

PIPE TAP SERIES



Rc	Pipe-1	Rp	Pipe-28
PT	Pipe-2	PS	Pipe-29
PT LH	Pipe-3	PS LH	Pipe-30
PT-X	Pipe-4	LS-PS	Pipe-31
S-PT	Pipe-5	SP-PS	Pipe-32
S-PT LH	Pipe-6	LS-SP-PS	Pipe-33
LS-PT	Pipe-7	CT-PS	Pipe-34
LS-S-PT	Pipe-8	G	Pipe-35
SP-PT	Pipe-9	PF	Pipe-36
SP-S-PT	Pipe-10	PF LH	Pipe-37
SP-PT-X	Pipe-11	LS-PF	Pipe-38
LS-SP-PT	Pipe-12	SP-PF	Pipe-39
LS-SP-S-PT	Pipe-13	LS-SP-PF	Pipe-40
INT-PT	Pipe-14	SU-PF	Pipe-41
INT-S-PT	Pipe-15	FC-PF	Pipe-42
LS-INT-PT	Pipe-16	CT-PF	Pipe-43
LS-INT-S-PT	Pipe-17	NPT	Pipe-44
LC-PT	Pipe-18	S-NPT	Pipe-45
LC-S-PT	Pipe-19	LS-NPT	Pipe-46
SU-PT	Pipe-20	SP-NPT	Pipe-47
SU-S-PT	Pipe-21	LS-SP-S-NPT	Pipe-48
SU-SP-PT	Pipe-22	INT-NPT	Pipe-49
SU-SP-S-PT	Pipe-23	INT-S-NPT	Pipe-50
FC-PT	Pipe-24	NPTF	Pipe-51
FC-S-PT	Pipe-25	LS-NPTF	Pipe-52
CT-PT	Pipe-26	NPS	Pipe-53
CT-S-PT	Pipe-27	NPSF	Pipe-54

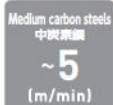
Rc

Hand Taps for Taper Pipe Threads

Specification

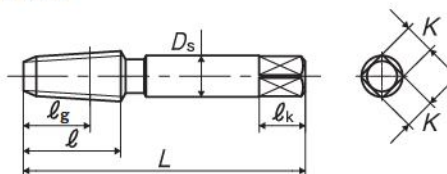


Recommended Tapping Speeds depending on Materials

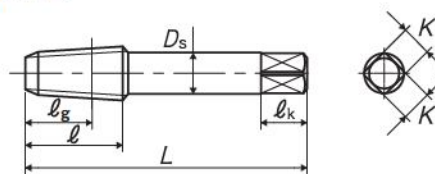


For icon explanation, refer to P.24

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	Stock
For Pipe Threads													
Rc 1/16-28	II	TH2RC01K	2.5P	7.723	59	14	10.1	8	6	9	4	1	○
Rc 1/8-28	II	TH2RC02K	2.5P	9.728	59	15	10.1	8	6	9	4	2	○
Rc 1/4-19	II	TH2RC04-	2.5P	13.157	67	19	15	11	9	12	4	2	○
Rc 3/8-19	II	TH2RC06-	2.5P	16.662	75	21	15.4	14	11	14	4	2	○
Rc 1/2-14	II	TH2RC08Q	2.5P	20.955	87	26	20.5	18	14	17	4	2	○
Rc 3/4-14	II	TH2RC12Q	2.5P	26.441	96	28	21.8	23	17	20	4	2	○
Rc 1-11	II	TH2RC16U	2.5P	33.249	109	33	26	26	21	24	5	2	○
Rc 1 1/4-11	II	TH2RC20U	2.5P	41.910	119	36	28.3	32	26	30	5	2	○
Rc 1 1/2-11	II	TH2RC24U	2.5P	47.803	125	37	28.3	38	29	32	6	2	○
Rc 2-11	II	TH2RC32U	2.5P	59.614	140	41	32.7	46	35	38	6	2	○

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

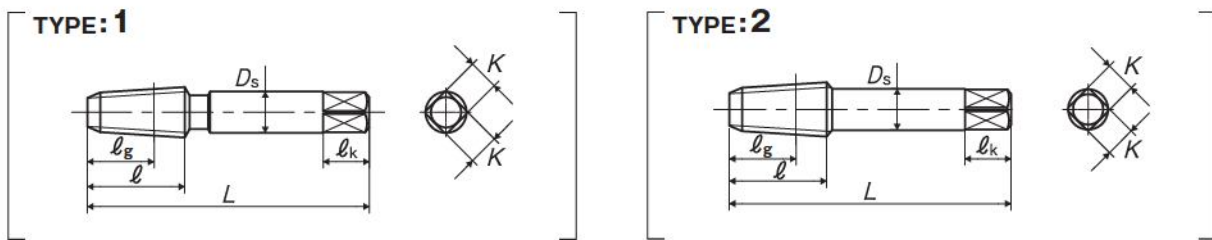
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/16-28	II	TH2T01K-8	2.5P	7.723	55	19	13	8	6	9	4	1	◎
PT 1/8-28	II	TH2T02K	2.5P	9.728	55	19	13	8	6	9	4	2	◎
PT 1/4-19	II	TH2T04-	2.5P	13.157	62	28	21	11	9	12	4	2	◎
PT 3/8-19	II	TH2T06-	2.5P	16.662	65	28	21	14	11	14	4	2	◎
PT 1/2-14	II	TH2T08Q	2.5P	20.955	80	35	25	18	14	17	4	2	◎
PT 5/8-14	II	TH2T10Q	2.5P	22.911	82	35	25	19	15	18	4	2	△
PT 3/4-14	II	TH2T12Q	2.5P	26.441	85	35	25	23	17	20	4	2	◎
PT 7/8-14	II	TH2T14Q	2.5P	30.201	90	40	28	24	19	22	4	2	△
PT 1 -11	II	TH2T16U	2.5P	33.249	95	45	32	26	21	24	5	2	◎
PT 1 1/8-11	II	TH2T18U	2.5P	37.897	100	45	32	28	21	24	5	2	△
PT 1 1/4-11	II	TH2T20U	2.5P	41.910	105	45	32	32	26	30	5	2	◎
PT 1 1/2-11	II	TH2T24U	2.5P	47.803	110	45	32	38	29	32	6	2	◎
PT 1 3/4-11	II	TH2T28U	2.5P	53.746	115	45	32	42	32	35	6	2	△
PT 2 -11	II	TH2T32U	2.5P	59.614	120	50	35	46	35	38	6	2	◎
PT 2 1/4-11	II	TH2T36U	2.5P	65.710	145	65	50	50	38	42	6	2	△
PT 2 1/2-11	II	TH2T40U	2.5P	75.184	145	65	50	55	41	44	8	2	△
PT 3 -11	II	TH2T48U	2.5P	87.884	155	65	52	65	50	52	8	2	△
PT 3 1/2-11	II	TH2T56U	2.5P	100.330	165	68	52	70	54	58	8	2	△
PT 4 -11	II	TH2T64U	2.5P	113.030	170	70	55	75	58	62	10	2	△

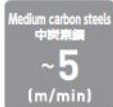
PT LH

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

Specification

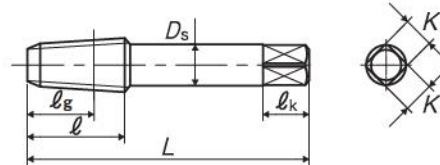


Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24

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	Stock
For Pipe Threads													
PT 1/8-28	II	TH2T02K--L	2.5P	9.728	55	19	13	8	6	9	4	1	△
PT 1/4-19	II	TH2T04---L	2.5P	13.157	62	28	21	11	9	12	4	1	△
PT 3/8-19	II	TH2T06---L	2.5P	16.662	65	28	21	14	11	14	4	1	△
PT 1/2-14	II	TH2T08Q--L	2.5P	20.955	80	35	25	18	14	17	4	1	△
PT 3/4-14	II	TH2T12Q--L	2.5P	26.441	85	35	25	23	17	20	4	1	△
PT 1 -11	II	TH2T16U--L	2.5P	33.249	95	45	32	26	21	24	5	1	△
PT 1 1/4-11	II	TH2T20U--L	2.5P	41.910	105	45	32	32	26	30	5	1	△
PT 1 1/2-11	II	TH2T24U--L	2.5P	47.803	110	45	32	38	29	32	6	1	△
PT 2 -11	II	TH2T32U--L	2.5P	59.614	120	50	35	46	35	38	6	1	△

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

PT-X

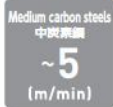
X Series Hand Taps for Taper Pipe Threads Short (ℓg) Type

Specification

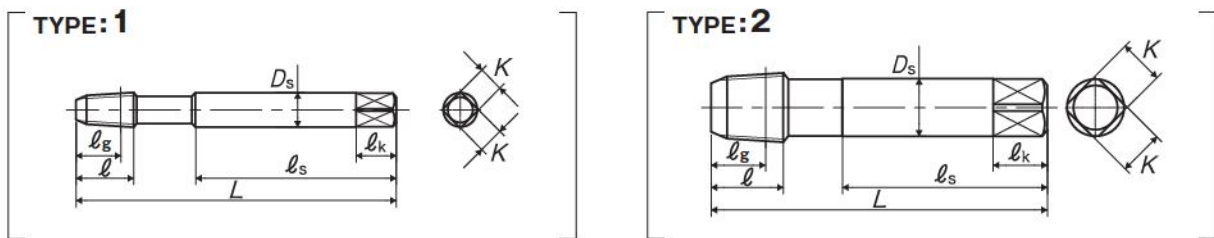


■PT-X Hand Tap, adopting new tap blank, ensures properly long projection length of the tool. Having short thread length, this tap is suitable for tapping of such machine components as have the limit in their thickness.

Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



Segment : 1G

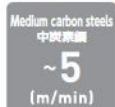
Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Pipe Threads														
PT 1/16-28	II	THX2T01K-8	2.5P	7.723	75	13.5	10.5	47	8	6	9	4	1	○
PT 1/8-28	II	THX2T02K	2.5P	9.728	75	13.5	10.5	48	8	6	9	4	2	○
PT 1/4-19	II	THX2T04-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

S-PT

Hand Taps for Taper Pipe Threads Short (ℓ_g) Type
Specification



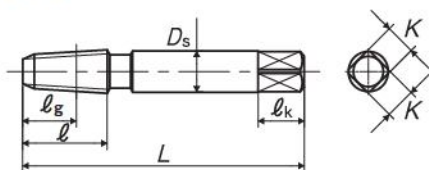
Recommended Tapping Speeds depending on Materials



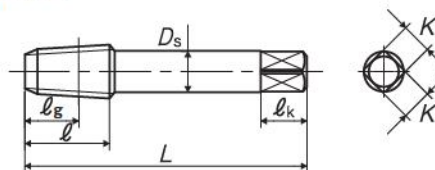
For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/16-28	II	TSPT01K-8	2.5P	7.723	55	16.5	10.5	8	6	9	4	1	○
PT 1/8-28	II	TSPT02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	2	◎
PT 1/4-19	II	TSPT04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	2	◎
PT 3/8-19	II	TSPT06-	2.5P	16.662	65	21	14	14	11	14	4	2	◎
PT 1/2-14	II	TSPT08Q	2.5P	20.955	80	27	17	18	14	17	4	2	◎
PT 3/4-14	II	TSPT12Q	2.5P	26.441	85	29	19	23	17	20	4	2	◎
PT 1 -11	II	TSPT16U	2.5P	33.249	95	35	22	26	21	24	5	2	◎
PT 1 1/4-11	II	TSPT20U	2.5P	41.910	105	37.5	24.5	32	26	30	5	2	○
PT 1 1/2-11	II	TSPT24U	2.5P	47.803	110	38.5	25.5	38	29	32	6	2	○
PT 1 3/4-11	II	TSPT28U	2.5P	53.746	115	39.5	26.5	42	32	35	6	2	△
PT 2 -11	II	TSPT32U	2.5P	59.614	120	42.5	27.5	46	35	38	6	2	○
PT 2 1/2-11	II	TSPT40U	2.5P	75.184	145	47	32	55	41	44	8	2	△
PT 3 -11	II	TSPT48U	2.5P	87.884	155	51	36	65	50	52	8	2	△

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

S-PT LH

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

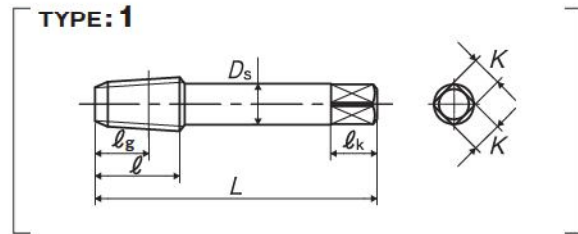
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	TSPT02K--L	2.5P	9.728	55	16.5	10.5	8	6	9	4	1	△
PT 1/4-19	II	TSPT04---L	2.5P	13.157	62	19.5	12.5	11	9	12	4	1	△
PT 3/8-19	II	TSPT06---L	2.5P	16.662	65	21	14	14	11	14	4	1	△
PT 1/2-14	II	TSPT08Q--L	2.5P	20.955	80	27	17	18	14	17	4	1	△
PT 3/4-14	II	TSPT12Q--L	2.5P	26.441	85	29	19	23	17	20	4	1	△
PT 1 -11	II	TSPT16U--L	2.5P	33.249	95	35	22	26	21	24	5	1	△
PT 1 1/4-11	II	TSPT20U--L	2.5P	41.910	105	37.5	24.5	32	26	30	5	1	△
PT 1 1/2-11	II	TSPT24U--L	2.5P	47.803	110	38.5	25.5	38	29	32	6	1	△
PT 2 -11	II	TSPT32U--L	2.5P	59.614	120	42.5	27.5	46	35	38	6	1	△

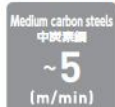
LS-PT

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

Specification



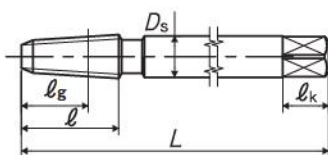
Recommended Tapping Speeds depending on Materials



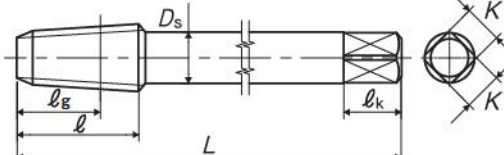
For icon explanation, refer to P.24



TYPE:1



TYPE:2



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	Stock
For Pipe Threads													
PT 1/16-28	II	L10T01K-8	2.5P	7.723	100	19	13	8	6	9	4	1	△
PT 1/8-28	II	L10T02K	2.5P	9.728	100	19	13	8	6	9	4	2	○
		L15T02K			150								△
		L20T02K			200								△
PT 1/4-19	II	L10T04-	2.5P	13.157	100	28	21	11	9	12	4	2	○
		L15T04-			150								△
		L20T04-			200								△
PT 3/8-19	II	L10T06-	2.5P	16.662	100	28	21	14	11	14	4	2	○
		L12T06-			120								△
		L15T06-			150								○
		L20T06-			200								△
PT 1/2-14	II	L15T08Q	2.5P	20.955	150	35	25	18	14	17	4	2	○
		L20T08Q			200								△
PT 3/4-14	II	L15T12Q	2.5P	26.441	150	35	25	23	17	20	4	2	○
		L20T12Q			200								△
PT 1 -11	II	L15T16U	2.5P	33.249	150	45	32	26	21	24	5	2	○
		L20T16U			200								△
PT 1 1/4-11	II	-	2.5P	41.910	200	45	32	32	26	30	5	2	△
PT 1 1/2-11	II	-	2.5P	47.803	200	45	32	38	29	32	6	2	△

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

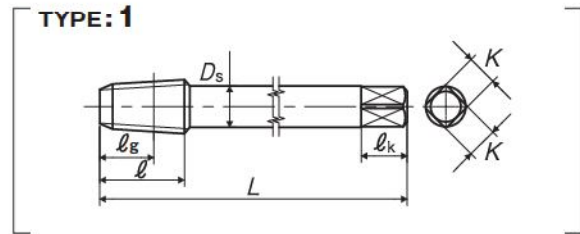
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	TSPT02KL10	2.5P	9.728	100	16.5	10.5	8	6	9	4	1	○
		TSPT02KL15			150								△
		TSPT02KL20			200								△
PT 1/4-19	II	TSPT04-L10	2.5P	13.157	100	19.5	12.5	11	9	12	4	1	○
		TSPT04-L15			150								△
		TSPT04-L20			200								△
PT 3/8-19	II	TSPT06-L10	2.5P	16.662	100	21	14	14	11	14	4	1	○
		TSPT06-L12			120								△
		TSPT06-L15			150								○
		TSPT06-L20			200								△
PT 1/2-14	II	TSPT08QL15	2.5P	20.955	150	27	17	18	14	17	4	1	○
		TSPT08QL20			200								△
PT 3/4-14	II	TSPT12QL15	2.5P	26.441	150	29	19	23	17	20	4	1	○
		TSPT12QL20			200								△
PT 1-11	II	TSPT16UL15	2.5P	33.249	150	35	22	26	21	24	5	1	○
		TSPT16UL20			200								△

