4	7	4	1	¥ 16,400 ※
	M5 × 0.8	P3	TCNR5.0K3	3P	60	16	-	5.5	4.5	7	4	1	¥ 15,500
⑦ Special Thread Taps Simple Inspection Tools	M5 × 0.8	P3	TCNR5.0K1	1.5P	60	16	-	5.5	4.5	7	4	1	¥ 15,500
	M5 × 0.5	P3	TCNR5.0G3	3P	52	11	-	5.5	4.5	7	4	1	¥ 16,700 ※
	M5 × 0.5	P3	TCNR5.0G1	1.5P	52	11	-	5.5	4.5	7	4	1	¥ 16,700 ※
⑧ Pipe Taps	M6 × 1	P3	TCNR6.0M3	3P	62	19	-	6	4.5	7	4	2	¥ 16,600
	M6 × 1	P3	TCNR6.0M3F	3P	62	19	-	6	4.5	7	4	3	¥ 16,600
	M6 × 1	P3	TCNR6.0M1	1.5P	62	19	-	6	4.5	7	4	2	¥ 16,600
⑨ Thread Mills Premium Thread Mills	M6 × 1	P3	TCNR6.0M1F	1.5P	62	19	-	6	4.5	7	4	3	¥ 16,600
	M6 × 0.75	P3	TCNR6.0J3	3P	62	13	-	6	4.5	7	4	2	¥ 18,300
	M6 × 0.75	P3	TCNR6.0J1	1.5P	62	13	-	6	4.5	7	4	2	¥ 18,300
⑩ Dies	M6 × 0.5	P3	TCNR6.0G3	3P	55	11	-	6	4.5	7	4	2	¥ 21,400 ※
	M6 × 0.5	P3	TCNR6.0G1	1.5P	55	11	-	6	4.5	7	4	2	¥ 21,400 ※
	M7 × 1	P3	TCNR7.0M3	3P	65	19	-	6.2	5	8	4	4	¥ 21,600
⑪ Center Drills Centering Tools	M7 × 1	P3	TCNR7.0M1	1.5P	65	19	-	6.2	5	8	4	4	¥ 21,600
	M7 × 0.75	P3	TCNR7.0J3	3P	62	13	-	6.2	5	8	4	4	¥ 23,400 ※
	M7 × 0.75	P3	TCNR7.0J1	1.5P	62	13	-	6.2	5	8	4	4	¥ 23,400 ※
⑫ Precision Machinery/ Medical Surgical Instruments	M8 × 1.25	P3	TCNR8.0N3	3P	70	22	-	6.2	5	8	4	4	¥ 21,600
	M8 × 1.25	P3	TCNR8.0N1	1.5P	70	22	-	6.2	5	8	4	4	¥ 21,600
	M8 × 1.25	P4	TCNS8.0N3	3P	70	22	-	6.2	5	8	4	4	¥ 21,600 ※
	M8 × 1.25	P4	TCNS8.0N1	1.5P	70	22	-	6.2	5	8	4	4	¥ 21,600 ※
	M8 × 1	P3	TCNR8.0M3	3P	70	19	-	6.2	5	8	4	4	¥ 21,600
	M8 × 1	P3	TCNR8.0M1	1.5P	70	19	-	6.2	5	8	4	4	¥ 21,600
	M8 × 0.75	P3	TCNR8.0J3	3P	62	13	-	6.2	5	8	4	4	¥ 23,400 ※
	M8 × 0.75	P3	TCNR8.0J1	1.5P	62	13	-	6.2	5	8	4	4	¥ 23,400 ※
	M10 × 1.5	P3	TCNR010O3	3P	75	24	-	7	5.5	8	4	4	¥ 29,300
	M10 × 1.5	P3	TCNR010O1	1.5P	75	24	-	7	5.5	8	4	4	¥ 29,300
	M10 × 1.5	P4	TCNS010O3	3P	75	24	-	7	5.5	8	4	4	¥ 29,300 ※
	M10 × 1.5	P4	TCNS010O1	1.5P	75	24	-	7	5.5	8	4	4	¥ 29,300 ※
	M10 × 1.25	P3	TCNR010N3	3P	75	22	-	7	5.5	8	4	4	¥ 29,300
	M10 × 1.25	P3	TCNR010N1	1.5P	75	22	-	7	5.5	8	4	4	¥ 29,300
	M10 × 1.25	P4	TCNS010N3	3P	75	22	-	7	5.5	8	4	4	¥ 29,300 ※
	M10 × 1.25	P4	TCNS010N1	1.5P	75	22	-	7	5.5	8	4	4	¥ 29,300 ※
	M10 × 1	P3	TCNR010M3	3P	70	19	-	7	5.5	8	4	4	¥ 29,300

JIS

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

N-CT FC Carbide Taps for Cast Irons

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M10 × 1	P3	TCNR010M1	1.5P	70	19	-	7	5.5	8	4	4	¥ 29,300
M10 × 1	P4	TCNS010M3	3P	70	19	-	7	5.5	8	4	4	¥ 29,300 ※
M10 × 1	P4	TCNS010M1	1.5P	70	19	-	7	5.5	8	4	4	¥ 29,300 ※
M12 × 1.75	P3	TCNR012P3	3P	82	30	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.75	P3	TCNR012P1	1.5P	82	30	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.75	P4	TCNS012P3	3P	82	30	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.75	P4	TCNS012P1	1.5P	82	30	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.5	P3	TCNR012O3	3P	82	24	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.5	P3	TCNR012O1	1.5P	82	24	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.5	P4	TCNS012O3	3P	82	24	-	8.5	6.5	9	4	4	¥ 38,900 ※
M12 × 1.5	P4	TCNS012O1	1.5P	82	24	-	8.5	6.5	9	4	4	¥ 38,900 ※
M12 × 1.25	P3	TCNR012N3	3P	80	22	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.25	P3	TCNR012N1	1.5P	80	22	-	8.5	6.5	9	4	4	¥ 38,900
M12 × 1.25	P4	TCNS012N3	3P	80	22	-	8.5	6.5	9	4	4	¥ 38,900 ※
M12 × 1.25	P4	TCNS012N1	1.5P	80	22	-	8.5	6.5	9	4	4	¥ 38,900 ※
M12 × 1	P3	TCNR012M3	3P	70	19	-	8.5	6.5	9	4	4	¥ 42,900 ※
M12 × 1	P3	TCNR012M1	1.5P	70	19	-	8.5	6.5	9	4	4	¥ 42,900 ※
M12 × 1	P4	TCNS012M3	3P	70	19	-	8.5	6.5	9	4	4	¥ 42,900 ※
M12 × 1	P4	TCNS012M1	1.5P	70	19	-	8.5	6.5	9	4	4	¥ 42,900 ※
M14 × 2	P3	TCNR014Q3	3P	88	30	34	10.5	8	11	4	5	¥ 40,200 ※
M14 × 2	P3	TCNR014Q1	1.5P	88	30	34	10.5	8	11	4	5	¥ 40,200 ※
M14 × 2	P4	TCNS014Q3	3P	88	30	34	10.5	8	11	4	5	¥ 40,200
M14 × 2	P4	TCNS014Q1	1.5P	88	30	34	10.5	8	11	4	5	¥ 40,200
M14 × 1.5	P3	TCNR014O3	3P	88	24	34	10.5	8	11	4	5	¥ 40,200
M14 × 1.5	P3	TCNR014O1	1.5P	88	24	34	10.5	8	11	4	5	¥ 40,200
M14 × 1.5	P4	TCNS014O3	3P	88	24	34	10.5	8	11	4	5	¥ 40,200 ※
M14 × 1.5	P4	TCNS014O1	1.5P	88	24	34	10.5	8	11	4	5	¥ 40,200 ※
M14 × 1.25	P3	TCNR014N3	3P	88	22	34	10.5	8	11	4	5	¥ 43,900 ※
M14 × 1.25	P3	TCNR014N1	1.5P	88	22	34	10.5	8	11	4	5	¥ 43,900 ※
M14 × 1.25	P4	TCNS014N3	3P	88	22	34	10.5	8	11	4	5	¥ 43,900 ※
M14 × 1.25	P4	TCNS014N1	1.5P	88	22	34	10.5	8	11	4	5	¥ 43,900 ※
M14 × 1	P3	TCNR014M3	3P	70	19	37	10.5	8	11	4	5	¥ 43,900 ※
M14 × 1	P3	TCNR014M1	1.5P	70	19	37	10.5	8	11	4	5	¥ 43,900 ※
M14 × 1	P4	TCNS014M3	3P	70	19	37	10.5	8	11	4	5	¥ 43,900 ※
M14 × 1	P4	TCNS014M1	1.5P	70	19	37	10.5	8	11	4	5	¥ 43,900 ※
M16 × 2	P4	TCNS016Q3	3P	95	30	37	12.5	10	13	4	5	¥ 48,900
M16 × 2	P4	TCNS016Q1	1.5P	95	30	37	12.5	10	13	4	5	¥ 48,900
M16 × 1.5	P3	TCNR016O3	3P	95	24	37	12.5	10	13	4	5	¥ 48,900 ※
M16 × 1.5	P3	TCNR016O1	1.5P	95	24	37	12.5	10	13	4	5	¥ 48,900 ※
M16 × 1.5	P4	TCNS016O3	3P	95	24	37	12.5	10	13	4	5	¥ 48,900
M16 × 1.5	P4	TCNS016O1	1.5P	95	24	37	12.5	10	13	4	5	¥ 48,900
M16 × 1	P4	TCNS016M3	3P	75	19	41	12.5	10	13	4	5	¥ 52,200
M16 × 1	P4	TCNS016M1	1.5P	75	19	41	12.5	10	13	4	5	¥ 52,200
M18 × 2.5	P4	TCNS018R3	3P	100	35	38	14	11	14	4	5	¥ 57,600 ※
M18 × 2.5	P4	TCNS018R1	1.5P	100	35	38	14	11	14	4	5	¥ 57,600 ※
M18 × 1.5	P4	TCNS018O3	3P	95	24	43	14	11	14	4	5	¥ 57,600
M18 × 1.5	P4	TCNS018O1	1.5P	95	24	43	14	11	14	4	5	¥ 57,600
M20 × 2.5	P4	TCNS020R3	3P	105	35	41	15	12	15	4	5	¥ 67,900
M20 × 2.5	P4	TCNS020R1	1.5P	105	35	41	15	12	15	4	5	¥ 67,900
M20 × 1.5	P4	TCNS020O3	3P	95	24	43	15	12	15	4	5	¥ 67,900

※ = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

5

JIS

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

JIS

⑤-12

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

JIS

N-CT FC Carbide Taps for Cast Irons

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M20 × 1.5	P4	TCNS020O1	1.5P	95	24	43	15	12	15	4	5	¥ 67,900
M22 × 2.5	P4	TCNS022R3	3P	115	35	45	17	13	16	4	5	¥ 76,800 ※
M22 × 2.5	P4	TCNS022R1	1.5P	115	35	45	17	13	16	4	5	¥ 76,800 ※
M22 × 1.5	P4	TCNS022O3	3P	95	24	42	17	13	16	4	5	¥ 76,800 ※
M22 × 1.5	P4	TCNS022O1	1.5P	95	24	42	17	13	16	4	5	¥ 76,800 ※
M24 × 3	P4	TCNS024S3	3P	120	35	47	19	15	18	4	5	¥ 86,300 ※
M24 × 3	P4	TCNS024S1	1.5P	120	35	47	19	15	18	4	5	¥ 86,300 ※
M24 × 1.5	P4	TCNS024O3	3P	95	24	42	19	15	18	4	5	¥ 86,300 ※
M24 × 1.5	P4	TCNS024O1	1.5P	95	24	42	19	15	18	4	5	¥ 86,300 ※
M30 × 3.5	P5	TCNT030T3	3P	135	45	53	23	17	20	4	5	¥ 109,000 ※
M30 × 3.5	P5	TCNT030T1	1.5P	135	45	53	23	17	20	4	5	¥ 109,000 ※
For Unified Threads												
No.4-40UNC	P3	TCNRUN4H3	3P	44	9.5	-	3	2.5	5	3	1	¥ 15,900 ※
No.4-40UNC	P3	TCNRUN4H1	1.5P	44	9.5	-	3	2.5	5	3	1	¥ 15,900 ※
No.4-48UNF	P3	TCNRUN4F3	3P	44	9.5	-	3	2.5	5	3	1	¥ 15,900 ※
No.4-48UNF	P3	TCNRUN4F1	1.5P	44	9.5	-	3	2.5	5	3	1	¥ 15,900 ※
No.5-40UNC	P3	TCNRUN5H3	3P	46	9.5	-	4	3.2	6	3	1	¥ 16,700 ※
No.5-40UNC	P3	TCNRUN5H1	1.5P	46	9.5	-	4	3.2	6	3	1	¥ 16,700 ※
No.6-32UNC	P3	TCNRUN6J3	3P	48	11	-	4	3.2	6	3	1	¥ 16,700 ※
No.6-32UNC	P3	TCNRUN6J1	1.5P	48	11	-	4	3.2	6	3	1	¥ 16,700 ※
No.8-32UNC	P3	TCNRUN8J3	3P	52	11	-	5	4	7	4	1	¥ 17,300 ※
No.8-32UNC	P3	TCNRUN8J1	1.5P	52	11	-	5	4	7	4	1	¥ 17,300 ※
No.10-24UNC	P3	TCNRUNAM3	3P	60	16	-	5.5	4.5	7	4	1	¥ 17,300 ※
No.10-24UNC	P3	TCNRUNAM1	1.5P	60	16	-	5.5	4.5	7	4	1	¥ 17,300 ※
No.10-32UNF	P3	TCNRUNAJ3	3P	60	11	-	5.5	4.5	7	4	1	¥ 17,300 ※
No.10-32UNF	P3	TCNRUNAJ1	1.5P	60	11	-	5.5	4.5	7	4	1	¥ 17,300 ※
1/4-20UNC	P3	TCNRU04N3	3P	62	19	-	6	4.5	7	4	3	¥ 19,200 ※
1/4-20UNC	P3	TCNRU04N1	1.5P	62	19	-	6	4.5	7	4	3	¥ 19,200 ※
1/4-28UNF	P3	TCNRU04K3	3P	62	16	-	6	4.5	7	4	3	¥ 19,200 ※
1/4-28UNF	P3	TCNRU04K1	1.5P	62	16	-	6	4.5	7	4	3	¥ 19,200 ※
5/16-18UNC	P3	TCNRU05O3	3P	70	22	-	6.1	5	8	4	4	¥ 24,600 ※
5/16-18UNC	P3	TCNRU05O1	1.5P	70	22	-	6.1	5	8	4	4	¥ 24,600 ※
5/16-24UNF	P3	TCNRU05M3	3P	70	16	-	6.1	5	8	4	4	¥ 24,600 ※
5/16-24UNF	P3	TCNRU05M1	1.5P	70	16	-	6.1	5	8	4	4	¥ 24,600 ※
3/8-16UNC	P3	TCNRU06P3	3P	75	24	-	7	5.5	8	4	4	¥ 33,600 ※
3/8-16UNC	P3	TCNRU06P1	1.5P	75	24	-	7	5.5	8	4	4	¥ 33,600 ※
3/8-24UNF	P3	TCNRU06M3	3P	75	16	-	7	5.5	8	4	4	¥ 33,600 ※
3/8-24UNF	P3	TCNRU06M1	1.5P	75	16	-	7	5.5	8	4	4	¥ 33,600 ※
7/16-14UNC	P3	TCNRU07Q3	3P	80	24	-	8	6	9	4	4	¥ 44,700 ※
7/16-14UNC	P3	TCNRU07Q1	1.5P	80	24	-	8	6	9	4	4	¥ 44,700 ※
7/16-20UNF	P3	TCNRU07N3	3P	80	19	-	8	6	9	4	4	¥ 44,700 ※
7/16-20UNF	P3	TCNRU07N1	1.5P	80	19	-	8	6	9	4	4	¥ 44,700 ※
1/2-13UNC	P3	TCNRU08R3	3P	85	30	32	9	7	10	4	5	¥ 47,400 ※
1/2-13UNC	P3	TCNRU08R1	1.5P	85	30	32	9	7	10	4	5	¥ 47,400 ※
1/2-20UNF	P3	TCNRU08N3	3P	85	19	32	9	7	10	4	5	¥ 47,400 ※
1/2-20UNF	P3	TCNRU08N1	1.5P	85	19	32	9	7	10	4	5	¥ 47,400 ※
5/8-11UNC	P4	TCNSU10U3	3P	95	30	38	12	9	12	4	5	¥ 56,100 ※
5/8-11UNC	P4	TCNSU10U1	1.5P	95	30	38	12	9	12	4	5	¥ 56,100 ※
5/8-18UNF	P4	TCNSU10O3	3P	95	22	38	12	9	12	4	5	¥ 56,100 ※

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

JIS

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

N-CT FC Carbide Taps for Cast Irons

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
5/8-18UNF	P4	TCNSU10O1	1.5P	95	22	38	12	9	12	4	5	¥ 56,100 ※
3/4-10UNC	P4	TCNSU12V3	3P	105	35	41	14	11	14	4	5	¥ 77,400 ※
3/4-10UNC	P4	TCNSU12V1	1.5P	105	35	41	14	11	14	4	5	¥ 77,400 ※
3/4-16UNF	P4	TCNSU12P3	3P	95	24	43	14	11	14	4	5	¥ 77,400 ※
3/4-16UNF	P4	TCNSU12P1	1.5P	95	24	43	14	11	14	4	5	¥ 77,400 ※

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JIS

- ① Spiral Fluted Taps (for blind hole)
- ② Spiral Fluted Taps (for through hole)
- ③ Spiral Pointed Taps (for through hole)
- ④ Hand Taps
- ⑤ Cemented Carbide Taps
- ⑥ Roll Taps
- ⑦ Special Thread Taps Simple Inspection Tools
- ⑧ Pipe Taps
- ⑨ Thread Mills Premium Thread Mills
- ⑩ Dies
- ⑪ Center Drills Centering Tools
- ⑫ Precision Machinery/ Medical Surgical Instruments

※ = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

JIS

⑤-14

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

ANSI

ZELX CARB CI

Carbide Taps for Cast Irons



Specification



■ ZELX CARB CI is the carbide tap suitable for hard and abrasive materials such as cast irons. For volume production.

Tapping Speed depending on Materials

Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄	Brass castings 黄銅鑄物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps



⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection tools

⑧ Pipe Taps

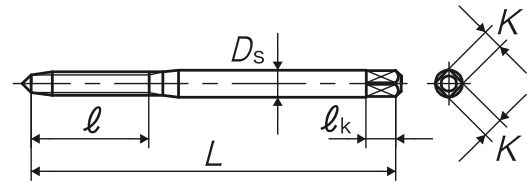
⑨ Thread Mills
Premium Thread Mills

⑩ Dies

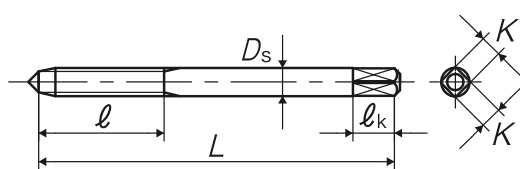
⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

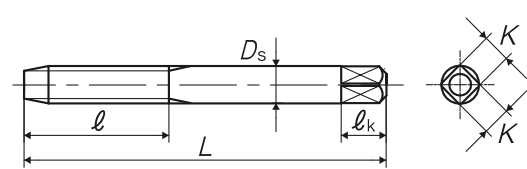
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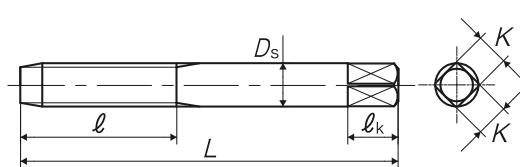
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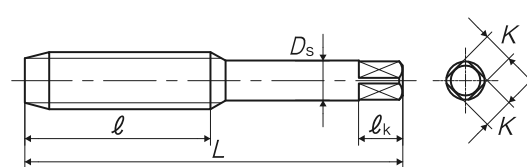
TYPE: 3



TYPE: 4



TYPE: 5



Segment : 1L

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Metric Threads										
M3 × 0.5	D3	Y70000	4P	1.937	0.625	0.141	0.11	0.187	3	1
M3 × 0.5	D3	Y70001	1.5P	1.937	0.625	0.141	0.11	0.187	3	1
M4 × 0.7	D4	Y70002	4P	2.125	0.75	0.168	0.131	0.25	4	2
M4 × 0.7	D4	Y70003	1.5P	2.125	0.75	0.168	0.131	0.25	4	2
M5 × 0.8	D4	Y70004	4P	2.375	0.875	0.194	0.152	0.25	4	2
M5 × 0.8	D4	Y70005	1.5P	2.375	0.875	0.194	0.152	0.25	4	2
M6 × 1	D5	Y70006	4P	2.5	1	0.255	0.191	0.312	4	3
M6 × 1	D5	Y70007	1.5P	2.5	1	0.255	0.191	0.312	4	3
M8 × 1.25	D5	Y70010	4P	2.718	1.125	0.318	0.238	0.375	4	4

ANSI

⑤-15

Think threads with
YAMAWA

· This product is different from JIS products in shape and dimensions, please be careful when using.

