

JIS • ANSI • DIN

LINE UP

⑧ PIPE TAP SERIES



	JIS	ANSI	DIN
Z-PRO AUSP Rc	⑧-7		⑧-9
Z-PRO PMST OX Rc	⑧-11		⑧-13
Z-PRO PMSP OX Rc	⑧-15		⑧-17
Z-PRO AUSP Rp	⑧-19		⑧-21
Z-PRO AUSP G	⑧-23		⑧-25
Rc	⑧-27		
PT	⑧-28		
PT LH	⑧-29		
PT-X	⑧-30		
S-PT	⑧-31		
S-PT LH	⑧-32		
LS-PT	⑧-33		
LS-S-PT	⑧-34		
SP-PT	⑧-35		
SP-S-PT	⑧-36		
SP-PT-X	⑧-37		
LS-SP-PT	⑧-38		
LS-SP-S-PT	⑧-39		
INT-PT	⑧-40		
INT-S-PT	⑧-41		
LS-INT-PT	⑧-42		
LS-INT-S-PT	⑧-43		
LC-PT	⑧-44		
LC-S-PT	⑧-45		
SU-PT	⑧-46		
SU-S-PT	⑧-47		
SU-SP-PT	⑧-48		
SU-SP-S-PT	⑧-49		
FC-PT	⑧-50		
FC-S-PT	⑧-51		
CT-PT	⑧-52		
CT-S-PT	⑧-53		
Rp	⑧-54		
PS	⑧-55		
PS LH	⑧-57		
LS-PS	⑧-58		
SP-PS	⑧-59		
LS-SP-PS	⑧-60		
FC-PS	⑧-61		
CT-PS	⑧-62		
G	⑧-63		
SP G			⑧-65
SP OX G			⑧-66
SP V G			⑧-67
SP-VA G			⑧-68
SU2-SP G			⑧-69
LO-SP G			⑧-70
LO-SP OX G			⑧-71
PH-SP G			⑧-72
PO G			⑧-73

	JIS	ANSI	DIN
PO OX G			⑧-74
PO V G			⑧-75
PO-VA G			⑧-76
HT G			⑧-77
Z-PRO GGST G			⑧-79
GG-HT G			⑧-80
GG-HT G (Coating)			⑧-81
EH-HT G			⑧-82
R-D G			⑧-83
R-D G (Coating)			⑧-84
PF	⑧-85		
PF LH	⑧-87		
LS-PF	⑧-88		
SP-PF	⑧-89		
LS-SP-PF	⑧-90		
SU-PF	⑧-91		
SU-SP-PF	⑧-92		
FC-PF	⑧-93		
CT-PF	⑧-94		
NPT	⑧-95	⑧-96	
ZELX MOLD NPT		⑧-97	
NPT-CI		⑧-98	
S-NPT	⑧-99		
LS-NPT	⑧-100		
SP-NPT	⑧-101		
ZELX SS NPT		⑧-102	
LS-SP-S-NPT	⑧-103		
INT-NPT	⑧-104	⑧-105	
INT-S-NPT	⑧-106		
NPTF	⑧-107	⑧-108	
NPTF-CI		⑧-109	
ZELX SS NPTF		⑧-110	
LS-NPTF	⑧-111		
NPS	⑧-112	⑧-113	
NPSF	⑧-114	⑧-115	

Selection chart of taps

Tapping conditions											
Product symbol		Z-PRO AUSP Rc	Z-PRO PMST OX Rc	Z-PRO PMSP OX Rc	Rc	PT	PT-X	S-PT	SP-PT	SP-S-PT	
Tap material Surface treatment		HSS Coating	HSS-P OX	HSS-P OX	HSS	HSS	HSS	HSS	HSS	HSS	
Name		For taper pipe threads, coated	Straight fluted taps for taper pipe threads (for hard steels)	Spiral fluted taps for taper pipe threads (for hard steels)	For taper pipe threads; For general use						
											
Bored Hole Shape											
For Metric Threads											
For Unified Threads											
For Whitworth Threads											
For Screw Threads used on Sewing Machines											
Pipe Threads		⑧-8	⑧-12	⑧-16	⑧-27	⑧-28	⑧-30	⑧-31	⑧-35	⑧-36	
American Pipe Threads											
For Miniature Threads											
For Trapezoidal Threads											

⑦	Special Thread Taps Simple Inspection Tools	~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																	

Machining, in low-speed tapping area

[illegible][illegible]

⑧-2

Selection chart of taps

Tapping conditions													
Product symbol		INT-PT	INT-S-PT	LS-INT-PT	LS-INT-S-PT	FC-PT	FC-S-PT	CT-PT	CT-S-PT	NPT			
Tap material Surface treatment		HSSOX	HSSOX	HSSOX	HSSOX	HSSNI	HSSNI	HF	HF	HSS			
Name		For taper pipe threads For stainless steel, interrupted		For taper pipe threads, long For stainless steel, interrupted		For taper pipe threads; For cast iron				For American taper pipe threads; For general use			
Bored Hole Shape													
For Metric Threads													
For Unified Threads													
For Whitworth Threads													
For Screw Threads used on Sewing Machines													
Pipe Threads		⑧-40	⑧-41	⑧-42	⑧-43	⑧-50	⑧-51	⑧-52	⑧-53				
American Pipe Threads										⑧-95			
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																		

[illegible]

Selection chart of taps

Tapping conditions											
Product symbol		SP-PF	LS-PS	LS-SP-PS	LS-PF	LS-SP-PF	PS LH	PF LH	Z-PRO AUSP Rp	Z-PRO AUSP G	
Tap material Surface treatment		HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS Coating	HSS Coating	
Name		For parallel pipe threads; For general use	For parallel pipe threads; Long, for general use	For parallel pipe threads; Long, for general use			For parallel pipe threads; For general use For left-hand threads		For parallel pipe threads, coated		
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	Bored Hole Shape										
	For Metric Threads										
	For Unified Threads										
	For Whitworth Threads										
	For Screw Threads used on Sewing Machines										
⑥ Roll Taps	Pipe Threads	⑧-89	⑧-58	⑧-60	⑧-88	⑧-90	⑧-57	⑧-87	⑧-20	⑧-24	
	American Pipe Threads										
	For Miniature Threads										
	For Trapezoidal Threads										
⑦ Special Thread Taps Simple Inspection Tools	~S25C	Low carbon steels	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	
	S25C~S45C	Medium carbon steels	◆ ◎	◆ ◎	◆ ◎	◆ ◎	◆ ◎	◆ ◎	◆ ◎	◆ ◎	
	S45C~	High carbon steels	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	◆ ○	
	SCM	Alloy steels							◆ ◎	◆ ◎	
⑧ Pipe Taps	25~35HRC	Heat treated steel									
	35~45HRC	Heat treated steel									
	45~55HRC	Heat treated steel									
	55~63HRC	Heat treated steel									
⑨ Thread Mills Premium Thread Mills	SUS	Stainless steels (SUS)							◆ ○	◆ ○	
	SKD	Tool steels									
	SC	Cast steels									
	FC	Cast irons									
⑩ Dies	FCD	Ductile cast irons									
	Cu	Copper									
	Bs	Brass									
	BsC	Brass castings									
	PB	Bronze									
⑪ Center Drills Centering Tools	AL	Wrought aluminum									
	AC, ADC	Aluminum alloy casting							◆ ○	◆ ○	
	Mg	Magnesium alloy die castings									
	ZDC	Zinc alloy die castings							◆ ○	◆ ○	
⑫ Precision Machinery/Medical Surgical Instruments		Titanium alloys									
		Nickel base alloys									
		Thermosetting plastic									
		Thermoplastic resin									

[illegible][illegible]

Spiral Fluted Taps (for blind hole)

Spiral Fluted Taps (for through hole)

Spiral Pointed Taps (for through hole)

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps

Special Thread Taps

Pipe Taps

Thread Mills
Premium Thread Mills

10 Dies

Center Drills Centering Tools

Precision Machinery/
Medical Surgical Instruments

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-7



Z-PRO

AUSP Rc

Z-PRO

Coated Spiral Fluted Taps for Taper Pipe Threads



Specification

HSS

Coating



Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
~7
(m/min)

Medium carbon steels
中炭素鋼
~7
(m/min)

High carbon steels
高炭素鋼
~7
(m/min)

Alloy steels
合金鋼
~5
(m/min)

Stainless steels
ステンレス鋼
~3
(m/min)

Aluminum alloy castings
アルミ合金鋳物
~10
(m/min)

Zinc alloy castings
亜鉛合金鋳物
~10
(m/min)

Product Features

- Proper tool projection length is secured, achieving a good chip ejection efficiency.
- Good internal thread surface and long tool life are achieved through adoption of the unique cutting edge shape and special coating.

Tapping Data

Tapping conditions [AUSP Rc 1/4-19]

Workpiece Materials	SS400
Tapping Speed	5m/min
Machine	Machining center
Holder	With tension and compression
Tapping Fluid	Water soluble cutting fluid

YAMAWA

AUSP Rc Good surface roughness



Competitor

Spiral fluted tap Gouges have occurred



• Compatible with tapping of a wide range of work materials

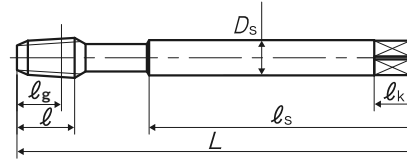
AUSP Rc Standard tapping conditions

Workpiece Materials		Standard Tapping Speed (m/min)
Stainless Steels	SUS304	~3
Alloy Steels	SCM/SCr	~5
High Carbon Steels	S45C ~	~7
Medium Carbon Steels	S25C ~ S45C	~7
Low Carbon Steels	~ S20C/SS400	~7
Aluminum Alloy Casting/ Zinc Alloy Casting	AC/ADC/ZDC	~10

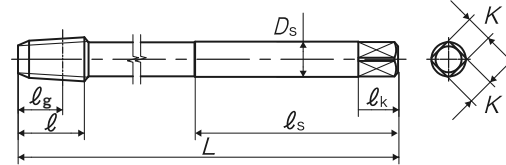
Think threads with
YAMAWA

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ _g	ℓ _s	D _s	K	ℓ _k

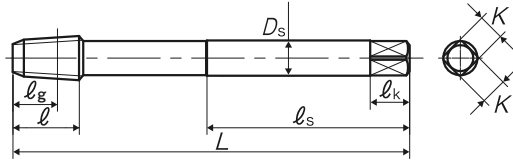
TYPE: 1

Spiral Fluted Taps
(for blind hole) ①

TYPE: 3

Spiral Fluted Taps
(for through hole) ②

TYPE: 2

Spiral Pointed Taps
(for through hole) ③

Segment : 1G

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ _g (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
Rc 1/16-28	SJRC010FET	C(2.5P)	7.723	90	14	10.1	60	8	6	9	3	1	¥ 6,470
Rc 1/8-28	SJRC020FET	C(2.5P)	9.728	90	15	10.1	46	8	6	9	3	2	¥ 6,470
Rc 1/4-19	SJRC040FET	C(2.5P)	13.157	100	19	15.0	51	11	9	12	3	2	¥ 9,640
Rc 3/8-19	SJRC060FET	C(2.5P)	16.662	100	21	15.4	51	14	11	14	3	2	¥ 15,200
Rc 1/2-14	SJRC080FET	C(2.5P)	20.955	125	26	20.5	64	18	14	17	4	2	¥ 24,000
Rc 3/4-14	SJRC120FET	C(2.5P)	26.441	140	28	21.8	71	23	17	20	4	2	¥ 39,700
Rc 1 -11	SJRC160FET	C(2.5P)	33.249	160	33	26.0	82	26	21	24	4	2	¥ 71,100
Long shank, for Pipe Threads													
Rc 1/8-28	SJRC020FETG	C(2.5P)	9.728	150	15	10.1	40	8	6	9	3	3	¥ 15,100
Rc 1/8-28	SJRC020FETK	C(2.5P)	9.728	200	15	10.1	40	8	6	9	3	3	¥ 21,600 ※
Rc 1/4-19	SJRC040FETG	C(2.5P)	13.157	150	19	15.0	50	11	9	12	3	3	¥ 17,400
Rc 1/4-19	SJRC040FETK	C(2.5P)	13.157	200	19	15.0	50	11	9	12	3	3	¥ 24,800 ※
Rc 3/8-19	SJRC060FETG	C(2.5P)	16.662	150	21	15.4	50	14	11	14	3	3	¥ 25,600
Rc 3/8-19	SJRC060FETK	C(2.5P)	16.662	200	21	15.4	50	14	11	14	3	3	¥ 37,300 ※
Rc 1/2-14	SJRC080FETK	C(2.5P)	20.955	200	26	20.5	60	18	14	17	4	3	¥ 44,400 ※
Rc 3/4-14	SJRC120FETK	C(2.5P)	26.441	200	28	21.8	70	23	17	20	4	3	¥ 57,900 ※
Rc 1 -11	SJRC160FETK	C(2.5P)	33.249	200	33	26.0	70	26	21	24	4	3	¥ 80,600 ※

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

⑧-8

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_g	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

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

⑧-9



Z-PRO

AUSP Rc

Z-PRO

Coated Spiral Fluted Taps for Taper Pipe Threads



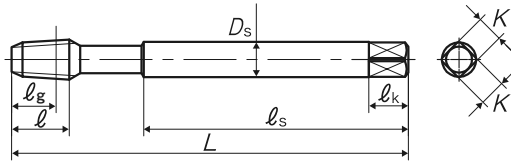
Specification



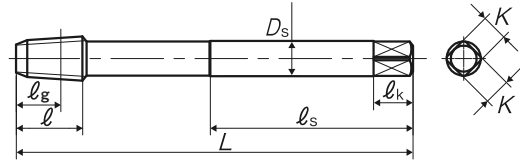
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~7 (m/min)	Medium carbon steels 中炭素鋼 ~7 (m/min)	High carbon steels 高炭素鋼 ~7 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~3 (m/min)	Aluminum alloy castings アルミ合金鋳物 ~10 (m/min)	Zinc alloy castings 亜鉛合金鋳物 ~10 (m/min)
--	---	---	--------------------------------------	---	--	---

TYPE:1



TYPE:2



Segment : 1G

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_g (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Pipe Threads												
Rc 1/16-28	3119020002	C(2.5P)	7.723	90	14	10.1	46	6	4.9	8	3	1
Rc 1/8-28	3119020004	C(2.5P)	9.728	90	15	10.1	46	7	5.5	8	3	2
Rc 1/4-19	3119020006	C(2.5P)	13.157	100	19	15.0	51	11	9	12	3	2
Rc 3/8-19	3119020008	C(2.5P)	16.662	100	21	15.4	51	12	9	12	3	2
Rc 1/2-14	3119020009	C(2.5P)	20.955	125	26	20.5	64	16	12	15	4	2
Rc 3/4-14	3119020011	C(2.5P)	26.441	140	28	21.8	71	20	16	19	4	2
Rc 1 -11	3119020013	C(2.5P)	33.249	160	33	26.0	82	25	20	23	4	2

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

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

Z-PRO

PMST OX Rc

Z-PRO

Straight Fluted Taps for Taper Pipe Threads, for High Hardness Materials



Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)	Medium carbon steels 中炭素鋼 ~5 (m/min)	High carbon steels 高炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Thermal refined steels 調質鋼 ~3 (m/min) 25~35HRC	Thermal refined steels 調質鋼 ~3 (m/min) 35~45HRC	Tool steels 工具鋼 ~5 (m/min)	Cast steels 鋳鋼 ~5 (m/min)
Cast irons 鑄鉄 ~5 (m/min)	Ductile cast irons 強靱鑄鉄 ~5 (m/min)	Aluminum alloy castings アルミ合金鑄物 ~7 (m/min)	Magnesium alloy die castings マグネシウム合金鑄物 ~7 (m/min)	Zinc alloy castings 亜鉛合金鑄物 ~7 (m/min)	Brass 黄銅 ~7 (m/min)	Brass castings 黄銅鑄物 ~7 (m/min)	

Product Features

- Proper tool projection length is secured, achieving an excellent supply of cutting fluid.
- Ideal for tapping hard steels from 30 to 45 HRC, such as plastic die steels.

Tapping Data

Tapping conditions

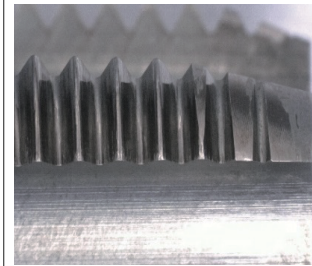
Workpiece Material	NAK55 (40HRC)
Tapping Speed	3m/min
M a c h i n e	Machining center (Vertical)
H o l d e r	With tension and compression
Tapping Fluid	Non-water soluble cutting oil

PMST OX Rc 1/4-19 (After 10 holes)

Excellent internal thread



Less damage on the edge



Comparison of Rc and PT tap dimensions

Comparison table of tap dimensions between PMST OX Rc and "SP-PT (long thread type)"

Size	PMST OX Rc			
	Overall length L (mm)	Thread length ℓ (mm)	Position on basic dia. ℓg (mm)	Shank dia. Ds (mm)
Rc 1/16-28	90	14	10.1	8
Rc 1/8-28	90	15	10.1	8
Rc 1/4-19	100	19	15	11
Rc 3/8-19	100	21	15.4	14
Rc 1/2-14	125	26	20.5	18
Rc 3/4-14	140	28	21.8	23
Rc 1 -11	160	33	26	26

Size	SP-PT (Long (ℓg) Type)			
	Overall length L (mm)	Thread length ℓ (mm)	Position on basic dia. ℓg (mm)	Shank dia. Ds (mm)
PT 1/16-28	55	19	13	8
PT 1/8-28	55	19	13	8
PT 1/4-19	62	28	21	11
PT 3/8-19	65	28	21	14
PT 1/2-14	80	35	25	18
PT 3/4-14	85	35	25	23
PT 1 -11	95	45	32	26

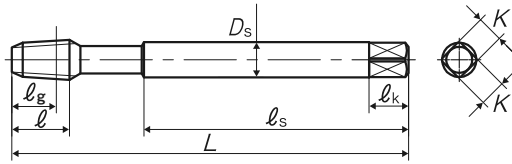
JIS

⑧-11

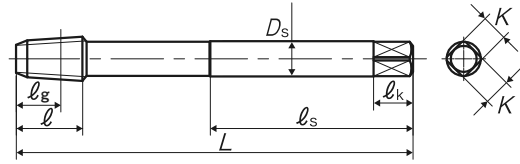
Think threads with
YAMAWA

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

TYPE:1



TYPE:2



Segment : 1H

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_g (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
Rc 1/16-28	TJRC010DPX	C(2.5P)	7.723	90	14	10.1	60	8	6	9	4	1	¥ 7,810 ※
Rc 1/8-28	TJRC020DPX	C(2.5P)	9.728	90	15	10.1	46	8	6	9	4	2	¥ 7,810 ※
Rc 1/4-19	TJRC040DPX	C(2.5P)	13.157	100	19	15.0	51	11	9	12	4	2	¥ 11,400 ※
Rc 3/8-19	TJRC060DPX	C(2.5P)	16.662	100	21	15.4	51	14	11	14	4	2	¥ 18,500 ※
Rc 1/2-14	TJRC080DPX	C(2.5P)	20.955	125	26	20.5	64	18	14	17	4	2	¥ 30,100 ※
Rc 3/4-14	TJRC120DPX	C(2.5P)	26.441	140	28	21.8	71	23	17	20	4	2	¥ 46,000 ※
Rc 1 -11	TJRC160DPX	C(2.5P)	33.249	160	33	26.0	82	26	21	24	5	2	¥ 79,700 ※

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③Spiral 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 ⑫Precision Machinery/
Medical Surgical Instruments ⑬

JIS ⑭-12

⑧ Pipe Tap Series

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

DIN

Z-PRO

PMST OX Rc



Z-PRO

Straight Fluted Taps for Taper Pipe Threads, for High Hardness Materials

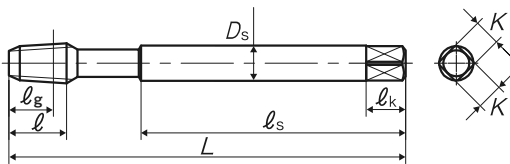
Specification



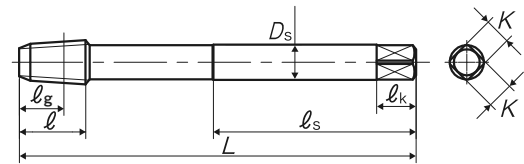
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)	Medium carbon steels 中炭素鋼 ~5 (m/min)	High carbon steels 高炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Thermal refined steels 調質鋼 ~3 (m/min) 25~35HRC	Thermal refined steels 調質鋼 ~3 (m/min) 35~45HRC	Tool steels 工具鋼 ~5 (m/min)	Cast steels 鋳鋼 ~5 (m/min)
Cast irons 鑄鉄 ~5 (m/min)	Ductile cast irons 強靱鑄鉄 ~5 (m/min)	Aluminum alloy castings アルミ合金鑄物 ~7 (m/min)	Magnesium alloy die castings マグネシウム合金鑄物 ~7 (m/min)	Zinc alloy castings 亜鉛合金鑄物 ~7 (m/min)	Brass 黄銅 ~7 (m/min)	Brass castings 黄銅鑄物 ~7 (m/min)	

TYPE:1



TYPE:2



Segment : 1H

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For Pipe Threads												
Rc 1/16-28	3118020002	C(2.5P)	7.723	90	14	10.1	46	6	4.9	8	4	1
Rc 1/8-28	3118020004	C(2.5P)	9.728	90	15	10.1	46	7	5.5	8	4	2
Rc 1/4-19	3118020006	C(2.5P)	13.157	100	19	15.0	51	11	9	12	4	2
Rc 3/8-19	3118020008	C(2.5P)	16.662	100	21	15.4	51	12	9	12	4	2
Rc 1/2-14	3118020009	C(2.5P)	20.955	125	26	20.5	64	16	12	15	4	2
Rc 3/4-14	3118020011	C(2.5P)	26.441	140	28	21.8	71	20	16	19	4	2
Rc 1 -11	3118020013	C(2.5P)	33.249	160	33	26.0	82	25	20	23	5	2

- 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

⑧-13

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

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

Z-PRO

PMSP OX Rc

Z-PRO

Spiral Fluted Taps for Taper Pipe Threads, for High Hardness Materials



Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)	Medium carbon steels 中炭素鋼 ~5 (m/min)	High carbon steels 高炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Thermal refined steels 調質鋼 ~3 (m/min) 25~35HRC	Thermal refined steels 調質鋼 ~3 (m/min) 35~45HRC	Tool steels 工具鋼 ~5 (m/min)	Cast steels 鋳鋼 ~5 (m/min)
Cast irons 鑄鉄 ~5 (m/min)	Ductile cast irons 強靱鑄鉄 ~5 (m/min)	Aluminum alloy castings アルミ合金鑄物 ~7 (m/min)	Magnesium alloy die castings マグネシウム合金鑄物 ~7 (m/min)	Zinc alloy castings 亜鉛合金鑄物 ~7 (m/min)	Brass 黄銅 ~7 (m/min)	Brass castings 黄銅鑄物 ~7 (m/min)	

Product Features

- Proper tool projection length is secured, achieving an excellent chip ejection efficiency.
- Ideal for tapping hard steels from 30 to 45 HRC, such as plastic die steels.

Tapping Data

Tapping conditions

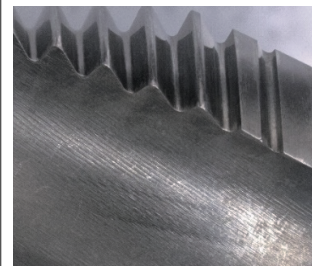
Workpiece Material	NAK55 (40HRC)
Tapping Speed	3m/min
M a c h i n e	Machining center (Vertical)
H o l d e r	With tension and compression
Tapping Fluid	Non-water soluble cutting oil

PMSP OX Rc 1/4-19 (After 10 holes)

Excellent internal thread



Less damage on the edge



Comparison of Rc and PT tap dimensions

Comparison table of tap dimensions between PMSP OX Rc and "SP-PT (long thread type)"

Size	PMSP OX Rc			
	Overall length L (mm)	Thread length ℓ (mm)	Position on basic dia ℓg (mm)	Shank dia. Ds (mm)
Rc 1/16-28	90	14	10.1	8
Rc 1/8-28	90	15	10.1	8
Rc 1/4-19	100	19	15	11
Rc 3/8-19	100	21	15.4	14
Rc 1/2-14	125	26	20.5	18
Rc 3/4-14	140	28	21.8	23
Rc 1 -11	160	33	26	26

Size	SP-PT (Long (ℓg) Type)			
	Overall length L (mm)	Thread length ℓ (mm)	Position on basic dia ℓg (mm)	Shank dia. Ds (mm)
PT 1/16-28	55	19	13	8
PT 1/8-28	55	19	13	8
PT 1/4-19	62	28	21	11
PT 3/8-19	65	28	21	14
PT 1/2-14	80	35	25	18
PT 3/4-14	85	35	25	23
PT 1 -11	95	45	32	26

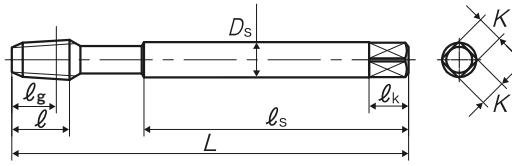
JIS

⑧-15

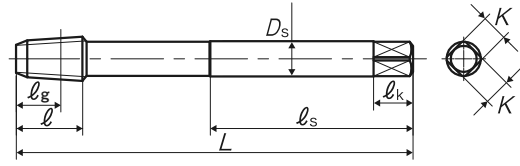
Think threads with
YAMAWA

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

TYPE:1



TYPE:2



Segment : 1H

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_g (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
Rc 1/16-28	SJRC010DPX	C(2.5P)	7.723	90	14	10.1	60	8	6	9	3	1	¥ 7,810 ※
Rc 1/8-28	SJRC020DPX	C(2.5P)	9.728	90	15	10.1	46	8	6	9	3	2	¥ 7,810 ※
Rc 1/4-19	SJRC040DPX	C(2.5P)	13.157	100	19	15.0	51	11	9	12	3	2	¥ 11,400 ※
Rc 3/8-19	SJRC060DPX	C(2.5P)	16.662	100	21	15.4	51	14	11	14	3	2	¥ 18,500 ※
Rc 1/2-14	SJRC080DPX	C(2.5P)	20.955	125	26	20.5	64	18	14	17	4	2	¥ 30,100 ※
Rc 3/4-14	SJRC120DPX	C(2.5P)	26.441	140	28	21.8	71	23	17	20	4	2	¥ 46,000 ※
Rc 1 -11	SJRC160DPX	C(2.5P)	33.249	160	33	26.0	82	26	21	24	4	2	¥ 79,700 ※

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

⑧-16

8 Pipe Tap Series

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

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

Z-PRO

PMSP OX Rc

Z-PRO

Spiral Fluted Taps for Taper Pipe Threads, for High Hardness Materials



Specification

HSS-P

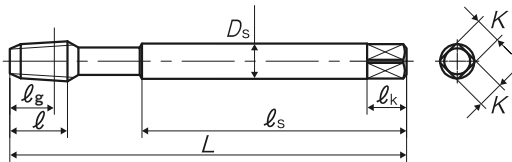
OX
Oxide



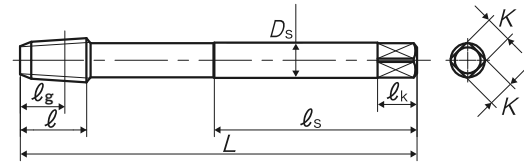
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)	Medium carbon steels 中炭素鋼 ~5 (m/min)	High carbon steels 高炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Thermal refined steels 調質鋼 ~3 (m/min) 25~35HRC	Thermal refined steels 調質鋼 ~3 (m/min) 35~45HRC	Tool steels 工具鋼 ~5 (m/min)	Cast steels 鋳鋼 ~5 (m/min)
Cast irons 鑄鉄 ~5 (m/min)	Ductile cast irons 強靱鑄鉄 ~5 (m/min)	Aluminum alloy castings アルミ合金鑄物 ~7 (m/min)	Magnesium alloy die castings マグネシウム合金鑄物 ~7 (m/min)	Zinc alloy castings 亜鉛合金鑄物 ~7 (m/min)	Brass 黄銅 ~7 (m/min)	Brass castings 黄銅鑄物 ~7 (m/min)	

TYPE:1



TYPE:2



Segment : 1H

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For Pipe Threads												
Rc 1/16-28	3117020002	C(2.5P)	7.723	90	14	10.1	46	6	4.9	8	3	1
Rc 1/8-28	3117020004	C(2.5P)	9.728	90	15	10.1	46	7	5.5	8	3	2
Rc 1/4-19	3117020006	C(2.5P)	13.157	100	19	15.0	51	11	9	12	3	2
Rc 3/8-19	3117020008	C(2.5P)	16.662	100	21	15.4	51	12	9	12	3	2
Rc 1/2-14	3117020009	C(2.5P)	20.955	125	26	20.5	64	16	12	15	4	2
Rc 3/4-14	3117020011	C(2.5P)	26.441	140	28	21.8	71	20	16	19	4	2
Rc 1 -11	3117020013	C(2.5P)	33.249	160	33	26.0	82	25	20	23	4	2

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

⑧ Pipe 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

⑧-19



Z-PRO

AUSP Rp

Z-PRO

Coated Spiral Fluted Taps for Parallel Pipe Threads



Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 5~15 (m/min)	Medium carbon steels 中炭素鋼 5~15 (m/min)	High carbon steels 高炭素鋼 5~15 (m/min)	Alloy steels 合金鋼 5~15 (m/min)	Stainless steels ステンレス鋼 ~3 (m/min)	Aluminum alloy castings アルミ合金鋳物 5~15 (m/min)	Zinc alloy castings 亜鉛合金鋳物 5~15 (m/min)
---	--	--	---	--	--	---

Product Features

- New shape is adopted. Proper tool projection length is secured, achieving a good chip ejection efficiency.
- Good internal thread surface and long tool life are achieved by the adoption of the unique cutting edge shape and special coating.