SP-PT

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

Specification

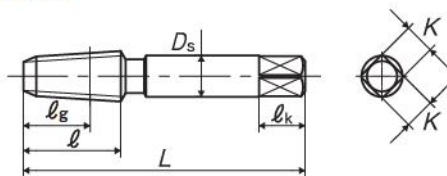


Recommended Tapping Speeds depending on Materials

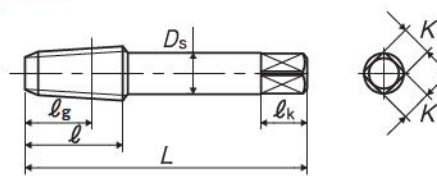
Low carbon steels
低炭素鋼
~5
(m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



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	Stock
For Pipe Threads													
PT 1/16-28	II	SH2T01K-8	2.5P	7.723	55	19	13	8	6	9	3	1	△
PT 1/8-28	II	SH2T02K	2.5P	9.728	55	19	13	8	6	9	3	2	◎
PT 1/4-19	II	SH2T04-	2.5P	13.157	62	28	21	11	9	12	3	2	◎
PT 3/8-19	II	SH2T06-	2.5P	16.662	65	28	21	14	11	14	3	2	◎
PT 1/2-14	II	SH2T08Q	2.5P	20.955	80	35	25	18	14	17	4	2	○
PT 3/4-14	II	SH2T12Q	2.5P	26.441	85	35	25	23	17	20	4	2	○
PT 1 -11	II	SH2T16U	2.5P	33.249	95	45	32	26	21	24	4	2	○
PT 1 1/4-11	II	SH2T20U	2.5P	41.910	105	45	32	32	26	30	4	2	△
PT 1 1/2-11	II	SH2T24U	2.5P	47.803	110	45	32	38	29	32	4	2	△
PT 2 -11	II	SH2T32U	2.5P	59.614	120	50	35	46	35	38	4	2	△

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

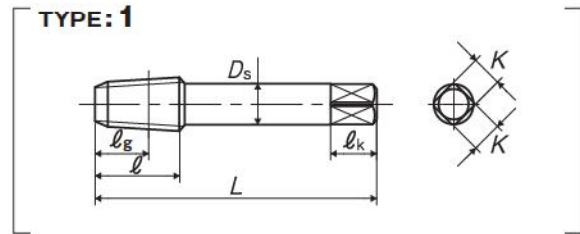
Specification



Recommended Tapping Speeds depending on Materials

Low carbon steels
RECOMMENDED
~5
(m/min)

For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	SSPT02K	2.5P	9.728	55	16.5	10.5	8	6	9	3	1	○
PT 1/4-19	II	SSPT04-	2.5P	13.157	62	19.5	12.5	11	9	12	3	1	○
PT 3/8-19	II	SSPT06-	2.5P	16.662	65	21	14	14	11	14	3	1	○
PT 1/2-14	II	SSPT08Q	2.5P	20.955	80	27	17	18	14	17	4	1	○
PT 3/4-14	II	SSPT12Q	2.5P	26.441	85	29	19	23	17	20	4	1	○
PT 1 -11	II	SSPT16U	2.5P	33.249	95	35	22	26	21	24	4	1	○
PT 1 1/4-11	II	SSPT20U	2.5P	41.910	105	37.5	24.5	32	26	30	4	1	△
PT 1 1/2-11	II	SSPT24U	2.5P	47.803	110	38.5	25.5	38	29	32	4	1	△
PT 2 -11	II	SSPT32U	2.5P	59.614	120	42.5	27.5	46	35	38	4	1	△

SP-PT-X

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

Specification



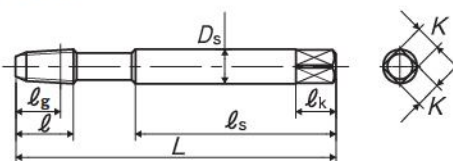
■SP-PT-X Spiral Fluted Tap, adopting new blank, ensures properly long projection length of the tool. Having short thread length, this tap is suitable for tapping of such machine components as have the limit in their thickness.

Recommended Tapping Speeds depending on Materials

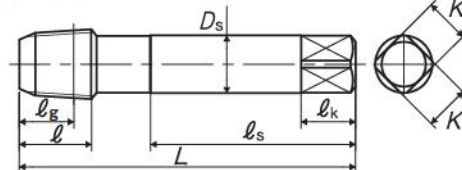
Low carbon steels
低炭素鋼
~5
(m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



Segment : 1G

Size	Class	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	Stock
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	○
PT 1/8-28	II	SHX2T02K	2.5P	9.728	75	13.5	10.5	48	8	6	9	3	2	○
PT 1/4-19	II	SHX2T04-	2.5P	13.157	85	16.5	12.5	54	11	9	12	3	2	○
PT 3/8-19	II	SHX2T06-	2.5P	16.662	95	18	14	60	14	11	14	3	2	○
PT 1/2-14	II	SHX2T08Q	2.5P	20.955	105	22.5	17	64	18	14	17	4	2	○

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

LS-SP-PT



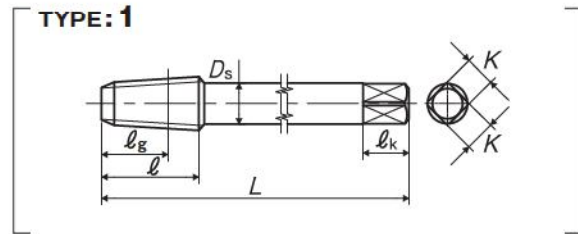
Long Shank Spiral Fluted Taps for Taper Pipe Threads, Long (ℓg) Type
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	SH2T02KL10	2.5P	9.728	100	19	13	8	6	9	3	1	$\triangle$
		SH2T02KL12			120								
		SH2T02KL15			150								
PT 1/4-19	II	SH2T04-L10	2.5P	13.157	100	28	21	11	9	12	3	1	$\triangle$
		SH2T04-L12			120								
		SH2T04-L15			150								
PT 3/8-19	II	SH2T06-L12	2.5P	16.662	120	28	21	14	11	14	3	1	$\triangle$
		SH2T06-L15			150								
PT 1/2-14	II	SH2T08QL15	2.5P	20.955	150	35	25	18	14	17	4	1	$\triangle$
PT 3/4-14	II	SH2T12QL15	2.5P	26.441	150	35	25	23	17	20	4	1	$\triangle$
PT 1 -11	II	SH2T16UL15	2.5P	33.249	150	45	32	26	21	24	4	1	$\triangle$
		SH2T16UL20			200								

LS-SP-S-PT



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

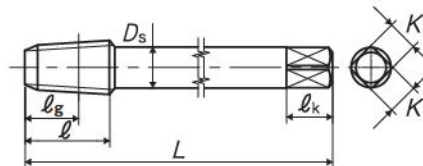


Recommended Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
~5
(m/min)

For icon explanation, refer to P.24

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	Stock
For Pipe Threads													
PT 1/8-28	II	SSPT02KL10	2.5P	9.728	100	16.5	10.5	8	6	9	3	1	$\triangle$
		SSPT02KL12			120								
		SSPT02KL15			150								
PT 1/4-19	II	SSPT04-L10	2.5P	13.157	100	19.5	12.5	11	9	12	3	1	$\triangle$
		SSPT04-L12			120								
		SSPT04-L15			150								
PT 3/8-19	II	SSPT06-L12	2.5P	16.662	120	21	14	14	11	14	3	1	$\triangle$
		SSPT06-L15			150								
PT 1/2-14	II	SSPT08QL15	2.5P	20.955	150	27	17	18	14	17	4	1	$\triangle$
PT 3/4-14	II	SSPT12QL15	2.5P	26.441	150	29	19	23	17	20	4	1	$\triangle$
PT 1 -11	II	SSPT16UL15	2.5P	33.249	150	35	22	26	21	24	4	1	$\triangle$
		SSPT16UL20			200								

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

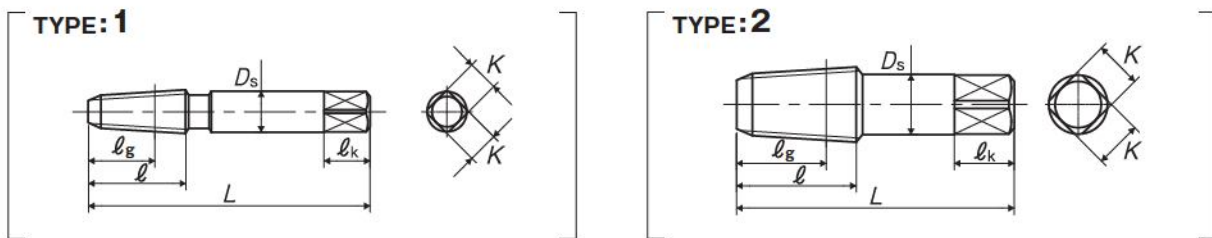


■INT-PT having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque.
INT-PT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

Recommended Tapping Speeds depending on Materials

Stainless steels
ステンレス鋼
~5
(m/min)