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

5

ANSI

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M8 × 1.25	D5	Y70011	1.5P	2.718	1.125	0.318	0.238	0.375	4	4
M8 × 1	D5	Y70008	4P	2.718	1.125	0.318	0.238	0.375	4	4
M8 × 1	D5	Y70009	1.5P	2.718	1.125	0.318	0.238	0.375	4	4
M10 × 1.5	D6	Y70014	4P	2.937	1.25	0.381	0.286	0.437	4	4
M10 × 1.5	D6	Y70015	1.5P	2.937	1.25	0.381	0.286	0.437	4	4
M10 × 1.25	D5	Y70012	4P	2.937	1.25	0.381	0.286	0.437	4	4
M10 × 1.25	D5	Y70013	1.5P	2.937	1.25	0.381	0.286	0.437	4	4
M12 × 1.75	D6	Y70020	4P	3.375	1.656	0.367	0.275	0.437	4	5
M12 × 1.75	D6	Y70021	1.5P	3.375	1.656	0.367	0.275	0.437	4	5
M12 × 1.5	D6	Y70018	4P	3.375	1.656	0.367	0.275	0.437	4	5
M12 × 1.25	D5	Y70016	4P	3.375	1.656	0.367	0.275	0.437	4	5
M12 × 1.25	D5	Y70017	1.5P	3.375	1.656	0.367	0.275	0.437	4	5
M14 × 2	D7	Y70024	4P	3.593	1.656	0.429	0.322	0.5	4	5
M14 × 2	D7	Y70025	1.5P	3.593	1.656	0.429	0.322	0.5	4	5
M14 × 1.5	D6	Y70022	4P	3.593	1.656	0.429	0.322	0.5	4	5
M16 × 2	D7	Y70028	4P	3.812	1.812	0.48	0.36	0.562	4	5
M16 × 2	D7	Y70029	1.5P	3.812	1.812	0.48	0.36	0.562	4	5
M16 × 1.5	D6	Y70026	4P	3.812	1.812	0.48	0.36	0.562	4	5
M16 × 1.5	D6	Y70027	1.5P	3.812	1.812	0.48	0.36	0.562	4	5
For Unified Threads										
No.10-24UNC	GH3	Y83806	4P	2.375	0.875	0.194	0.152	0.25	4	2
No.10-24UNC	GH3	Y83807	1.5P	2.375	0.875	0.194	0.152	0.25	4	2
No.10-32UNF	GH3	Y83808	4P	2.375	0.875	0.194	0.152	0.25	4	2
No.10-32UNF	GH3	Y83809	1.5P	2.375	0.875	0.194	0.152	0.25	4	2
1/4-20UNC	GH3	Y83810	4P	2.5	1	0.255	0.191	0.312	4	3
1/4-20UNC	GH3	Y83811	1.5P	2.5	1	0.255	0.191	0.312	4	3
1/4-20UNC	GH5	Y83860	4P	2.5	1	0.255	0.191	0.312	4	3
1/4-20UNC	GH5	Y83861	1.5P	2.5	1	0.255	0.191	0.312	4	3
1/4-28UNF	GH3	Y83812	4P	2.5	1	0.255	0.191	0.312	4	3
1/4-28UNF	GH3	Y83813	1.5P	2.5	1	0.255	0.191	0.312	4	3
1/4-28UNF	GH5	Y83862	4P	2.5	1	0.255	0.191	0.312	4	3
1/4-28UNF	GH5	Y83863	1.5P	2.5	1	0.255	0.191	0.312	4	3
5/16-18UNC	GH3	Y83814	4P	2.718	1.125	0.318	0.238	0.375	4	4
5/16-18UNC	GH3	Y83815	1.5P	2.718	1.125	0.318	0.238	0.375	4	4
5/16-18UNC	GH5	Y83864	4P	2.718	1.125	0.318	0.238	0.375	4	4
5/16-18UNC	GH5	Y83865	1.5P	2.718	1.125	0.318	0.238	0.375	4	4
5/16-24UNF	GH3	Y83816	4P	2.718	1.125	0.318	0.238	0.375	4	4
5/16-24UNF	GH3	Y83817	1.5P	2.718	1.125	0.318	0.238	0.375	4	4
5/16-24UNF	GH5	Y83866	4P	2.718	1.125	0.318	0.238	0.375	4	4
5/16-24UNF	GH5	Y83867	1.5P	2.718	1.125	0.318	0.238	0.375	4	4
3/8-16UNC	GH3	Y83818	4P	2.937	1.25	0.381	0.286	0.437	4	4
3/8-16UNC	GH3	Y83819	1.5P	2.937	1.25	0.381	0.286	0.437	4	4
3/8-16UNC	GH5	Y83868	4P	2.937	1.25	0.381	0.286	0.437	4	4
3/8-16UNC	GH5	Y83869	1.5P	2.937	1.25	0.381	0.286	0.437	4	4
3/8-24UNF	GH3	Y83820	4P	2.937	1.25	0.381	0.286	0.437	4	4
3/8-24UNF	GH3	Y83821	1.5P	2.937	1.25	0.381	0.286	0.437	4	4
3/8-24UNF	GH5	Y83870	4P	2.937	1.25	0.381	0.286	0.437	4	4
3/8-24UNF	GH5	Y83871	1.5P	2.937	1.25	0.381	0.286	0.437	4	4
7/16-14UNC	GH3	Y83822	4P	3.156	1.437	0.323	0.242	0.406	4	5
7/16-14UNC	GH3	Y83823	1.5P	3.156	1.437	0.323	0.242	0.406	4	5

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

ANSI

⑤-16

 Think threads with
YAMAWA

· This product is different from JIS products in shape and dimensions, please be careful when using.

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

ANSI

ZELX CARB CI Carbide Taps for Cast Irons

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
7/16-14UNC	GH5	Y83872	4P	3.156	1.437	0.323	0.242	0.406	4	5
7/16-14UNC	GH5	Y83873	1.5P	3.156	1.437	0.323	0.242	0.406	4	5
7/16-20UNF	GH3	Y83824	4P	3.156	1.437	0.323	0.242	0.406	4	5
7/16-20UNF	GH3	Y83825	1.5P	3.156	1.437	0.323	0.242	0.406	4	5
7/16-20UNF	GH5	Y83874	4P	3.156	1.437	0.323	0.242	0.406	4	5
7/16-20UNF	GH5	Y83875	1.5P	3.156	1.437	0.323	0.242	0.406	4	5
1/2-13UNC	GH3	Y83826	4P	3.375	1.656	0.367	0.275	0.437	4	5
1/2-13UNC	GH3	Y83827	1.5P	3.375	1.656	0.367	0.275	0.437	4	5
1/2-13UNC	GH5	Y83876	4P	3.375	1.656	0.367	0.275	0.437	4	5
1/2-13UNC	GH5	Y83877	1.5P	3.375	1.656	0.367	0.275	0.437	4	5
1/2-20UNF	GH3	Y83828	4P	3.375	1.656	0.367	0.275	0.437	4	5
1/2-20UNF	GH3	Y83829	1.5P	3.375	1.656	0.367	0.275	0.437	4	5
1/2-20UNF	GH5	Y83878	4P	3.375	1.656	0.367	0.275	0.437	4	5
1/2-20UNF	GH5	Y83879	1.5P	3.375	1.656	0.367	0.275	0.437	4	5
5/8-11UNC	GH3	Y83834	4P	3.812	1.812	0.48	0.36	0.562	4	5
5/8-11UNC	GH3	Y83835	1.5P	3.812	1.812	0.48	0.36	0.562	4	5
5/8-11UNC	GH5	Y83884	4P	3.812	1.812	0.48	0.36	0.562	4	5
5/8-11UNC	GH5	Y83885	1.5P	3.812	1.812	0.48	0.36	0.562	4	5
5/8-18UNF	GH3	Y83836	4P	3.812	1.812	0.48	0.36	0.562	4	5
5/8-18UNF	GH3	Y83837	1.5P	3.812	1.812	0.48	0.36	0.562	4	5
5/8-18UNF	GH5	Y83886	4P	3.812	1.812	0.48	0.36	0.562	4	5
5/8-18UNF	GH5	Y83887	1.5P	3.812	1.812	0.48	0.36	0.562	4	5

①

Spiral Fluted Taps
(for blind hole)

②

Spiral Fluted Taps
(for through hole)

③

Spiral Pointed Taps
(for through hole)

④

Hand Taps

⑤

Cemented
Carbide Taps

⑥

Roll Taps

⑦

Special Thread Taps
Simple Inspection Tools

⑧

Pipe Taps

⑨

Thread Mills
Premium Thread Mills

⑩

Dies

⑪

Center Drills
Centering Tools

⑫

Precision Machinery/
Medical Surgical Instruments

ANSI

⑤-17

Think threads with
YAMAWA

· This product is different from JIS products in shape and dimensions, please be careful when using.

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

5

JIS

LS-N-CT

Long Shank Carbide Taps



Specification

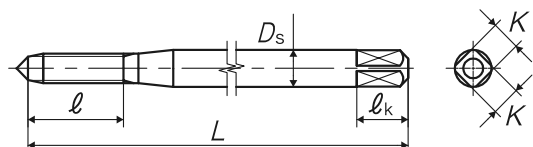


■ The LS-N-CT is a long shank carbide tap suitable for thread processing in mass production of hard and brittle materials

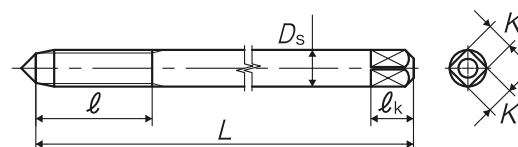
Tapping Speeds depending on Materials

Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄	Brass castings 黄銅鑄物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

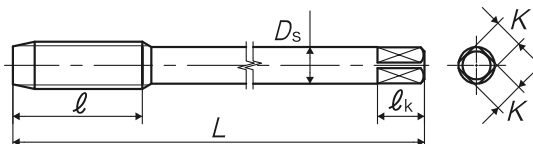
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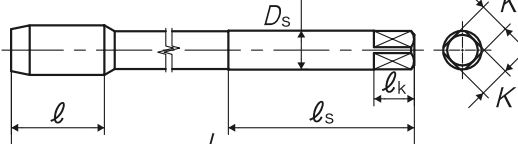
TYPE:2



TYPE:3



TYPE:4



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M3 × 0.5	P3	TY3.0GRAWB3E	3P	100	11	-	4	3.2	6	3	1	¥ 20,600 ※
M3 × 0.5	P3	TY3.0GRAWBAE	1.5P	100	11	-	4	3.2	6	3	1	¥ 20,600 ※
M4 × 0.7	P3	TY4.0IRAWB3E	3P	100	13	-	5	4	7	4	1	¥ 20,900 ※
M4 × 0.7	P3	TY4.0IRAWBAE	1.5P	100	13	-	5	4	7	4	1	¥ 20,900 ※
M5 × 0.8	P3	TY5.0KRAWB3E	3P	100	16	-	5.5	4.5	7	4	1	¥ 21,400 ※
M5 × 0.8	P3	TY5.0KRAWBAE	1.5P	100	16	-	5.5	4.5	7	4	1	¥ 21,400 ※
M6 × 1	P3	TY6.0MRAWB3E	3P	100	19	-	6	4.5	7	4	2	¥ 23,300 ※
M6 × 1	P3	TY6.0MRAWBAE	1.5P	100	19	-	6	4.5	7	4	2	¥ 23,300 ※
M8 × 1.25	P3	TY8.0NRAWB3E	3P	100	22	-	6.2	5	8	4	3	¥ 25,700 ※
M8 × 1.25	P3	TY8.0NRAWB3G	3P	150	22	-	6.2	5	8	4	3	¥ 32,400 ※
M8 × 1.25	P3	TY8.0NRAWBAE	1.5P	100	22	-	6.2	5	8	4	3	¥ 25,700 ※
M8 × 1.25	P3	TY8.0NRAWBAG	1.5P	150	22	-	6.2	5	8	4	3	¥ 32,400 ※
M10 × 1.5	P3	TY10.0ORAWB3E	3P	100	24	-	7	5.5	8	4	3	¥ 35,200 ※
M10 × 1.5	P3	TY10.0ORAWB3G	3P	150	24	-	7	5.5	8	4	3	¥ 43,900 ※
M10 × 1.5	P3	TY10.0ORAWBAE	1.5P	100	24	-	7	5.5	8	4	3	¥ 35,200 ※
M10 × 1.5	P3	TY10.0ORAWBAG	1.5P	150	24	-	7	5.5	8	4	3	¥ 43,900 ※
M10 × 1.25	P3	TY10.0NRAWB3E	3P	100	22	-	7	5.5	8	4	3	¥ 35,200 ※

※ = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

JIS

⑤-18

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

JIS

LS-N-CT Long Shank Carbide Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M10 × 1.25	P3	TY010NRAWB3G	3P	150	22	-	7	5.5	8	4	3	¥ 43,900 ※
M10 × 1.25	P3	TY010NRAWBAE	1.5P	100	22	-	7	5.5	8	4	3	¥ 35,200 ※
M10 × 1.25	P3	TY010NRAWBAG	1.5P	150	22	-	7	5.5	8	4	3	¥ 43,900 ※
M12 × 1.75	P4	TY012PSAWB3G	3P	150	30	50	8.5	6.5	9	4	4	¥ 54,300 ※
M12 × 1.75	P4	TY012PSAWBAG	1.5P	150	30	50	8.5	6.5	9	4	4	¥ 54,300 ※
M12 × 1.5	P4	TY012OSAWB3G	3P	150	24	50	8.5	6.5	9	4	4	¥ 54,300 ※
M12 × 1.5	P4	TY012OSAWBAG	1.5P	150	24	50	8.5	6.5	9	4	4	¥ 54,300 ※
M12 × 1.25	P4	TY012NSAWB3G	3P	150	22	50	8.5	6.5	9	4	4	¥ 54,300 ※
M12 × 1.25	P4	TY012NSAWBAG	1.5P	150	22	50	8.5	6.5	9	4	4	¥ 54,300 ※
M14 × 2	P4	TY014QSAWB3G	3P	150	30	60	10.5	8	11	4	4	¥ 46,700 ※
M14 × 2	P4	TY014QSAWBAG	1.5P	150	30	60	10.5	8	11	4	4	¥ 46,700 ※
M14 × 1.5	P4	TY014OSAWB3G	3P	150	24	60	10.5	8	11	4	4	¥ 46,700 ※
M14 × 1.5	P4	TY014OSAWBAG	1.5P	150	24	60	10.5	8	11	4	4	¥ 46,700 ※
M16 × 2	P4	TY016QSAWB3G	3P	150	30	60	12.5	10	13	4	4	¥ 54,300 ※
M16 × 2	P4	TY016QSAWBAG	1.5P	150	30	60	12.5	10	13	4	4	¥ 54,300 ※
M16 × 1.5	P4	TY016OSAWB3G	3P	150	24	60	12.5	10	13	4	4	¥ 54,300 ※
M16 × 1.5	P4	TY016OSAWBAG	1.5P	150	24	60	12.5	10	13	4	4	¥ 54,300 ※
M18 × 2.5	P4	TY018RSAWB3G	3P	150	35	70	14	11	14	4	4	¥ 63,500 ※
M18 × 2.5	P4	TY018RSAWBAG	1.5P	150	35	70	14	11	14	4	4	¥ 63,500 ※
M18 × 1.5	P4	TY018OSAWB3G	3P	150	24	70	14	11	14	4	4	¥ 63,500 ※
M18 × 1.5	P4	TY018OSAWBAG	1.5P	150	24	70	14	11	14	4	4	¥ 63,500 ※
M20 × 2.5	P4	TY020RSAWB3G	3P	150	35	70	15	12	15	4	4	¥ 72,500 ※
M20 × 2.5	P4	TY020RSAWBAG	1.5P	150	35	70	15	12	15	4	4	¥ 72,500 ※
M20 × 1.5	P4	TY020OSAWB3G	3P	150	24	70	15	12	15	4	4	¥ 72,500 ※
M20 × 1.5	P4	TY020OSAWBAG	1.5P	150	24	70	15	12	15	4	4	¥ 72,500 ※
M22 × 2.5	P4	TY022RSAWB3G	3P	150	35	70	17	13	16	4	4	¥ 81,500 ※
M22 × 2.5	P4	TY022RSAWBAG	1.5P	150	35	70	17	13	16	4	4	¥ 81,500 ※
M22 × 1.5	P4	TY022OSAWB3G	3P	150	24	70	17	13	16	4	4	¥ 82,900 ※
M22 × 1.5	P4	TY022OSAWBAG	1.5P	150	24	70	17	13	16	4	4	¥ 82,900 ※
M24 × 3	P4	TY024SSAWB3G	3P	150	35	80	19	15	18	4	4	¥ 91,500 ※
M24 × 3	P4	TY024SSAWBAG	1.5P	150	35	80	19	15	18	4	4	¥ 91,500 ※
M24 × 1.5	P4	TY024OSAWB3G	3P	150	24	80	19	15	18	4	4	¥ 93,300 ※
M24 × 1.5	P4	TY024OSAWBAG	1.5P	150	24	80	19	15	18	4	4	¥ 93,300 ※

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

JIS

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

5

JIS

S
JIS

N-CT-SP

Spiral Fluted Carbide Taps



Specification

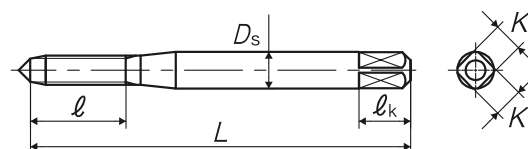


■ The N-CT-SP is a cemented carbide spiral flute tap most suitable for blind hole mass production of aluminum castings (AC), aluminum die cast (ADC), zinc die cast (ZDC) etc.

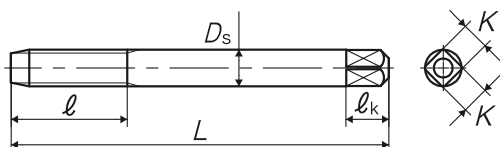
Tapping Speeds depending on Materials

Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
10~20 (m/min)	10~20 (m/min)	10~20 (m/min)

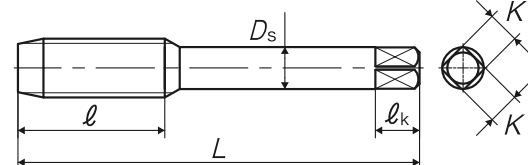
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads											
M3 × 0.5	P3	SY3.0GRKWB	2.5P	46	11	4	3.2	6	3	1	¥ 16,200 ※
M4 × 0.7	P3	SY4.0IRKWB	2.5P	52	13	5	4	7	3	1	¥ 17,000 ※
M5 × 0.8	P3	SY5.0KRKWB	2.5P	60	16	5.5	4.5	7	3	1	¥ 17,900 ※
M6 × 1	P3	SY6.0MRKWB	2.5P	62	19	6	4.5	7	3	2	¥ 19,400 ※
M8 × 1.25	P3	SY8.0NRKWB	2.5P	70	22	6.2	5	8	3	3	¥ 25,000 ※
M10 × 1.5	P3	SY010ORKWB	2.5P	75	24	7	5.5	8	3	3	¥ 34,900 ※
M10 × 1.25	P3	SY010NRKWB	2.5P	75	22	7	5.5	8	3	3	¥ 34,900 ※
M12 × 1.75	P4	SY012PSKWB	2.5P	82	30	8.5	6.5	9	3	3	¥ 45,900 ※
M12 × 1.5	P4	SY012OSKWB	2.5P	82	24	8.5	6.5	9	3	3	¥ 45,900 ※
M12 × 1.25	P4	SY012NSKWB	2.5P	80	22	8.5	6.5	9	3	3	¥ 45,900 ※
M14 × 2	P4	SY014QSKWB	2.5P	88	30	10.5	8	11	3	3	¥ 60,000 ※
M14 × 1.5	P4	SY014OSKWB	2.5P	88	24	10.5	8	11	3	3	¥ 60,000 ※
M16 × 2	P4	SY016QSKWB	2.5P	95	30	12.5	10	13	3	3	¥ 78,500 ※
M16 × 1.5	P4	SY016OSKWB	2.5P	95	24	12.5	10	13	3	3	¥ 78,500 ※
M18 × 2.5	P4	SY018RSKWB	2.5P	100	35	14	11	14	4	3	¥ 84,500 ※
M18 × 1.5	P4	SY018OSKWB	2.5P	95	24	14	11	14	4	3	¥ 84,500 ※
M20 × 2.5	P4	SY020RSKWB	2.5P	105	35	15	12	15	4	3	¥ 107,000 ※
M20 × 1.5	P4	SY020OSKWB	2.5P	95	24	15	12	15	4	3	¥ 107,000 ※

※ = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

JIS ⑤-20

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple inspection tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

N-CT-PO

Spiral Pointed Carbide Taps



Specification

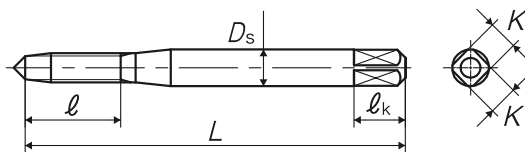


■ The N-CT-PO is a cemented carbide spiral flute tap most suitable for blind hole mass production of aluminum castings (AC), aluminum die cast (ADC), zinc die cast (ZDC) etc.

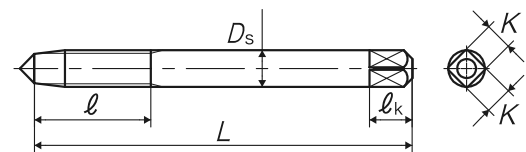
Tapping Speeds depending on Materials

Brass 黄銅	Brass castings 黄銅鑄物	Bronze 青銅	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鑄物	Magnesium alloy die castings マグネシウム合金鑄物	Zinc alloy castings 亜鉛合金鑄物
10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)

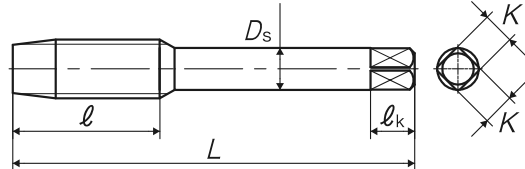
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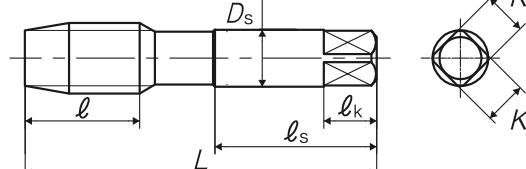
TYPE:2



TYPE:3



TYPE:4



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M3 × 0.5	P3	PCNR3.0G	5P	46	11	-	4	3.2	6	3	1	¥ 16,200 ※
M4 × 0.7	P3	PCNR4.0I	5P	52	13	-	5	4	7	3	1	¥ 17,000 ※
M5 × 0.8	P3	PCNR5.0K	5P	60	16	-	5.5	4.5	7	3	1	¥ 17,900 ※
M6 × 1	P3	PCNR6.0M	5P	62	19	-	6	4.5	7	3	2	¥ 19,400 ※
M8 × 1.25	P3	PCNR8.0N	5P	70	22	-	6.2	5	8	3	3	¥ 25,000 ※
M10 × 1.5	P4	PCNS010O	5P	75	24	-	7	5.5	8	3	3	¥ 34,900 ※
M10 × 1.25	P3	PCNR010N	5P	75	22	-	7	5.5	8	3	3	¥ 34,900 ※
M12 × 1.75	P4	PCNS012P	5P	82	30	-	8.5	6.5	9	3	3	¥ 45,900 ※
M12 × 1.5	P4	PCNS012O	5P	82	24	-	8.5	6.5	9	3	3	¥ 45,900 ※
M12 × 1.25	P4	PCNS012N	5P	80	22	-	8.5	6.5	9	3	3	¥ 45,900 ※
M14 × 2	P4	PCNS014Q	5P	88	30	34	10.5	8	11	3	4	¥ 60,000 ※
M14 × 1.5	P4	PCNS014O	5P	88	24	34	10.5	8	11	3	4	¥ 60,000 ※
M16 × 2	P4	PCNS016Q	5P	95	30	37	12.5	10	13	3	4	¥ 78,500 ※
M16 × 1.5	P4	PCNS016O	5P	95	24	37	12.5	10	13	3	4	¥ 78,500 ※
M18 × 2.5	P4	PCNS018R	5P	100	35	38	14	11	14	3	4	¥ 84,500 ※
M18 × 1.5	P4	PCNS018O	5P	95	24	43	14	11	14	3	4	¥ 84,500 ※
M20 × 2.5	P4	PCNS020R	5P	105	35	41	15	12	15	3	4	¥107,000 ※

JIS

Overall length	Thread length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓs	Ds	K	ℓk

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M20 × 1.5	P4	PCNS020O	5P	95	24	43	15	12	15	3	4	¥107,000 ※

- 5
- JIS
- Spiral Fluted Taps
(for blind hole) ①
- Spiral Fluted Taps
(for through hole) ②
- Spiral Pointed Taps
(for through hole) ③
- Hand Taps ④
- Cemented Carbide Taps ⑤
- Roll Taps ⑥
- Special Thread Taps
Simple Inspection Tools ⑦
- Pipe Taps ⑧
- Thread Mills
Premium Thread Mills ⑨
- Dies ⑩
- Center Drills
Centering Tools ⑪
- Precision Machinery/
Medical Surgical Instruments ⑫

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple inspection tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

⑬ Precision Machinery/
Medical Surgical Instruments

JIS

⑤-23



EH-CT

Carbide Taps for Hard Materials



Specification

HF

Coating



Synchro
nized

<1.5D

Tapping Speeds depending on Materials

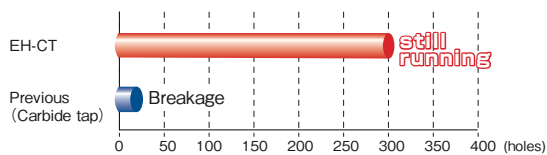
Thermal refined steels
調質鋼
~5
(m/min)
45~55HRC

Product Features

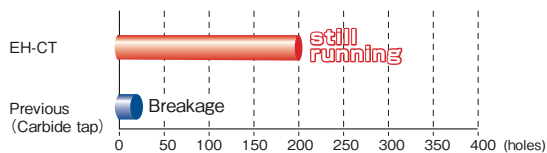
- Ideal for high hardness steel tapping from 45 to 55 HRC. For hot mold SKS 3 and SKD 11.
- The ultra fine grain cemented carbide is superior in abrasion resistance and impact resistance.
- Better concentricity improves the accuracy of the entire tap and roundness of the shank.
- Recommended tapping length is "Major diameter size x 1.5" or less 5P chamfer for better tool life.
- For the bored hole diameter, the maximum minor diameter of a 6H internal thread diameter maximum value is recommended.