Tapping Data

Tapping conditions [AUSP Rp 1/4-19]

Workpiece Materials	SUS304
Tapping Speed	5m/min
Machine	Machining center
Holder	Fixed
Tapping Fluid	Water soluble cutting fluid

Chips Do Not Interfere with the Holder.



Good Internal Thread



• Compatible with tapping of a wide range of work materials

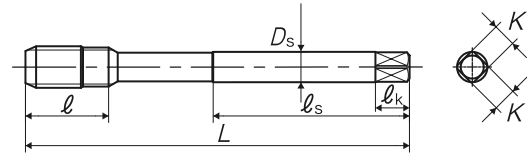
AUSP Rp Standard tapping conditions

Workpiece Materials	Standard Tapping Speed (m/min)
Stainless Steels SUS304	~ 3
Alloy Steels SCM/SCr	5 ~ 15
High Carbon Steels S45C ~	5 ~ 15
Medium Carbon Steels S25C ~ S45C	5 ~ 15
Low Carbon Steels ~ S20C/SS400	5 ~ 15
Aluminum Alloy Casting/ Zinc Alloy Casting AC/ADC/ZDC	5 ~ 15

Think threads with
YAMAWA

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

TYPE: 1



Segment : 1G

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
Rp 1/8-28	SJRP020FET	C (2.5P)	9.728	90	15	46	8	6	9	3	1	¥ 5,320
Rp 1/4-19	SJRP040FET	C (2.5P)	13.157	100	19	51	11	9	12	3	1	¥ 7,910
Rp 3/8-19	SJRP060FET	C (2.5P)	16.662	100	21	51	14	11	14	3	1	¥ 12,500
Rp 1/2-14	SJRP080FET	C (2.5P)	20.955	125	26	64	18	14	17	4	1	¥ 19,700
Rp 3/4-14	SJRP120FET	C (2.5P)	26.441	140	28	71	23	17	20	4	1	¥ 32,600
Rp 1 -11	SJRP160FET	C (2.5P)	33.249	160	33	82	26	21	24	4	1	¥ 58,400

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

⑧ Pipe 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

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

Z-PRO

AUSP Rp

Z-PRO

Coated Spiral Fluted Taps for Parallel Pipe Threads



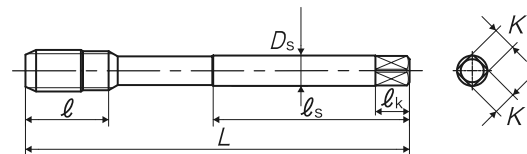
Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	~3 (m/min)	5~15 (m/min)	5~15 (m/min)

TYPE: 1



Segment : 1G

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Pipe Threads											
Rp 1/8-28	3119026004	C (2.5P)	9.728	90	19	46	7	5.5	8	3	1
Rp 1/4-19	3119026006	C (2.5P)	13.157	100	21	51	11	9	12	3	1
Rp 3/8-19	3119026008	C (2.5P)	16.662	100	21	51	12	9	12	3	1
Rp 1/2-14	3119026009	C (2.5P)	20.955	125	24	64	16	12	15	4	1
Rp 3/4-14	3119026011	C (2.5P)	26.441	140	27	71	20	16	19	4	1
Rp 1 -11	3119026013	C (2.5P)	33.249	160	29	82	25	20	23	4	1

DIN

⑧-21

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

8 Pipe 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

Z-PRO AUSP G

Z-PRO
Coated Spiral Fluted Taps for Parallel Pipe Threads



Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 5~15 (m/min)	Medium carbon steels 中炭素鋼 5~15 (m/min)	High carbon steels 高炭素鋼 5~15 (m/min)	Alloy steels 合金鋼 5~15 (m/min)	Stainless steels ステンレス鋼 ~3 (m/min)	Aluminum alloy castings アルミ合金鋳物 5~15 (m/min)	Zinc alloy castings 亜鉛合金鋳物 5~15 (m/min)
---	--	--	---	--	--	---

Product Features

- New shape is adopted. Proper tool projection length is secured, achieving a good chip ejection efficiency.
- Good internal thread surface and long tool life are achieved by the adoption of the unique cutting edge shape and special coating.

Tapping Data

Tapping conditions [AUSP G 1/4-19]

Workpiece Materials	SUS304
Tapping Speed	5m/min
Machine	Machining center
Holder	Fixed
Tapping Fluid	Water soluble cutting fluid

Chips Do Not Interfere with the Holder.



Good Internal Thread

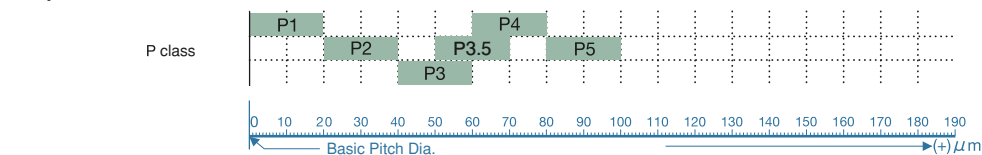


• Compatible with tapping of a wide range of work materials

AUSP G Standard tapping conditions

Workpiece Materials	Standard Tapping Speed (m/min)
Stainless Steels SUS304	~ 3
Alloy Steels SCM/SCr	5 ~ 15
High Carbon Steels S45C ~	5 ~ 15
Medium Carbon Steels S25C ~ S45C	5 ~ 15
Low Carbon Steels ~ S20C/SS400	5 ~ 15
Aluminum Alloy Casting/ Zinc Alloy Casting AC/ADC/ZDC	5 ~ 15

• Tap class and internal thread class



Nominal size	Basic Major Dia.	P class	Basic Pitch Dia.
G 1/8-28	9.147	P3	107
G 1/4-19	12.301	P3.5	125
G 3/8-19	15.806	P3.5	125
G 1/2-14	19.793	P4	142
G 3/4-14	25.279	P4	142
G 1-11	31.770	P5	180

Pitch diameter tolerance zone of JIS (ISO) internal thread (JIS B 0202)

JIS

⑧-23

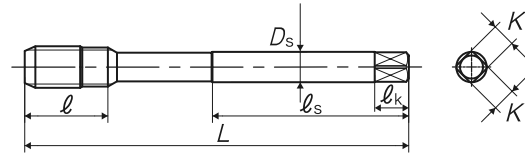
Think threads with
YAMAWA

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

8

JIS

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
G 1/8-28	P3	SJG0020FET	C (2.5P)	9.728	90	15	46	8	6	9	3	1	¥ 5,320
G 1/4-19	P3.5	SJG0040FET	C (2.5P)	13.157	100	19	51	11	9	12	3	1	¥ 7,910
G 3/8-19	P3.5	SJG0060FET	C (2.5P)	16.662	100	21	51	14	11	14	3	1	¥ 12,500
G 1/2-14	P4	SJG0080FET	C (2.5P)	20.955	125	26	64	18	14	17	4	1	¥ 19,700
G 3/4-14	P4	SJG0120FET	C (2.5P)	26.441	140	28	71	23	17	20	4	1	¥ 32,600
G 1 -11	P5	SJG0160FET	C (2.5P)	33.249	160	33	82	26	21	24	4	1	¥ 58,400

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

8 Pipe 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

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

⑧-25

DIN

Z-PRO

AUSP G

Z-PRO

Coated Spiral Fluted Taps for Parallel Pipe Threads



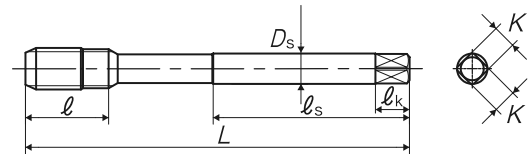
Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	~3 (m/min)	5~15 (m/min)	5~15 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Pipe Threads												
G 1/8-28	ISO228X	3119130004	C (2.5P)	9.728	90	19	46	7	5.5	8	3	1
G 1/4-19	ISO228X	3119130006	C (2.5P)	13.157	100	21	51	11	9	12	3	1
G 3/8-19	ISO228X	3119130008	C (2.5P)	16.662	100	21	51	12	9	12	3	1
G 1/2-14	ISO228X	3119130009	C (2.5P)	20.955	125	24	64	16	12	15	4	1
G 3/4-14	ISO228X	3119130011	C (2.5P)	26.441	140	27	71	20	16	19	4	1
G 1 -11	ISO228X	3119130013	C (2.5P)	33.249	160	29	82	25	20	23	4	1

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-27

S

Rc

Hand Taps for Taper Pipe Threads



Specification

HSS



■ The Rc is a hand tap for a tapered pipe threads conforming to ISO specifications. It is used for mating with external tapered pipe threads R(PT).

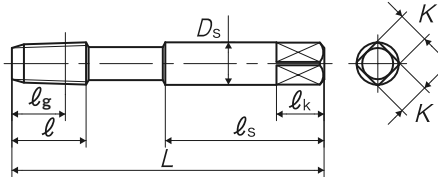
Tapping Speeds depending on Materials

Medium carbon steels
中炭素鋼
~5
(m/min)

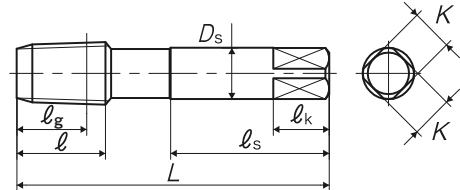
High carbon steels
高炭素鋼
~5
(m/min)

Alloy steels
合金鋼
~5
(m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads														
Rc 1/16-28	II	TH2RC01K	2.5P	7.723	59	14	10.1	30	8	6	9	4	1	¥ 3,740
Rc 1/8-28	II	TH2RC02K	2.5P	9.728	59	15	10.1	30	8	6	9	4	2	¥ 3,740
Rc 1/4-19	II	TH2RC04-	2.5P	13.157	67	19	15.0	34	11	9	12	4	2	¥ 5,770
Rc 3/8-19	II	TH2RC06-	2.5P	16.662	75	21	15.4	38	14	11	14	4	2	¥ 9,480
Rc 1/2-14	II	TH2RC08Q	2.5P	20.955	87	26	20.5	44	18	14	17	4	2	¥ 15,700
Rc 3/4-14	II	TH2RC12Q	2.5P	26.441	96	28	21.8	49	23	17	20	4	2	¥ 24,900
Rc 1 -11	II	TH2RC16U	2.5P	33.249	109	33	26.0	56	26	21	24	5	2	¥ 45,800
Rc 1 1/4-11	II	TH2RC20U	2.5P	41.910	119	36	28.3	61	32	26	30	5	2	¥ 69,200
Rc 1 1/2-11	II	TH2RC24U	2.5P	47.803	125	37	28.3	64	38	29	32	6	2	¥ 96,800
Rc 2 -11	II	TH2RC32U	2.5P	59.614	140	41	32.7	71	46	35	38	6	2	¥ 158,000

Think threads with
YAMAWA

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

PT

Hand Taps for Taper Pipe Threads, Long (ℓg) Type



Specification

HSS

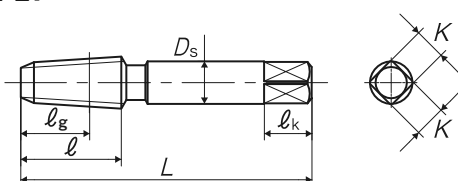


■ The PT is a hand tap for tapered pipe threads and is used for tapping products whose main purpose is the tightness of the threaded portion when connecting pipe parts etc.

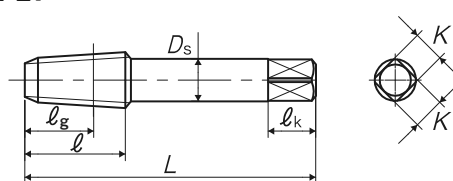
Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	TH2T01K-8	2.5P	7.723	55	19	13	8	6	9	4	1	¥ 3,740
PT 1/8-28	II	TH2T02K	2.5P	9.728	55	19	13	8	6	9	4	2	¥ 3,740
PT 1/4-19	II	TH2T04-	2.5P	13.157	62	28	21	11	9	12	4	2	¥ 5,770
PT 3/8-19	II	TH2T06-	2.5P	16.662	65	28	21	14	11	14	4	2	¥ 9,480
PT 1/2-14	II	TH2T08Q	2.5P	20.955	80	35	25	18	14	17	4	2	¥ 15,700
PT 5/8-14	II	TH2T10Q	2.5P	22.911	82	35	25	19	15	18	4	2	¥ 20,600 ※
PT 3/4-14	II	TH2T12Q	2.5P	26.441	85	35	25	23	17	20	4	2	¥ 24,900
PT 7/8-14	II	TH2T14Q	2.5P	30.201	90	40	28	24	19	22	4	2	¥ 40,400 ※
PT 1 -11	II	TH2T16U	2.5P	33.249	95	45	32	26	21	24	5	2	¥ 45,800
PT 1 1/8-11	II	TH2T18U	2.5P	37.897	100	45	32	28	21	24	5	2	¥ 65,300 ※
PT 1 1/4-11	II	TH2T20U	2.5P	41.910	105	45	32	32	26	30	5	2	¥ 69,200
PT 1 3/8-11	II	TH2T22U	2.5P	44.323	110	45	32	35	26	30	6	2	¥ 96,800 ※
PT 1 1/2-11	II	TH2T24U	2.5P	47.803	110	45	32	38	29	32	6	2	¥ 96,800
PT 1 3/4-11	II	TH2T28U	2.5P	53.746	115	45	32	42	32	35	6	2	¥ 144,000 ※
PT 2 -11	II	TH2T32U	2.5P	59.614	120	50	35	46	35	38	6	2	¥ 158,000
PT 2 1/4-11	II	TH2T36U	2.5P	65.710	145	65	50	50	38	42	6	2	¥ 257,000 ※
PT 2 1/2-11	II	TH2T40U	2.5P	75.184	145	65	50	55	41	44	8	2	¥ 264,000 ※
PT 3 -11	II	TH2T48U	2.5P	87.884	155	65	52	65	50	52	8	2	¥ 396,000 ※
PT 3 1/2-11	II	TH2T56U	2.5P	100.330	165	68	52	70	54	58	8	2	¥ 518,000 ※
PT 4 -11	II	TH2T64U	2.5P	113.030	170	70	55	75	58	62	10	2	¥ 701,000 ※

- 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

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-29

PT LH

Hand Taps for Taper Pipe Threads Long (ℓg) Type for LH Threads



Specification

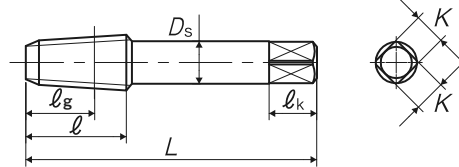


■ The PT LH is a hand tap for left hand tapered pipe threads and is used for tapping products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.

Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	TH2T02K-L	2.5P	9.728	55	19	13	8	6	9	4	1	¥ 5,390 ※
PT 1/4-19	II	TH2T04-L	2.5P	13.157	62	28	21	11	9	12	4	1	¥ 7,700 ※
PT 3/8-19	II	TH2T06-L	2.5P	16.662	65	28	21	14	11	14	4	1	¥ 12,800 ※
PT 1/2-14	II	TH2T08Q-L	2.5P	20.955	80	35	25	18	14	17	4	1	¥ 21,000 ※
PT 3/4-14	II	TH2T12Q-L	2.5P	26.441	85	35	25	23	17	20	4	1	¥ 33,800 ※
PT 1 -11	II	TH2T16U-L	2.5P	33.249	95	45	32	26	21	24	5	1	¥ 62,200 ※
PT 1 1/4-11	II	TH2T20U-L	2.5P	41.910	105	45	32	32	26	30	5	1	¥ 93,900 ※
PT 1 1/2-11	II	TH2T24U-L	2.5P	47.803	110	45	32	38	29	32	6	1	¥ 132,000 ※
PT 2 -11	II	TH2T32U-L	2.5P	59.614	120	50	35	46	35	38	6	1	¥ 215,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

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

PT-X

X Series Hand Taps for Taper Pipe Threads Short (ℓg) Type



Specification

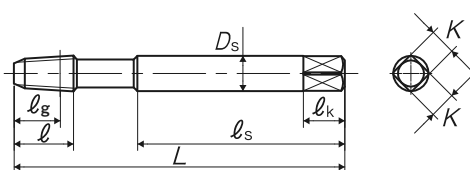


■PT-X hand tap, adopting new tap blank, ensures properly long projection length of the tool. Having short thread length, this tap is suitable for tapping of such machine components as have the limit in their thickness.

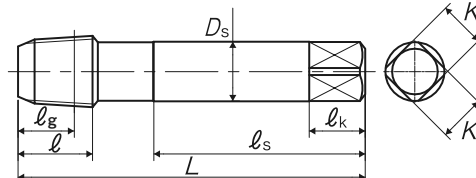
Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



TYPE: 2



Segment: 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads														
PT 1/16-28	II	THX2T01K-8	2.5P	7.723	75	13.5	10.5	47	8	6	9	4	1	¥ 4,470
PT 1/8-28	II	THX2T02K	2.5P	9.728	75	13.5	10.5	48	8	6	9	4	2	¥ 4,470
PT 1/4-19	II	THX2T04-	2.5P	13.157	85	16.5	12.5	54	11	9	12	4	2	¥ 6,430
PT 3/8-19	II	THX2T06-	2.5P	16.662	95	18	14	60	14	11	14	4	2	¥ 10,700
PT 1/2-14	II	THX2T08Q	2.5P	20.955	105	22.5	17	64	18	14	17	4	2	¥ 17,500

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-31

S-PT

Hand Taps for Taper Pipe Threads Short (ℓg) Type



Specification

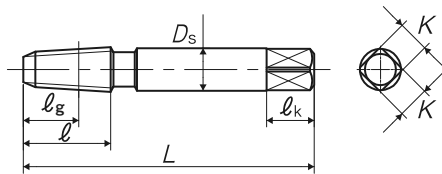


Tapping Speeds depending on Materials

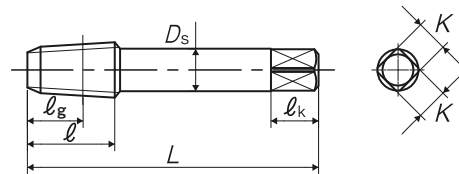
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■The S-PT is a tapered pipe hand tap used for tapping when it is necessary to shorten the fitting length and is used in thread tapping of products such as parts for pipes.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	TSPT01K-8	2.5P	7.723	55	16.5	10.5	8	6	9	4	1	¥ 3,740
PT 1/8-28	II	TSPT02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	2	¥ 3,740
PT 1/4-19	II	TSPT04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	2	¥ 5,770
PT 3/8-19	II	TSPT06-	2.5P	16.662	65	21	14	14	11	14	4	2	¥ 9,480
PT 1/2-14	II	TSPT08Q	2.5P	20.955	80	27	17	18	14	17	4	2	¥ 15,700
PT 3/4-14	II	TSPT12Q	2.5P	26.441	85	29	19	23	17	20	4	2	¥ 24,900
PT 1 -11	II	TSPT16U	2.5P	33.249	95	35	22	26	21	24	5	2	¥ 45,800
PT 1 1/4-11	II	TSPT20U	2.5P	41.910	105	37.5	24.5	32	26	30	5	2	¥ 69,200
PT 1 1/2-11	II	TSPT24U	2.5P	47.803	110	38.5	25.5	38	29	32	6	2	¥ 96,800
PT 1 3/4-11	II	TSPT28U	2.5P	53.746	115	39.5	26.5	42	32	35	6	2	¥ 144,000 ※
PT 2 -11	II	TSPT32U	2.5P	59.614	120	42.5	27.5	46	35	38	6	2	¥ 158,000
PT 2 1/2-11	II	TSPT40U	2.5P	75.184	145	47	32	55	41	44	8	2	¥ 264,000 ※
PT 3 -11	II	TSPT48U	2.5P	87.884	155	51	36	65	50	52	8	2	¥ 396,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

S-PT LH

Hand Taps for Taper Pipe Threads Short (ℓg) Type for LH Threads

Specification



■ The S-PT LH is a hand tap for left hand tapered pipe threads and is used where it is necessary to shorten the fitting length for products such as parts for pipes.