For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/16-28	II	TINT01K-8	3P	7.723	55	19	13	8	6	9	3	1	△
PT 1/8-28	II	TINT02K	3P	9.728	55	19	13	8	6	9	5	2	○
PT 1/4-19	II	TINT04-	3P	13.157	62	28	21	11	9	12	5	2	○
PT 3/8-19	II	TINT06-	3P	16.662	65	28	21	14	11	14	5	2	○
PT 1/2-14	II	TINT08Q	3P	20.955	80	35	25	18	14	17	5	2	○
PT 3/4-14	II	TINT12Q	3P	26.441	85	35	25	23	17	20	5	2	○
PT 1 -11	II	TINT16U	3P	33.249	95	45	32	26	21	24	5	2	○
PT 1 1/4-11	II	TINT20U	3P	41.910	105	45	32	32	26	30	5	2	○
PT 1 1/2-11	II	TINT24U	3P	47.803	110	45	32	38	29	32	7	2	○
PT 2 -11	II	TINT32U	3P	59.614	120	50	35	46	35	38	7	2	△

INT-S-PT

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

Specification

HSS

OX

Oxide



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

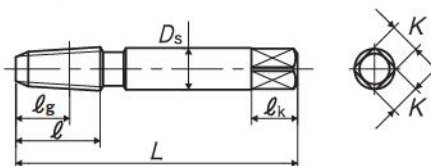
INT-S-PT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

Recommended Tapping Speeds depending on Materials

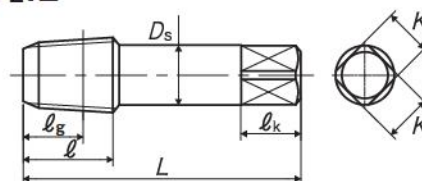
Stainless steels
ステンレス鋼
~5
(m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



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	Stock
For Pipe Threads													
PT 1/16-28	II	TIST01K-8	3P	7.723	55	16.5	10.5	8	6	9	3	1	△
PT 1/8-28	II	TIST02K	3P	9.728	55	16.5	10.5	8	6	9	5	2	○
PT 1/4-19	II	TIST04-	3P	13.157	62	19.5	12.5	11	9	12	5	2	○
PT 3/8-19	II	TIST06-	3P	16.662	65	21	14	14	11	14	5	2	○
PT 1/2-14	II	TIST08Q	3P	20.955	80	27	17	18	14	17	5	2	○
PT 3/4-14	II	TIST12Q	3P	26.441	85	29	19	23	17	20	5	2	○
PT 1 -11	II	TIST16U	3P	33.249	95	35	22	26	21	24	5	2	○
PT 1 1/4-11	II	TIST20U	3P	41.910	105	37.5	24.5	32	26	30	5	2	○
PT 1 1/2-11	II	TIST24U	3P	47.803	110	38.5	25.5	38	29	32	7	2	○
PT 2 -11	II	TIST32U	3P	59.614	120	42.5	27.5	46	35	38	7	2	○

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



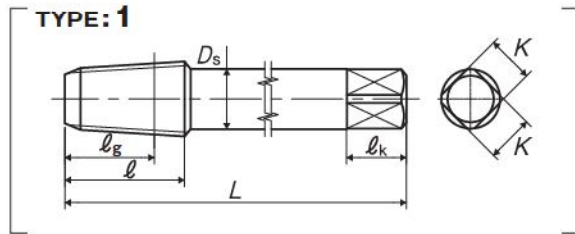
■LS-INT-PT Long Shank Spiral Fluted Tap, having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque.

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

Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	TINT02KL10	3P	9.728	100	19	13	8	6	9	5	1	$\triangle$
		TINT02KL12			120								
		TINT02KL15			150								
PT 1/4-19	II	TINT04-L10	3P	13.157	100	28	21	11	9	12	5	1	$\triangle$
		TINT04-L12			120								
		TINT04-L15			150								
PT 3/8-19	II	TINT06-L10	3P	16.662	100	28	21	14	11	14	5	1	$\triangle$
		TINT06-L12			120								
		TINT06-L15			150								
PT 1/2-14	II	TINT08QL15	3P	20.955	150	35	25	18	14	17	5	1	$\triangle$
PT 3/4-14	II	TINT12QL15	3P	26.441	150	35	25	23	17	20	5	1	$\triangle$
PT 1 -11	II	TINT16UL15	3P	33.249	150	45	32	26	21	24	5	1	$\triangle$
		TINT16UL20			200								

LS-INT-S-PT



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

Specification

HSS

OX

Oxide



■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.

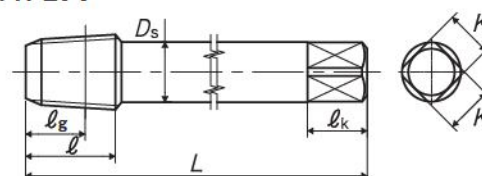
LS-INT-S-PT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

Recommended Tapping Speeds depending on Materials

Stainless steels
ステンレス鋼
~5
(m/min)

For icon explanation, refer to P.24

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	Stock
For Pipe Threads													
PT 1/8-28	II	TIST02KL10	3P	9.728	100	16.5	10.5	8	6	9	5	1	$\triangle$
		TIST02KL12			120								
		TIST02KL15			150								
PT 1/4-19	II	TIST04-L10	3P	13.157	100	19.5	12.5	11	9	12	5	1	$\triangle$
		TIST04-L12			120								
		TIST04-L15			150								
PT 3/8-19	II	TIST06-L10	3P	16.662	100	21	14	14	11	14	5	1	$\triangle$
		TIST06-L12			120								
		TIST06-L15			150								
PT 1/2-14	II	TIST08QL15	3P	20.955	150	27	17	18	14	17	5	1	$\triangle$
PT 3/4-14	II	TIST12QL15	3P	26.441	150	29	19	23	17	20	5	1	$\triangle$
PT 1 -11	II	TIST16UL15	3P	33.249	150	35	22	26	21	24	5	1	$\triangle$
		TIST16UL20			200								

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

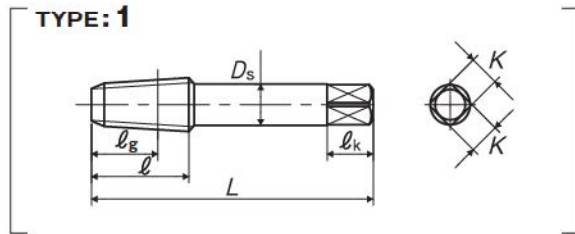


■ Tap suitable for such soft steels (Low Carbon Steels) as SS400 and S25C.

Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	LCPT02K	2.5P	9.728	55	19	13	8	6	9	4	1	△
PT 1/4-19	II	LCPT04-	2.5P	13.157	62	28	21	11	9	12	4	1	△
PT 3/8-19	II	LCPT06-	2.5P	16.662	65	28	21	14	11	14	4	1	△
PT 1/2-14	II	LCPT08Q	2.5P	20.955	80	35	25	18	14	17	4	1	△
PT 3/4-14	II	LCPT12Q	2.5P	26.441	85	35	25	23	17	20	4	1	△
PT 1 -11	II	LCPT16U	2.5P	33.249	95	45	32	26	21	24	5	1	△
PT 1 1/4-11	II	LCPT20U	2.5P	41.910	105	45	32	32	26	30	5	1	△
PT 1 1/2-11	II	LCPT24U	2.5P	47.803	110	45	32	38	29	32	6	1	△
PT 2 -11	II	LCPT32U	2.5P	59.614	120	50	35	46	35	38	6	1	△

LC-S-PT

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

Specification



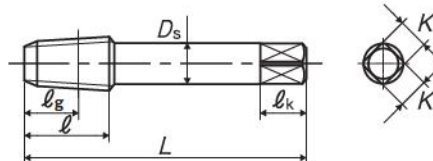
■ Tap, having short thread portion, suitable for such soft steels (Low Carbon Steels) as SS400 and S25C.

Recommended Tapping Speeds depending on Materials

Low carbon steels
低炭鋼
~5
(m/min)

For icon explanation, refer to P.24

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	Stock
For Pipe Threads													
PT 1/8-28	II	LCSPT02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	1	△
PT 1/4-19	II	LCSPT04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	1	△
PT 3/8-19	II	LCSPT06-	2.5P	16.662	65	21	14	14	11	14	4	1	△
PT 1/2-14	II	LCSPT08Q	2.5P	20.955	80	27	17	18	14	17	4	1	△
PT 3/4-14	II	LCSPT12Q	2.5P	26.441	85	29	19	23	17	20	4	1	△
PT 1-11	II	LCSPT16U	2.5P	33.249	95	35	22	26	21	24	5	1	△

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

SU-PT



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

Specification

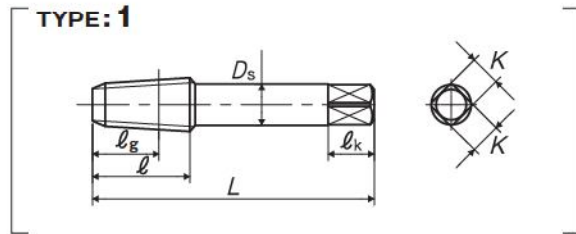


■SU-PT is the hand tap suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels.

Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	TU2T02K	2.5P	9.728	55	19	13	8	6	9	4	1	△
PT 1/4-19	II	TU2T04-	2.5P	13.157	62	28	21	11	9	12	4	1	△
PT 3/8-19	II	TU2T06-	2.5P	16.662	65	28	21	14	11	14	4	1	△
PT 1/2-14	II	TU2T08Q	2.5P	20.955	80	35	25	18	14	17	4	1	△
PT 3/4-14	II	TU2T12Q	2.5P	26.441	85	35	25	23	17	20	4	1	△
PT 1-11	II	TU2T16U	2.5P	33.249	95	45	32	26	21	24	4	1	△
PT 1 1/4-11	II	TU2T20U	2.5P	41.910	105	45	32	32	26	30	5	1	△
PT 1 1/2-11	II	TU2T24U	2.5P	47.803	110	45	32	38	29	32	6	1	△

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

SU-S-PT



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

Specification



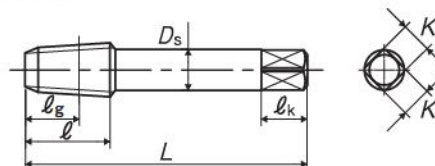
■SU-S-PT is the hand tap with short thread portion, suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels.

Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24

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	Stock
For Pipe Threads													
PT 1/8-28	II	TUST02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	1	△
PT 1/4-19	II	TUST04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	1	△
PT 3/8-19	II	TUST06-	2.5P	16.662	65	21	14	14	11	14	4	1	△
PT 1/2-14	II	TUST08Q	2.5P	20.955	80	27	17	18	14	17	4	1	△
PT 3/4-14	II	TUST12Q	2.5P	26.441	85	29	19	23	17	20	4	1	△
PT 1-11	II	TUST16U	2.5P	33.249	95	35	22	26	21	24	4	1	△
PT 1 1/4-11	II	TUST20U	2.5P	41.910	105	37.5	24.5	32	26	30	5	1	△
PT 1 1/2-11	II	TUST24U	2.5P	47.803	110	38.5	25.5	38	29	32	6	1	△

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

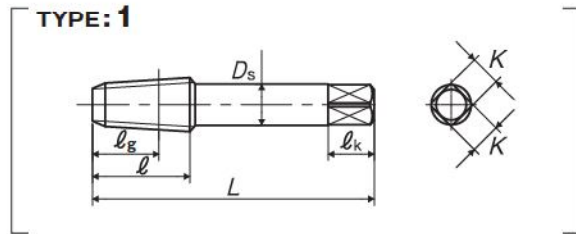


■SU-SP-PT is the tap suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels, blind hole use.

Recommended Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)	Alloy steels 合金鋼 ~5 (m/min)	Stainless steels ステンレス鋼 ~5 (m/min)
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For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	-	2P	9.728	55	19	13	8	6	9	4	1	△
PT 1/4-19	II	-	2P	13.157	62	28	21	11	9	12	4	1	△
PT 3/8-19	II	-	2P	16.662	65	28	21	14	11	14	4	1	△
PT 1/2-14	II	-	2P	20.955	80	35	25	18	14	17	4	1	△
PT 3/4-14	II	-	2P	26.441	85	35	25	23	17	20	4	1	△
PT 1-11	II	-	2P	33.249	95	45	32	26	21	24	5	1	△

SU-SP-S-PT

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

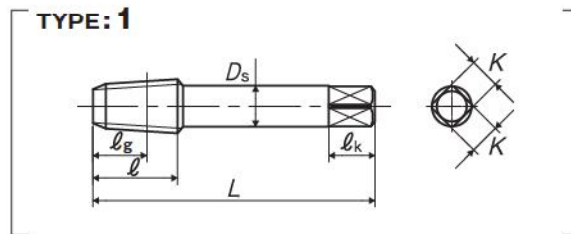


■SU-SP-S-PT is the tap with short thread portion, suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels and molybdenum steels, blind hole use.

Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	-	2P	9.728	55	16.5	10.5	8	6	9	4	1	△
PT 1/4-19	II	-	2P	13.157	62	19.5	12.5	11	9	12	4	1	△
PT 3/8-19	II	-	2P	16.662	65	21	14	14	11	14	4	1	△
PT 1/2-14	II	-	2P	20.955	80	27	17	18	14	17	4	1	△
PT 3/4-14	II	-	2P	26.441	85	29	19	23	17	20	4	1	△
PT 1-11	II	-	2P	33.249	95	35	22	26	21	24	5	1	△

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

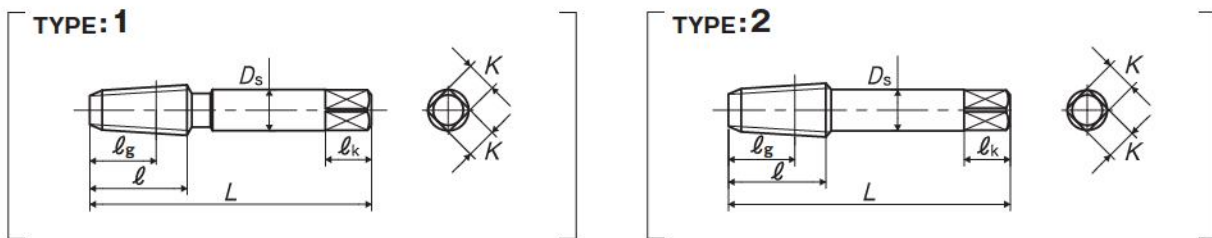


■FC-PT is suitable for hard and abrasive materials such as cast irons.

Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/16-28	II	FCPT01K-8	2.5P	7.723	55	19	13	8	6	9	4	1	△
PT 1/8-28	II	FCPT02K	2.5P	9.728	55	19	13	8	6	9	4	2	△
PT 1/4-19	II	FCPT04-	2.5P	13.157	62	28	21	11	9	12	4	2	△
PT 3/8-19	II	FCPT06-	2.5P	16.662	65	28	21	14	11	14	4	2	△
PT 1/2-14	II	FCPT08Q	2.5P	20.955	80	35	25	18	14	17	4	2	△
PT 3/4-14	II	FCPT12Q	2.5P	26.441	85	35	25	23	17	20	4	2	△
PT 1 -11	II	FCPT16U	2.5P	33.249	95	45	32	26	21	24	5	2	△
PT 1 1/4-11	II	FCPT20U	2.5P	41.910	105	45	32	32	26	30	5	2	△
PT 1 1/2-11	II	FCPT24U	2.5P	47.803	110	45	32	38	29	32	6	2	△
PT 2 -11	II	FCPT32U	2.5P	59.614	120	50	35	46	35	38	6	2	△

FC-S-PT

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

Specification



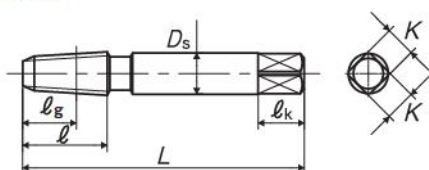
■FC-S-PT is the tap with short thread portion, suitable for hard and abrasive materials such as cast irons.

Recommended Tapping Speeds depending on Materials

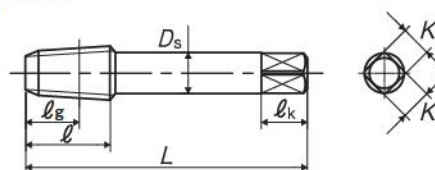
Cast Irons 鑄鉄	Ductile cast irons 強靱鑄鉄
~5 (m/min)	~5 (m/min)

For icon explanation, refer to P.24

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	Stock
For Pipe Threads													
PT 1/16-28	II	FCST01K-8	2.5P	7.723	55	16.5	10.5	8	6	9	4	1	△
PT 1/8-28	II	FCST02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	2	△
PT 1/4-19	II	FCST04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	2	△
PT 3/8-19	II	FCST06-	2.5P	16.662	65	21	14	14	11	14	4	2	△
PT 1/2-14	II	FCST08Q	2.5P	20.955	80	27	17	18	14	17	4	2	△
PT 3/4-14	II	FCST12Q	2.5P	26.441	85	29	19	23	17	20	4	2	△
PT 1 -11	II	FCST16U	2.5P	33.249	95	35	22	26	21	24	5	2	△
PT 1 1/4-11	II	FCST20U	2.5P	41.910	105	37.5	24.5	32	26	30	5	2	△
PT 1 1/2-11	II	FCST24U	2.5P	47.803	110	38.5	25.5	38	29	32	6	2	△
PT 2 -11	II	FCST32U	2.5P	59.614	120	42.5	27.5	46	35	38	6	2	△