Tapping Data [M8×1.25]

Tapping Data

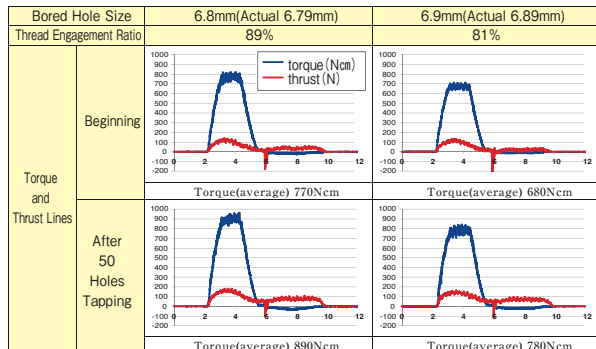


Work Material	Type	Hot forged die steel (SKD61)
	Hardness	50HRC
Tapping Speed		6m/min
Feed		Full rigid
Tapping Fluid		Non-water soluble cutting oil



Work Material	Type	Stainless steel for plastic die (SUS420J2)
	Hardness	52HRC
Tapping Speed		6m/min
Feed		Full rigid
Tapping Fluid		Non-water soluble cutting oil

(Torque line in the different bored hole size)



Tapping condition

Work Material	DAC (equivalent to SKD61) 50HRC
Tapping Speed	6m/min
Feed	Rigid
Tapping Fluid	Non-water soluble cutting oil

Bored hole size enlarged by 0.1mm can reduce the tapping resistance torque by 10%.

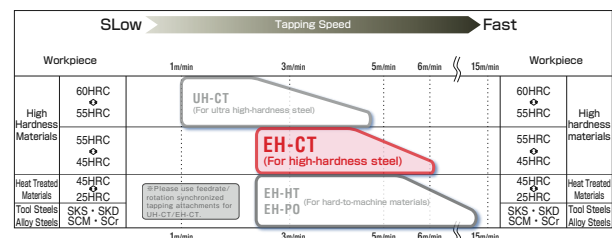
In tapping the material of high hardness, it is recommendable to make the bored hole size as large as possible.

Recommended bored hole size (for reference)

unit : mm

Size	Recommended Bored Hole Size	Minor Dia. of JIS 6H Class Internal Screw Thread	
		Max. Tolerance	Min. Tolerance
M3 × 0.5	2.56	2.599	2.459
M4 × 0.7	3.40	3.422	3.242
M5 × 0.8	4.30	4.334	4.134
M6 × 1	5.10	5.153	4.917
M8 × 1.25	6.90	6.912	6.647
M10 × 1.5	8.60	8.676	8.376
M12 × 1.75	10.4	10.441	10.106

Application

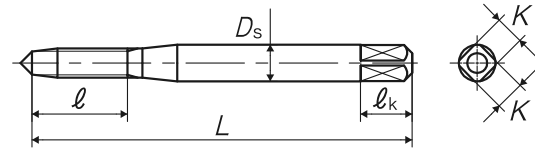


Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

5

JIS

TYPE: 1

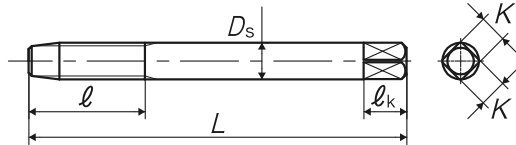
Spiral Fluted Taps
(for blind hole)

①

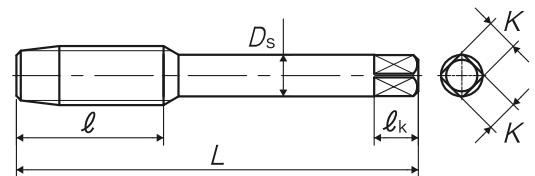
Spiral Fluted Taps
(for through hole)

②

TYPE: 2



TYPE: 3

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads											
M3 × 0.5	P3	EHCR3.0G5	5P	46	11	4	3.2	6	4	1	¥ 16,600
M4 × 0.7	P3	EHCR4.0I5	5P	52	13	5	4	7	4	1	¥ 17,600
M5 × 0.8	P3	EHCR5.0K5	5P	60	16	5.5	4.5	7	4	1	¥ 18,300
M6 × 1	P3	EHCR6.0M5	5P	62	19	6	4.5	7	5	2	¥ 19,900
M8 × 1.25	P4	EHCS8.0N5	5P	70	22	6.2	5	8	5	3	¥ 24,600
M10 × 1.5	P4	EHCS010O5	5P	75	24	7	5.5	8	5	3	¥ 33,200
M12 × 1.75	P4	EHCS012P5	5P	82	30	8.5	6.5	9	5	3	¥ 43,700

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

DIN

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

DIN

EH-CT

Carbide Taps for Hard Materials



Specification



Tapping Speeds depending on Materials



Product Features

- Ideal for high hardness steel blind hole tapping of 45 to 55 HRC materials such as steel for hot dies (SKS 3, SKD 11, etc.).
- The EH-CT utilizes an ultra fine grain cemented carbide that is superior in abrasion resistance and impact resistance.
- Improved run-out accuracy of whole tap and circularity of shank.
- Tapping length is the "major diameter size $\times$ 1.5 or less", 5P chamfer for better tool life.
- For the bored hole diameter, the maximum minor diameter of a 6H internal thread diameter maximum value is recommended.

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

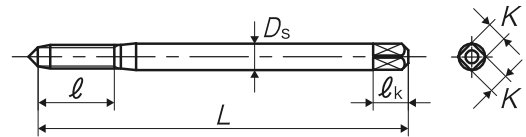
⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

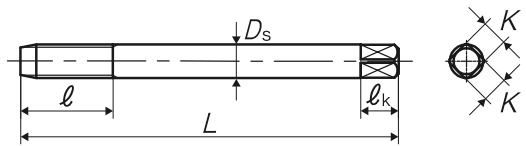
TYPE: 1

YAMAWA



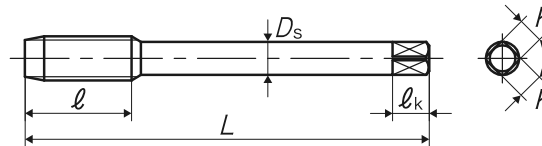
TYPE: 2

YAMAWA



TYPE: 3

DIN376



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads										
M3 $\times$ 0.5	ISO2X	TD3.0GBCWA5	5P	56	11	3.5	2.7	6	4	1
M4 $\times$ 0.7	ISO2X	TD4.0IBCWA5	5P	63	13	4.5	3.4	6	4	1
M5 $\times$ 0.8	ISO2X	TD5.0KBCWA5	5P	70	16	6	4.9	8	4	1
M6 $\times$ 1	ISO2X	TD6.0MBCWA5	5P	80	19	6	4.9	8	5	1
M8 $\times$ 1.25	ISO2X	TD8.0NBCWA5	5P	90	22	8	6.2	9	5	2
M10 $\times$ 1.5	ISO2X	TD10.0OBCWA5	5P	100	24	10	8	11	5	2
M12 $\times$ 1.75	ISO2X	TG012PBCWA5	5P	110	29	9	7	10	5	3

DIN

⑤-25

Think threads with
YAMAWA

This product is different from JIS products in shape and dimensions, please be careful when using.

M E M O

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

JIS

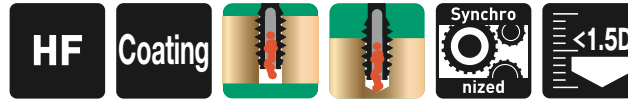
⑤-27

UH-CT

Carbide Taps for Ultra Hard Materials



Specification



Tapping Speeds depending on Materials



Product Features

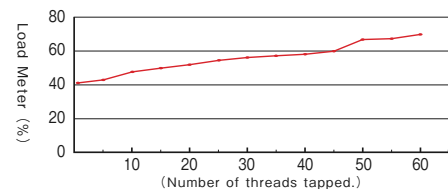
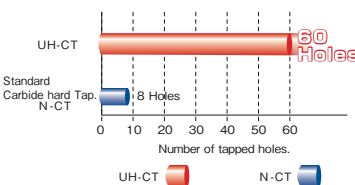
- The UH-CT is designed for tapping SKD and pre-hardened steel 50HRC to 63HRC (Max 63).
- It is produced from a ultra fine grain cemented carbide with superior abrasion resistance and impact resistance.
- The UH-CT has an improved shank roundness accuracy.
- Recommended tapping length is "Major diameter size x 1.5" or less 5P chamfer for better tool life.
- For the bored hole diameter, the maximum minor diameter of a 6H internal thread diameter maximum value is recommended.

Tapping Data

Tapping Conditions [M8×1.25]

Workpiece Material	SKD11 hardened material (60 HRC)
Bore Diameter	φ6.9
Tapping Length	16mm through hole
Tapping Speed	1.5m/min (60rpm)
Machinery Type	CNC rigid tapping machine
Tapping Fluid	Non-water soluble cutting oil

Tool Life



The figure above is a comparison of the number of tapped holes using a standard carbide tap (N-CT) and a carbide tap in SKD 11 high hardness quenched steel at 60 HRC. The N-CT tap, had chipped flutes at 8 holes. Compared to the N-CT, the UH-CT was able to process 60 holes in ultra high hardness steel. It is important to watch for a dull drill as it will cause the taps flutes to wear prematurely. The drilling is processed at a 6m/min. cutting speed and a 0.04mm/rev. feed which can easily cause work hardening.

• Bored hole in this test was prepared by using a carbide drill under such condition as could cause no work-hardening. (cutting speed: 6m/min, feed 0.04m/rev.)

The figure above shows the relationship between the number of tapped holes and the load meter (%) of the machine when machining tests are conducted up to 60 holes with UH - CT tap. The numerical value of the load meter tends to increase as the number of tapped holes increase at 50 completed threads. The cutting edge damage at this point causes the load meter to raise quickly beyond 50 tapped holes. As the number of tapped holes progresses further, the risk of tap breakage is considerable and the load will increase, so it is recommended to set the life expectancy at a safe level considering the high hardness of the steel being processed.