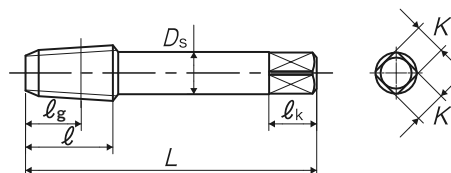
Tapping Speeds depending on Materials

Medium carbon steels
中炭素鋼
~5
(m/min)

High carbon steels
高炭素鋼
~5
(m/min)

Alloy steels
合金鋼
~5
(m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	D_s (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	TSPT02K-L	2.5P	9.728	55	16.5	10.5	8	6	9	4	1	¥ 5,390 ※
PT 1/4-19	II	TSPT04-L	2.5P	13.157	62	19.5	12.5	11	9	12	4	1	¥ 7,700 ※
PT 3/8-19	II	TSPT06-L	2.5P	16.662	65	21	14	14	11	14	4	1	¥ 12,800 ※
PT 1/2-14	II	TSPT08Q-L	2.5P	20.955	80	27	17	18	14	17	4	1	¥ 21,000 ※
PT 3/4-14	II	TSPT12Q-L	2.5P	26.441	85	29	19	23	17	20	4	1	¥ 33,800 ※
PT 1 -11	II	TSPT16U-L	2.5P	33.249	95	35	22	26	21	24	5	1	¥ 62,200 ※
PT 1 1/4-11	II	TSPT20U-L	2.5P	41.910	105	37.5	24.5	32	26	30	5	1	¥ 93,900 ※
PT 1 1/2-11	II	TSPT24U-L	2.5P	47.803	110	38.5	25.5	38	29	32	6	1	¥ 132,000 ※
PT 2 -11	II	TSPT32U-L	2.5P	59.614	120	42.5	27.5	46	35	38	6	1	¥ 215,000 ※

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

LS-PT

Long Shank Hand Taps for Taper Pipe Threads Long (ℓg) Type



Specification

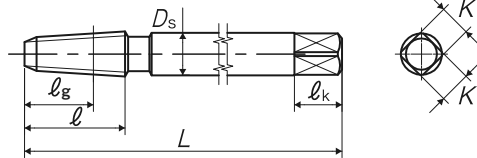


Tapping Speeds depending on Materials

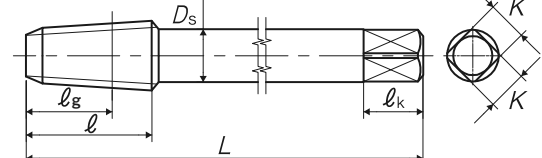
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■ The LS-PT is a long shank tapered pipe thread tap and is used for products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	L10T01K-8	2.5P	7.723	100	19	13	8	6	9	4	1	¥ 8,590 ※
PT 1/8-28	II	L10T02K	2.5P	9.728	100	19	13	8	6	9	4	2	¥ 8,590
PT 1/8-28	II	L15T02K	2.5P	9.728	150	19	13	8	6	9	4	2	¥ 13,700
PT 1/8-28	II	L20T02K	2.5P	9.728	200	19	13	8	6	9	4	2	¥ 19,600 ※
PT 1/4-19	II	L10T04-	2.5P	13.157	100	28	21	11	9	12	4	2	¥ 9,270
PT 1/4-19	II	L15T04-	2.5P	13.157	150	28	21	11	9	12	4	2	¥ 14,000
PT 1/4-19	II	L20T04-	2.5P	13.157	200	28	21	11	9	12	4	2	¥ 19,800 ※
PT 3/8-19	II	L10T06-	2.5P	16.662	100	28	21	14	11	14	4	2	¥ 15,700
PT 3/8-19	II	L12T06-	2.5P	16.662	120	28	21	14	11	14	4	2	¥ 16,100 ※
PT 3/8-19	II	L15T06-	2.5P	16.662	150	28	21	14	11	14	4	2	¥ 23,000
PT 3/8-19	II	L20T06-	2.5P	16.662	200	28	21	14	11	14	4	2	¥ 32,500 ※
PT 1/2-14	II	L15T08Q	2.5P	20.955	150	35	25	18	14	17	4	2	¥ 27,700
PT 1/2-14	II	L20T08Q	2.5P	20.955	200	35	25	18	14	17	4	2	¥ 39,400 ※
PT 3/4-14	II	L15T12Q	2.5P	26.441	150	35	25	23	17	20	4	2	¥ 41,600
PT 3/4-14	II	L20T12Q	2.5P	26.441	200	35	25	23	17	20	4	2	¥ 50,400 ※
PT 1 -11	II	L15T16U	2.5P	33.249	150	45	32	26	21	24	5	2	¥ 58,600
PT 1 -11	II	L20T16U	2.5P	33.249	200	45	32	26	21	24	5	2	¥ 71,500 ※
PT 1 1/4-11	II	L20T20U	2.5P	41.910	200	45	32	32	26	30	5	2	¥ 107,000 ※
PT 1 1/2-11	II	L20T24U	2.5P	47.803	200	45	32	38	29	32	6	2	¥ 136,000 ※
PT 2 -11	II	L20T32U	2.5P	59.614	200	50	35	46	35	38	6	2	¥ 193,000 ※

JIS

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

LS-S-PT

Long Shank Hand Taps for Taper Pipe Threads, Short (ℓg) Type



Specification

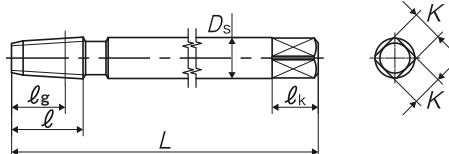


Tapping Speeds depending on Materials

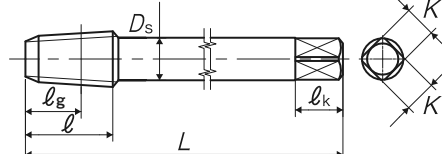
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■The LS-S-PT is a long shank tapered pipe tap and is used when it is necessary to shorten the fitting length in a product whose main purpose is the tightness of the threaded portion in the connection of pipe parts etc.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	TSPT01KL10	2.5P	7.723	100	16.5	10.5	8	6	9	4	1	¥ 8,590 ※
PT 1/8-28	II	TSPT02KL10	2.5P	9.728	100	16.5	10.5	8	6	9	4	2	¥ 8,590
PT 1/8-28	II	TSPT02KL15	2.5P	9.728	150	16.5	10.5	8	6	9	4	2	¥ 13,700
PT 1/8-28	II	TSPT02KL20	2.5P	9.728	200	16.5	10.5	8	6	9	4	2	¥ 19,600 ※
PT 1/4-19	II	TSPT04-L10	2.5P	13.157	100	19.5	12.5	11	9	12	4	2	¥ 9,270
PT 1/4-19	II	TSPT04-L15	2.5P	13.157	150	19.5	12.5	11	9	12	4	2	¥ 14,000
PT 1/4-19	II	TSPT04-L20	2.5P	13.157	200	19.5	12.5	11	9	12	4	2	¥ 19,800 ※
PT 3/8-19	II	TSPT06-L10	2.5P	16.662	100	21	14	14	11	14	4	2	¥ 15,700
PT 3/8-19	II	TSPT06-L12	2.5P	16.662	120	21	14	14	11	14	4	2	¥ 16,100 ※
PT 3/8-19	II	TSPT06-L15	2.5P	16.662	150	21	14	14	11	14	4	2	¥ 23,000
PT 3/8-19	II	TSPT06-L20	2.5P	16.662	200	21	14	14	11	14	4	2	¥ 32,500 ※
PT 1/2-14	II	TSPT08QL15	2.5P	20.955	150	27	17	18	14	17	4	2	¥ 27,700
PT 1/2-14	II	TSPT08QL20	2.5P	20.955	200	27	17	18	14	17	4	2	¥ 39,400 ※
PT 3/4-14	II	TSPT12QL15	2.5P	26.441	150	29	19	23	17	20	4	2	¥ 41,600
PT 3/4-14	II	TSPT12QL20	2.5P	26.441	200	29	19	23	17	20	4	2	¥ 50,400 ※
PT 1 -11	II	TSPT16UL15	2.5P	33.249	150	35	22	26	21	24	5	2	¥ 58,600
PT 1 -11	II	TSPT16UL20	2.5P	33.249	200	35	22	26	21	24	5	2	¥ 71,500 ※

※ = Specified Distribution Items. Made to order products.

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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 Mills
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

SP-PT

Spiral Fluted Taps for Taper Pipe Threads, Long (ℓg) Type



Specification

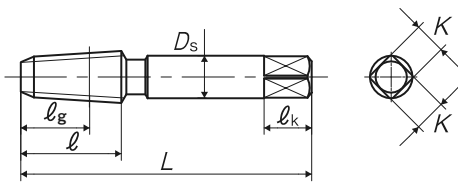


■ The SP-PT is a spiral flute tapered pipe tap and is used for thread products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.

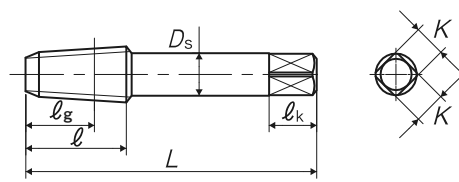
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	SH2T01K-8	2.5P	7.723	55	19	13	8	6	9	3	1	¥ 4,880 ※
PT 1/8-28	II	SH2T02K	2.5P	9.728	55	19	13	8	6	9	3	2	¥ 4,880
PT 1/4-19	II	SH2T04-	2.5P	13.157	62	28	21	11	9	12	3	2	¥ 7,000
PT 3/8-19	II	SH2T06-	2.5P	16.662	65	28	21	14	11	14	3	2	¥ 11,600
PT 1/2-14	II	SH2T08Q	2.5P	20.955	80	35	25	18	14	17	4	2	¥ 19,000
PT 3/4-14	II	SH2T12Q	2.5P	26.441	85	35	25	23	17	20	4	2	¥ 30,100
PT 1 -11	II	SH2T16U	2.5P	33.249	95	45	32	26	21	24	4	2	¥ 55,500
PT 1 1/4-11	II	SH2T20U	2.5P	41.910	105	45	32	32	26	30	4	2	¥ 83,800 ※
PT 1 1/2-11	II	SH2T24U	2.5P	47.803	110	45	32	38	29	32	4	2	¥ 118,000 ※
PT 2 -11	II	SH2T32U	2.5P	59.614	120	50	35	46	35	38	4	2	¥ 191,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

SP-S-PT

Spiral Fluted Taps for Taper Pipe Threads Short (ℓg) Type



Specification

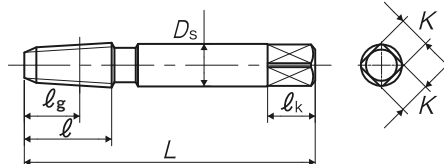


Tapping Speeds depending on Materials

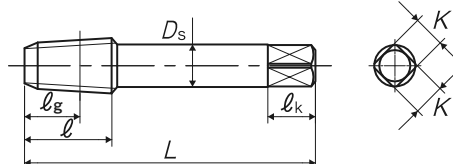
Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■The SP-S-PT is a spiral flute tapered pipe tap and is used for thread tapping when it is necessary to shorten the fitting length with a product whose main purpose is the tightness of the threaded portion when connecting pipe parts etc.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	SSPT01K	2.5P	7.723	55	16.5	10.5	8	6	9	3	1	¥ 4,880 *
PT 1/8-28	II	SSPT02K	2.5P	9.728	55	16.5	10.5	8	6	9	3	2	¥ 4,880
PT 1/4-19	II	SSPT04-	2.5P	13.157	62	19.5	12.5	11	9	12	3	2	¥ 7,000
PT 3/8-19	II	SSPT06-	2.5P	16.662	65	21	14	14	11	14	3	2	¥ 11,600
PT 1/2-14	II	SSPT08Q	2.5P	20.955	80	27	17	18	14	17	4	2	¥ 19,000
PT 3/4-14	II	SSPT12Q	2.5P	26.441	85	29	19	23	17	20	4	2	¥ 30,100
PT 1 -11	II	SSPT16U	2.5P	33.249	95	35	22	26	21	24	4	2	¥ 55,500
PT 1 1/4-11	II	SSPT20U	2.5P	41.910	105	37.5	24.5	32	26	30	4	2	¥ 83,800 *
PT 1 1/2-11	II	SSPT24U	2.5P	47.803	110	38.5	25.5	38	29	32	4	2	¥ 118,000 *
PT 2 -11	II	SSPT32U	2.5P	59.614	120	42.5	27.5	46	35	38	4	2	¥ 191,000 *

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

⑧-36

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-37



SP-PT-X

X Series Spiral Fluted Taps for Taper Pipe Threads Short (ℓg) Type



Specification

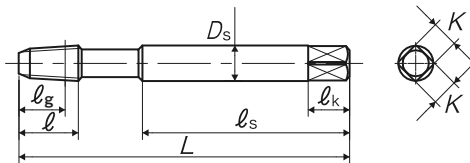


Tapping Speeds depending on Materials

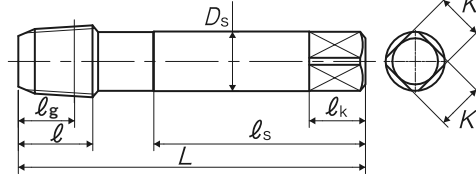
Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■SP-PT-X spiral fluted tap, adopting new blank, ensures properly long projection length of the tool. Having short thread length, this tap is suitable for tapping of such machine components as have the limit in their thickness.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads														
PT 1/16-28	II	SHX2T01K-8	2.5P	7.723	75	13.5	10.5	47	8	6	9	3	1	¥ 4,880
PT 1/8-28	II	SHX2T02K	2.5P	9.728	75	13.5	10.5	48	8	6	9	3	2	¥ 4,880
PT 1/4-19	II	SHX2T04-	2.5P	13.157	85	16.5	12.5	54	11	9	12	3	2	¥ 7,000
PT 3/8-19	II	SHX2T06-	2.5P	16.662	95	18	14	60	14	11	14	3	2	¥ 11,600
PT 1/2-14	II	SHX2T08Q	2.5P	20.955	105	22.5	17	64	18	14	17	4	2	¥ 19,000

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_g	Ds	K	ℓ_k

LS-SP-PT



Long Shank Spiral Fluted Taps for Taper Pipe Threads, Long (ℓ_g) Type

Specification

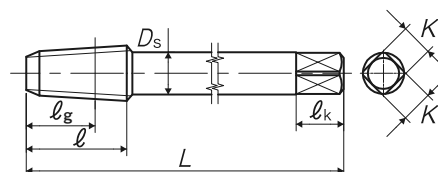


■The LS-SP-PT is a spiral flute long shank tapered pipe tap and is used for products whose main purpose is the tightness of threaded parts in connection with pipe parts, etc.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_g (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	SH2T02KL10	2.5P	9.728	100	19	13	8	6	9	3	1	¥ 10,500 ※
PT 1/8-28	II	SH2T02KL12	2.5P	9.728	120	19	13	8	6	9	3	1	¥ 12,100 ※
PT 1/8-28	II	SH2T02KL15	2.5P	9.728	150	19	13	8	6	9	3	1	¥ 16,800 ※
PT 1/4-19	II	SH2T04-L10	2.5P	13.157	100	28	21	11	9	12	3	1	¥ 11,300 ※
PT 1/4-19	II	SH2T04-L12	2.5P	13.157	120	28	21	11	9	12	3	1	¥ 13,200 ※
PT 1/4-19	II	SH2T04-L15	2.5P	13.157	150	28	21	11	9	12	3	1	¥ 17,300 ※
PT 3/8-19	II	SH2T06-L10	2.5P	16.662	100	28	21	14	11	14	3	1	¥ 19,000 ※
PT 3/8-19	II	SH2T06-L12	2.5P	16.662	120	28	21	14	11	14	3	1	¥ 19,200 ※
PT 3/8-19	II	SH2T06-L15	2.5P	16.662	150	28	21	14	11	14	3	1	¥ 27,900 ※
PT 1/2-14	II	SH2T08QL15	2.5P	20.955	150	35	25	18	14	17	4	1	¥ 33,600 ※
PT 3/4-14	II	SH2T12QL15	2.5P	26.441	150	35	25	23	17	20	4	1	¥ 50,300 ※
PT 1 -11	II	SH2T16UL15	2.5P	33.249	150	45	32	26	21	24	4	1	¥ 71,100 ※
PT 1 -11	II	SH2T16UL20	2.5P	33.249	200	45	32	26	21	24	4	1	¥ 86,500 ※

- 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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

LS-SP-S-PT



Long Shank Spiral Fluted Taps for Taper Pipe Threads, Short (ℓg) Type

Specification



Tapping Speeds depending on Materials

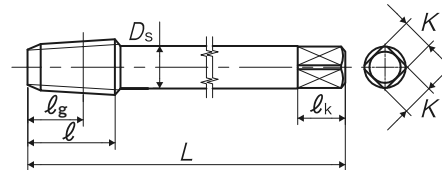
Low carbon steels
低炭素鋼
~5
(m/min)

Medium carbon steels
中炭素鋼
~5
(m/min)

High carbon steels
高炭素鋼
~5
(m/min)

■The LS-SP-S-PT is a spiral flute long shank tapered pipe tap and is used for tapping where it is necessary to shorten the fitting length with a product whose main purpose is the tightness of the threaded portion in connection with pipe parts etc.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	SSPT02KL10	2.5P	9.728	100	16.5	10.5	8	6	9	3	1	¥ 10,500 ※
PT 1/8-28	II	SSPT02KL12	2.5P	9.728	120	16.5	10.5	8	6	9	3	1	¥ 12,100 ※
PT 1/8-28	II	SSPT02KL15	2.5P	9.728	150	16.5	10.5	8	6	9	3	1	¥ 16,800 ※
PT 1/4-19	II	SSPT04-L10	2.5P	13.157	100	19.5	12.5	11	9	12	3	1	¥ 11,300 ※
PT 1/4-19	II	SSPT04-L12	2.5P	13.157	120	19.5	12.5	11	9	12	3	1	¥ 13,200 ※
PT 1/4-19	II	SSPT04-L15	2.5P	13.157	150	19.5	12.5	11	9	12	3	1	¥ 17,300 ※
PT 3/8-19	II	SSPT06-L10	2.5P	16.662	100	21	14	14	11	14	3	1	¥ 19,000 ※
PT 3/8-19	II	SSPT06-L12	2.5P	16.662	120	21	14	14	11	14	3	1	¥ 19,200 ※
PT 3/8-19	II	SSPT06-L15	2.5P	16.662	150	21	14	14	11	14	3	1	¥ 27,900 ※
PT 1/2-14	II	SSPT08QL15	2.5P	20.955	150	27	17	18	14	17	4	1	¥ 33,600 ※
PT 3/4-14	II	SSPT12QL15	2.5P	26.441	150	29	19	23	17	20	4	1	¥ 50,300 ※
PT 1 -11	II	SSPT16UL15	2.5P	33.249	150	35	22	26	21	24	4	1	¥ 71,100 ※
PT 1 -11	II	SSPT16UL20	2.5P	33.249	200	35	22	26	21	24	4	1	¥ 86,500 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

INT-PT

Interrupted Taps for Taper Pipe Threads, Long (ℓg) Type



Specification



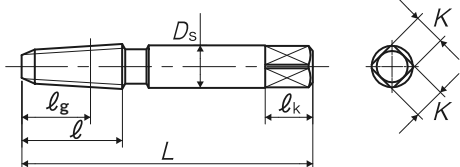
■INT-PT having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque.

INT-PT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

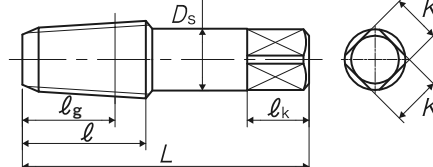
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Stainless steels ステンレス鋼	Cast steels 鋳鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	TINT01K-8	3P	7.723	55	19	13	8	6	9	3	1	¥ 5,860 *
PT 1/8-28	II	TINT02K	3P	9.728	55	19	13	8	6	9	5	2	¥ 5,860
PT 1/4-19	II	TINT04-	3P	13.157	62	28	21	11	9	12	5	2	¥ 8,410
PT 3/8-19	II	TINT06-	3P	16.662	65	28	21	14	11	14	5	2	¥ 14,000
PT 1/2-14	II	TINT08Q	3P	20.955	80	35	25	18	14	17	5	2	¥ 22,800
PT 3/4-14	II	TINT12Q	3P	26.441	85	35	25	23	17	20	5	2	¥ 36,100
PT 1 -11	II	TINT16U	3P	33.249	95	45	32	26	21	24	5	2	¥ 66,600
PT 1 1/4-11	II	TINT20U	3P	41.910	105	45	32	32	26	30	5	2	¥101,000
PT 1 1/2-11	II	TINT24U	3P	47.803	110	45	32	38	29	32	7	2	¥142,000
PT 2 -11	II	TINT32U	3P	59.614	120	50	35	46	35	38	7	2	¥229,000 *

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-41

S

INT-S-PT

Interrupted Taps for Taper Pipe Threads, Short (ℓg) Type



Specification

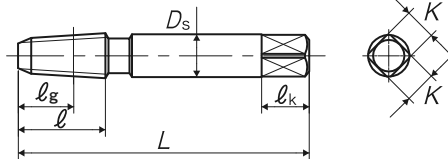


Tapping Speeds depending on Materials

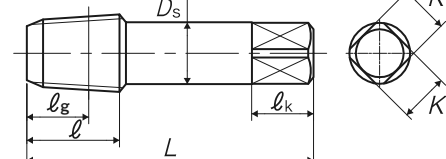
Low carbon steels 低炭素鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~5 (m/min)	Cast steels 鋳鋼 ~5 (m/min)
--	---	------------------------------------

■INT-S-PT Short Spiral Fluted Tap, having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque. INT-S-PT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	TIST01K-8	3P	7.723	55	16.5	10.5	8	6	9	3	1	¥ 5,860 *
PT 1/8-28	II	TIST02K	3P	9.728	55	16.5	10.5	8	6	9	5	2	¥ 5,860
PT 1/4-19	II	TIST04-	3P	13.157	62	19.5	12.5	11	9	12	5	2	¥ 8,410
PT 3/8-19	II	TIST06-	3P	16.662	65	21	14	14	11	14	5	2	¥ 14,000
PT 1/2-14	II	TIST08Q	3P	20.955	80	27	17	18	14	17	5	2	¥ 22,800
PT 3/4-14	II	TIST12Q	3P	26.441	85	29	19	23	17	20	5	2	¥ 36,100
PT 1 -11	II	TIST16U	3P	33.249	95	35	22	26	21	24	5	2	¥ 66,600
PT 1 1/4-11	II	TIST20U	3P	41.910	105	37.5	24.5	32	26	30	5	2	¥ 101,000
PT 1 1/2-11	II	TIST24U	3P	47.803	110	38.5	25.5	38	29	32	7	2	¥ 142,000
PT 2 -11	II	TIST32U	3P	59.614	120	42.5	27.5	46	35	38	7	2	¥ 229,000 *

Think threads with
YAMAWA

* = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

LS-INT-PT

Long Shank Interrupted Taps for Taper Pipe Threads, Long (ℓg) Type



Specification

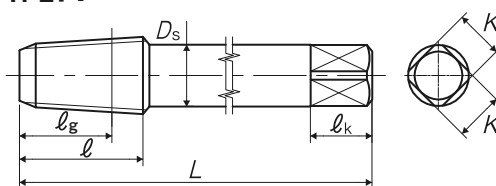


■LS-INT-PT long shank spiral fluted tap, having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque. LS-INT-PT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Stainless steels ステンレス鋼	Cast steels 鋳鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	TINT02KL10	3P	9.728	100	19	13	8	6	9	5	1	¥ 12,600 ※
PT 1/8-28	II	TINT02KL12	3P	9.728	120	19	13	8	6	9	5	1	¥ 14,600 ※
PT 1/8-28	II	TINT02KL15	3P	9.728	150	19	13	8	6	9	5	1	¥ 20,200 ※
PT 1/4-19	II	TINT04-L10	3P	13.157	100	28	21	11	9	12	5	1	¥ 13,600 ※
PT 1/4-19	II	TINT04-L12	3P	13.157	120	28	21	11	9	12	5	1	¥ 15,800 ※
PT 1/4-19	II	TINT04-L15	3P	13.157	150	28	21	11	9	12	5	1	¥ 20,800 ※
PT 3/8-19	II	TINT06-L10	3P	16.662	100	28	21	14	11	14	5	1	¥ 22,800 ※
PT 3/8-19	II	TINT06-L12	3P	16.662	120	28	21	14	11	14	5	1	¥ 23,100 ※
PT 3/8-19	II	TINT06-L15	3P	16.662	150	28	21	14	11	14	5	1	¥ 33,500 ※
PT 1/2-14	II	TINT08QL15	3P	20.955	150	35	25	18	14	17	5	1	¥ 40,300 ※
PT 3/4-14	II	TINT12QL15	3P	26.441	150	35	25	23	17	20	5	1	¥ 60,400 ※
PT 1 -11	II	TINT16UL15	3P	33.249	150	45	32	26	21	24	5	1	¥ 85,300 ※
PT 1 -11	II	TINT16UL20	3P	33.249	200	45	32	26	21	24	5	1	¥ 104,000 ※

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-43

LS-INT-S-PT



Long Shank Interrupted Taps for Taper Pipe Threads, Short (ℓg) Type

Specification



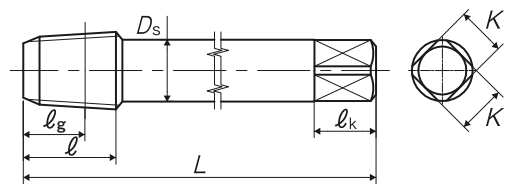
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Stainless steels ステンレス鋼	Cast steels 鋳鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■LS-INT-S-PT long shank short spiral fluted tap, having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque.

LS-INT-S-PT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	TIST02KL10	3P	9.728	100	16.5	10.5	8	6	9	5	1	¥ 12,600 ※
PT 1/8-28	II	TIST02KL12	3P	9.728	120	16.5	10.5	8	6	9	5	1	¥ 14,600 ※
PT 1/8-28	II	TIST02KL15	3P	9.728	150	16.5	10.5	8	6	9	5	1	¥ 20,200 ※
PT 1/4-19	II	TIST04-L10	3P	13.157	100	19.5	12.5	11	9	12	5	1	¥ 13,600 ※
PT 1/4-19	II	TIST04-L12	3P	13.157	120	19.5	12.5	11	9	12	5	1	¥ 15,800 ※
PT 1/4-19	II	TIST04-L15	3P	13.157	150	19.5	12.5	11	9	12	5	1	¥ 20,800 ※
PT 3/8-19	II	TIST06-L10	3P	16.662	100	21	14	14	11	14	5	1	¥ 22,800 ※
PT 3/8-19	II	TIST06-L12	3P	16.662	120	21	14	14	11	14	5	1	¥ 23,100 ※
PT 3/8-19	II	TIST06-L15	3P	16.662	150	21	14	14	11	14	5	1	¥ 33,500 ※
PT 1/2-14	II	TIST08QL15	3P	20.955	150	27	17	18	14	17	5	1	¥ 40,300 ※
PT 3/4-14	II	TIST12QL15	3P	26.441	150	29	19	23	17	20	5	1	¥ 60,400 ※
PT 1 -11	II	TIST16UL15	3P	33.249	150	35	22	26	21	24	5	1	¥ 85,300 ※
PT 1 -11	II	TIST16UL20	3P	33.249	200	35	22	26	21	24	5	1	¥ 104,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

LC-PT

Hand Taps for Taper Pipe Threads Long (ℓg) Type, for Low Carbon Steels



Specification

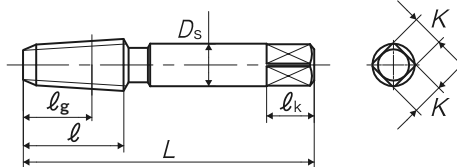


■ Tap suitable for such soft steels (low carbon steels) as SS400 and S25C.

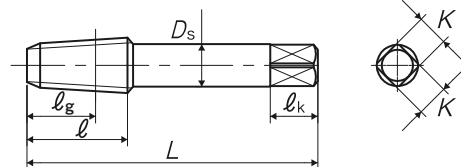
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Cast steels 鋳鋼
~5 (m/min)	~5 (m/min)

TYPE: 1



TYPE: 2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	LCPT01K	2.5P	7.723	55	19	13	8	6	9	4	1	¥ 4,450 ※
PT 1/8-28	II	LCPT02K	2.5P	9.728	55	19	13	8	6	9	4	2	¥ 4,450 ※
PT 1/4-19	II	LCPT04-	2.5P	13.157	62	28	21	11	9	12	4	2	¥ 6,360 ※
PT 3/8-19	II	LCPT06-	2.5P	16.662	65	28	21	14	11	14	4	2	¥ 10,500 ※
PT 1/2-14	II	LCPT08Q	2.5P	20.955	80	35	25	18	14	17	4	2	¥ 17,400 ※
PT 3/4-14	II	LCPT12Q	2.5P	26.441	85	35	25	23	17	20	4	2	¥ 27,400 ※
PT 1 -11	II	LCPT16U	2.5P	33.249	95	45	32	26	21	24	5	2	¥ 50,400 ※
PT 1 1/4-11	II	LCPT20U	2.5P	41.910	105	45	32	32	26	30	5	2	¥ 76,200 ※
PT 1 1/2-11	II	LCPT24U	2.5P	47.803	110	45	32	38	29	32	6	2	¥ 107,000 ※
PT 2 -11	II	LCPT32U	2.5P	59.614	120	50	35	46	35	38	6	2	¥ 174,000 ※

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-45

LC-S-PT

Hand Taps for Taper Pipe Threads Short (ℓg) Type, for Low Carbon Steels



Specification

HSS

OX
Oxide



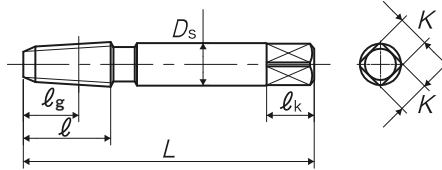
■ Tap, having short thread portion, suitable for such soft steels (low carbon steels) as SS400 and S25C.