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

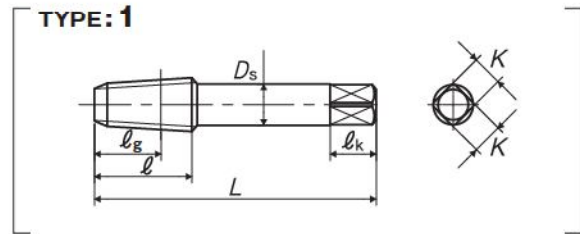
Specification



Recommended Tapping Speeds depending on Materials

Cast Irons 鑄鉄 ~5 (m/min)	Ductile cast Irons 強靱鑄鉄 ~5 (m/min)	Brass castings 黄銅鑄造 ~5 (m/min)
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For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	TCPT02K	2.5P	9.728	55	19	13	8	6	9	4	1	△
PT 1/4-19	II	TCPT04-	2.5P	13.157	62	28	21	11	9	12	4	1	△
PT 3/8-19	II	TCPT06-	2.5P	16.662	65	28	21	14	11	14	4	1	△
PT 1/2-14	II	TCPT08Q	2.5P	20.955	80	35	25	18	14	17	4	1	△
PT 3/4-14	II	TCPT12Q	2.5P	26.441	85	35	25	23	17	20	4	1	△
PT 1-11	II	TCPT16U	2.5P	33.249	95	45	32	26	21	24	5	1	△

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Hand Taps
Spiral Pointed Taps
(for through hole)

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

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

CT-S-PT

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

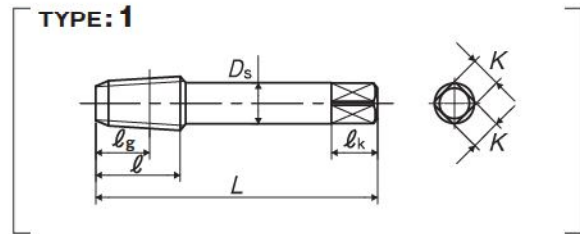
Specification



Recommended 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)
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For icon explanation, refer to P.24



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	Stock
For Pipe Threads													
PT 1/8-28	II	TCST02K	2.5P	9.728	55	16.5	10.5	8	6	9	4	1	△
PT 1/4-19	II	TCST04-	2.5P	13.157	62	19.5	12.5	11	9	12	4	1	△
PT 3/8-19	II	TCST06-	2.5P	16.662	65	21	14	14	11	14	4	1	△
PT 1/2-14	II	TCST08Q	2.5P	20.955	80	27	17	18	14	17	4	1	△

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

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

Rp

Hand Taps for Parallel Pipe Threads

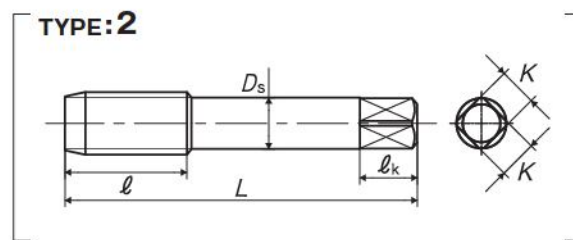
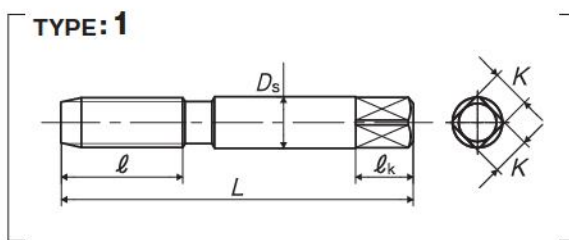
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
Rp 1/16-28	II	TH2RP01K	3.5P	7.723	59	14	8	6	9	4	1	○
Rp 1/8-28	II	TH2RP02K	3.5P	9.728	59	15	8	6	9	4	2	○
Rp 1/4-19	II	TH2RP04-	3.5P	13.157	67	19	11	9	12	4	2	○
Rp 3/8-19	II	TH2RP06-	3.5P	16.662	75	21	14	11	14	4	2	○
Rp 1/2-14	II	TH2RP08Q	3.5P	20.955	87	26	18	14	17	4	2	○
Rp 3/4-14	II	TH2RP12Q	3.5P	26.441	96	28	23	17	20	4	2	○
Rp 1-11	II	TH2RP16U	3.5P	33.249	109	33	26	21	24	5	2	○
Rp 1 1/4-11	II	TH2RP20U	3.5P	41.910	119	36	32	26	30	5	2	○
Rp 1 1/2-11	II	TH2RP24U	3.5P	47.803	125	37	38	29	32	6	2	○
Rp 2-11	II	TH2RP32U	3.5P	59.614	140	41	46	35	38	6	2	○

Spiral Fluted Taps (for blind hole)
Spiral Fluted Taps (for through hole)
Spiral Pointed Taps (for through hole)
Hand Taps
Cemented Carbide Taps
Roll Taps
Special Thread Taps Simple Inspection Tools
Pipe Taps
Thread Mills
Dies
Center Drills
Centering Tools

PS

Hand Taps for Parallel Pipe Threads

Specification



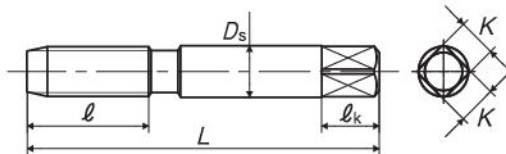
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

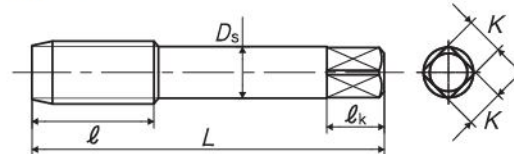
For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PS 1/16-28	II	TH2P01K-8	3.5P	7.723	55	19	8	6	9	4	1	△
PS 1/8-28	II	TH2P02K	3.5P	9.728	55	19	8	6	9	4	2	○
		TH2P02K1	1.5P									△
PS 1/4-19	II	TH2P04-	3.5P	13.157	62	28	11	9	12	4	2	○
		TH2P04-1	1.5P									△
PS 3/8-19	II	TH2P06-	3.5P	16.662	65	28	14	11	14	4	2	○
		TH2P06-1	1.5P									△
PS 1/2-14	II	TH2P08Q	3.5P	20.955	80	35	18	14	17	4	2	○
		TH2P08Q1	1.5P									△
PS 5/8-14	II	TH2P10Q	3.5P	22.911	82	35	19	15	18	4	2	△
PS 3/4-14	II	TH2P12Q	3.5P	26.441	85	35	23	17	20	4	2	○
		TH2P12Q1	1.5P									△
PS 7/8-14	II	TH2P14Q	3.5P	30.201	90	40	24	19	22	4	2	△
PS 1 -11	II	TH2P16U	3.5P	33.249	95	45	26	21	24	5	2	○
		TH2P16U1	1.5P									△
PS 1 1/4-11	II	TH2P20U	3.5P	41.910	105	45	32	26	30	5	2	○
		TH2P20U1	1.5P									△
PS 1 1/2-11	II	TH2P24U	3.5P	47.803	110	45	38	29	32	6	2	○
		TH2P24U1	1.5P									△
PS 2 -11	II	TH2P32U	3.5P	59.614	120	50	46	35	38	6	2	○
PS 2 1/2-11	II	TH2P40U	3.5P	75.184	145	65	55	41	44	8	2	△
PS 3 -11	II	TH2P48U	3.5P	87.884	155	65	65	50	52	8	2	△
PS 4 -11	II	TH2P64U	3.5P	113.030	170	70	75	58	62	10	2	△

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

PS LH

Hand Taps for Parallel Pipe Threads, for LH Threads

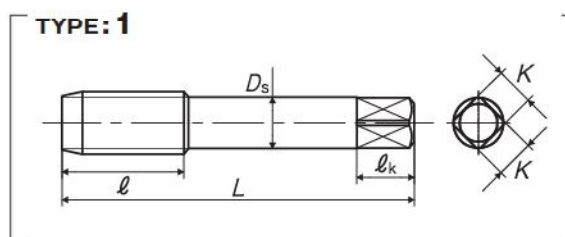
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PS 1/8-28	II	TH2P02K--L	3.5P	9.728	55	19	8	6	9	4	1	△
PS 1/4-19	II	TH2P04---L	3.5P	13.157	62	28	11	9	12	4	1	△
PS 3/8-19	II	TH2P06---L	3.5P	16.662	65	28	14	11	14	4	1	△
PS 1/2-14	II	TH2P08Q--L	3.5P	20.955	80	35	18	14	17	4	1	△
PS 3/4-14	II	TH2P12Q--L	3.5P	26.441	85	35	23	17	20	4	1	△
PS 1 -11	II	TH2P16U--L	3.5P	33.249	95	45	26	21	24	5	1	△
PS 1 1/4-11	II	TH2P20U--L	3.5P	41.910	105	45	32	26	30	5	1	△
PS 1 1/2-11	II	TH2P24U--L	3.5P	47.803	110	45	38	29	32	6	1	△
PS 2 -11	II	TH2P32U--L	3.5P	59.614	120	50	46	35	38	6	1	△