Selection of hole diameter (reference)

Thread Size	Hole Size	JIS6H (Level 2) Internal Thread Diameter	
		Hole Size (Max)	Hole Size (Min)
M2 ×0.4	1.65	1.679	1.567
M2.5×0.45	2.11	2.138	2.013
M2.6×0.45	2.21	2.238	2.113
M3 ×0.5	2.56	2.599	2.459
M4 ×0.7	3.40	3.422	3.242
M5 ×0.8	4.30	4.334	4.134
M6 ×1	5.10	5.153	4.917
M8 ×1.25	6.90	6.912	6.647
M10 ×1.5	8.60	8.676	8.376
M10 ×1.25	8.90	8.912	8.647

Thread Size	Hole Size	JIS6H (Level 2) Internal Thread Diameter	
		Hole Size (Max)	Hole Size (Min)
M12×1.75	10.4	10.441	10.106
M12×1.5	10.60	10.676	10.376
M12×1.25	10.90	10.912	10.647
M14×2	12.1	12.210	11.835
M14×1.5	12.60	12.676	12.376
M16×2	14.1	14.210	13.835
M16×1.5	14.60	14.676	14.376
M18×2.5	15.7	15.744	15.294
M18×1.5	16.60	16.676	16.376
M20×2.5	17.6	17.744	17.294
M20×1.5	18.60	18.676	18.376

Product system table

Slow		Tapping Speed		Fast	
Work piece Material		1m/min	3m/min	5m/min	15m/min
High hardness material	60HRC 55HRC	UH-CT (For ultra high-hardness steel)		60HRC 55HRC	
	55HRC 45HRC	EH-CT (For high-hardness steel)		55HRC 45HRC	
Tempered material Tool steel Alloy steel	45HRC 25HRC	EH-HT EH-PO (For hard-to-machine materials)		45HRC 25HRC	
	SKS • SKD SCM • SCR			SKS • SKD SCM • SCR	
		1m/min	3m/min	5m/min	15m/min

• Please use synchronous type tooling for UH - CT / EH - CT.

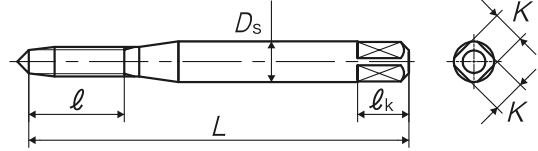
Think threads with
YAMAWA

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

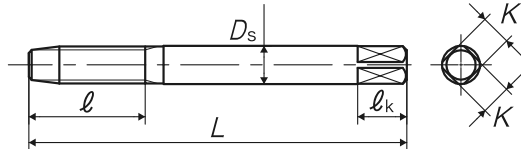
5

JIS

TYPE: 1

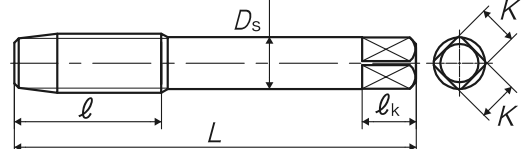
Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②

TYPE: 2

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

TYPE: 3



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads											
M2 × 0.4	P3	UHCR2.0E5	5P	40	8	4	3.2	6	3	1	¥ 18,100
M2.5 × 0.45	P3	UHCR2.5F5	5P	44	9.5	4	3.2	6	4	1	¥ 17,000
M2.6 × 0.45	P3	UHCR2.6F5	5P	44	9.5	4	3.2	6	4	1	¥ 17,000
M3 × 0.5	P3	UHCR3.0G5	5P	46	11	5	4	7	4	1	¥ 16,600
M4 × 0.7	P3	UHCR4.0I5	5P	52	13	5.5	4.5	7	4	1	¥ 17,600
M5 × 0.8	P3	UHCR5.0K5	5P	60	16	6	4.5	7	4	1	¥ 18,300
M6 × 1	P3	UHCR6.0M5	5P	62	19	6.2	5	8	5	2	¥ 19,900
M8 × 1.25	P4	UHCS8.0N5	5P	70	22	7	5.5	8	5	3	¥ 24,600
M10 × 1.5	P4	UHCS010O5	5P	75	24	8.5	6.5	9	5	3	¥ 33,200
M10 × 1.25	P4	UHCS010N5	5P	75	24	8.5	6.5	9	5	3	¥ 33,200 ※
M12 × 1.75	P4	UHCS012P5	5P	82	30	10.5	8	11	5	3	¥ 43,700
M12 × 1.5	P4	UHCS012O5	5P	82	30	10.5	8	11	5	3	¥ 43,700 ※
M12 × 1.25	P4	UHCS012N5	5P	82	30	10.5	8	11	5	3	¥ 43,700 ※
M14 × 2	P4	UHCS014Q5	5P	88	30	12.5	10	13	6	3	¥ 60,000 ※
M14 × 1.5	P4	UHCS014O5	5P	88	30	12.5	10	13	6	3	¥ 60,000 ※
M16 × 2	P4	UHCS016Q5	5P	95	30	14	11	14	6	3	¥ 72,600 ※
M16 × 1.5	P4	UHCS016O5	5P	95	30	14	11	14	6	3	¥ 72,600 ※
M18 × 2.5	P4	UHCS018R5	5P	100	35	15	12	15	6	3	¥ 85,700 ※
M18 × 1.5	P4	UHCS018O5	5P	100	35	15	12	15	6	3	¥ 85,700 ※
M20 × 2.5	P4	UHCS020R5	5P	105	35	17	13	16	6	3	¥ 101,000 ※
M20 × 1.5	P4	UHCS020O5	5P	105	35	17	13	16	6	3	¥ 101,000 ※

Note: Ds, K and ℓ_k of UH-CT are one rank higher than those of standard tap dimensions.Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

JIS

⑤-28

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

DIN

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

DIN

UH-CT

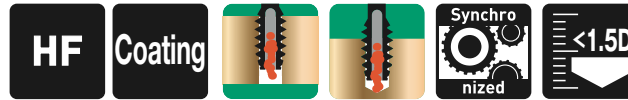
Carbide Taps for Ultra Hard Materials



Product Features

- The UH-CT is designed for tapping SKD and pre-hardened steel 50HRC to 63HRC (Max 63).
- It is produced from a ultra fine grain cemented carbide with superior abrasion resistance and impact resistance.
- The UH-CT has an improved shank roundness accuracy.
- Recommended tapping length is "Major diameter size x 1.5" or less 5P chamfer for better tool life.
- For the bored hole diameter, the maximum minor diameter of a 6H internal thread diameter maximum value is recommended.

Specification

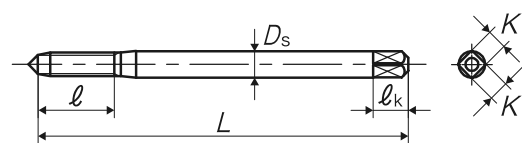


Tapping Speeds depending on Materials

Thermal refined steels
調質鋼
~5
(m/min)
50~63HRC

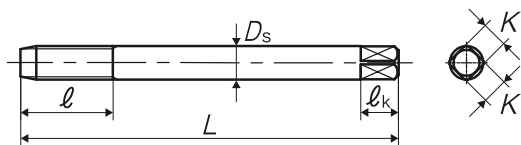
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YAMAWA



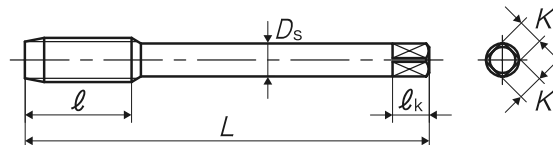
TYPE: 2

YAMAWA



TYPE: 3

DIN376



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads										
M3 × 0.5	ISO2X	TD3.0GBBWA5	5P	56	11	3.5	2.7	6	4	1
M4 × 0.7	ISO2X	TD4.0IBBWA5	5P	63	13	4.5	3.4	6	4	1
M5 × 0.8	ISO2X	TD5.0KBBWA5	5P	70	16	6	4.9	8	4	1
M6 × 1	ISO2X	TD6.0MBBWA5	5P	80	19	6	4.9	8	5	1
M8 × 1.25	ISO2X	TD8.0NBBWA5	5P	90	22	8	6.2	9	5	2
M10 × 1.5	ISO2X	TD010OBBWA5	5P	100	24	10	8	11	5	2
M12 × 1.75	ISO2X	TG012PBBWA5	5P	110	29	9	7	10	5	3
M14 × 2	ISO2X	TG014QBBWA5	5P	110	30	11	9	12	6	3
M16 × 2	ISO2X	TG016QBBWA5	5P	110	32	12	9	12	6	3
M18 × 2.5	ISO2X	TG018RBBWA5	5P	125	34	14	11	14	6	3
M20 × 2.5	ISO2X	TG020RBBWA5	5P	140	34	16	12	15	6	3

Think threads with
YAMAWA

This product is different from JIS products in shape and dimensions, please be careful when using.

M E M O

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓs	Ds

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

JIS

HFACT-P



Carbide Taps for Ultra Fast Tappings, Through Hole Use, for Aluminum

Specification



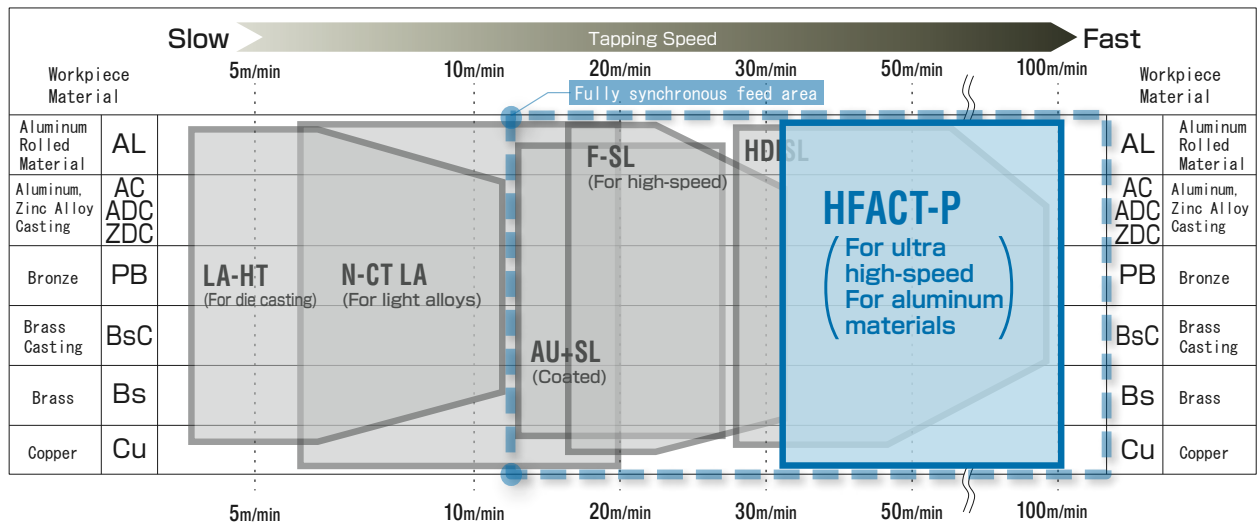
Tapping Speeds depending on Materials

Brass castings 黄銅鑄物	Aluminum alloy castings アルミ合金鑄物	Magnesium alloy die castings マグネシウム合金鑄物	Zinc alloy castings 亜鉛合金鑄物
30~100 (m/min)	30~100 (m/min)	30~100 (m/min)	30~100 (m/min)

Product Features

- The HFACT-P is a carbide tap capable of ultra high speed tapping in Aluminum. Utilizing a side coolant through hole shape, it is compatible with internal lubrication and mist applications for through hole tapping. It lowers temperature cooling in dry tapping where necessary. It is suitable for materials such as aluminum casting or aluminum die casting.

Product system table



A diagram of tapping range.