Tapping Speeds depending on Materials

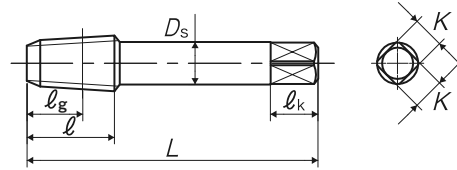
Low carbon steels
低炭素鋼
~5
(m/min)

Cast steels
鋳鋼
~5
(m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	LCSP01K	2.5P	7.723	55	16.5	10.5	8	6	9	4	1	¥ 4,450 ※
PT 1/8-28	II	LCSP02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	2	¥ 4,450 ※
PT 1/4-19	II	LCSP04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	2	¥ 6,360 ※
PT 3/8-19	II	LCSP06-	2.5P	16.662	65	21	14	14	11	14	4	2	¥ 10,500 ※
PT 1/2-14	II	LCSP08Q	2.5P	20.955	80	27	17	18	14	17	4	2	¥ 17,400 ※
PT 3/4-14	II	LCSP12Q	2.5P	26.441	85	29	19	23	17	20	4	2	¥ 27,400 ※
PT 1 -11	II	LCSP16U	2.5P	33.249	95	35	22	26	21	24	5	2	¥ 50,400 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

SU-PT

Hand Taps for Taper Pipe Threads Long (ℓg) Type, for Stainless Steels



Specification

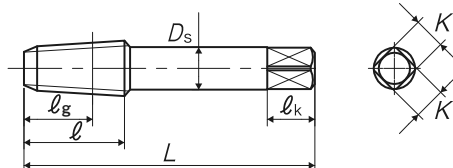


■SU-PT is the hand tap suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	D_s (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	TU2T02K	2.5P	9.728	55	19	13	8	6	9	4	1	¥ 4,650 ※
PT 1/4-19	II	TU2T04-	2.5P	13.157	62	28	21	11	9	12	4	1	¥ 6,640 ※
PT 3/8-19	II	TU2T06-	2.5P	16.662	65	28	21	14	11	14	4	1	¥ 11,000 ※
PT 1/2-14	II	TU2T08Q	2.5P	20.955	80	35	25	18	14	17	4	1	¥ 18,200 ※
PT 3/4-14	II	TU2T12Q	2.5P	26.441	85	35	25	23	17	20	4	1	¥ 28,700 ※
PT 1 -11	II	TU2T16U	2.5P	33.249	95	45	32	26	21	24	4	1	¥ 52,700 ※
PT 1 1/4-11	II	TU2T20U	2.5P	41.910	105	45	32	32	26	30	5	1	¥ 79,600 ※
PT 1 1/2-11	II	TU2T24U	2.5P	47.803	110	45	32	38	29	32	6	1	¥ 112,000 ※

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-47

SU-S-PT

Hand Taps for Taper Pipe Threads Short (ℓg) Type, for Stainless Steels



Specification

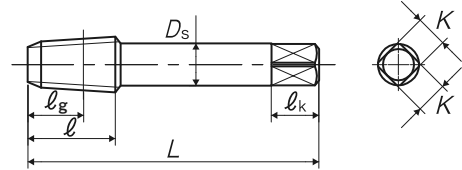


■SU-S-PT is the hand tap with short thread portion, suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)	Medium carbon steels 中炭素鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~5 (m/min)
--	---	---

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	TUST02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	1	¥ 4,650 ※
PT 1/4-19	II	TUST04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	1	¥ 6,640 ※
PT 3/8-19	II	TUST06-	2.5P	16.662	65	21	14	14	11	14	4	1	¥ 11,000 ※
PT 1/2-14	II	TUST08Q	2.5P	20.955	80	27	17	18	14	17	4	1	¥ 18,200 ※
PT 3/4-14	II	TUST12Q	2.5P	26.441	85	29	19	23	17	20	4	1	¥ 28,700 ※
PT 1 -11	II	TUST16U	2.5P	33.249	95	35	22	26	21	24	4	1	¥ 52,700 ※
PT 1 1/4-11	II	TUST20U	2.5P	41.910	105	37.5	24.5	32	26	30	5	1	¥ 79,600 ※
PT 1 1/2-11	II	TUST24U	2.5P	47.803	110	38.5	25.5	38	29	32	6	1	¥ 112,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

SU-SP-PT

Spiral Fluted Taps for Taper Pipe Threads, Long (ℓg) Type for Stainless Steels



Specification

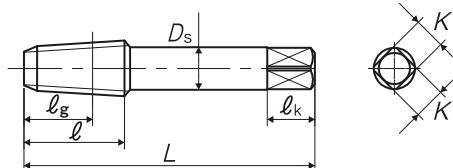


■SU-SP-PT is the tap suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels, blind hole use.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)	Medium carbon steels 中炭素鋼 ~5 (m/min)	High carbon steels 高炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~5 (m/min)
--	---	---	--------------------------------------	---

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	SYPT022GEX	2P	9.728	55	19	13	8	6	9	4	1	¥ 5,630 ※
PT 1/4-19	II	SYPT042GEX	2P	13.157	62	28	21	11	9	12	4	1	¥ 8,060 ※
PT 3/8-19	II	SYPT062GEX	2P	16.662	65	28	21	14	11	14	4	1	¥ 13,400 ※
PT 1/2-14	II	SYPT082GEX	2P	20.955	80	35	25	18	14	17	4	1	¥ 21,800 ※
PT 3/4-14	II	SYPT122GEX	2P	26.441	85	35	25	23	17	20	4	1	¥ 34,700 ※
PT 1 -11	II	SYPT162GEX	2P	33.249	95	45	32	26	21	24	5	1	¥ 63,900 ※
PT 1 1/4-11	II	SYPT202GEX	2P	41.910	105	45	32	32	26	30	5	1	¥ 96,500 ※
PT 1 1/2-11	II	SYPT242GEX	2P	47.803	110	45	32	38	29	32	6	1	¥ 136,000 ※
PT 2 -11	II	SYPT322GEX	2P	59.614	120	50	35	46	35	38	6	1	¥ 220,000 ※

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-49

S

SU-SP-S-PT

Spiral Fluted Taps for Taper Pipe Threads Short (ℓg) Type for Stainless Steels



Specification

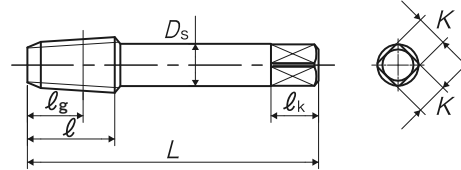


■SU-SP-S-PT is the tap with short thread portion, suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels, blind hole use.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	SYPT022GEXS	2P	9.728	55	16.5	10.5	8	6	9	4	1	¥ 5,630 ※
PT 1/4-19	II	SYPT042GEXS	2P	13.157	62	19.5	12.5	11	9	12	4	1	¥ 8,060 ※
PT 3/8-19	II	SYPT062GEXS	2P	16.662	65	21	14	14	11	14	4	1	¥ 13,400 ※
PT 1/2-14	II	SYPT082GEXS	2P	20.955	80	27	17	18	14	17	4	1	¥ 21,800 ※
PT 3/4-14	II	SYPT122GEXS	2P	26.441	85	29	19	23	17	20	4	1	¥ 34,700 ※
PT 1 -11	II	SYPT162GEXS	2P	33.249	95	35	22	26	21	24	5	1	¥ 63,900 ※
PT 1 1/4-11	II	SYPT202GEXS	2P	41.910	105	37.5	24.5	32	26	30	5	1	¥ 96,500 ※
PT 1 1/2-11	II	SYPT242GEXS	2P	47.803	110	38.5	25.5	38	29	32	6	1	¥ 136,000 ※
PT 2 -11	II	SYPT322GEXS	2P	59.614	120	42.5	27.5	46	35	38	6	1	¥ 220,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

FC-PT

Hand Taps for Taper Pipe Threads, Long (ℓg) Type, for Cast Irons



Specification

HSS

NI
Nitride



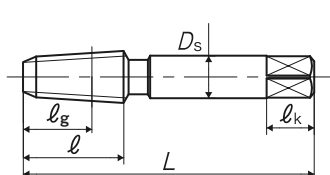
■FC-PT is suitable for hard and abrasive materials such as cast irons.

Tapping Speeds depending on Materials

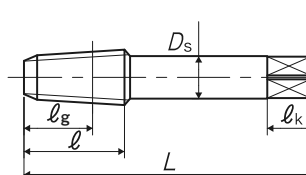
Cast irons
鑄鉄
~5
(m/min)

Ductile cast irons
強靱鑄鉄
~5
(m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	FCPT01K-8	2.5P	7.723	55	19	13	8	6	9	4	1	¥ 4,650 ※
PT 1/8-28	II	FCPT02K	2.5P	9.728	55	19	13	8	6	9	4	2	¥ 4,650 ※
PT 1/4-19	II	FCPT04-	2.5P	13.157	62	28	21	11	9	12	4	2	¥ 6,640 ※
PT 3/8-19	II	FCPT06-	2.5P	16.662	65	28	21	14	11	14	4	2	¥ 11,000 ※
PT 1/2-14	II	FCPT08Q	2.5P	20.955	80	35	25	18	14	17	4	2	¥ 18,200 ※
PT 3/4-14	II	FCPT12Q	2.5P	26.441	85	35	25	23	17	20	4	2	¥ 28,700 ※
PT 1 -11	II	FCPT16U	2.5P	33.249	95	45	32	26	21	24	5	2	¥ 52,700 ※
PT 1 1/4-11	II	FCPT20U	2.5P	41.910	105	45	32	32	26	30	5	2	¥ 79,600 ※
PT 1 1/2-11	II	FCPT24U	2.5P	47.803	110	45	32	38	29	32	6	2	¥112,000 ※
PT 2 -11	II	FCPT32U	2.5P	59.614	120	50	35	46	35	38	6	2	¥182,000 ※

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

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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 Mills
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

FC-S-PT

Hand Taps for Taper Pipe Threads, Short (ℓg) Type, for Cast Irons



Specification

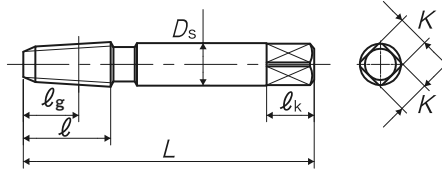


■FC-S-PT is the tap with short thread portion, suitable for hard and abrasive materials such as cast irons.

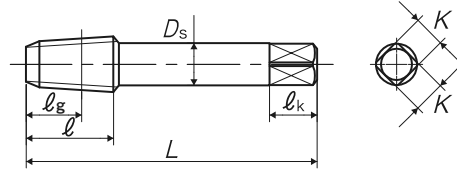
Tapping Speeds depending on Materials

Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄
~5 (m/min)	~5 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	FCSPT01K-8	2.5P	7.723	55	16.5	10.5	8	6	9	4	1	¥ 4,650 ※
PT 1/8-28	II	FCSPT02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	2	¥ 4,650 ※
PT 1/4-19	II	FCSPT04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	2	¥ 6,640 ※
PT 3/8-19	II	FCSPT06-	2.5P	16.662	65	21	14	14	11	14	4	2	¥ 11,000 ※
PT 1/2-14	II	FCSPT08Q	2.5P	20.955	80	27	17	18	14	17	4	2	¥ 18,200 ※
PT 3/4-14	II	FCSPT12Q	2.5P	26.441	85	29	19	23	17	20	4	2	¥ 28,700 ※
PT 1 -11	II	FCSPT16U	2.5P	33.249	95	35	22	26	21	24	5	2	¥ 52,700 ※
PT 1 1/4-11	II	FCSPT20U	2.5P	41.910	105	37.5	24.5	32	26	30	5	2	¥ 79,600 ※
PT 1 1/2-11	II	FCSPT24U	2.5P	47.803	110	38.5	25.5	38	29	32	6	2	¥112,000 ※
PT 2 -11	II	FCSPT32U	2.5P	59.614	120	42.5	27.5	46	35	38	6	2	¥182,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

CT-PT

Carbide Taps for Taper Pipe Threads, Long (ℓg) Type, for Cast Irons



Specification

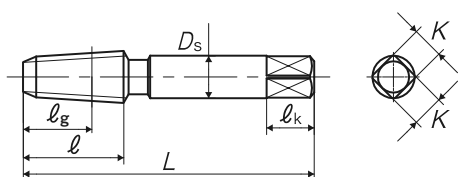


■ The CT-PT is a hand tap for tapered pipe threads and is suitable for thread processing in mass production of materials that are hard and brittle such as cast iron. Those products are mainly used for connecting parts for pipes for thread resistance.

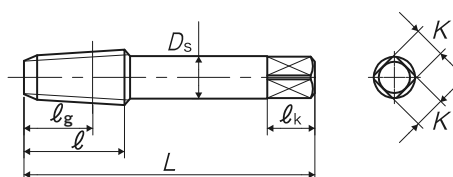
Tapping Speeds depending on Materials

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

TYPE: 1



TYPE: 2



Segment : 1L

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/16-28	II	TCPT01K	2.5P	7.723	55	19	13	8	6	9	4	1	¥ 31,900 ※
PT 1/8-28	II	TCPT02K	2.5P	9.728	55	19	13	8	6	9	4	2	¥ 31,900 ※
PT 1/4-19	II	TCPT04-	2.5P	13.157	62	28	21	11	9	12	4	2	¥ 49,600 ※
PT 3/8-19	II	TCPT06-	2.5P	16.662	65	28	21	14	11	14	4	2	¥ 62,000 ※
PT 1/2-14	II	TCPT08Q	2.5P	20.955	80	35	25	18	14	17	4	2	¥ 61,200 ※
PT 3/4-14	II	TCPT12Q	2.5P	26.441	85	35	25	23	17	20	4	2	¥ 75,800 ※
PT 1 -11	II	TCPT16U	2.5P	33.249	95	45	32	26	21	24	5	2	¥ 109,000 ※

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

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

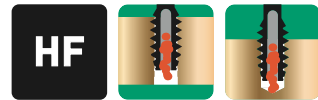
JIS

CT-S-PT

Carbide Taps for Taper Pipe Threads, Short (ℓg) Type, for Cast Irons



Specification

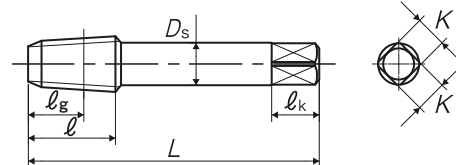


Tapping Speeds depending on Materials

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

■The CT-S-PT is a hand tap for tapered pipe threads and is suitable for thread processing in mass produced hard and brittle material such as cast iron. It is used for tapping when the fitting length needs to be shortened. It produces a threaded product whose main purpose is the tightness of the threaded parts.

TYPE: 1



Segment : 1L

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PT 1/8-28	II	TCST02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	1	¥ 31,900 ※
PT 1/4-19	II	TCST04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	1	¥ 49,600 ※
PT 3/8-19	II	TCST06-	2.5P	16.662	65	21	14	14	11	14	4	1	¥ 62,000 ※
PT 1/2-14	II	TCST08Q	2.5P	20.955	80	27	17	18	14	17	4	1	¥ 61,200 ※
PT 3/4-14	II	TCST12Q	2.5P	26.441	85	29	19	23	17	20	4	1	¥ 75,800 ※
PT 1 -11	II	TCST16U	2.5P	33.249	95	35	22	26	21	24	5	1	¥109,000 ※

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

Rp

Hand Taps for Parallel Pipe Threads



Specification

HSS



■ This is a hand tap for parallel pipe threads based on ISO shape standards. It is used for engagement with the taper pipe external thread R (PT).

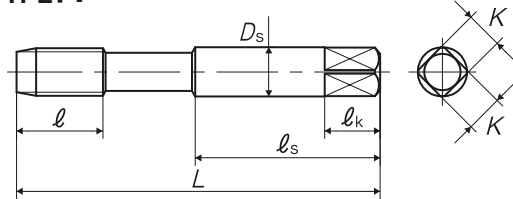
Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
5~10
(m/min)

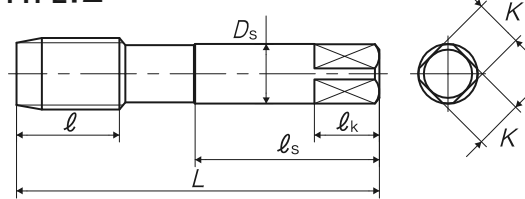
Medium carbon steels
中炭素鋼
5~10
(m/min)

High carbon steels
高炭素鋼
5~10
(m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
Rp 1/16-28	II	TH2RP01K	3.5P	7.723	59	14	30	8	6	9	4	1	¥ 3,060
Rp 1/8-28	II	TH2RP02K	3.5P	9.728	59	15	30	8	6	9	4	2	¥ 3,060
Rp 1/4-19	II	TH2RP04-	3.5P	13.157	67	19	34	11	9	12	4	2	¥ 4,800
Rp 3/8-19	II	TH2RP06-	3.5P	16.662	75	21	38	14	11	14	4	2	¥ 7,910
Rp 1/2-14	II	TH2RP08Q	3.5P	20.955	87	26	44	18	14	17	4	2	¥ 12,900
Rp 3/4-14	II	TH2RP12Q	3.5P	26.441	96	28	49	23	17	20	4	2	¥ 20,600
Rp 1 -11	II	TH2RP16U	3.5P	33.249	109	33	56	26	21	24	5	2	¥ 38,600
Rp 1 1/4-11	II	TH2RP20U	3.5P	41.910	119	36	61	32	26	30	5	2	¥ 60,900
Rp 1 1/2-11	II	TH2RP24U	3.5P	47.803	125	37	64	38	29	32	6	2	¥ 83,800
Rp 2 -11	II	TH2RP32U	3.5P	59.614	140	41	71	46	35	38	6	2	¥ 143,000

* For tapping with this tap, follow the bored hole size before threading of "PS" on page 41 of the Technical Materials.

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

8 Pipe 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

PS

Hand Taps for Parallel Pipe Threads



Specification

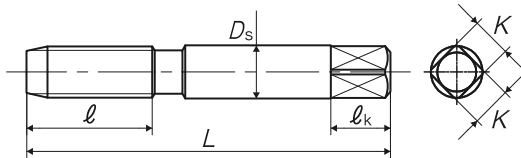


Tapping Speeds depending on Materials

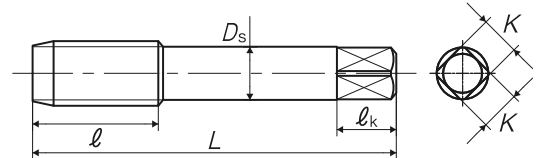
Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■The PS is a hand tap for parallel pipe threads and is used for products whose main purpose is the tightness of the threaded part in connection with pipe parts etc. The PS internal thread is used for fitting with PT external thread.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PS 1/16-28	II	TH2P01K-8	3.5P	7.723	55	19	8	6	9	4	1	¥ 3,060 ※
PS 1/8-28	II	TH2P02K	3.5P	9.728	55	19	8	6	9	4	2	¥ 3,060
PS 1/8-28	II	TH2P02K1	1.5P	9.728	55	19	8	6	9	4	2	¥ 3,060 ※
PS 1/4-19	II	TH2P04-	3.5P	13.157	62	28	11	9	12	4	2	¥ 4,800
PS 1/4-19	II	TH2P04-1	1.5P	13.157	62	28	11	9	12	4	2	¥ 4,800 ※
PS 3/8-19	II	TH2P06-	3.5P	16.662	65	28	14	11	14	4	2	¥ 7,910
PS 3/8-19	II	TH2P06-1	1.5P	16.662	65	28	14	11	14	4	2	¥ 7,910 ※
PS 1/2-14	II	TH2P08Q	3.5P	20.955	80	35	18	14	17	4	2	¥ 12,900
PS 1/2-14	II	TH2P08Q1	1.5P	20.955	80	35	18	14	17	4	2	¥ 12,900 ※
PS 5/8-14	II	TH2P10Q	3.5P	22.911	82	35	19	15	18	4	2	¥ 18,100 ※
PS 3/4-14	II	TH2P12Q	3.5P	26.441	85	35	23	17	20	4	2	¥ 20,600
PS 3/4-14	II	TH2P12Q1	1.5P	26.441	85	35	23	17	20	4	2	¥ 20,600 ※
PS 7/8-14	II	TH2P14Q	3.5P	30.201	90	40	24	19	22	4	2	¥ 31,000 ※
PS 1 -11	II	TH2P16U	3.5P	33.249	95	45	26	21	24	5	2	¥ 38,600
PS 1 -11	II	TH2P16U1	1.5P	33.249	95	45	26	21	24	5	2	¥ 38,600 ※
PS 1 1/8-11	II	TH2P18U	3.5P	37.897	100	45	28	21	24	5	2	¥ 56,900 ※
PS 1 1/4-11	II	TH2P20U	3.5P	41.910	105	45	32	26	30	5	2	¥ 60,900
PS 1 1/4-11	II	TH2P20U1	1.5P	41.910	105	45	32	26	30	5	2	¥ 60,900 ※
PS 1 1/2-11	II	TH2P24U	3.5P	47.803	110	45	38	29	32	6	2	¥ 83,800
PS 1 1/2-11	II	TH2P24U1	1.5P	47.803	110	45	38	29	32	6	2	¥ 83,800 ※
PS 1 3/4-11	II	TH2P28U	3.5P	53.746	115	45	42	32	35	6	2	¥ 115,000 ※
PS 2 -11	II	TH2P32U	3.5P	59.614	120	50	46	35	38	6	2	¥ 143,000
PS 2 1/4-11	II	TH2P36U	3.5P	65.710	145	65	50	38	42	6	2	¥ 228,000 ※
PS 2 1/2-11	II	TH2P40U	3.5P	75.184	145	65	55	41	44	8	2	¥ 236,000 ※

JIS

⑧-55

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	ℓk

8

JIS

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
PS 3 -11	II	TH2P48U	3.5P	87.884	155	65	65	50	52	8	2	¥ 354,000 ※
PS 3 1/2-11	II	TH2P56U	3.5P	100.330	165	68	70	54	58	8	2	¥ 459,000 ※
PS 4 -11	II	TH2P64U	3.5P	113.030	170	70	75	58	62	10	2	¥ 620,000 ※

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

⑧-56

⑧ Pipe Tap Series

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

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

⑧-57

PS LH

Hand Taps for Parallel Pipe Threads, for LH Threads



Specification

HSS



LH
Left hand

■ The PS LH is a hand tap for left hand parallel pipe threads and is used for products whose main purpose is the tightness of threaded parts in connecting piping parts. The PS internal thread is used for fitting with PT external thread.

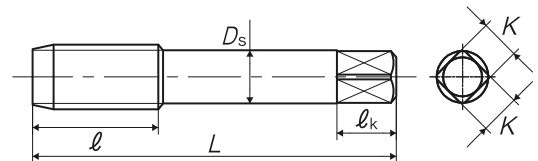
Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
5~10
(m/min)

Medium carbon steels
中炭素鋼
5~10
(m/min)

High carbon steels
高炭素鋼
5~10
(m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PS 1/8-28	II	TH2P02K--L	3.5P	9.728	55	19	8	6	9	4	1	¥ 4,410 ※
PS 1/4-19	II	TH2P04---L	3.5P	13.157	62	28	11	9	12	4	1	¥ 6,400 ※
PS 3/8-19	II	TH2P06---L	3.5P	16.662	65	28	14	11	14	4	1	¥ 10,600 ※
PS 1/2-14	II	TH2P08Q--L	3.5P	20.955	80	35	18	14	17	4	1	¥ 17,200 ※
PS 3/4-14	II	TH2P12Q--L	3.5P	26.441	85	35	23	17	20	4	1	¥ 28,000 ※
PS 1 -11	II	TH2P16U--L	3.5P	33.249	95	45	26	21	24	5	1	¥ 52,400 ※
PS 1 1/4-11	II	TH2P20U--L	3.5P	41.910	105	45	32	26	30	5	1	¥ 82,600 ※
PS 1 1/2-11	II	TH2P24U--L	3.5P	47.803	110	45	38	29	32	6	1	¥ 114,000 ※
PS 2 -11	II	TH2P32U--L	3.5P	59.614	120	50	46	35	38	6	1	¥ 195,000 ※

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	ℓk

8

JIS

LS-PS

Long Shank Hand Taps for Parallel Pipe Threads



Specification

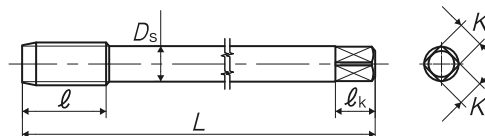


Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■ The LS-PS is a long shank tap for parallel pipe threads and is used for products whose main purpose is the tightness of the threaded part in connection with parts for pipes. The PS internal thread is used for fitting with PT external thread.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PS 1/8-28	II	L10P02K	3.5P	9.728	100	19	8	6	9	4	1	¥ 6,090
PS 1/8-28	II	L15P02K	3.5P	9.728	150	19	8	6	9	4	1	¥ 11,000
PS 1/8-28	II	L20P02K	3.5P	9.728	200	19	8	6	9	4	1	¥ 15,700 ※
PS 1/4-19	II	L10P04-	3.5P	13.157	100	28	11	9	12	4	1	¥ 8,170
PS 1/4-19	II	L15P04-	3.5P	13.157	150	28	11	9	12	4	1	¥ 11,200
PS 1/4-19	II	L20P04-	3.5P	13.157	200	28	11	9	12	4	1	¥ 16,100 ※
PS 3/8-19	II	L10P06-	3.5P	16.662	100	28	14	11	14	4	1	¥ 10,500
PS 3/8-19	II	L15P06-	3.5P	16.662	150	28	14	11	14	4	1	¥ 18,900
PS 3/8-19	II	L20P06-	3.5P	16.662	200	28	14	11	14	4	1	¥ 26,600 ※
PS 1/2-14	II	L15P08Q	3.5P	20.955	150	35	18	14	17	4	1	¥ 23,200
PS 1/2-14	II	L20P08Q	3.5P	20.955	200	35	18	14	17	4	1	¥ 32,500 ※
PS 3/4-14	II	L15P12Q	3.5P	26.441	150	35	23	17	20	4	1	¥ 34,200
PS 3/4-14	II	L20P12Q	3.5P	26.441	200	35	23	17	20	4	1	¥ 41,400 ※
PS 1 -11	II	L15P16U	3.5P	33.249	150	45	26	21	24	5	1	¥ 50,100
PS 1 -11	II	L20P16U	3.5P	33.249	200	45	26	21	24	5	1	¥ 58,100 ※
PS 1 1/4-11	II	L20P20U	3.5P	41.910	200	45	32	26	30	5	1	¥ 90,900 ※
PS 1 1/2-11	II	L20P24U	3.5P	47.803	200	45	38	29	32	6	1	¥ 115,000 ※

※ = 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

⑧-58

⑧ Pipe Tap Series

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

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

⑧-59

S
P
S

SP-PS

Spiral Fluted Taps for Parallel Pipe Threads



Specification

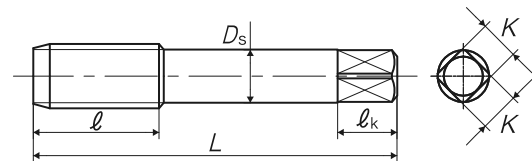


Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■The SP-PS is a spiral flute tap for parallel pipe threads and is used for products whose main purpose is the tightness of threaded parts in connection with pipe parts etc. The PS internal thread is used for fitting with PT external thread.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PS 1/8-28	II	SH2P02K	2.5P	9.728	55	19	8	6	9	3	1	¥ 3,550
PS 1/4-19	II	SH2P04-	2.5P	13.157	62	28	11	9	12	3	1	¥ 5,130
PS 3/8-19	II	SH2P06-	2.5P	16.662	65	28	14	11	14	3	1	¥ 8,480
PS 1/2-14	II	SH2P08Q	2.5P	20.955	80	35	18	14	17	4	1	¥ 13,800
PS 3/4-14	II	SH2P12Q	2.5P	26.441	85	35	23	17	20	4	1	¥ 22,100
PS 1 -11	II	SH2P16U	2.5P	33.249	95	45	26	21	24	4	1	¥ 41,300
PS 1 1/4-11	II	SH2P20U	2.5P	41.910	105	45	32	26	30	4	1	¥ 65,000 ※
PS 1 1/2-11	II	SH2P24U	2.5P	47.803	110	45	38	29	32	4	1	¥ 89,600 ※
PS 2 -11	II	SH2P32U	2.5P	59.614	120	50	46	35	38	4	1	¥ 153,000 ※