LS-PS

Long Shank Hand Taps for Parallel Pipe Threads

Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PS 1/8-28	II	L10P02K	3.5P	9.728	100	19	8	6	9	4	1	○
		L15P02K			150							△
		L20P02K			200							△
PS 1/4-19	II	L10P04-	3.5P	13.157	100	28	11	9	12	4	1	○
		L15P04-			150							△
		L20P04-			200							△
PS 3/8-19	II	L10P06-	3.5P	16.662	100	28	14	11	14	4	1	○
		L15P06-			150							△
		L20P06-			200							△
PS 1/2-14	II	L15P08Q	3.5P	20.955	150	35	18	14	17	4	1	○
		L20P08Q			200							△
PS 3/4-14	II	L15P12Q	3.5P	26.441	150	35	23	17	20	4	1	○
		L20P12Q			200							△
PS 1 -11	II	L15P16U	3.5P	33.249	150	45	26	21	24	5	1	○
		L20P16U			200							△

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

SP-PS

Spiral Fluted Taps for Parallel Pipe Threads

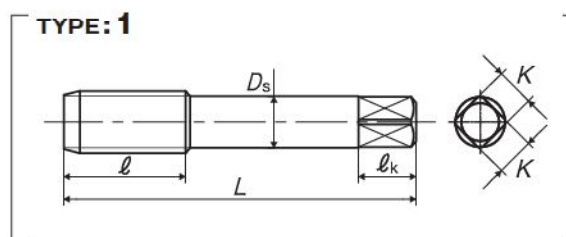
Specification



Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼類
5~10
(m/min)

For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PS 1/8-28	II	SH2P02K	2.5P	9.728	55	19	8	6	9	3	1	○
PS 1/4-19	II	SH2P04-	2.5P	13.157	62	28	11	9	12	3	1	○
PS 3/8-19	II	SH2P06-	2.5P	16.662	65	28	14	11	14	3	1	○
PS 1/2-14	II	SH2P08Q	2.5P	20.955	80	35	18	14	17	4	1	○
PS 3/4-14	II	SH2P12Q	2.5P	26.441	85	35	23	17	20	4	1	○
PS 1 -11	II	SH2P16U	2.5P	33.249	95	45	26	21	24	4	1	○
PS 1 1/4-11	II	SH2P20U	2.5P	41.910	105	45	32	26	30	4	1	△
PS 1 1/2-11	II	SH2P24U	2.5P	47.803	110	45	38	29	32	4	1	△
PS 2 -11	II	SH2P32U	2.5P	59.614	120	50	46	35	38	4	1	△

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

LS-SP-PS

Long Shank Spiral Fluted Taps for Parallel Pipe Threads

Specification



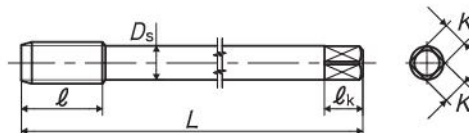
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PS 1/8-28	II	SH2P02KL10	2.5P	9.728	100	19	8	6	9	3	1	△
		SH2P02KL15			150							
PS 1/4-19	II	SH2P04-L10	2.5P	13.157	100	28	11	9	12	3	1	△
		SH2P04-L15			150							
PS 3/8-19	II	SH2P06-L15	2.5P	16.662	150	28	14	11	14	3	1	△
PS 1/2-14	II	SH2P08QL15	2.5P	20.955	150	35	18	14	17	4	1	△
PS 3/4-14	II	SH2P12QL15	2.5P	26.441	150	35	23	17	20	4	1	△
PS 1 -11	II	SH2P16UL15	2.5P	33.249	150	45	26	21	24	4	1	△
		SH2P16UL20			200							

CT-PS

Carbide Taps for Parallel Pipe Threads

Specification

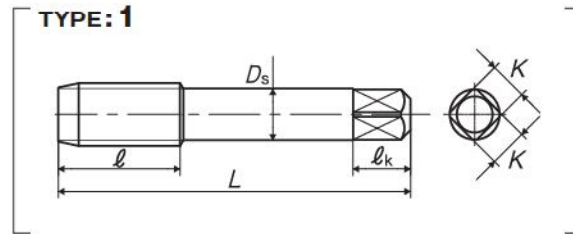


Recommended Tapping Speeds depending on Materials

Cast Irons 鑄鉄	Ductile cast Irons 強靱鑄鉄	Brass castings 黄銅鑄物
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

For icon explanation, refer to P.24

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



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	Stock
For Pipe Threads												
PS 1/8-28	II	TCPS02K	3.5P	9.728	55	19	8	6	9	4	1	△
PS 1/4-19	II	TCPS04-	3.5P	13.157	62	28	11	9	12	4	1	△
PS 3/8-19	II	TCPS06-	3.5P	16.662	65	28	14	11	14	4	1	△
PS 1/2-14	II	TCPS08Q	3.5P	20.955	80	35	18	14	17	4	1	△
PS 3/4-14	II	TCPS12Q	3.5P	26.441	85	35	23	17	20	4	1	△
PS 1 -11	II	TCPS16U	3.5P	33.249	95	45	26	21	24	5	1	△

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

G

Hand Taps for Parallel Pipe Threads

Specification



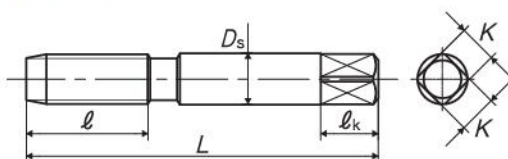
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

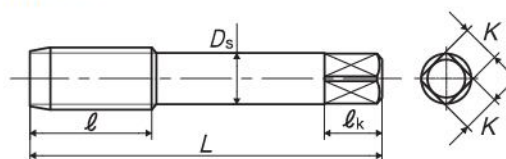
For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
G 1/16-28	II	TH2G01K	3.5P	7.723	59	14	8	6	9	4	1	○
G 1/8-28	II	TH2G02K	3.5P	9.728	59	15	8	6	9	4	2	○
G 1/4-19	II	TH2G04-	3.5P	13.157	67	19	11	9	12	4	2	○
G 3/8-19	II	TH2G06-	3.5P	16.662	75	21	14	11	14	4	2	○
G 1/2-14	II	TH2G08Q	3.5P	20.955	87	26	18	14	17	4	2	○
G 3/4-14	II	TH2G12Q	3.5P	26.441	96	28	23	17	20	4	2	○
G 1 -11	II	TH2G16U	3.5P	33.249	109	33	26	21	24	4	2	○
G 1 1/4-11	II	TH2G20U	3.5P	41.910	119	36	32	26	30	4	2	○
G 1 1/2-11	II	TH2G24U	3.5P	47.803	125	37	38	29	32	6	2	○
G 2 -11	II	TH2G32U	3.5P	59.614	140	41	46	35	38	6	2	○

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

PF

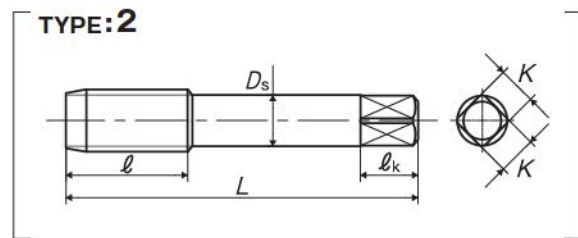
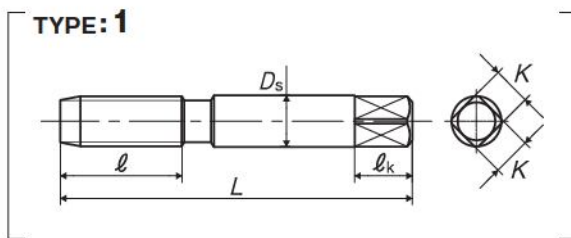
Hand Taps for Parallel Pipe Threads Specification



Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼類
5~10
(m/min)