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

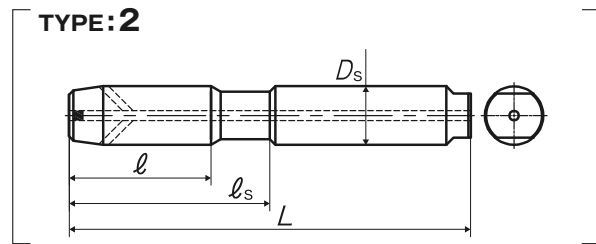
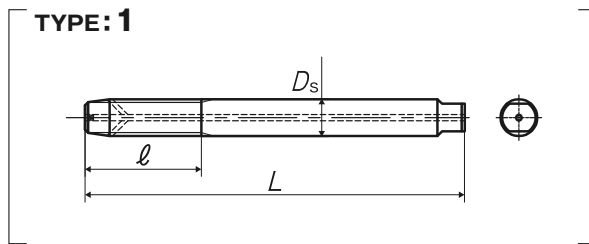
⑫ Precision Machinery/
Medical Surgical Instruments

JIS

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓ_s	Ds

5

JIS



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M6 × 1	P3	HFACTPR6.0M	4P	62	19	-	6	-	-	3	1	¥ 28,200
M8 × 1.25	P3	HFACTPR8.0N	4P	70	22	36	8	-	-	3	2	¥ 36,500
M10 × 1.5	P3	HFACTPR010O	4P	75	24	37	10	-	-	3	2	¥ 50,200
M10 × 1.25	P3	HFACTPR010N	4P	75	24	37	10	-	-	3	2	¥ 50,200
M12 × 1.75	P3	HFACTPR012P	4P	82	29	40	12	-	-	3	2	¥ 65,500
M12 × 1.5	P3	HFACTPR012O	4P	82	29	40	12	-	-	3	2	¥ 65,500
M12 × 1.25	P3	HFACTPR012N	4P	82	29	40	12	-	-	3	2	¥ 65,500

Note:

- There is no shank square so please use a holder with high holding force such as milling chuck.
- The back end of the shank is a tongue drive specification. If the area where the back end of the shank contacts the holder is a V dish shape, the coolant may leak.

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓs	Ds

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

JIS

HFACT-B

Carbide Taps for Ultra Fast Tappings, Blind Hole Use, for Aluminum



Specification



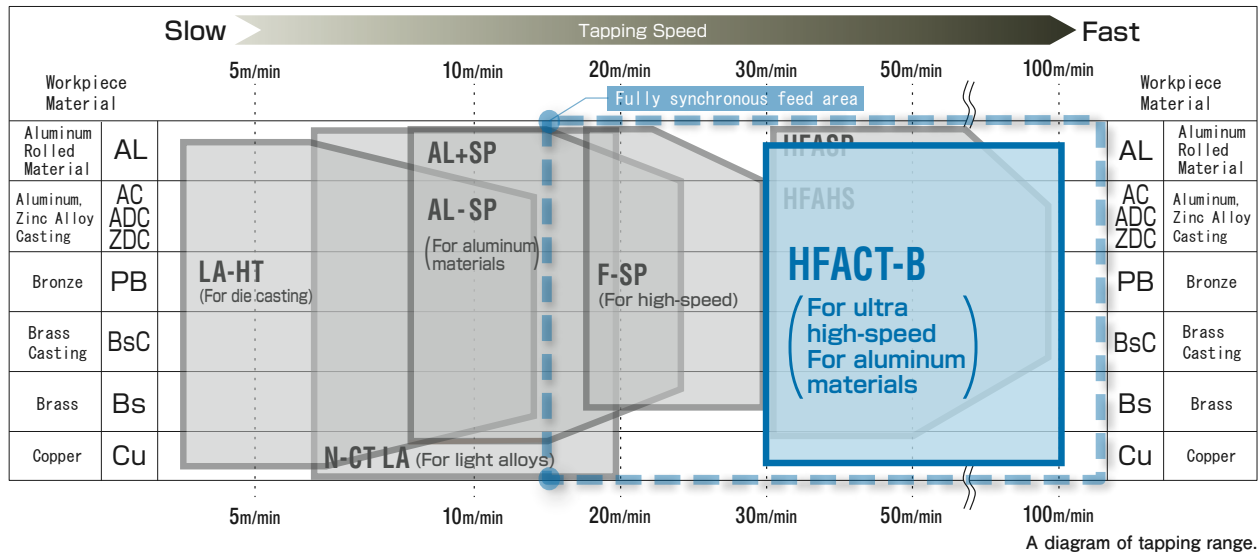
Tapping Speeds depending on Materials

Brass castings 黄銅鑄物	Aluminum alloy castings アルミ合金鑄物	Magnesium alloy die castings マグネシウム合金鑄物	Zinc alloy castings 亜鉛合金鑄物
30~100 (m/min)	30~100 (m/min)	30~100 (m/min)	30~100 (m/min)

Product Features

- The HFACT-B is a carbide tap capable of ultra high speed tapping. It has a center coolant through hole for internal lubrication distribution or mist applications. It can lower temperature by cooling in a dry tapping application where necessary with an air blast. It is suitable for blind hole tapping in materials such as aluminum casting or aluminum die casting.

Product system table



⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

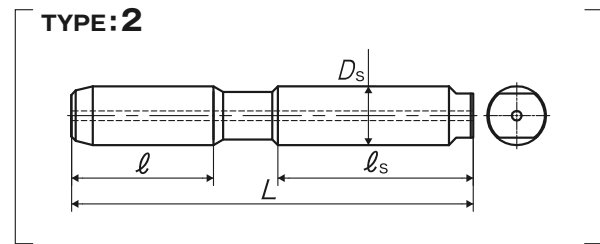
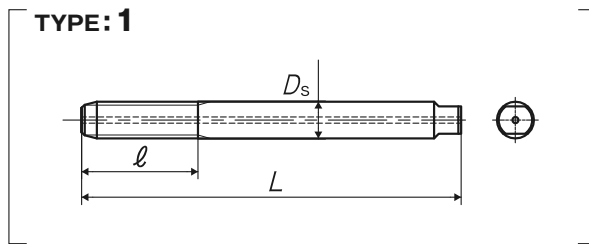
JIS

⑤-33

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓ_s	Ds

5

JIS



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M6 × 1	P3	HFACTBR6.0M	2.5P	62	19	-	6	-	-	3	1	¥ 28,200
M8 × 1.25	P3	HFACTBR8.0N	2.5P	70	22	36	8	-	-	3	2	¥ 36,500
M10 × 1.5	P3	HFACTBR010O	2.5P	75	24	37	10	-	-	3	2	¥ 50,200
M10 × 1.25	P3	HFACTBR010N	2.5P	75	24	37	10	-	-	3	2	¥ 50,200
M12 × 1.75	P3	HFACTBR012P	2.5P	82	29	40	12	-	-	3	2	¥ 65,500
M12 × 1.5	P3	HFACTBR012O	2.5P	82	29	40	12	-	-	3	2	¥ 65,500
M12 × 1.25	P3	HFACTBR012N	2.5P	82	29	40	12	-	-	3	2	¥ 65,500

Note:

- There is no shank square so please use a holder with high holding force such as milling chuck.
- The back end of the shank is a tongue drive specification. If the area where the back end of the shank contacts the holder is a V dish shape, the coolant may leak.

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for blind hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓs	Ds

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

JIS

HFICT-P



Carbide Taps for Ultra Fast Tappings, Through Hole Use, for Cast Irons

Specification



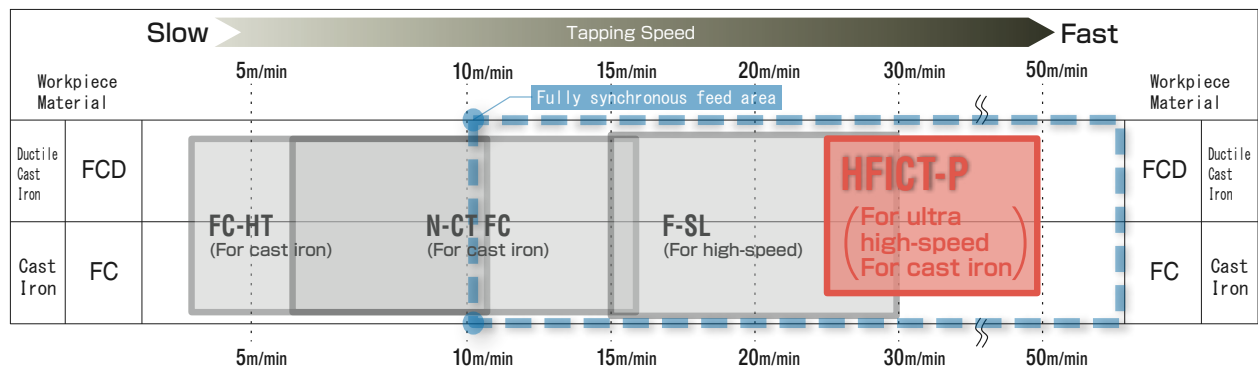
Tapping Speeds depending on Materials

Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄	Brass castings 黄銅鑄物
25 ~ 50 (m/min)	25 ~ 50 (m/min)	25 ~ 50 (m/min)

Product Features

- The HFICT-P is a carbide tap capable of ultra high speed tapping. It has a side coolant through hole for internal lubrication distribution or mist applications. It can lower temperature by cooling in a dry tapping application where necessary with an air blast. It is suitable for through hole tapping in materials such as cast irons and brass castings.

Product system table



A diagram of tapping range.

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

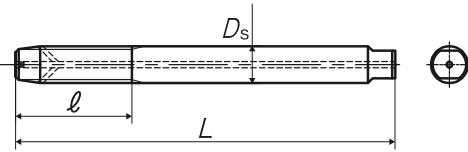
JIS

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓ_s	Ds

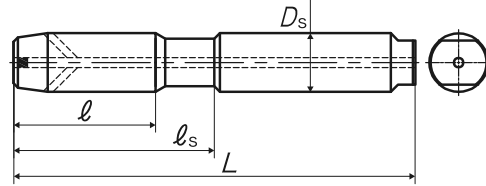
5

JIS

TYPE:1



TYPE:2



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M6 × 1	P3	HFICTPR6.0M	4P	62	19	-	6	-	-	4	1	¥ 28,200
M8 × 1.25	P3	HFICTPR8.0N	4P	70	22	36	8	-	-	4	2	¥ 36,500
M10 × 1.5	P3	HFICTPR010O	4P	75	24	37	10	-	-	4	2	¥ 50,200
M10 × 1.25	P3	HFICTPR010N	4P	75	24	37	10	-	-	4	2	¥ 50,200
M12 × 1.75	P3	HFICTPR012P	4P	82	29	40	12	-	-	4	2	¥ 65,500
M12 × 1.5	P3	HFICTPR012O	4P	82	29	40	12	-	-	4	2	¥ 65,500
M12 × 1.25	P3	HFICTPR012N	4P	82	29	40	12	-	-	4	2	¥ 65,500

Note:

- There is no shank square so please use a holder with high holding force such as milling chuck.
- The back end of the shank is a tongue drive specification. If the area where the back end of the shank contacts the holder is a V dish shape, the coolant may leak.

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

⑤ Cemented Carbide Tap Series

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓs	Ds

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

JIS

HFICT-B



Carbide Taps for Ultra Fast Tappings, Blind Hole Use, for Cast Irons

Specification



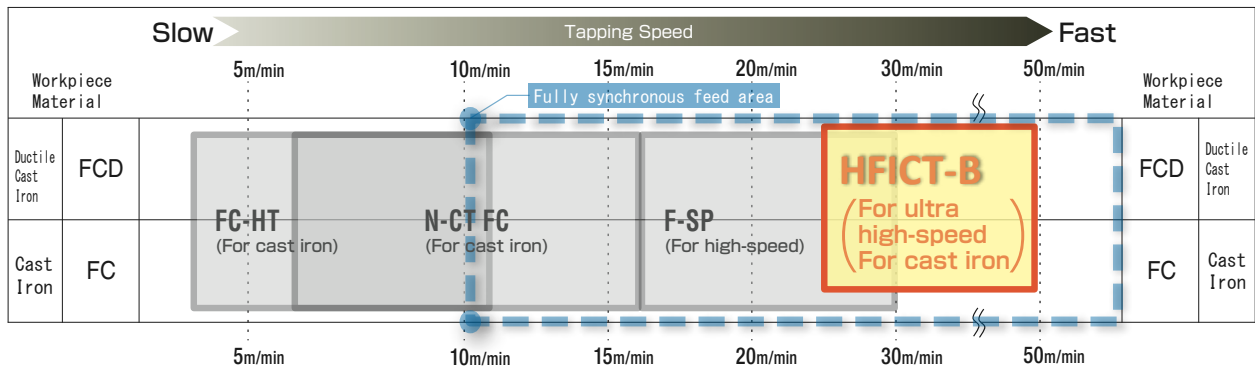
Tapping Speeds depending on Materials

Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄	Brass castings 黄銅鑄物
25 ~ 50 (m/min)	25 ~ 50 (m/min)	25 ~ 50 (m/min)

Product Features

- The HFICT-B is a carbide tap capable of ultra high speed tapping. It has a coolant through hole for internal lubrication distribution or mist applications. It can lower temperature by cooling in a dry tapping application where necessary with an air blast. It is suitable for blind hole tapping in materials such as cast irons and brass castings.