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	ℓk

LS-SP-PS

Long Shank Spiral Fluted Taps for Parallel Pipe Threads



Specification

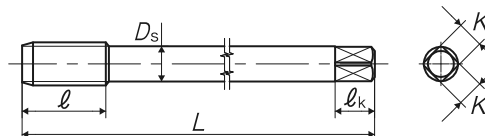


Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■The LS-SP-PS is a long shank spiral flute tap for parallel pipe threads and is used for products whose main purpose is the tightness of the threaded portion in connection with pipe parts etc. The PS internal thread is used for fitting with PT external thread.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PS 1/8-28	II	SH2P02KL10	2.5P	9.728	100	19	8	6	9	3	1	¥ 6,530 ※
PS 1/8-28	II	SH2P02KL12	2.5P	9.728	120	19	8	6	9	3	1	¥ 7,320 ※
PS 1/8-28	II	SH2P02KL15	2.5P	9.728	150	19	8	6	9	3	1	¥ 11,800 ※
PS 1/4-19	II	SH2P04-L10	2.5P	13.157	100	28	11	9	12	3	1	¥ 8,760 ※
PS 1/4-19	II	SH2P04-L15	2.5P	13.157	150	28	11	9	12	3	1	¥ 12,100 ※
PS 3/8-19	II	SH2P06-L10	2.5P	16.662	100	28	14	11	14	3	1	¥ 11,300 ※
PS 3/8-19	II	SH2P06-L12	2.5P	16.662	120	28	14	11	14	3	1	¥ 12,900 ※
PS 3/8-19	II	SH2P06-L15	2.5P	16.662	150	28	14	11	14	3	1	¥ 20,200 ※
PS 1/2-14	II	SH2P08QL15	2.5P	20.955	150	35	18	14	17	4	1	¥ 24,900 ※
PS 3/4-14	II	SH2P12QL15	2.5P	26.441	150	35	23	17	20	4	1	¥ 36,700 ※
PS 1 -11	II	SH2P16UL15	2.5P	33.249	150	45	26	21	24	4	1	¥ 53,500 ※
PS 1 -11	II	SH2P16UL20	2.5P	33.249	200	45	26	21	24	4	1	¥ 62,200 ※

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

⑧ Pipe Tap Series

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

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

⑧-61

FC-PS

Hand Tap for Parallel Pipe Threads in Cast Irons



Specification

HSS

NI
Nitride



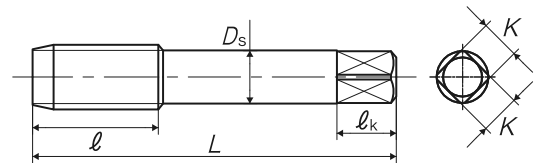
Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~10
(m/min)

Ductile cast irons
強靱鑄鉄
5~10
(m/min)

■The FC-PS is a hand tap for parallel pipe threads and is suitable for thread processing of hard and brittle material in mass production such as cast iron. It produces parallel pipe threads for products whose main purpose is the tightness of thread. It is used for parts in connection with pipe parts etc. The PS internal thread is used for fitting with PT external.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PS 1/8-28	II	FCPS02K	3.5P	9.728	55	19	8	6	9	4	1	¥ 3,810 ※
PS 1/4-19	II	FCPS04-	3.5P	13.157	62	28	11	9	12	4	1	¥ 5,530 ※
PS 3/8-19	II	FCPS06-	3.5P	16.662	65	28	14	11	14	4	1	¥ 9,110 ※
PS 1/2-14	II	FCPS08Q	3.5P	20.955	80	35	18	14	17	4	1	¥ 14,900 ※
PS 3/4-14	II	FCPS12Q	3.5P	26.441	85	35	23	17	20	4	1	¥ 23,700 ※
PS 1 -11	II	FCPS16U	3.5P	33.249	95	45	26	21	24	5	1	¥ 44,400 ※
PS 1 1/4-11	II	FCPS20U	3.5P	41.910	105	45	32	26	30	5	1	¥ 70,100 ※
PS 1 1/2-11	II	FCPS24U	3.5P	47.803	110	45	38	29	32	6	1	¥ 96,400 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

CT-PS

Carbide Taps for Parallel Pipe Threads

Specification



Tapping Speeds depending on Materials

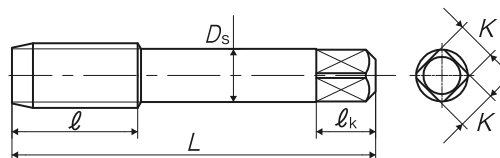
Cast irons
鑄鉄
5~10
(m/min)

Ductile cast irons
強靱鑄鉄
5~10
(m/min)

Brass castings
黄銅鑄物
5~10
(m/min)

■The CT-PS is a cemented carbide hand tap for parallel pipe threads and is suitable for thread processing of hard and brittle material such as cast iron. It is used on products whose main purpose is the tightness of the threaded part in connection with pipe parts etc. The PS internal thread is used for fitting with PT external thread.

TYPE: 1



Segment : 1L

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	l (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PS 1/8-28	II	TCPS02K	3.5P	9.728	55	19	8	6	9	4	1	¥ 27,300 ※
PS 1/4-19	II	TCPS04-	3.5P	13.157	62	28	11	9	12	4	1	¥ 42,900 ※
PS 3/8-19	II	TCPS06-	3.5P	16.662	65	28	14	11	14	4	1	¥ 52,900 ※
PS 1/2-14	II	TCPS08Q	3.5P	20.955	80	35	18	14	17	4	1	¥ 52,500 ※
PS 3/4-14	II	TCPS12Q	3.5P	26.441	85	35	23	17	20	4	1	¥ 71,900 ※
PS 1 -11	II	TCPS16U	3.5P	33.249	95	45	26	21	24	5	1	¥102,000 ※

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



⑧ Pipe 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

⑧-63

G

Hand Taps for Parallel Pipe Threads



Specification

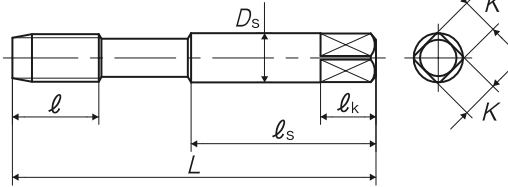


Tapping Speeds depending on Materials

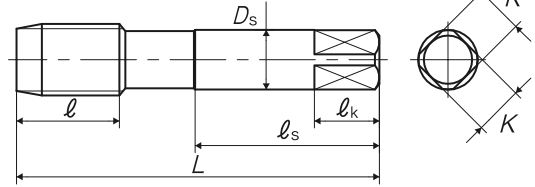
Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■The G tap is a hand tap for parallel pipe threads and conforms to the ISO thread specifications. It is used for fitting with the pipe parallel external thread G (PF).

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
G 1/16-28	II	TH2G01K	3.5P	7.723	59	14	30	8	6	9	4	1	¥ 3,060
G 1/8-28	II	TH2G02K	3.5P	9.728	59	15	30	8	6	9	4	2	¥ 3,060
G 1/4-19	II	TH2G04-	3.5P	13.157	67	19	34	11	9	12	4	2	¥ 4,800
G 3/8-19	II	TH2G06-	3.5P	16.662	75	21	38	14	11	14	4	2	¥ 7,910
G 1/2-14	II	TH2G08Q	3.5P	20.955	87	26	44	18	14	17	4	2	¥ 12,900
G 3/4-14	II	TH2G12Q	3.5P	26.441	96	28	49	23	17	20	4	2	¥ 20,600
G 1 -11	II	TH2G16U	3.5P	33.249	109	33	56	26	21	24	4	2	¥ 38,600
G 1 1/4-11	II	TH2G20U	3.5P	41.910	119	36	61	32	26	30	4	2	¥ 60,900
G 1 1/2-11	II	TH2G24U	3.5P	47.803	125	37	64	38	29	32	6	2	¥ 83,800
G 2 -11	II	TH2G32U	3.5P	59.614	140	41	71	46	35	38	6	2	¥ 143,000

Think threads with
YAMAWA

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

⑧ Pipe Tap Series

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

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

⑧-65

DIN

SP G

Spiral Fluted Taps for Parallel Pipe Threads



Specification



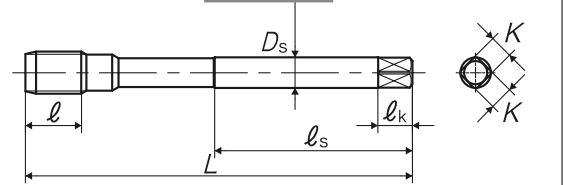
■ Spiral flutes continuously curl the chips and discharge them back toward the shank of the tap. Spiral flute taps are the most suitable for blind hole processing.

Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)

TYPE: 1

DIN5156



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For G Threads											
G 1/16-28	-	SVG0010NEB	2.5P	90	12	46	6	4.9	8	3	1
G 1/8-28	-	SVG0020NEB	2.5P	90	12	46	7	5.5	8	3	1
G 1/4-19	-	SVG0040NEB	2.5P	100	14	51	11	9	12	3	1
G 3/8-19	-	SVG0060NEB	2.5P	100	14	51	12	9	12	3	1
G 1/2-14	-	SVG0080NEB	2.5P	125	18	64	16	12	15	4	1
G 3/4-14	-	SVG0120NEB	2.5P	140	20	71	20	16	19	4	1
G 7/8-14	-	SVG0140NEB	2.5P	150	20	77	22	18	21	4	1
G 1 -11	-	SVG0160NEB	2.5P	160	20	82	25	20	23	4	1
G 1 1/8-11	-	SVG0180NEB	2.5P	170	20	87	28	22	25	4	1
G 1 1/4-11	-	SVG0200NEB	2.5P	170	20	87	32	24	27	4	1
G 1 1/2-11	-	SVG0240NEB	2.5P	190	25	97	36	29	32	4	1

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	ℓ_s	Ds	K	ℓ_k

SP OX G



Spiral Fluted Taps for Parallel Pipe Threads, Oxidized

Specification

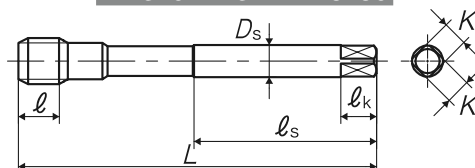


Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■The SP OX G is a spiral flute tap for blind hole tapping. These taps have an applied oxidation treatment to prevent chip welding on the surface of the taps threaded portion. They are suitable for thread processing of soft steel materials where the chips easily weld to the tap like low carbon.

TYPE: 1 DIN376/DIN374/DIN5156



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/16-28	-	SVG0010NEX	2.5P	90	12	46	6	4.9	8	3	1
G 1/8-28	-	SVG0020NEX	2.5P	90	12	46	7	5.5	8	3	1
G 1/4-19	-	SVG0040NEX	2.5P	100	14	51	11	9	12	3	1
G 3/8-19	-	SVG0060NEX	2.5P	100	14	51	12	9	12	3	1
G 1/2-14	-	SVG0080NEX	2.5P	125	18	64	16	12	15	4	1
G 5/8-14	-	SVG0100NEX	2.5P	125	18	64	18	14.5	17	4	1
G 3/4-14	-	SVG0120NEX	2.5P	140	20	71	20	16	19	4	1
G 7/8-14	-	SVG0140NEX	2.5P	150	20	77	22	18	21	4	1
G 1 -11	-	SVG0160NEX	2.5P	160	20	82	25	20	23	4	1
G 1 1/8-11	-	SVG0180NEX	2.5P	170	20	87	28	22	25	4	1
G 1 1/4-11	-	SVG0200NEX	2.5P	170	20	87	32	24	27	4	1
G 1 1/2-11	-	SVG0240NEX	2.5P	190	25	97	36	29	32	4	1

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

⑧ Pipe Tap Series

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

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

⑧-67

DIN

SP V G

Spiral Fluted Taps for Parallel Pipe Threads, Coated



Specification

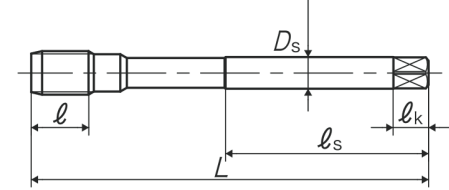


■ This is a coated spiral fluted tap for blind holes.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)

TYPE: 1 DIN376/DIN374/DIN5156



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	9940R02TI	2.5P	90	12	46	7	5.5	8	3	1
G 1/4-19	-	9940R04TI	2.5P	100	14	51	11	9	12	3	1
G 3/8-19	-	9940R06TI	2.5P	100	14	51	12	9	12	3	1
G 1/2-14	-	9940R08TI	2.5P	125	18	64	16	12	15	4	1

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	ℓ_s	Ds	K	ℓ_k

SP-VA G

Spiral Fluted Taps for Parallel Pipe Threads, for Stainless Steels

Specification

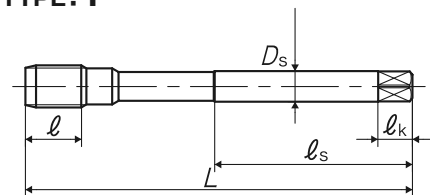


■ Most suitable for stainless steels, sticky and tending to work-harden, as well as chrome steels and molybdenum steels, blind hole use.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~10 (m/min)	Medium carbon steels 中炭素鋼 ~10 (m/min)	High carbon steels 高炭素鋼 ~10 (m/min)	Alloy steels 合金鋼 ~10 (m/min)	Stainless steels ステンレス鋼 ~10 (m/min)
---	--	--	---------------------------------------	--

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	SVG0020GEX	2.5P	90	12	46	7	5.5	8	3	1
G 1/4-19	-	SVG0040GEX	2.5P	100	14	51	11	9	12	3	1
G 3/8-19	-	SVG0060GEX	2.5P	100	14	51	12	9	12	3	1
G 1/2-14	-	SVG0080GEX	2.5P	125	18	64	16	12	15	4	1
G 3/4-14	-	SVG0120GEX	2.5P	140	20	71	20	16	19	4	1
G 1 -11	-	SVG0160GEX	2.5P	160	20	82	25	20	23	4	1

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

⑧ Pipe 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

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

SU2-SP G



Spiral Fluted Taps for Parallel Pipe Threads, for Tough Stainless Steels

Specification

HSS

OX
Oxide



Synchro
nized

■ SU2-SP G is the spiral fluted tap most suitable for tough stainless steels, blind hole use.

Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
5~20
(m/min)

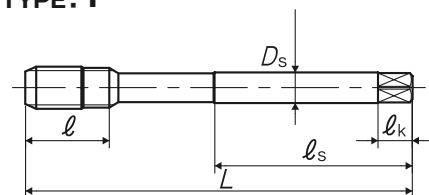
Medium carbon steels
中炭素鋼
5~20
(m/min)

High carbon steels
高炭素鋼
5~20
(m/min)

Alloy steels
合金鋼
5~20
(m/min)

Stainless steels
ステンレス鋼
5~15
(m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	SVG0020GEXJ	3P	90	19	46	7	5.5	8	3	1
G 1/4-19	-	SVG0040GEXJ	3P	100	21	51	11	9	12	4	1
G 3/8-19	-	SVG0060GEXJ	3P	100	21	51	12	9	12	4	1
G 1/2-14	-	SVG0080GEXJ	3P	125	24	64	16	12	15	4	1
G 3/4-14	-	SVG0120GEXJ	3P	140	27	71	20	16	19	4	1

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	ℓ_s	Ds	K	ℓ_k

LO-SP G



Low Spiral Fluted Taps for Parallel Pipe Threads

Specification

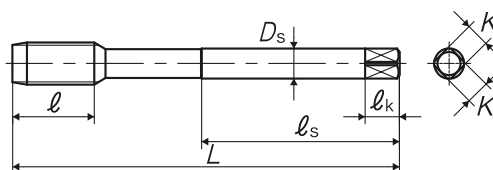


■Spiral flutes with low helix can break down chips and can eject them smoothly. Suitable for thermal refined high carbon steels and alloy tool steels. Effective in horizontal tapping.

Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	SVG0020NEBH	3.5P	90	19	46	7	5.5	8	3	1
G 1/4-19	-	SVG0040NEBH	3.5P	100	21	51	11	9	12	3	1
G 3/8-19	-	SVG0060NEBH	3.5P	100	21	51	12	9	12	3	1
G 1/2-14	-	SVG0080NEBH	3.5P	125	24	64	16	12	15	4	1
G 1 -11	-	SVG0160NEBH	3.5P	160	29	82	25	20	23	4	1

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

⑧ Pipe 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

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

LO-SP OX G

Low Spiral Fluted Taps for Parallel Pipe Threads, Oxidized



Specification

HSS

OX

Oxide



■ Spiral flutes with low helix can break down chips and can eject them smoothly. Suitable for thermal refined high carbon steels and alloy tool steels. Effective in horizontal tapping.

Tapping Speeds depending on Materials

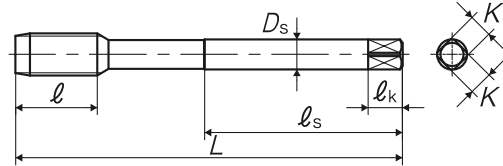
Medium carbon steels
中炭素鋼

5~10
(m/min)

High carbon steels
高炭素鋼

5~10
(m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	SVG0020NEXH	3.5P	90	19	46	7	5.5	8	3	1
G 1/4-19	-	SVG0040NEXH	3.5P	100	21	51	11	9	12	3	1
G 3/8-19	-	SVG0060NEXH	3.5P	100	21	51	12	9	12	3	1
G 1/2-14	-	SVG0080NEXH	3.5P	125	24	64	16	12	15	4	1
G 3/4-14	-	SVG0120NEXH	3.5P	140	27	71	20	16	19	4	1
G 1 -11	-	SVG0160NEXH	3.5P	160	29	82	25	20	23	4	1

⑧-71

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

PH-SP G



Spiral Fluted Taps for Parallel Pipe Threads, for Hard-to-Machine Materials

Specification

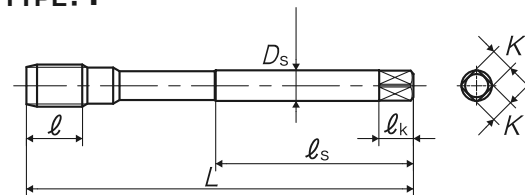


■ Suitable for hard steels of 27-38HRC, such as forgings and thermal refined steels of high carbon steels and alloy steels, and die steels.

Tapping Speeds depending on Materials

High carbon steels 高炭素鋼	Alloy steels 合金鋼	Thermal refined steels 調質鋼
2~7 (m/min)	2~7 (m/min)	~5 (m/min)
		25~35HRC

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	SVG0020EEX	3P	90	12	46	7	5.5	8	3	1
G 1/4-19	-	SVG0040EEX	3P	100	14	51	11	9	12	4	1
G 3/8-19	-	SVG0060EEX	3P	100	14	51	12	9	12	4	1
G 1/2-14	-	SVG0080EEX	3P	125	18	64	16	12	15	5	1

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

8 Pipe Tap Series

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

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

DIN

PO G

Spiral Pointed Taps for Parallel Pipe Threads



Specification

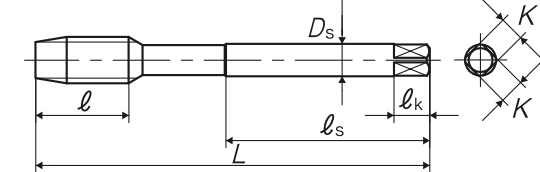


Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)

■The PO taps push the chips forward and discharge them in the direction of tapping. These taps cut a stable thread with few problems due to chips, making them ideal for through hole machining.

TYPE: 1 DIN376/DIN374/DIN5156



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For G Threads											
G 1/16-28	-	PVG0010NEB	5P	90	19	46	6	4.9	8	3	1
G 1/8-28	-	PVG0020NEB	5P	90	19	46	7	5.5	8	3	1
G 1/4-19	-	PVG0040NEB	5P	100	21	51	11	9	12	3	1
G 3/8-19	-	PVG0060NEB	5P	100	21	51	12	9	12	3	1
G 1/2-14	-	PVG0080NEB	5P	125	24	64	16	12	15	3	1
G 5/8-14	-	PVG0100NEB	5P	125	24	64	18	14.5	17	3	1
G 3/4-14	-	PVG0120NEB	5P	140	27	71	20	16	19	4	1
G 7/8-14	-	PVG0140NEB	5P	150	27	77	22	18	21	4	1
G 1 -11	-	PVG0160NEB	5P	160	29	82	25	20	23	4	1
G 1 1/8-11	-	PVG0180NEB	5P	170	29	87	28	22	25	4	1
G 1 1/4-11	-	PVG0200NEB	5P	170	29	87	32	24	27	4	1
G 1 1/2-11	-	PVG0240NEB	5P	190	31	97	36	29	32	4	1

DIN

⑧-73

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	ℓ_s	Ds	K	ℓ_k

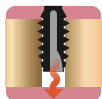
PO OX G

Spiral Pointed Taps for Parallel Pipe Threads, Oxidized

Specification

HSS
OX

Oxide



■ The PO OX G is a spiral pointed tap for through hole tapping and is suitable for synchronous feed processing in middle to high thread processing of soft steel materials whose chips easily weld to the taps thread such as low carbon steels.

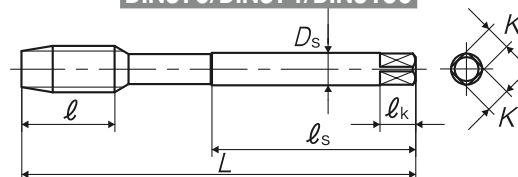
Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
5~10
(m/min)

Medium carbon steels
中炭素鋼
5~10
(m/min)

High carbon steels
高炭素鋼
5~10
(m/min)

TYPE: 1 DIN376/DIN374/DIN5156



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/16-28	-	PVG0010NEX	5P	90	19	46	6	4.9	8	3	1
G 1/8-28	-	PVG0020NEX	5P	90	19	46	7	5.5	8	3	1
G 1/4-19	-	PVG0040NEX	5P	100	21	51	11	9	12	3	1
G 3/8-19	-	PVG0060NEX	5P	100	21	51	12	9	12	3	1
G 1/2-14	-	PVG0080NEX	5P	125	24	64	16	12	15	3	1
G 5/8-14	-	PVG0100NEX	5P	125	24	64	18	14.5	17	3	1
G 3/4-14	-	PVG0120NEX	5P	140	27	71	20	16	19	4	1
G 7/8-14	-	PVG0140NEX	5P	150	27	77	22	18	21	4	1
G 1 -11	-	PVG0160NEX	5P	160	29	82	25	20	23	4	1
G 1 1/8-11	-	PVG0180NEX	5P	170	29	87	28	22	25	4	1
G 1 1/4-11	-	PVG0200NEX	5P	170	29	87	32	24	27	4	1
G 1 1/2-11	-	PVG0240NEX	5P	190	31	97	36	29	32	4	1

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

⑧ Pipe Tap Series

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

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

PO V G

Spiral Pointed Taps for Parallel Pipe Threads, Coated



Specification

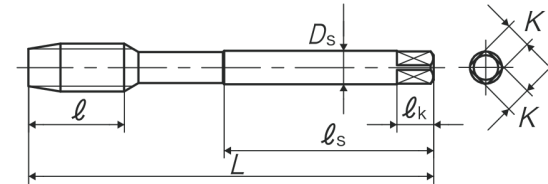


■ Adopting the optimum coating for the tapping condition.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	9930R02TI	5P	90	19	46	7	5.5	8	3	1
G 1/4-19	-	9930R04TI	5P	100	21	51	11	9	12	3	1
G 3/8-19	-	9930R06TI	5P	100	21	51	12	9	12	3	1
G 1/2-14	-	9930R08TI	5P	125	24	64	16	12	15	3	1

Think threads with
YAMAWA

⑧-75

・ 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	ℓ_s	Ds	K	ℓ_k

PO-VA G



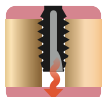
Spiral Pointed Taps for Parallel Pipe Threads, for Stainless Steels

Specification

HSS

OX

Oxide



■ Suitable for stainless steels tending to cause work harden and sticky, as well as chrome steels and molybdenum steels. Through hole use.

Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
~15
(m/min)

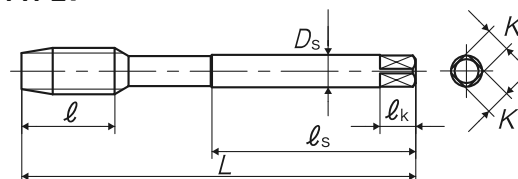
Medium carbon steels
中炭素鋼
~15
(m/min)

High carbon steels
高炭素鋼
~15
(m/min)

Alloy steels
合金鋼
~15
(m/min)

Stainless steels
ステンレス鋼
~10
(m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	PVG0020GEX	4.5P	90	19	46	7	5.5	8	3	1
G 1/4-19	-	PVG0040GEX	4.5P	100	21	51	11	9	12	3	1
G 3/8-19	-	PVG0060GEX	4.5P	100	21	51	12	9	12	3	1
G 1/2-14	-	PVG0080GEX	4.5P	125	24	64	16	12	15	3	1
G 3/4-14	-	PVG0120GEX	4.5P	140	27	71	20	16	19	4	1
G 1 -11	-	PVG0160GEX	4.5P	160	29	82	25	20	23	4	1

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

DIN

⑧-76

⑧ Pipe Tap Series

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

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

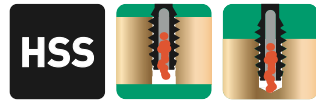
DIN

HT G

Hand Taps for Parallel Pipe Threads



Specification

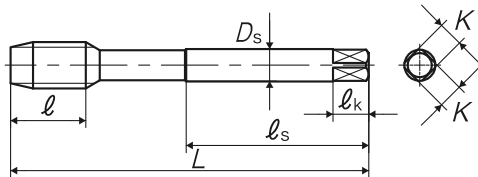


■ Hand taps for parallel pipe threads conforming to the DIN dimensional standard. These are used for mating with external parallel pipe threads G (PF).

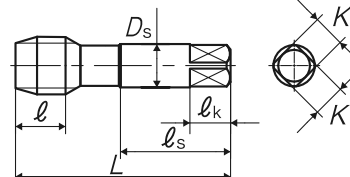
Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

TYPE:1



TYPE:2



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For G Threads											
G 1/16-28	-	TVG0010NEBC	2.5P	90	19	46	6	4.9	8	3	1
G 1/16-28	-	T9G0010NEB2	F	56	19	29	6	4.9	8	4	2
G 1/16-28	-	T9G0010NEB5	V	56	19	29	6	4.9	8	4	2
G 1/8-28	-	TVG0020NEBC	2.5P	90	19	46	7	5.5	8	3	1
G 1/8-28	-	T9G0020NEB2	F	63	19	32	7	5.5	8	4	2
G 1/8-28	-	T9G0020NEB5	V	63	19	32	7	5.5	8	4	2
G 1/8-28	-	6412G02S	SET	63	19	32	7	5.5	8	4	2
G 1/4-19	-	TVG0040NEBC	2.5P	100	21	51	11	9	12	3	1
G 1/4-19	-	T9G0040NEB2	F	70	21	36	11	9	12	4	2
G 1/4-19	-	T9G0040NEB5	V	70	21	36	11	9	12	4	2
G 1/4-19	-	6412G04S	SET	70	21	36	11	9	12	4	2
G 3/8-19	-	TVG0060NEBC	2.5P	100	21	51	12	9	12	3	1
G 3/8-19	-	T9G0060NEB2	F	70	21	36	12	9	12	4	2
G 3/8-19	-	T9G0060NEB5	V	70	21	36	12	9	12	4	2
G 3/8-19	-	6412G06S	SET	70	21	36	12	9	12	4	2
G 1/2-14	-	TVG0080NEBC	2.5P	125	24	64	16	12	15	3	1
G 1/2-14	-	T9G0080NEB2	F	80	21	41	16	12	15	4	2
G 1/2-14	-	T9G0080NEB5	V	80	21	41	16	12	15	4	2
G 1/2-14	-	6412G08S	SET	80	21	41	16	12	15	4	2
G 5/8-14	-	TVG0100NEBC	2.5P	125	24	64	18	14.5	17	4	1
G 5/8-14	-	T9G0100NEB2	F	80	21	41	18	14.5	17	4	2
G 5/8-14	-	T9G0100NEB5	V	80	21	41	18	14.5	17	4	2
G 3/4-14	-	TVG0120NEBC	2.5P	140	27	71	20	16	19	4	1
G 3/4-14	-	T9G0120NEB2	F	90	21	46	20	16	19	4	2

DIN

⑧-77

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

8

DIN

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
G 3/4-14	-	T9G0120NEB5	V	90	21	46	20	16	19	4	2
G 3/4-14	-	6412G12S	SET	90	21	46	20	16	19	4	2
G 7/8-14	-	TVG0140NEBC	2.5P	150	27	77	22	18	21	4	1
G 7/8-14	-	T9G0140NEB2	F	90	21	46	22	18	21	4	2
G 7/8-14	-	T9G0140NEB5	V	90	21	46	22	18	21	4	2
G 1 -11	-	TVG0160NEBC	2.5P	160	29	82	25	20	23	4	1
G 1 -11	-	T9G0160NEB2	F	100	24	51	25	20	23	4	2
G 1 -11	-	T9G0160NEB5	V	100	24	51	25	20	23	4	2
G 1 -11	-	6412G16S	SET	100	24	51	25	20	23	4	2
G 1 1/8-11	-	TVG0180NEBC	2.5P	170	29	87	28	22	25	4	1
G 1 1/8-11	-	T9G0180NEB2	F	125	39	64	28	22	25	4	2
G 1 1/8-11	-	T9G0180NEB5	V	125	39	64	28	22	25	4	2
G 1 1/4-11	-	TVG0200NEBC	2.5P	170	29	87	32	24	27	4	1
G 1 1/4-11	-	T9G0200NEB2	F	125	39	64	32	24	27	4	2
G 1 1/4-11	-	T9G0200NEB5	V	125	39	64	32	24	27	4	2
G 1 1/2-11	-	TVG0240NEBC	2.5P	190	31	97	36	29	32	6	1
G 1 1/2-11	-	T9G0240NEB2	F	140	39	71	36	29	32	6	2
G 1 1/2-11	-	T9G0240NEB5	V	140	39	71	36	29	32	6	2

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

DIN

⑧-78

8 Pipe 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

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

Z-PRO

GGST G

Z-PRO

Straight Fluted Taps for Parallel Pipe Threads, for Cast Irons



Specification

HSS

Coating



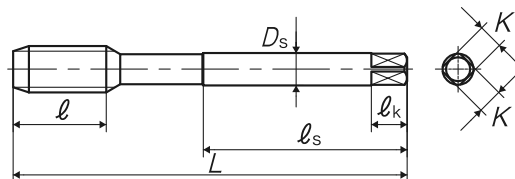
■ Suitable for hard and abrasive materials such as cast irons. Considering comparatively quick wear, GGST G is properly oversized.

Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~20
(m/min)

Ductile cast irons
強靱鑄鉄
5~20
(m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	3104130004	C (2.5P)	90	19	46	7	5.5	8	4	1
G 1/4-19	-	3104130006	C (2.5P)	100	21	51	11	9	12	4	1
G 3/8-19	-	3104130008	C (2.5P)	100	21	51	12	9	12	4	1
G 1/2-14	-	3104130009	C (2.5P)	125	24	64	16	12	15	4	1
G 3/4-14	-	3104130011	C (2.5P)	140	27	71	20	16	19	4	1
G 1 -11	-	3104130013	C (2.5P)	160	29	82	25	20	23	4	1

GG-HT G

Hand Taps for Parallel Pipe Threads, for Cast Irons



Specification

HSS

NI
Nitride



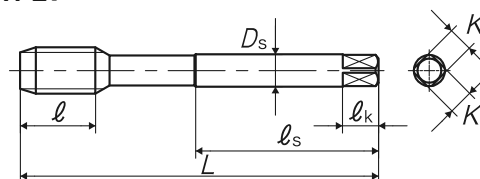
■ Suitable for hard and abrasive materials such as cast irons. Considering comparatively quick wear, GG-HT G is properly oversized.

Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~10
(m/min)

Ductile cast irons
強靱鑄鉄
5~10
(m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	l (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	TVG0020AENC	2.5P	90	19	46	7	5.5	8	4	1
G 1/4-19	-	TVG0040AENC	2.5P	100	21	51	11	9	12	4	1
G 3/8-19	-	TVG0060AENC	2.5P	100	21	51	12	9	12	4	1
G 1/2-14	-	TVG0080AENC	2.5P	125	24	64	16	12	15	4	1
G 3/4-14	-	TVG0120AENC	2.5P	140	27	71	20	16	19	4	1
G 1 -11	-	TVG0160AENC	2.5P	160	29	82	25	20	23	4	1

8 Pipe 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

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

⑧-81



GG-HT G

Hand Taps for Parallel Pipe Threads, for Cast Irons (Coated)

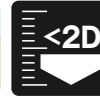
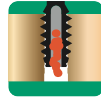


Specification

HSS

Coating

NI
Nitride



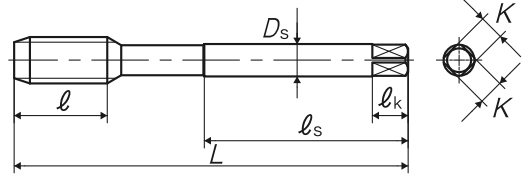
■ Suitable for hard and abrasive materials such as cast irons. Considering comparatively quick wear, GG-HT G is properly oversized.

Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~10
(m/min)

Ductile cast irons
強靱鑄鉄
5~10
(m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	9926R02TC	2.5P	90	19	46	7	5.5	8	4	1 ▲
G 1/4-19	-	9926R04TC	2.5P	100	21	51	11	9	12	4	1 ▲
G 3/8-19	-	9926R06TC	2.5P	100	21	51	12	9	12	4	1 ▲
G 1/2-14	-	9926R08TC	2.5P	125	24	64	16	12	15	4	1 ▲

• Products marked with ▲ are while supplies last.

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	ℓ_s	Ds	K	ℓ_k

EH-HT G



Hand Taps for Parallel Pipe Threads, for Hard-to-Machine Materials

Specification

HSS-Co



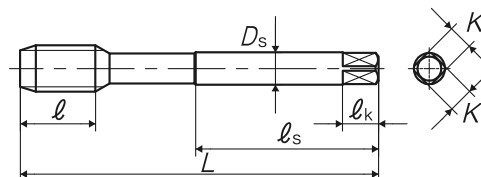
■EH-HT G is the hand tap suitable for hard steels of 35-45HRC, such as forgings and thermal refined steels of high carbon steels and alloy steels, and die steels.

Tapping Speeds depending on Materials

Thermal refined steels
調質鋼
~5
(m/min)
35~45HRC

Tool steels
工具鋼
~5
(m/min)

TYPE: 1



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For G Threads											
G 1/8-28	-	TVG0020DCBC	2.5P	90	19	46	7	5.5	8	4	1
G 1/4-19	-	TVG0040DCBC	2.5P	100	21	51	11	9	12	4	1
G 3/8-19	-	TVG0060DCBC	2.5P	100	21	51	12	9	12	4	1
G 1/2-14	-	TVG0080DCBC	2.5P	125	24	64	16	12	15	4	1

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

⑧ Pipe Tap Series

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

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

⑧-83

DIN

R-D G



Roll Taps for Parallel Pipe Threads, for General Purpose

Specification



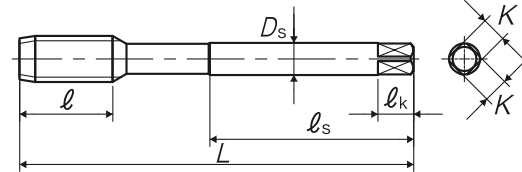
■ Suitable for tapping internal threads used for simple joining in thin steel sheets such as SPC, SPH, or soft steels such as SS400, S20C.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼	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)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)

TYPE: 1

DIN376/DIN5156



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE
For G Threads											
G 1/8-28	-	RVG0026NEBB	2P	90	19	46	7	5.5	8	8	1
G 1/4-19	-	RVG0047NEBB	2P	100	21	51	11	9	12	8	1
G 3/8-19	-	RVG0067NEBB	2P	100	21	51	12	9	12	8	1

Number of oil grooves: G = 4

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	ℓ_s	Ds	K	ℓ_k

R-D G



Roll Taps for Parallel Pipe Threads, for General Purpose, Coated

Specification



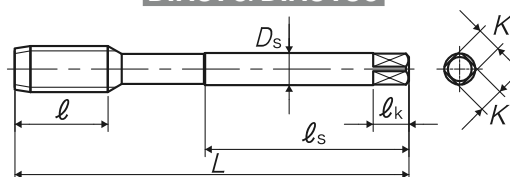
■ Suitable for tapping internal threads used for simple joining in thin steel sheets such as SPC, SPH, or soft steels such as SS400, S20C.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼	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)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)	10 ~ 20 (m/min)

TYPE: 1

DIN376/DIN5156



Segment : 1H

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	Lobe	TYPE
For G Threads											
G 1/8-28	-	9953R02TI	2P	90	19	46	7	5.5	8	8	1
G 1/4-19	-	9953R04TI	2P	100	21	51	11	9	12	8	1
G 3/8-19	-	9953R06TI	2P	100	21	51	12	9	12	8	1

Number of oil grooves: G = 4

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

8 Pipe Tap Series

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

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

PF

Hand Taps for Parallel Pipe Threads



Specification

HSS



Tapping Speeds depending on Materials

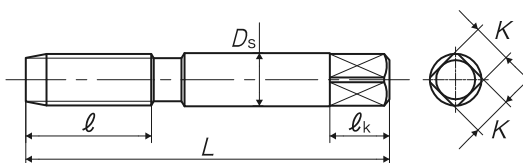
Low carbon steels
低炭素鋼
5~10
(m/min)

Medium carbon steels
中炭素鋼
5~10
(m/min)

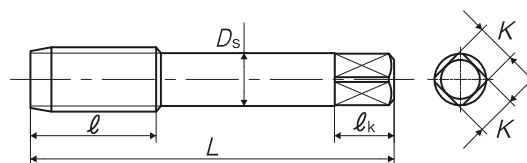
High carbon steels
高炭素鋼
5~10
(m/min)

■The PF tap is a hand tap for parallel pipe threads and is used for products whose main purpose is to connect mechanical parts such as pipe parts. The PF internal thread is used for fitting with the PF external thread.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/16-28	II	TH2F01K-8	3.5P	7.723	55	19	8	6	9	4	1	¥ 3,060 ※
PF 1/8-28	II	TH2F02K	3.5P	9.728	55	19	8	6	9	4	2	¥ 3,060
PF 1/8-28	II	TH2F02K1	1.5P	9.728	55	19	8	6	9	4	2	¥ 3,060 ※
PF 1/4-19	II	TH2F04-	3.5P	13.157	62	28	11	9	12	4	2	¥ 4,800
PF 1/4-19	II	TH2F04-1	1.5P	13.157	62	28	11	9	12	4	2	¥ 4,800 ※
PF 3/8-19	II	TH2F06-	3.5P	16.662	65	28	14	11	14	4	2	¥ 7,910
PF 3/8-19	II	TH2F06-1	1.5P	16.662	65	28	14	11	14	4	2	¥ 7,910 ※
PF 1/2-14	II	TH2F08Q	3.5P	20.955	80	35	18	14	17	4	2	¥ 12,900
PF 1/2-14	II	TH2F08Q1	1.5P	20.955	80	35	18	14	17	4	2	¥ 12,900 ※
PF 5/8-14	II	TH2F10Q	3.5P	22.911	82	35	19	15	18	4	2	¥ 18,100 ※
PF 3/4-14	II	TH2F12Q	3.5P	26.441	85	35	23	17	20	4	2	¥ 20,600
PF 3/4-14	II	TH2F12Q1	1.5P	26.441	85	35	23	17	20	4	2	¥ 20,600 ※
PF 7/8-14	II	TH2F14Q	3.5P	30.201	90	40	24	19	22	4	2	¥ 31,000 ※
PF 1 -11	II	TH2F16U	3.5P	33.249	95	45	26	21	24	4	2	¥ 38,600
PF 1 -11	II	TH2F16U1	1.5P	33.249	95	45	26	21	24	4	2	¥ 38,600 ※
PF 1 1/8-11	II	TH2F18U	3.5P	37.897	100	45	28	21	24	4	2	¥ 56,900 ※
PF 1 1/4-11	II	TH2F20U	3.5P	41.910	105	45	32	26	30	4	2	¥ 60,900
PF 1 1/4-11	II	TH2F20U1	1.5P	41.910	105	45	32	26	30	4	2	¥ 60,900 ※
PF 1 1/2-11	II	TH2F24U	3.5P	47.803	110	45	38	29	32	6	2	¥ 83,800
PF 1 1/2-11	II	TH2F24U1	1.5P	47.803	110	45	38	29	32	6	2	¥ 83,800 ※
PF 1 3/4-11	II	TH2F28U	3.5P	53.746	115	45	42	32	35	6	2	¥ 115,000 ※
PF 1 3/4-11	II	TH2F28U1	1.5P	53.746	115	45	42	32	35	6	2	¥ 115,000 ※
PF 2 -11	II	TH2F32U	3.5P	59.614	120	50	46	35	38	6	2	¥ 143,000
PF 2 -11	II	TH2F32U1	1.5P	59.614	120	50	46	35	38	6	2	¥ 143,000 ※
PF 2 1/2-11	II	TH2F40U	3.5P	75.184	145	65	55	41	44	8	2	¥ 236,000 ※

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	ℓk

8

JIS

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
PF 3 -11	II	TH2F48U	3.5P	87.884	155	65	65	50	52	8	2	¥ 354,000 ※
PF 3 -11	II	TH2F48U1	1.5P	87.884	155	65	65	50	52	8	2	¥ 354,000 ※
PF 3 1/2-11	II	TH2F56U	3.5P	100.330	165	68	70	54	58	8	2	¥ 459,000 ※
PF 4 -11	II	TH2F64U	3.5P	113.030	170	70	75	58	62	10	2	¥ 620,000 ※

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

⑧-86

 Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

⑧ Pipe 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

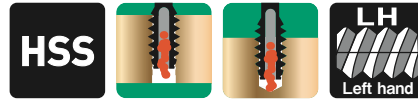
⑧-87

PF LH

Hand Taps for Parallel Pipe Threads, for LH Threads



Specification

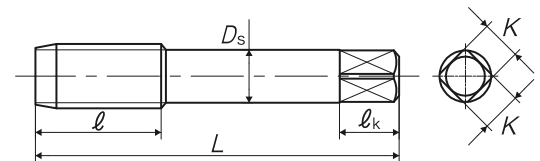


■ The PF LH is a hand tap for left hand parallel pipe threads and is used for tapping products whose main purpose is to connect mechanical parts such as pipe parts. The PF internal thread is used for fitting with the PF external thread.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/8-28	II	TH2F02K-L	3.5P	9.728	55	19	8	6	9	4	1	¥ 4,410 ※
PF 1/4-19	II	TH2F04-L	3.5P	13.157	62	28	11	9	12	4	1	¥ 6,400 ※
PF 3/8-19	II	TH2F06-L	3.5P	16.662	65	28	14	11	14	4	1	¥ 10,600 ※
PF 1/2-14	II	TH2F08Q-L	3.5P	20.955	80	35	18	14	17	4	1	¥ 17,200 ※
PF 3/4-14	II	TH2F12Q-L	3.5P	26.441	85	35	23	17	20	4	1	¥ 28,000 ※
PF 1 -11	II	TH2F16U-L	3.5P	33.249	95	45	26	21	24	4	1	¥ 52,400 ※
PF 1 1/4-11	II	TH2F20U-L	3.5P	41.910	105	45	32	26	30	4	1	¥ 82,600 ※
PF 1 1/2-11	II	TH2F24U-L	3.5P	47.803	110	45	38	29	32	6	1	¥ 114,000 ※
PF 2 -11	II	TH2F32U-L	3.5P	59.614	120	50	46	35	38	6	1	¥ 195,000 ※

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

LS-PF

Long Shank Hand Taps for Parallel Pipe Threads



Specification

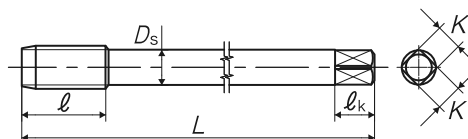


■ The LS-PF is a long shank hand tap for parallel pipe threads and is used for tapping products whose main purpose is to connect mechanical parts such as pipe parts. The PF internal thread is used for fitting with the PF external thread.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/8-28	II	L10F02K	3.5P	9.728	100	19	8	6	9	4	1	¥ 6,090
PF 1/8-28	II	L15F02K	3.5P	9.728	150	19	8	6	9	4	1	¥ 11,000
PF 1/8-28	II	L20F02K	3.5P	9.728	200	19	8	6	9	4	1	¥ 15,700 ※
PF 1/4-19	II	L10F04-	3.5P	13.157	100	28	11	9	12	4	1	¥ 8,170
PF 1/4-19	II	L15F04-	3.5P	13.157	150	28	11	9	12	4	1	¥ 11,200
PF 1/4-19	II	L20F04-	3.5P	13.157	200	28	11	9	12	4	1	¥ 16,100 ※
PF 3/8-19	II	L10F06-	3.5P	16.662	100	28	14	11	14	4	1	¥ 10,500
PF 3/8-19	II	L15F06-	3.5P	16.662	150	28	14	11	14	4	1	¥ 18,900
PF 3/8-19	II	L20F06-	3.5P	16.662	200	28	14	11	14	4	1	¥ 26,600 ※
PF 1/2-14	II	L15F08Q	3.5P	20.955	150	35	18	14	17	4	1	¥ 23,200
PF 1/2-14	II	L20F08Q	3.5P	20.955	200	35	18	14	17	4	1	¥ 32,500 ※
PF 3/4-14	II	L15F12Q	3.5P	26.441	150	35	23	17	20	4	1	¥ 34,200
PF 3/4-14	II	L20F12Q	3.5P	26.441	200	35	23	17	20	4	1	¥ 41,400 ※
PF 1 -11	II	L15F16U	3.5P	33.249	150	45	26	21	24	4	1	¥ 50,100
PF 1 -11	II	L20F16U	3.5P	33.249	200	45	26	21	24	4	1	¥ 58,100 ※
PF 1 1/4-11	II	L20F20U	3.5P	41.910	200	45	32	26	30	4	1	¥ 90,900 ※
PF 1 1/2-11	II	L20F24U	3.5P	47.803	200	45	38	29	32	6	1	¥ 115,000 ※
PF 2 -11	II	L20F32U	3.5P	59.614	200	50	46	35	38	6	1	¥ 170,000 ※

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

⑧ Pipe Tap Series

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

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

⑧-89

S
P
F

SP-PF

Spiral Fluted Taps for Parallel Pipe Threads



Specification

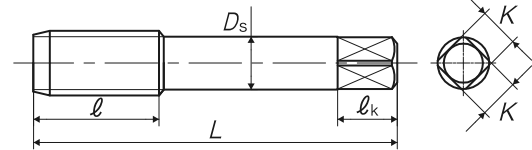


Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■ The SP-PF is a spiral flute tap for parallel pipe threads and is used for tapping of products whose main purpose is to connect mechanical parts for pipes. The PF internal thread is used for fitting with the PF external thread.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/8-28	II	SH2F02K	2.5P	9.728	55	19	8	6	9	3	1	¥ 3,550
PF 1/4-19	II	SH2F04-	2.5P	13.157	62	28	11	9	12	3	1	¥ 5,130
PF 3/8-19	II	SH2F06-	2.5P	16.662	65	28	14	11	14	3	1	¥ 8,480
PF 1/2-14	II	SH2F08Q	2.5P	20.955	80	35	18	14	17	4	1	¥ 13,800
PF 3/4-14	II	SH2F12Q	2.5P	26.441	85	35	23	17	20	4	1	¥ 22,100
PF 1 -11	II	SH2F16U	2.5P	33.249	95	45	26	21	24	4	1	¥ 41,300
PF 1 1/4-11	II	SH2F20U	2.5P	41.910	105	45	32	26	30	4	1	¥ 65,000 ※
PF 1 1/2-11	II	SH2F24U	2.5P	47.803	110	45	38	29	32	4	1	¥ 89,600 ※
PF 2 -11	II	SH2F32U	2.5P	59.614	120	50	46	35	38	4	1	¥ 153,000 ※

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	ℓk

LS-SP-PF

Long Shank Spiral Fluted Taps for Parallel Pipe Threads



Specification

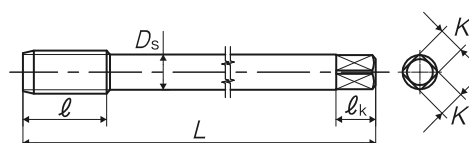


■The LS-SP-PF is a long shank spiral flute tap for parallel pipe threads and is used for tapping of products whose main purpose is to connect mechanical parts such as pipe parts. The PF internal thread is used for fitting with the PF external thread.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/8-28	II	SH2F02KL10	2.5P	9.728	100	19	8	6	9	3	1	¥ 6,530 ※
PF 1/8-28	II	SH2F02KL12	2.5P	9.728	120	19	8	6	9	3	1	¥ 7,320 ※
PF 1/8-28	II	SH2F02KL15	2.5P	9.728	150	19	8	6	9	3	1	¥ 11,800 ※
PF 1/4-19	II	SH2F04-L10	2.5P	13.157	100	28	11	9	12	3	1	¥ 8,760 ※
PF 1/4-19	II	SH2F04-L12	2.5P	13.157	120	28	11	9	12	3	1	¥ 9,900 ※
PF 1/4-19	II	SH2F04-L15	2.5P	13.157	150	28	11	9	12	3	1	¥ 12,100 ※
PF 3/8-19	II	SH2F06-L10	2.5P	16.662	100	28	14	11	14	3	1	¥ 11,300 ※
PF 3/8-19	II	SH2F06-L12	2.5P	16.662	120	28	14	11	14	3	1	¥ 12,900 ※
PF 3/8-19	II	SH2F06-L15	2.5P	16.662	150	28	14	11	14	3	1	¥ 20,200 ※
PF 1/2-14	II	SH2F08QL15	2.5P	20.955	150	35	18	14	17	4	1	¥ 24,900 ※
PF 3/4-14	II	SH2F12QL15	2.5P	26.441	150	35	23	17	20	4	1	¥ 36,700 ※
PF 1 -11	II	SH2F16UL15	2.5P	33.249	150	45	26	21	24	4	1	¥ 53,500 ※
PF 1 -11	II	SH2F16UL20	2.5P	33.249	200	45	26	21	24	4	1	¥ 62,200 ※

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

⑧-90

⑧ Pipe Tap Series

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

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

⑧-91

SU-PF

Hand Taps for Parallel Pipe Threads, for Stainless Steels



Specification

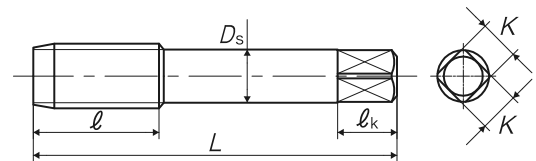


■ The SU-PF is a hand tap suitable for machining stainless steel, chromium steel, molybdenum steel. These are materials that have a remarkably high work hardened ability.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼
5~10 (m/min)	5~10 (m/min)	~5 (m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/8-28	II	TU2F02K	3.5P	9.728	55	19	8	6	9	4	1	¥ 3,810 ※
PF 1/4-19	II	TU2F04-	3.5P	13.157	62	28	11	9	12	4	1	¥ 5,530 ※
PF 3/8-19	II	TU2F06-	3.5P	16.662	65	28	14	11	14	4	1	¥ 9,110 ※
PF 1/2-14	II	TU2F08Q	3.5P	20.955	80	35	18	14	17	4	1	¥ 14,900 ※
PF 3/4-14	II	TU2F12Q	3.5P	26.441	85	35	23	17	20	4	1	¥ 23,700 ※
PF 1 -11	II	TU2F16U	3.5P	33.249	95	45	26	21	24	4	1	¥ 44,400 ※

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	ℓ_s	Ds	K	ℓ_k

SU-SP-PF

Spiral Fluted Taps for Parallel Pipe Threads, for Stainless Steels



Specification

HSS

OX
Oxide



■The SU-SP-PF is a spiral flute tap suitable for machining stainless steel, chromium steel, molybdenum steel. These are materials that have a remarkably high work hardened ability.

Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
5~10
(m/min)

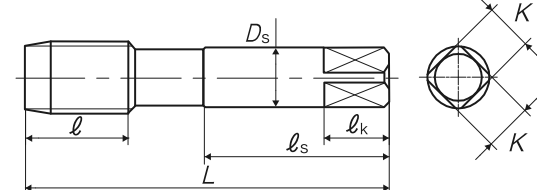
Medium carbon steels
中炭素鋼
5~10
(m/min)

High carbon steels
高炭素鋼
5~10
(m/min)

Alloy steels
合金鋼
5~10
(m/min)

Stainless steels
ステンレス鋼
~5
(m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads													
PF 1/8-28	II	SYPF022GEX	2.5P	9.728	59	15	34	8	6	9	3	1	¥ 4,090 ※
PF 1/4-19	II	SYPF042GEX	2.5P	13.157	67	19	37	11	9	12	3	1	¥ 5,910 ※
PF 3/8-19	II	SYPF062GEX	2.5P	16.662	75	21	42	14	11	14	3	1	¥ 9,750 ※
PF 1/2-14	II	SYPF082GEX	2.5P	20.955	87	26	47	18	14	17	4	1	¥ 16,000 ※
PF 3/4-14	II	SYPF122GEX	2.5P	26.441	96	28	53	23	17	20	4	1	¥ 25,500 ※
PF 1 -11	II	SYPF162GEX	2.5P	33.249	109	33	60	26	21	24	4	1	¥ 47,500 ※

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

JIS

⑧-92

⑧ Pipe Tap Series

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

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

⑧-93

FC-PF

Hand Taps for Parallel Pipe Threads, for Cast Irons



Specification

HSS

NI
Nitride



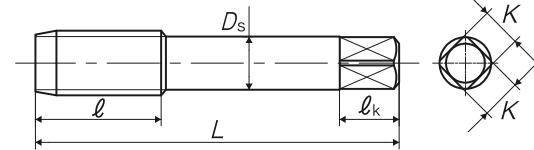
■ The FC-PF is a tap suitable for thread processing of hard and brittle material such as cast iron.

Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~10
(m/min)

Ductile cast irons
強靱鑄鉄
5~10
(m/min)

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/8-28	II	FCPF02K	3.5P	9.728	55	19	8	6	9	4	1	¥ 3,810 ※
PF 1/4-19	II	FCPF04-	3.5P	13.157	62	28	11	9	12	4	1	¥ 5,530 ※
PF 3/8-19	II	FCPF06-	3.5P	16.662	65	28	14	11	14	4	1	¥ 9,110 ※
PF 1/2-14	II	FCPF08Q	3.5P	20.955	80	35	18	14	17	4	1	¥ 14,900 ※
PF 3/4-14	II	FCPF12Q	3.5P	26.441	85	35	23	17	20	4	1	¥ 23,700 ※
PF 1 -11	II	FCPF16U	3.5P	33.249	95	45	26	21	24	4	1	¥ 44,400 ※
PF 1 1/4-11	II	FCPF20U	3.5P	41.910	105	45	32	26	30	4	1	¥ 70,100 ※
PF 1 1/2-11	II	FCPF24U	3.5P	47.803	110	45	38	29	32	6	1	¥ 96,400 ※
PF 2 -11	II	FCPF32U	3.5P	59.614	120	50	46	35	38	6	1	¥ 165,000 ※

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

8

JIS

CT-PF

Carbide Taps for Parallel Pipe Threads



Specification



■CT-PF is suitable for hard and abrasive materials such as cast irons.

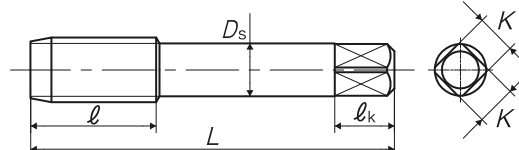
Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~10
(m/min)

Ductile cast irons
強靱鑄鉄
5~10
(m/min)

Brass castings
黄銅鑄物
5~10
(m/min)

TYPE: 1



Segment : 1L

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Pipe Threads												
PF 1/8-28	II	TCPF02K	3.5P	9.728	55	19	8	6	9	4	1	¥ 27,300 ※
PF 1/4-19	II	TCPF04-	3.5P	13.157	62	28	11	9	12	4	1	¥ 42,900 ※
PF 3/8-19	II	TCPF06-	3.5P	16.662	65	28	14	11	14	4	1	¥ 52,900 ※
PF 1/2-14	II	TCPF08Q	3.5P	20.955	80	35	18	14	17	4	1	¥ 52,500 ※
PF 3/4-14	II	TCPF12Q	3.5P	26.441	85	35	23	17	20	4	1	¥ 71,900 ※
PF 1 -11	II	TCPF16U	3.5P	33.249	95	45	26	21	24	4	1	¥102,000 ※

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

⑧-94

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-95

NPT

Hand Taps for American Taper Pipe Threads



Specification

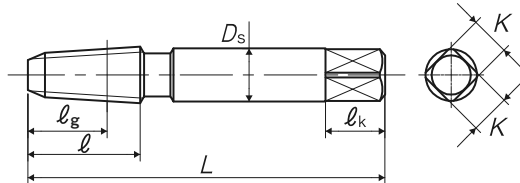


Tapping Speeds depending on Materials

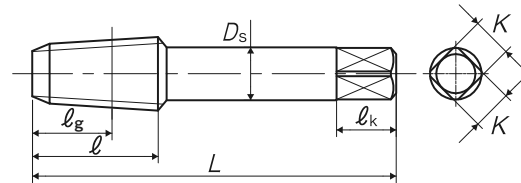
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■The NPT tap is a hand tap for the American tapered pipe threads and is used for products whose main purpose is the tightness of threaded parts in the connection of parts for pipes.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPT	ANSI G	TNPT01L	3P	7.770	54	17	12.00	8	6	9	4	1	¥ 6,300
1/8-27 NPT	ANSI G	TNPT02L	3P	10.117	55	19	12.05	8	6	9	4	2	¥ 6,300
1/4-18 NPT	ANSI G	TNPT04O	3P	13.426	62	28	17.45	11	9	12	4	2	¥ 8,930
3/8-18 NPT	ANSI G	TNPT06O	3P	16.866	65	28	17.65	14	11	14	4	2	¥ 15,000
1/2-14 NPT	ANSI G	TNPT08Q	3P	20.980	80	35	22.85	18	14	17	4	2	¥ 24,700
3/4-14 NPT	ANSI G	TNPT12Q	3P	26.325	85	35	22.95	23	17	20	4	2	¥ 39,600
1 -11 1/2 NPT	ANSI G	TNPT16T	3P	32.934	95	45	27.40	26	21	24	5	2	¥ 73,300
1 1/4-11 1/2 NPT	ANSI G	TNPT20T	3P	41.689	105	45	28.10	32	26	30	5	2	¥111,000 ※
1 1/2-11 1/2 NPT	ANSI G	TNPT24T	3P	47.760	110	45	28.40	38	29	32	6	2	¥159,000 ※
2 -11 1/2 NPT	ANSI G	TNPT32T	3P	59.797	120	50	28.00	46	35	38	6	2	¥249,000 ※
2 1/2-8 NPT	ANSI G	TNPT40X	3P	72.273	145	65	40.80	55	41	44	8	2	¥410,000 ※
3 -8 NPT	ANSI G	TNPT48X	3P	88.184	155	65	42.95	65	50	52	8	2	¥635,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

NPT

Hand Taps for American Taper Pipe Threads



Specification

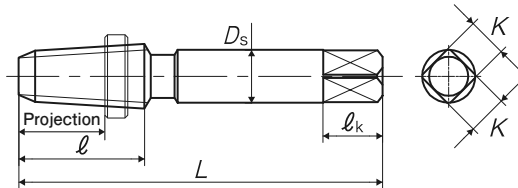


■ The NPT tap is a hand tap for the American tapered pipe threads and is used for products whose main purpose is the tightness of threaded parts in the connection of parts for pipes.

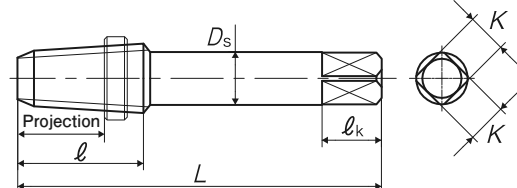
Tapping Speed depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



TYPE: 2



Segment : 1G

Size	Class	Code	Chamfer	L (inch)	l (inch)	Projection (inch)	Ds (inch)	K (inch)	lk (inch)	No. of flutes	TYPE
For American Pipe Threads											
1/16-27 NPT	ANSI G	Y83100	3P	2.125	0.687	0.312	0.312	0.234	0.375	4	1
1/16-27 NPT	ANSI G	Y83100BR	3P	2.125	0.687	0.312	0.312	0.234	0.375	4	1
1/8-27 NPT	ANSI G	Y83101	3P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPT	ANSI G	Y83101BR	3P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPT	ANSI G	Y83102	3P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/8-27 NPT	ANSI G	Y83102BR	3P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/4-18 NPT	ANSI G	Y83103	3P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
1/4-18 NPT	ANSI G	Y83103BR	3P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
3/8-18 NPT	ANSI G	Y83104	3P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
3/8-18 NPT	ANSI G	Y83104BR	3P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
1/2-14 NPT	ANSI G	Y83105	3P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
1/2-14 NPT	ANSI G	Y83105BR	3P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
3/4-14 NPT	ANSI G	Y83106	3P	3.25	1.375	0.565	0.906	0.679	0.687	4	2
3/4-14 NPT	ANSI G	Y83106BR	3P	3.25	1.375	0.565	0.906	0.679	0.687	4	2
1 -11 1/2 NPT	ANSI G	Y83107	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 -11 1/2 NPT	ANSI G	Y83107BR	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 1/4-11 1/2 NPT	ANSI G	Y83108	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/4-11 1/2 NPT	ANSI G	Y83108BR	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/2-11 1/2 NPT	ANSI G	Y83109	3P	4.25	1.75	0.699	1.5	1.125	1	6	2
1 1/2-11 1/2 NPT	ANSI G	Y83109BR	3P	4.25	1.75	0.699	1.5	1.125	1	6	2
2 -11 1/2 NPT	ANSI G	Y83110	3P	4.5	1.75	0.667	1.875	1.406	1.125	6	2
2 -11 1/2 NPT	ANSI G	Y83110BR	3P	4.5	1.75	0.667	1.875	1.406	1.125	6	2

8 Pipe Tap Series

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

ANSI

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

⑧-97

ANSI

ZELX MOLD NPT



Hand Taps for Hard-to-Machine Materials For American Taper Pipe Threads

Specification

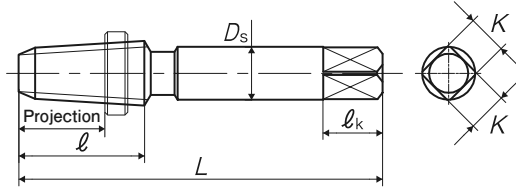


■ Suitable for hard steels of 35 ~ 45HRC, such as forgings and thermal refined steels of high carbon steels and alloy steels, and die steels.

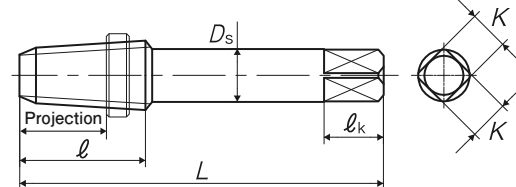
Tapping Speed depending on Materials

Thermal refined steels 調質鋼	Tool steels 工具鋼
~5 (m/min)	~5 (m/min)
35~45HRC	

TYPE:1



TYPE:2



Segment : 1H

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Projection (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For American Pipe Threads											
1/8-27 NPT	ANSI G	Y89641	3P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/4-18 NPT	ANSI G	Y89643	3P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
3/8-18 NPT	ANSI G	Y89644	3P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
1/2-14 NPT	ANSI G	Y89645	3P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
3/4-14 NPT	ANSI G	Y89646	3P	3.25	1.375	0.565	0.906	0.679	0.687	5	2

Think threads with
YAMAWA

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

NPT-CI

Hand Taps for American Taper Pipe Threads for Cast Irons



Specification

HSS

NI
Nitride



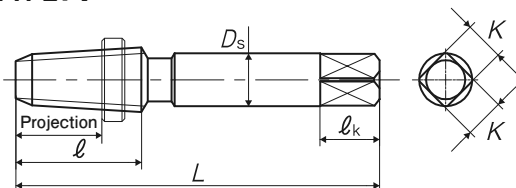
■ Suitable for hard and abrasive materials such as cast irons.

Tapping Speed depending on Materials

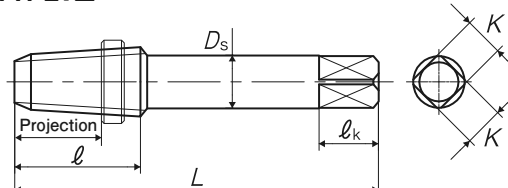
Cast irons
鑄鉄
~5
(m/min)

Ductile cast irons
強靱鑄鉄
~5
(m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Projection (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
For American Pipe Threads											
1/8-27 NPT	ANSI G	Y83201	3P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPT	ANSI G	Y83202	3P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/4-18 NPT	ANSI G	Y83203	3P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
3/8-18 NPT	ANSI G	Y83204	3P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
1/2-14 NPT	ANSI G	Y83205	3P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
3/4-14 NPT	ANSI G	Y83206	3P	3.25	1.375	0.565	0.906	0.679	0.687	5	2
1 -11 1/2 NPT	ANSI G	Y83207	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 1/4-11 1/2 NPT	ANSI G	Y83208	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/2-11 1/2 NPT	ANSI G	Y83209	3P	4.25	1.75	0.699	1.5	1.125	1	7	2
2 -11 1/2 NPT	ANSI G	Y83210	3P	4.5	1.75	0.667	1.875	1.406	1.125	7	2

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-99

S-NPT

Hand Taps for American Taper Pipe Threads, Short (ℓg) Type



Specification

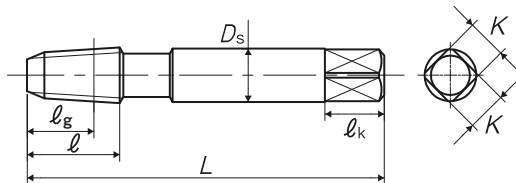


Tapping Speeds depending on Materials

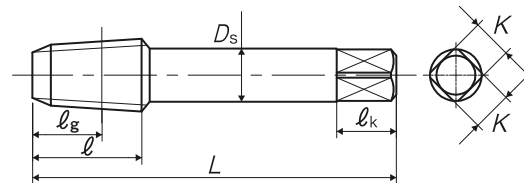
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■The S-NPT is a hand tap for the American tapered pipe threads and is used for tapping where it is necessary to shorten the fitting length for piping parts. Its main purpose is tightness of threaded parts in connection with pipe parts etc.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPT	ANSI G	TSNPT01L	3P	7.770	54	14	10.10	8	6	9	4	1	¥ 6,300 ※
1/8-27 NPT	ANSI G	TSNPT02L	3P	10.117	55	16.5	10.50	8	6	9	4	2	¥ 6,300 ※
1/4-18 NPT	ANSI G	TSNPT04O	3P	13.426	62	19.5	12.50	11	9	12	4	2	¥ 8,930 ※
3/8-18 NPT	ANSI G	TSNPT06O	3P	16.866	65	21	14.00	14	11	14	4	2	¥ 15,000 ※
1/2-14 NPT	ANSI G	TSNPT08Q	3P	20.980	80	27	17.00	18	14	17	4	2	¥ 24,700 ※
3/4-14 NPT	ANSI G	TSNPT12Q	3P	26.325	85	29	19.00	23	17	20	4	2	¥ 39,600 ※
1 -11 1/2 NPT	ANSI G	TSNPT16T	3P	32.934	95	35	22.00	26	21	24	5	2	¥ 73,300 ※
1 1/4-11 1/2 NPT	ANSI G	TSNPT20T	3P	41.689	105	37.5	24.50	32	26	30	5	2	¥ 111,000 ※
1 1/2-11 1/2 NPT	ANSI G	TSNPT24T	3P	47.760	110	38.5	25.50	38	29	32	6	2	¥ 159,000 ※
2 -11 1/2 NPT	ANSI G	TSNPT32T	3P	59.797	120	42.5	27.50	46	35	38	6	2	¥ 249,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

LS-NPT

Long Shank Hand Taps for American Taper Pipe Threads



Specification

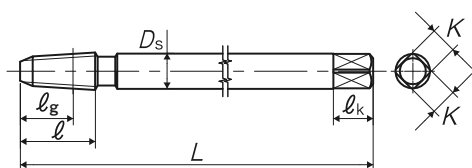


■ The LS-NPT is a long shank tap for the American tapered pipe threads and is used for products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.

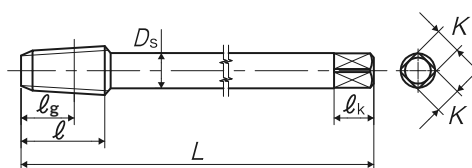
Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPT	ANSI G	TNPT01LL10	3P	7.770	100	17	12.00	8	6	9	4	1	¥ 11,100 ※
1/16-27 NPT	ANSI G	TNPT01LL15	3P	7.770	150	17	12.00	8	6	9	4	1	¥ 20,900 ※
1/8-27 NPT	ANSI G	TNPT02LL10	3P	10.117	100	19	12.05	8	6	9	4	2	¥ 11,100 ※
1/8-27 NPT	ANSI G	TNPT02LL15	3P	10.117	150	19	12.05	8	6	9	4	2	¥ 20,900 ※
1/4-18 NPT	ANSI G	TNPT04OL10	3P	13.426	100	28	17.45	11	9	12	4	2	¥ 15,700 ※
1/4-18 NPT	ANSI G	TNPT04OL15	3P	13.426	150	28	17.45	11	9	12	4	2	¥ 21,200 ※
3/8-18 NPT	ANSI G	TNPT06OL10	3P	16.866	100	28	17.65	14	11	14	4	2	¥ 18,400 ※
3/8-18 NPT	ANSI G	TNPT06OL15	3P	16.866	150	28	17.65	14	11	14	4	2	¥ 34,700 ※
1/2-14 NPT	ANSI G	TNPT08QL15	3P	20.980	150	35	22.85	18	14	17	4	2	¥ 41,900 ※
3/4-14 NPT	ANSI G	TNPT12QL15	3P	26.325	150	35	22.95	23	17	20	4	2	¥ 63,400 ※
1 -11 1/2 NPT	ANSI G	TNPT16TL15	3P	32.934	150	45	27.40	26	21	24	5	2	¥ 89,400 ※

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

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-101



SP-NPT

Spiral Fluted Taps for American Taper Pipe Threads



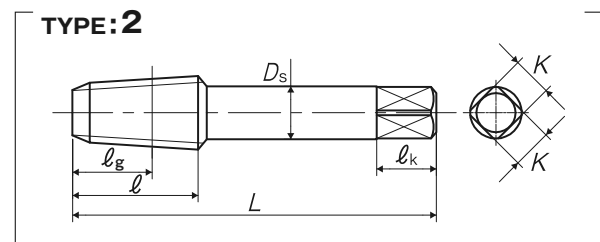
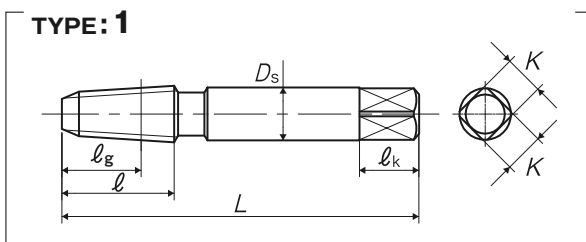
Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■ The SP-NPT is a spiral flute tap for the American tapered pipe threads and is used for products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPT	ANSI G	SNPT01L	2.5P	7.770	54	17	12.00	8	6	9	3	1	¥ 7,630 ※
1/8-27 NPT	ANSI G	SNPT02L	2.5P	10.117	55	19	12.05	8	6	9	3	2	¥ 7,630 ※
1/4-18 NPT	ANSI G	SNPT04O	2.5P	13.426	62	28	17.45	11	9	12	3	2	¥ 10,900 ※
3/8-18 NPT	ANSI G	SNPT06O	2.5P	16.866	65	28	17.65	14	11	14	3	2	¥ 18,200 ※
1/2-14 NPT	ANSI G	SNPT08Q	2.5P	20.980	80	35	22.85	18	14	17	4	2	¥ 29,900 ※
3/4-14 NPT	ANSI G	SNPT12Q	2.5P	26.325	85	35	22.95	23	17	20	4	2	¥ 48,000 ※
1 -11 1/2 NPT	ANSI G	SNPT16T	2.5P	32.934	95	45	27.40	26	21	24	4	2	¥ 88,800 ※

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

ANSI

ZELX SS NPT

Taps for American Taper Pipe Threads



Specification

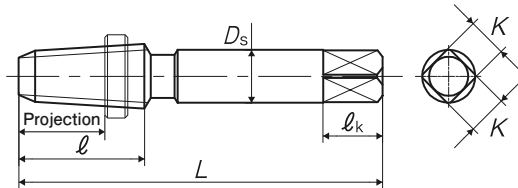


■ Suitable for tapping stainless steels, chrome steels and chrome molybdenum steels.

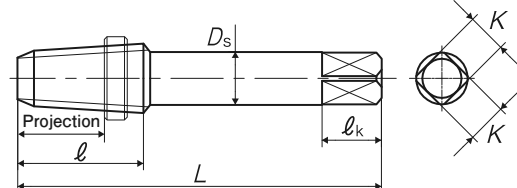
Tapping Speed depending on Materials

Medium carbon steels 中炭素鋼 ~5 (m/min)	High carbon steels 高炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~5 (m/min)	Ductile cast irons 強靱鑄鉄 ~5 (m/min)
---	---	--------------------------------------	---	---

TYPE: 1



TYPE: 2



Segment : 1H

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Projection (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For American Pipe Threads											
1/16-27 NPT	ANSI G	Y83640	2.5P	2.125	0.687	0.312	0.312	0.234	0.375	4	1
1/8-27 NPT	ANSI G	Y83641	2.5P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPT	ANSI G	Y83642	2.5P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/4-18 NPT	ANSI G	Y83643	2.5P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
3/8-18 NPT	ANSI G	Y83644	2.5P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
1/2-14 NPT	ANSI G	Y83645	2.5P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
3/4-14 NPT	ANSI G	Y83646	2.5P	3.25	1.375	0.565	0.906	0.679	0.687	4	2
1 -11 1/2 NPT	ANSI G	Y83647	2.5P	3.75	1.75	0.678	1.125	0.843	0.812	4	2

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-103

S
P
I
S

LS-SP-S-NPT



Long Shank Spiral Fluted Taps for American Taper Pipe Threads, Short (ℓg) Type

Specification

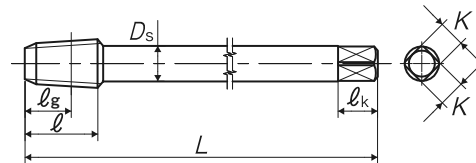


Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■ The LS-SP-S-NPT is a long shank spiral flute tap for the American tapered pipe threads where it is necessary to shorten the fitting length and is used for products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.

TYPE: 1



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/8-27 NPT	ANSI G	SSNPT02LL10	2.5P	10.117	100	16.5	10.50	8	6	9	3	1	¥ 13,500 ※
1/4-18 NPT	ANSI G	SSNPT04OL15	2.5P	13.426	150	19.5	12.50	11	9	12	3	1	¥ 25,600 ※
3/8-18 NPT	ANSI G	SSNPT06OL15	2.5P	16.866	150	21	14.00	14	11	14	3	1	¥ 42,200 ※
1/2-14 NPT	ANSI G	SSNPT08QL15	2.5P	20.980	150	27	17.00	18	14	17	4	1	¥ 50,900 ※
3/4-14 NPT	ANSI G	SSNPT12QL15	2.5P	26.325	150	29	19.00	23	17	20	4	1	¥ 76,800 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

INT-NPT

Interrupted Taps for American Taper Pipe Threads



Specification

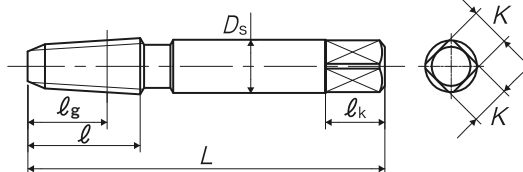


■INT-NPT having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque. INT-NPT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

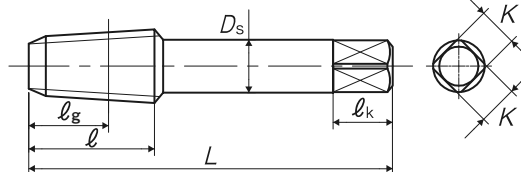
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Stainless steels ステンレス鋼	Cast steels 鋳鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	l (mm)	lg (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPT	ANSI G	TINPT01L	3P	7.770	54	17	12.00	8	6	9	3	1	¥ 9,160 ※
1/8-27 NPT	ANSI G	TINPT02L	3P	10.117	55	19	12.05	8	6	9	5	2	¥ 9,160 ※
1/4-18 NPT	ANSI G	TINPT04O	3P	13.426	62	28	17.45	11	9	12	5	2	¥ 13,000 ※
3/8-18 NPT	ANSI G	TINPT06O	3P	16.866	65	28	17.65	14	11	14	5	2	¥ 21,800 ※
1/2-14 NPT	ANSI G	TINPT08Q	3P	20.980	80	35	22.85	18	14	17	5	2	¥ 36,000 ※
3/4-14 NPT	ANSI G	TINPT12Q	3P	26.325	85	35	22.95	23	17	20	5	2	¥ 57,600 ※
1 -11 1/2 NPT	ANSI G	TINPT16T	3P	32.934	95	45	27.40	26	21	24	5	2	¥ 107,000 ※
1 1/4-11 1/2 NPT	ANSI G	TINPT20T	3P	41.689	105	45	28.10	32	26	30	5	2	¥ 164,000 ※
1 1/2-11 1/2 NPT	ANSI G	TINPT24T	3P	47.760	110	45	28.40	38	29	32	7	2	¥ 232,000 ※
2 -11 1/2 NPT	ANSI G	TINPT32T	3P	59.797	120	50	28.00	46	35	38	7	2	¥ 362,000 ※

8 Pipe Tap Series

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

ANSI

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

INT-NPT

Interrupted Taps for American Taper Pipe Threads



Specification

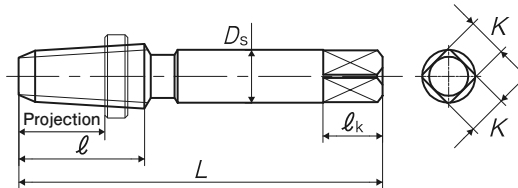


Tapping Speed depending on Materials

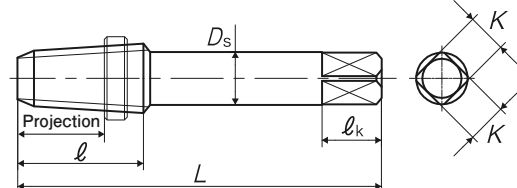
Low carbon steels 低炭素鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~5 (m/min)	Cast steels 鋳鋼 ~5 (m/min)
--	---	------------------------------------

■ INT-NPT having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque. INT-NPT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Projection (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For American Pipe Threads											
1/8-27 NPT	ANSI G	Y83151	3P	2.125	0.75	0.312	0.437	0.328	0.375	5	1
1/8-27 NPT	ANSI G	Y83151BR	3P	2.125	0.75	0.312	0.437	0.328	0.375	5	1
1/8-27 NPT	ANSI G	Y83152	3P	2.125	0.75	0.312	0.312	0.234	0.375	5	2
1/8-27 NPT	ANSI G	Y83152BR	3P	2.125	0.75	0.312	0.312	0.234	0.375	5	2
1/4-18 NPT	ANSI G	Y83153	3P	2.437	1.062	0.459	0.562	0.421	0.437	5	1
1/4-18 NPT	ANSI G	Y83153BR	3P	2.437	1.062	0.459	0.562	0.421	0.437	5	1
3/8-18 NPT	ANSI G	Y83154	3P	2.562	1.062	0.454	0.7	0.531	0.5	5	1
3/8-18 NPT	ANSI G	Y83154BR	3P	2.562	1.062	0.454	0.7	0.531	0.5	5	1
1/2-14 NPT	ANSI G	Y83155	3P	3.125	1.375	0.579	0.687	0.515	0.625	5	2
1/2-14 NPT	ANSI G	Y83155BR	3P	3.125	1.375	0.579	0.687	0.515	0.625	5	2
3/4-14 NPT	ANSI G	Y83156	3P	3.25	1.375	0.565	0.906	0.679	0.687	5	2
3/4-14 NPT	ANSI G	Y83156BR	3P	3.25	1.375	0.565	0.906	0.679	0.687	5	2
1 -11 1/2 NPT	ANSI G	Y83157	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 -11 1/2 NPT	ANSI G	Y83157BR	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 1/4-11 1/2 NPT	ANSI G	Y83158	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/4-11 1/2 NPT	ANSI G	Y83158BR	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/2-11 1/2 NPT	ANSI G	Y83159	3P	4.25	1.75	0.699	1.5	1.125	1	7	2
1 1/2-11 1/2 NPT	ANSI G	Y83159BR	3P	4.25	1.75	0.699	1.5	1.125	1	7	2
2 -11 1/2 NPT	ANSI G	Y83160	3P	4.5	1.75	0.667	1.875	1.406	1.125	7	2
2 -11 1/2 NPT	ANSI G	Y83160BR	3P	4.5	1.75	0.667	1.875	1.406	1.125	7	2

ANSI

⑧-105

Think threads with
YAMAWA

• This product is different from JIS products in shape and dimensions, please be careful when using.
• BR at the end of a product code indicates untreated products.