Product symbol table



A diagram of tapping range.

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

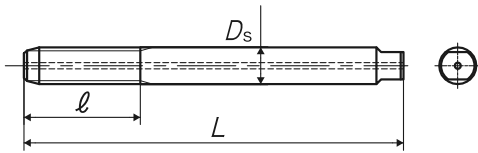
JIS

Overall length	Thread length	Shank length	Shank dia.
L	ℓ	ℓ_s	Ds

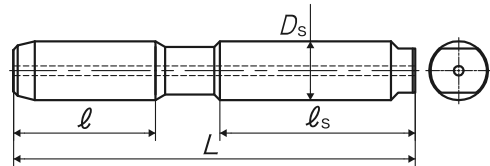
5

JIS

TYPE:1



TYPE:2



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M6 × 1	P3	HFICTBR6.0M	2.5P	62	19	-	6	-	-	4	1	¥ 28,200
M8 × 1.25	P3	HFICTBR8.0N	2.5P	70	22	36	8	-	-	4	2	¥ 36,500
M10 × 1.5	P3	HFICTBR010O	2.5P	75	24	37	10	-	-	4	2	¥ 50,200
M10 × 1.25	P3	HFICTBR010N	2.5P	75	24	37	10	-	-	4	2	¥ 50,200
M12 × 1.75	P3	HFICTBR012P	2.5P	82	29	40	12	-	-	4	2	¥ 65,500
M12 × 1.5	P3	HFICTBR012O	2.5P	82	29	40	12	-	-	4	2	¥ 65,500
M12 × 1.25	P3	HFICTBR012N	2.5P	82	29	40	12	-	-	4	2	¥ 65,500

Note:

- There is no shank square so please use a holder with high holding force such as milling chuck.
- The back end of the shank is a tongue drive specification. If the area where the back end of the shank contacts the holder is a V dish shape, the coolant may leak.

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

5 Cemented Carbide Tap Series

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.
L	ℓ	ℓn	ℓs	Ds

JIS

①

Spiral Fluted Taps
(for blind hole)

②

Spiral Fluted Taps
(for through hole)

③

Spiral Pointed Taps
(for through hole)

④

Hand Taps

S

ACHSP

Spiral Fluted Tap for Aluminum Casting



Specification



Tapping Speeds depending on Materials

Aluminum alloy castings
アルミ合金鋳物
30 ~ 50
(m/min)

Features

- Direct tapping of cored holes without drilling first, results in reducing the manufacturing time.
- Made from an ultrafine grain carbide alloy combining the hardness and toughness.
- The shank diameter is the same as the major diameter of the tap which improves rigidity and makes the ACHSP more resistant to deflection and the cutting side pressure caused from misalignment. (Maximum displacement of core hole: M6 · M8 within 0.3 mm, M 10 within 0.5 mm)
- A thin film coating offers improvements in wear resistance and a reduction of cutting edge chipping.

Tapping Data

Tapping Conditions [M8×1.25]

Workpiece Material		ADC12
Tapping Speed		50m/min
Number of Holes Tapped		50 hole
Bored Hole Shape	Bore Diameter	φ5.8
	Taper Angle	2°
	Depth	22mm
	Condition	Blind hole
Tapping Length		17mm
Misalignment Amount		X direction + 0.5 mm
Feed Type		Synchronous feed
Machine Type		M / C machine (horizontal type)
Tapping Fluid		Water soluble cutting fluid

Condition of Internal Threads

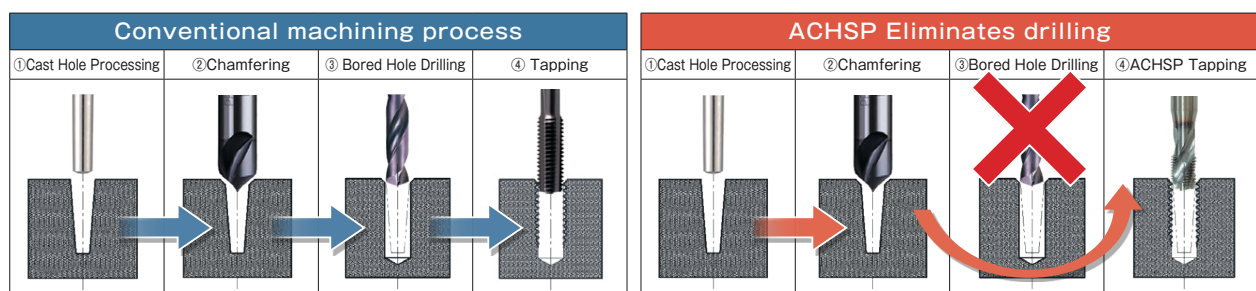


Chip Shape



Reduction of machining time

Correcting misaligned cast pilot holes is unnecessary shortening the tapping process time!



Recommendation

Internal coolant supply is recommended to prevent the tapped holes from being blocked by the ejected chips.

Think threads with
YAMAWA

JIS

⑤-39

⑤

Cemented Carbide Taps

⑥

Roll Taps

⑦

Special Thread Taps
Simple Inspection Tools

⑧

Pipe Taps

⑨

Thread Mills
Premium Thread Mills

⑩

Dies

⑪

Center Drills
Centering Tools

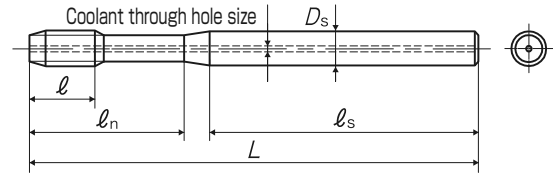
⑫

Precision Machinery/
Medical Surgical Instruments

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.
L	ℓ	ℓ_n	ℓ_s	D_s

5

JIS

TYPE: 1

Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	Coolant hole size (mm)	TYPE	MSRP
For Metric Threads														
M6 × 1	P3	SY6.0MRLXT	2.5P	80	12	27	48	6	-	-	3	1	1	¥ 42,500
M8 × 1.25	P4	SY8.0NSLXT	2.5P	90	15	30	54	8	-	-	3	1	1	¥ 53,200
M10 × 1.5	P4	SY010OSLXT	2.5P	100	18	36	57	10	-	-	3	1.5	1	¥ 69,500
M10 × 1.25	P4	SY010NSLXT	2.5P	100	18	36	57	10	-	-	3	1.5	1	¥ 69,500

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

⑤ Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

JIS

MC-AD-CT

Carbide Taps with Oil Hole



Specification



Tapping Speeds depending on Materials

Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
30 ~ 60 (m/min)	30 ~ 60 (m/min)	30 ~ 60 (m/min)

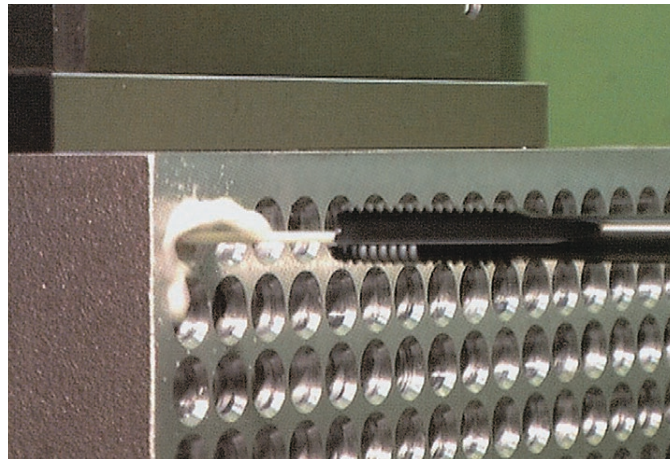
Product Features

- The MC-AD-CT is a carbide tap with an coolant through hole, suitable for screw thread tapping of aluminum alloy casting and aluminum die casting in blind holes.
- The flute shape develops less flute damage · The MC-AD-CT is a ultra fine grain cemented carbide tap with superior wear resistance · The superior carbide combined with an optimum coating produces a 5 times longer tool life than conventional aluminum taps.
- The center coolant through hole shape is designed for internal lubrication and mist applications. The lubrication or air lowers the temperature by cooling even in dry tapping. It is effective in removing chips from the pilot hole during tapping and prevents chip welding.

Tapping Data

Tapping conditions [M6×1]

Workpiece Material	ADC12
Bored Hole Shape	Blind Hole
Bored Hole Depth	14mm
Tapping Length	12mm
Tapping Speed	57m/min
Feed	Fully synchronous feed
Machinery Type	Horizontal machining center
Tapping Fluid	Water soluble cutting fluid
Number of Holes Tapped	240,000 holes



⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills
Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

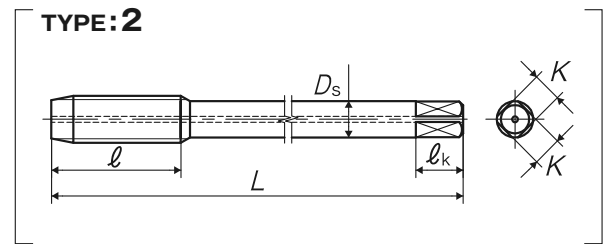
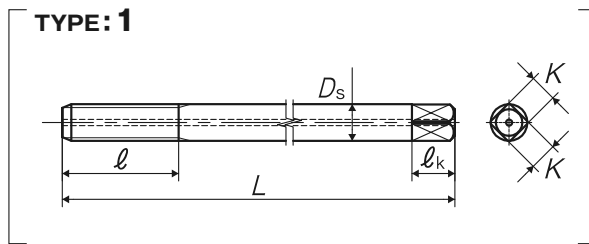
⑫ Precision Machinery/
Medical Surgical Instruments

JIS

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

5

JIS



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads											
M6 × 1	P3	MCADR6.0M1	1.5P	100	19	6	4.5	7	3	1	¥ 23,000 [□]
M8 × 1.25	P3	MCADR8.0N1	1.5P	100	22	6.2	5	8	3	2	¥ 25,400 [□]
M10 × 1.5	P4	MCADS010O1	1.5P	100	24	7	5.5	8	3	2	¥ 35,200 [□]
M10 × 1.25	P4	MCADS010N1	1.5P	100	22	7	5.5	8	3	2	¥ 35,200 [□]
M10 × 1	P4	MCADS010M1	1.5P	100	19	7	5.5	8	3	2	¥ 35,200 [□]
M12 × 1.75	P4	MCADS012P1	1.5P	100	30	8.5	6.5	9	3	2	¥ 44,600 [□]
M12 × 1.5	P4	MCADS012O1	1.5P	100	24	8.5	6.5	9	3	2	¥ 44,600 [□]
M12 × 1.25	P4	MCADS012N1	1.5P	100	22	8.5	6.5	9	3	2	¥ 44,600 [□]

Note: Products marked with an ▲ in the stock column are available while supplies last.

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Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

JIS

⑤-42

□=In stock at manufacturer.

 Think threads with
YAMAWA