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

INT-S-NPT

Interrupted Taps for American Taper Pipe Threads, Short (ℓg) Type



Specification

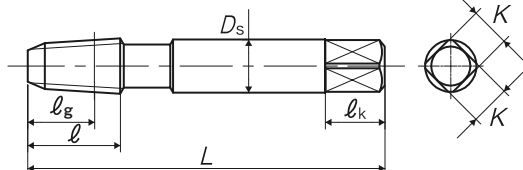


■INT-S-NPT is the tap with short thread portion, and, having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque. INT-S-NPT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

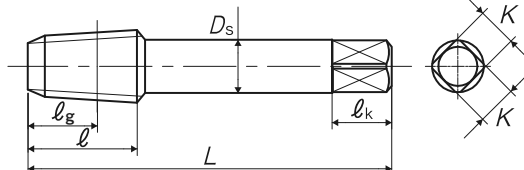
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Stainless steels ステンレス鋼	Cast steels 鋳鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPT	ANSI G	TISNT01L	3P	7.770	54	14	10.10	8	6	9	3	1	¥ 9,160 ※
1/8-27 NPT	ANSI G	TISNT02L	3P	10.117	55	16.5	10.50	8	6	9	5	2	¥ 9,160 ※
1/4-18 NPT	ANSI G	TISNT04O	3P	13.426	62	19.5	12.50	11	9	12	5	2	¥ 13,000 ※
3/8-18 NPT	ANSI G	TISNT06O	3P	16.866	65	21	14.00	14	11	14	5	2	¥ 21,800 ※
1/2-14 NPT	ANSI G	TISNT08Q	3P	20.980	80	27	17.00	18	14	17	5	2	¥ 36,000 ※
3/4-14 NPT	ANSI G	TISNT12Q	3P	26.325	85	29	19.00	23	17	20	5	2	¥ 57,600 ※
1 -11 1/2 NPT	ANSI G	TISNT16T	3P	32.934	95	35	22.00	26	21	24	5	2	¥ 107,000 ※
1 1/4-11 1/2 NPT	ANSI G	TISNT20T	3P	41.689	105	37.5	24.50	32	26	30	5	2	¥ 164,000 ※
1 1/2-11 1/2 NPT	ANSI G	TISNT24T	3P	47.760	110	38.5	25.50	38	29	32	7	2	¥ 232,000 ※
2 -11 1/2 NPT	ANSI G	TISNT32T	3P	59.797	120	42.5	27.50	46	35	38	7	2	¥ 362,000 ※

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

8 Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-107



NPTF

Hand Taps for American Dryseal Taper Pipe Threads



Specification

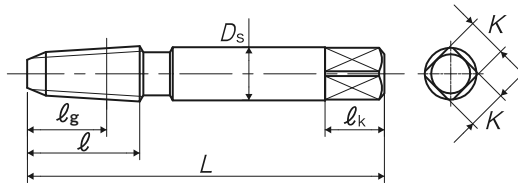


Tapping Speeds depending on Materials

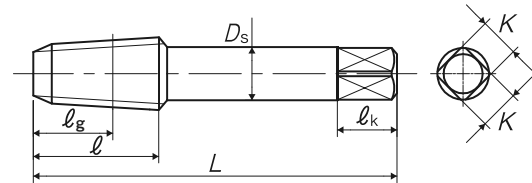
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■ The NPTF is a hand tap for the American dry seal tapered pipe threads and is used for products whose main purpose is the tightness of the threaded part in connection with pipe parts, etc.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPTF	ANSI G	TNTF01L	3P	7.770	54	17	12.00	8	6	9	4	1	¥ 7,560
1/8-27 NPTF	ANSI G	TNTF02L	3P	10.117	55	19	12.05	8	6	9	4	2	¥ 7,560
1/4-18 NPTF	ANSI G	TNTF04O	3P	13.426	62	28	17.45	11	9	12	4	2	¥ 10,800
3/8-18 NPTF	ANSI G	TNTF06O	3P	16.866	65	28	17.65	14	11	14	4	2	¥ 18,100
1/2-14 NPTF	ANSI G	TNTF08Q	3P	20.980	80	35	22.85	18	14	17	4	2	¥ 29,800
3/4-14 NPTF	ANSI G	TNTF12Q	3P	26.325	85	35	22.95	23	17	20	4	2	¥ 47,500
1 -11 1/2 NPTF	ANSI G	TNTF16T	3P	32.934	95	45	27.40	26	21	24	5	2	¥ 88,000
1 1/4-11 1/2 NPTF	ANSI G	TNTF20T	3P	41.689	105	45	28.10	32	26	30	5	2	¥134,000 ※
1 1/2-11 1/2 NPTF	ANSI G	TNTF24T	3P	47.760	110	45	28.40	38	29	32	6	2	¥191,000 ※
2 -11 1/2 NPTF	ANSI G	TNTF32T	3P	59.797	120	50	28.00	46	35	38	6	2	¥299,000 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

NPTF

Hand Taps for American Dryseal Taper Pipe Threads



Specification

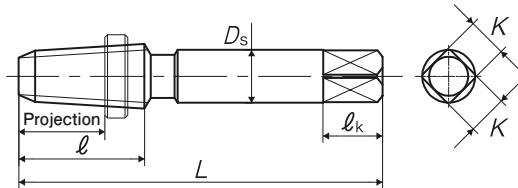


■ The NPTF is a hand tap for the American dry seal tapered pipe threads and is used for products whose main purpose is the tightness of the threaded part in connection with pipe parts, etc.

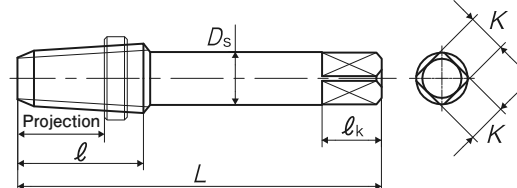
Tapping Speed depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

TYPE: 1



TYPE: 2



Segment : 1G

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Projection (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
For Dryseal American Pipe Threads											
1/16-27 NPTF	ANSI G	Y83125	3P	2.125	0.687	0.312	0.312	0.234	0.375	4	1
1/16-27 NPTF	ANSI G	Y83125BR	3P	2.125	0.687	0.312	0.312	0.234	0.375	4	1
1/8-27 NPTF	ANSI G	Y83126	3P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPTF	ANSI G	Y83126BR	3P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPTF	ANSI G	Y83127	3P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/8-27 NPTF	ANSI G	Y83127BR	3P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/4-18 NPTF	ANSI G	Y83128	3P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
1/4-18 NPTF	ANSI G	Y83128BR	3P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
3/8-18 NPTF	ANSI G	Y83129	3P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
3/8-18 NPTF	ANSI G	Y83129BR	3P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
1/2-14 NPTF	ANSI G	Y83130	3P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
1/2-14 NPTF	ANSI G	Y83130BR	3P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
3/4-14 NPTF	ANSI G	Y83131	3P	3.25	1.375	0.565	0.906	0.679	0.687	5	2
3/4-14 NPTF	ANSI G	Y83131BR	3P	3.25	1.375	0.565	0.906	0.679	0.687	5	2
1 -11 1/2 NPTF	ANSI G	Y83132	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 -11 1/2 NPTF	ANSI G	Y83132BR	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 1/4-11 1/2 NPTF	ANSI G	Y83133	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/4-11 1/2 NPTF	ANSI G	Y83133BR	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/2-11 1/2 NPTF	ANSI G	Y83134	3P	4.25	1.75	0.699	1.5	1.125	1	6	2
1 1/2-11 1/2 NPTF	ANSI G	Y83134BR	3P	4.25	1.75	0.699	1.5	1.125	1	6	2
2 -11 1/2 NPTF	ANSI G	Y83135	3P	4.5	1.75	0.667	1.875	1.406	1.125	6	2
2 -11 1/2 NPTF	ANSI G	Y83135BR	3P	4.5	1.75	0.667	1.875	1.406	1.125	6	2

8 Pipe Tap Series

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

ANSI

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 Mills
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

⑧-109

ANSI

NPTF-CI

Hand Taps for American Dryseal Taper Pipe Threads, for Cast Irons



Specification

HSS

NI
Nitride



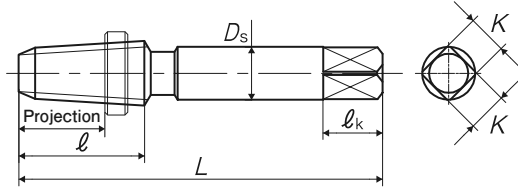
■ Suitable for hard and abrasive materials such as cast irons.

Tapping Speed depending on Materials

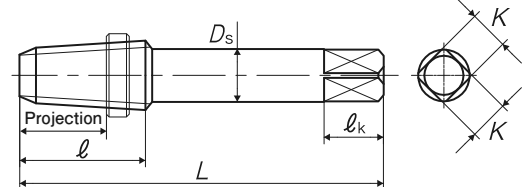
Cast irons
鑄鉄
~5
(m/min)

Ductile cast irons
強靱鑄鉄
~5
(m/min)

TYPE: 1



TYPE: 2



Segment : 1G

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Projection (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Dryseal American Pipe Threads											
1/8-27 NPTF	ANSI G	Y83226	3P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPTF	ANSI G	Y83227	3P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/4-18 NPTF	ANSI G	Y83228	3P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
3/8-18 NPTF	ANSI G	Y83229	3P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
1/2-14 NPTF	ANSI G	Y83230	3P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
3/4-14 NPTF	ANSI G	Y83231	3P	3.25	1.375	0.565	0.906	0.679	0.687	5	2
1 -11 1/2 NPTF	ANSI G	Y83232	3P	3.75	1.75	0.678	1.125	0.843	0.812	5	2
1 1/4-11 1/2 NPTF	ANSI G	Y83233	3P	4	1.75	0.686	1.312	0.984	0.937	5	2
1 1/2-11 1/2 NPTF	ANSI G	Y83234	3P	4.25	1.75	0.699	1.5	1.125	1	7	2
2 -11 1/2 NPTF	ANSI G	Y83235	3P	4.5	1.75	0.667	1.875	1.406	1.125	7	2

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	ℓ_k

ANSI

ZELX SS NPTF

Taps for American Dryseal Taper Pipe Threads



Specification

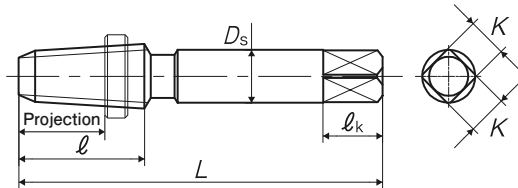


■ Suitable for tapping stainless steels, chrome steels and chrome molybdenum steels.

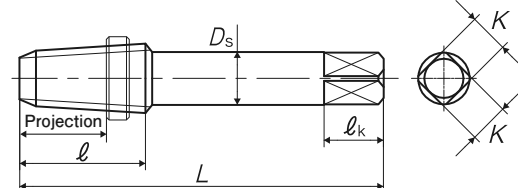
Tapping Speed depending on Materials

Medium carbon steels 中炭素鋼 ~5 (m/min)	High carbon steels 高炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~5 (m/min)	Ductile cast irons 強靱鑄鉄 ~5 (m/min)
---	---	--------------------------------------	---	---

TYPE: 1



TYPE: 2



Segment : 1H

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Projection (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Dryseal American Pipe Threads											
1/16-27 NPTF	ANSI G	Y83660	2.5P	2.125	0.687	0.312	0.312	0.234	0.375	4	1
1/8-27 NPTF	ANSI G	Y83661	2.5P	2.125	0.75	0.312	0.437	0.328	0.375	4	1
1/8-27 NPTF	ANSI G	Y83662	2.5P	2.125	0.75	0.312	0.312	0.234	0.375	4	2
1/4-18 NPTF	ANSI G	Y83663	2.5P	2.437	1.062	0.459	0.562	0.421	0.437	4	1
3/8-18 NPTF	ANSI G	Y83664	2.5P	2.562	1.062	0.454	0.7	0.531	0.5	4	1
1/2-14 NPTF	ANSI G	Y83665	2.5P	3.125	1.375	0.579	0.687	0.515	0.625	4	2
3/4-14 NPTF	ANSI G	Y83666	2.5P	3.25	1.375	0.565	0.906	0.679	0.687	4	2
1 -11 1/2 NPTF	ANSI G	Y83667	2.5P	3.75	1.75	0.678	1.125	0.843	0.812	4	2

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

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	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

⑧-111



LS-NPTF

Long Shank Hand Taps for American Dryseal Taper Pipe Threads



Specification

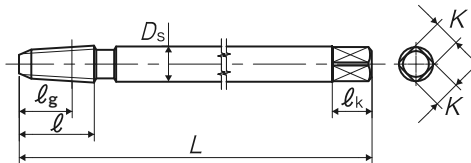


Tapping Speeds depending on Materials

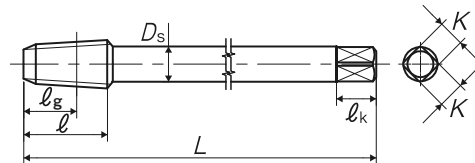
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)

■ The LS-NPTF is a long shank hand tap for the American dry seal tapered pipe threads and is used for products whose main purpose is to withstand screw threads in connection with parts for pipes.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads													
1/16-27 NPTF	ANSI G	TNTF01LL10	3P	7.770	100	17	12.00	8	6	9	4	1	¥ 12,800 ※
1/16-27 NPTF	ANSI G	TNTF01LL15	3P	7.770	150	17	12.00	8	6	9	4	1	¥ 24,000 ※
1/8-27 NPTF	ANSI G	TNTF02LL10	3P	10.117	100	19	12.05	8	6	9	4	2	¥ 12,800 ※
1/8-27 NPTF	ANSI G	TNTF02LL15	3P	10.117	150	19	12.05	8	6	9	4	2	¥ 24,000 ※
1/4-18 NPTF	ANSI G	TNTF04OL10	3P	13.426	100	28	17.45	11	9	12	4	2	¥ 18,200 ※
1/4-18 NPTF	ANSI G	TNTF04OL15	3P	13.426	150	28	17.45	11	9	12	4	2	¥ 24,500 ※
3/8-18 NPTF	ANSI G	TNTF06OL10	3P	16.866	100	28	17.65	14	11	14	4	2	¥ 21,200 ※
3/8-18 NPTF	ANSI G	TNTF06OL15	3P	16.866	150	28	17.65	14	11	14	4	2	¥ 39,900 ※
1/2-14 NPTF	ANSI G	TNTF08QL15	3P	20.980	150	35	22.85	18	14	17	4	2	¥ 48,300 ※
3/4-14 NPTF	ANSI G	TNTF12QL15	3P	26.325	150	35	22.95	23	17	20	4	2	¥ 73,000 ※
1 -11 1/2 NPTF	ANSI G	TNTF16TL15	3P	32.934	150	45	27.40	26	21	24	5	2	¥ 103,000 ※

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

8

JIS

NPS

Hand Taps for American Parallel Pipe Threads



Specification

HSS

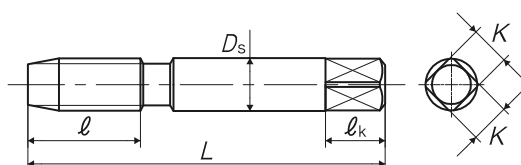


■ The NPS tap is a hand tap for American parallel pipe threads and is used for products whose main purpose is the tightness of the threaded part in connecting pipe parts and the like.

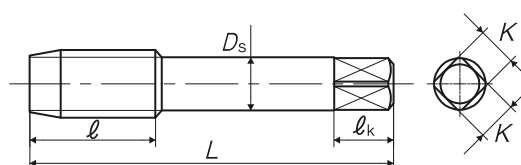
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads												
1/16-27 NPS	ANSI G	TNPS01L	5P	7.770	54	17	8	6	9	4	1	¥ 5,210 ※
1/8-27 NPS	ANSI G	TNPS02L	5P	10.117	55	19	8	6	9	4	2	¥ 5,210 ※
1/4-18 NPS	ANSI G	TNPS04O	5P	13.426	62	28	11	9	12	4	2	¥ 7,630 ※
3/8-18 NPS	ANSI G	TNPS06O	5P	16.866	65	28	14	11	14	4	2	¥ 12,700 ※
1/2-14 NPS	ANSI G	TNPS08Q	5P	20.980	80	35	18	14	17	4	2	¥ 20,600 ※
3/4-14 NPS	ANSI G	TNPS12Q	5P	26.325	85	35	23	17	20	4	2	¥ 33,200 ※
1 -11 1/2 NPS	ANSI G	TNPS16T	5P	32.934	95	45	26	21	24	5	2	¥ 61,600 ※
1 1/4-11 1/2 NPS	ANSI G	TNPS20T	5P	41.689	105	45	32	26	30	5	2	¥ 94,600 ※
1 1/2-11 1/2 NPS	ANSI G	TNPS24T	5P	47.760	110	45	38	29	32	6	2	¥ 135,000 ※
2 -11 1/2 NPS	ANSI G	TNPS32T	5P	59.797	120	50	46	35	38	6	2	¥ 225,000 ※

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

⑧-112

8 Pipe Tap Series

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

ANSI

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

⑧-113

ANSI

NPS

Hand Taps for American Parallel Pipe Threads



Specification

HSS

OX
Oxide



Tapping Speed depending on Materials

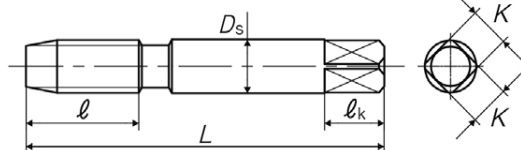
Low carbon steels
低炭素鋼
5~10
(m/min)

Medium carbon steels
中炭素鋼
5~10
(m/min)

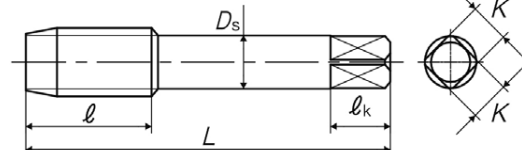
High carbon steels
高炭素鋼
5~10
(m/min)

■ The NPS tap is a hand tap for American parallel pipe threads and is used for products whose main purpose is the tightness of the threaded part in connecting pipe parts and the like.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
For American Pipe Threads										
1/8-27 NPS	ANSI G	Y83301	4P	2.125	0.75	0.437	0.328	0.375	4	1
1/8-27 NPS	ANSI G	Y83301BR	4P	2.125	0.75	0.437	0.328	0.375	4	1
1/8-27 NPS	ANSI G	Y83302	4P	2.125	0.75	0.312	0.234	0.375	4	2
1/8-27 NPS	ANSI G	Y83302BR	4P	2.125	0.75	0.312	0.234	0.375	4	2
1/4-18 NPS	ANSI G	Y83303	4P	2.437	1.062	0.562	0.421	0.437	4	1
1/4-18 NPS	ANSI G	Y83303BR	4P	2.437	1.062	0.562	0.421	0.437	4	1
3/8-18 NPS	ANSI G	Y83304	4P	2.562	1.062	0.7	0.531	0.5	4	1
3/8-18 NPS	ANSI G	Y83304BR	4P	2.562	1.062	0.7	0.531	0.5	4	1
1/2-14 NPS	ANSI G	Y83305	4P	3.125	1.375	0.687	0.515	0.625	4	2
1/2-14 NPS	ANSI G	Y83305BR	4P	3.125	1.375	0.687	0.515	0.625	4	2
3/4-14 NPS	ANSI G	Y83306	4P	3.25	1.375	0.906	0.679	0.687	5	2
3/4-14 NPS	ANSI G	Y83306BR	4P	3.25	1.375	0.906	0.679	0.687	5	2
1 -11 1/2 NPS	ANSI G	Y83307	4P	3.75	1.75	1.125	0.843	0.812	5	2
1 -11 1/2 NPS	ANSI G	Y83307BR	4P	3.75	1.75	1.125	0.843	0.812	5	2

Think threads with
YAMAWA

• This product is different from JIS products in shape and dimensions, please be careful when using.
• BR at the end of a product code indicates untreated products.

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

8

JIS

S
JIS

NPSF

Hand Taps for American Dryseal Parallel Pipe Threads



Specification

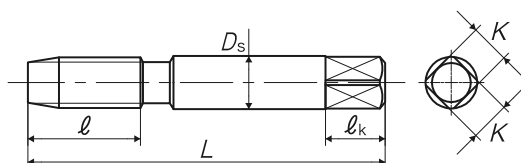


■ The NPSF is a hand tap for the American dry seal parallel pipe threads and is used for screw tapping of products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.

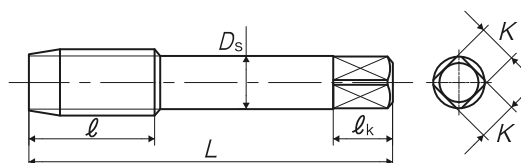
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For American Pipe Threads												
1/16-27 NPSF	ANSI G	TNSF01L	5P	7.770	54	17	8	6	9	4	1	¥ 6,250 ※
1/8-27 NPSF	ANSI G	TNSF02L	5P	10.117	55	19	8	6	9	4	2	¥ 6,250 ※
1/4-18 NPSF	ANSI G	TNSF04O	5P	13.426	62	28	11	9	12	4	2	¥ 9,170 ※
3/8-18 NPSF	ANSI G	TNSF06O	5P	16.866	65	28	14	11	14	4	2	¥ 15,300 ※
1/2-14 NPSF	ANSI G	TNSF08Q	5P	20.980	80	35	18	14	17	4	2	¥ 24,900 ※
3/4-14 NPSF	ANSI G	TNSF12Q	5P	26.325	85	35	23	17	20	4	2	¥ 39,800 ※
1 -11 1/2 NPSF	ANSI G	TNSF16T	5P	32.934	95	45	26	21	24	5	2	¥ 73,900 ※
1 1/4-11 1/2 NPSF	ANSI G	TNSF20T	5P	41.689	105	45	32	26	30	5	2	¥ 114,000 ※
1 1/2-11 1/2 NPSF	ANSI G	TNSF24T	5P	47.760	110	45	38	29	32	6	2	¥ 163,000 ※
2 -11 1/2 NPSF	ANSI G	TNSF32T	5P	59.797	120	50	46	35	38	6	2	¥ 270,000 ※

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

⑧-114

8 Pipe Tap Series

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

ANSI

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

NPSF

Hand Taps for American Dryseal Parallel Pipe Threads



Specification

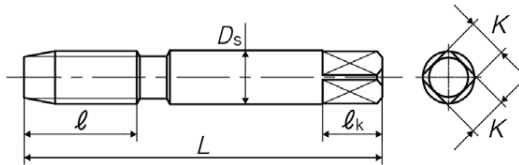


Tapping Speed depending on Materials

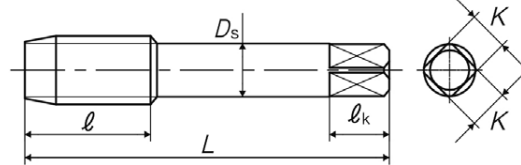
Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

■ The NPSF is a hand tap for the American dry seal parallel pipe threads and is used for screw tapping of products whose main purpose is the tightness of threaded parts in connection with pipe parts etc.

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
For Dryseal American Pipe Threads										
1/8-27 NPSF	ANSI G	Y83326	4P	2.125	0.75	0.437	0.328	0.375	4	1
1/8-27 NPSF	ANSI G	Y83326BR	4P	2.125	0.75	0.437	0.328	0.375	4	1
1/8-27 NPSF	ANSI G	Y83327	4P	2.125	0.75	0.312	0.234	0.375	4	2
1/8-27 NPSF	ANSI G	Y83327BR	4P	2.125	0.75	0.312	0.234	0.375	4	2
1/4-18 NPSF	ANSI G	Y83328	4P	2.437	1.062	0.562	0.421	0.437	4	1
1/4-18 NPSF	ANSI G	Y83328BR	4P	2.437	1.062	0.562	0.421	0.437	4	1
3/8-18 NPSF	ANSI G	Y83329	4P	2.562	1.062	0.7	0.531	0.5	4	1
1/2-14 NPSF	ANSI G	Y83330	4P	3.125	1.375	0.687	0.515	0.625	4	2
1/2-14 NPSF	ANSI G	Y83330BR	4P	3.125	1.375	0.687	0.515	0.625	4	2
3/4-14 NPSF	ANSI G	Y83331	4P	3.25	1.375	0.906	0.679	0.687	5	2
3/4-14 NPSF	ANSI G	Y83331BR	4P	3.25	1.375	0.906	0.679	0.687	5	2
1 -11 1/2 NPSF	ANSI G	Y83332	4P	3.75	1.75	1.125	0.843	0.812	5	2
1 -11 1/2 NPSF	ANSI G	Y83332BR	4P	3.75	1.75	1.125	0.843	0.812	5	2

ANSI

⑧-115

Think threads with
YAMAWA

- This product is different from JIS products in shape and dimensions, please be careful when using.
- BR at the end of a product code indicates untreated products.