For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PF 1/16-28	II	TH2F01K-8	3.5P	7.723	55	19	8	6	9	4	1	△
PF 1/8-28	II	TH2F02K	3.5P	9.728	55	19	8	6	9	4	2	○
		TH2F02K1	1.5P									△
PF 1/4-19	II	TH2F04-	3.5P	13.157	62	28	11	9	12	4	2	○
		TH2F04-1	1.5P									△
PF 3/8-19	II	TH2F06-	3.5P	16.662	65	28	14	11	14	4	2	○
		TH2F06-1	1.5P									△
PF 1/2-14	II	TH2F08Q	3.5P	20.955	80	35	18	14	17	4	2	○
		TH2F08Q1	1.5P									△
PF 5/8-14	II	TH2F10Q	3.5P	22.911	82	35	19	15	18	4	2	△
PF 3/4-14	II	TH2F12Q	3.5P	26.441	85	35	23	17	20	4	2	○
		TH2F12Q1	1.5P									△
PF 7/8-14	II	TH2F14Q	3.5P	30.201	90	40	24	19	22	4	2	△
PF 1 -11	II	TH2F16U	3.5P	33.249	95	45	26	21	24	4	2	○
		TH2F16U1	1.5P									△
PF 1 1/4-11	II	TH2F20U	3.5P	41.910	105	45	32	26	30	4	2	○
		TH2F20U1	1.5P									△
PF 1 1/2-11	II	TH2F24U	3.5P	47.803	110	45	38	29	32	6	2	○
		TH2F24U1	1.5P									△
PF 2 -11	II	TH2F32U	3.5P	59.614	120	50	46	35	38	6	2	○
		TH2F32U1	1.5P									△
PF 2 1/2-11	II	TH2F40U	3.5P	75.184	145	65	55	41	44	8	2	△
PF 3 -11	II	TH2F48U	3.5P	87.884	155	65	65	50	52	8	2	△
PF 3 1/2-11	II	TH2F56U	3.5P	100.330	165	68	70	54	58	8	2	△
PF 4 -11	II	TH2F64U	3.5P	113.030	170	70	75	58	62	10	2	△

○=Standard ○=Semi standard △=Made to order
For improvement, spec may change without advance notice.

Think threads with
YAMAWA

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

Pipe-36

333

PF LH

Hand Taps for Parallel Pipe Threads, for LH Threads

Specification

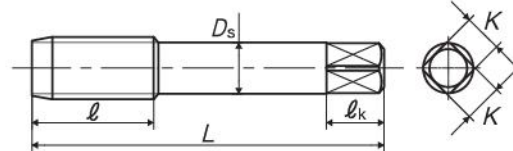


Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24

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	Stock
For Pipe Threads												
PF 1/8-28	II	TH2F02K--L	3.5P	9.728	55	19	8	6	9	4	1	△
PF 1/4-19	II	TH2F04---L	3.5P	13.157	62	28	11	9	12	4	1	△
PF 3/8-19	II	TH2F06---L	3.5P	16.662	65	28	14	11	14	4	1	△
PF 1/2-14	II	TH2F08Q--L	3.5P	20.955	80	35	18	14	17	4	1	△
PF 3/4-14	II	TH2F12Q--L	3.5P	26.441	85	35	23	17	20	4	1	△
PF 1 -11	II	TH2F16U--L	3.5P	33.249	95	45	26	21	24	4	1	△
PF 1 1/4-11	II	TH2F20U--L	3.5P	41.910	105	45	32	26	30	4	1	△
PF 1 1/2-11	II	TH2F24U--L	3.5P	47.803	110	45	38	29	32	6	1	△
PF 2 -11	II	TH2F32U--L	3.5P	59.614	120	50	46	35	38	6	1	△

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

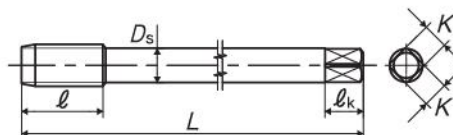


Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24

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	Stock
For Pipe Threads												
PF 1/8-28	II	L10F02K	3.5P	9.728	100	19	8	6	9	4	1	○
		L15F02K			150							△
		L20F02K			200							△
PF 1/4-19	II	L10F04-	3.5P	13.157	100	28	11	9	12	4	1	○
		L15F04-			150							△
		L20F04-			200							△
PF 3/8-19	II	L10F06-	3.5P	16.662	100	28	14	11	14	4	1	○
		L15F06-			150							△
		L20F06-			200							△
PF 1/2-14	II	L15F08Q	3.5P	20.955	150	35	18	14	17	4	1	○
		L20F08Q			200							△
PF 3/4-14	II	L15F12Q	3.5P	26.441	150	35	23	17	20	4	1	○
		L20F12Q			200							△
PF 1 -11	II	L15F16U	3.5P	33.249	150	45	26	21	24	4	1	○
		L20F16U			200							△

Spiral Fluted Taps (for blind hole)
Spiral Fluted Taps (for through hole)
Spiral Pointed Taps (for through hole)
Hand Taps
Cemented Carbide Taps
Roll Taps
Special Thread Taps Simple Inspection Tools
Pipe Taps
Thread Mills
Dies
Center Drills
Centering Tools

SP-PF

Spiral Fluted Taps for Parallel Pipe Threads

Specification

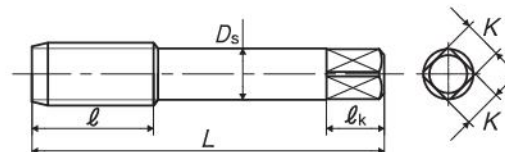


Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

For icon explanation, refer to P.24

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	Stock
For Pipe Threads												
PF 1/8-28	II	SH2F02K	2.5P	9.728	55	19	8	6	9	3	1	○
PF 1/4-19	II	SH2F04-	2.5P	13.157	62	28	11	9	12	3	1	○
PF 3/8-19	II	SH2F06-	2.5P	16.662	65	28	14	11	14	3	1	○
PF 1/2-14	II	SH2F08Q	2.5P	20.955	80	35	18	14	17	4	1	○
PF 3/4-14	II	SH2F12Q	2.5P	26.441	85	35	23	17	20	4	1	○
PF 1 -11	II	SH2F16U	2.5P	33.249	95	45	26	21	24	4	1	○
PF 1 1/4-11	II	SH2F20U	2.5P	41.910	105	45	32	26	30	4	1	△
PF 1 1/2-11	II	SH2F24U	2.5P	47.803	110	45	38	29	32	4	1	△
PF 2 -11	II	SH2F32U	2.5P	59.614	120	50	46	35	38	4	1	△

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

LS-SP-PF

Long Shank Spiral Fluted Taps for Parallel Pipe Threads

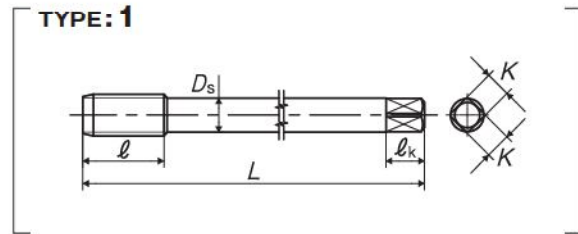
Specification



Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼類
5~10
(m/min)

For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PF 1/8-28	II	SH2F02KL10	2.5P	9.728	100	19	8	6	9	3	1	△
		SH2F02KL12			120							
		SH2F02KL15			150							
PF 1/4-19	II	SH2F04-L10	2.5P	13.157	100	28	11	9	12	3	1	△
		SH2F04-L12			120							
		SH2F04-L15			150							
PF 3/8-19	II	SH2F06-L12	2.5P	16.662	120	28	14	11	14	3	1	△
		SH2F06-L15			150							
PF 1/2-14	II	SH2F08QL15	2.5P	20.955	150	35	18	14	17	4	1	△
PF 3/4-14	II	SH2F12QL15	2.5P	26.441	150	35	23	17	20	4	1	△
PF 1 -11	II	SH2F16UL15	2.5P	33.249	150	45	26	21	24	4	1	△
		SH2F16UL20			200							

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

SU-PF

Hand Taps for Parallel Pipe Threads, for Stainless Steels

Specification



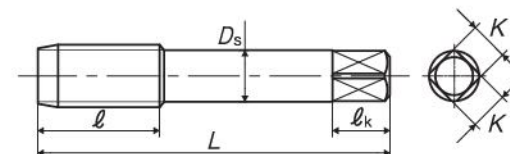
■SU-PF is the hand tap suitable for stainless steels which tend to work-harden and sticky, as well as chrome steels, and molybdenum steels.

Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to P.24

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	Stock
For Pipe Threads												
PF 1/8-28	II	TU2F02K	3.5P	9.728	55	19	8	6	9	4	1	△
PF 1/4-19	II	TU2F04-	3.5P	13.157	62	28	11	9	12	4	1	△
PF 3/8-19	II	TU2F06-	3.5P	16.662	65	28	14	11	14	4	1	△
PF 1/2-14	II	TU2F08Q	3.5P	20.955	80	35	18	14	17	4	1	△
PF 3/4-14	II	TU2F12Q	3.5P	26.441	85	35	23	17	20	4	1	△
PF 1 -11	II	TU2F16U	3.5P	33.249	95	45	26	21	24	4	1	△

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

FC-PF

Hand Taps for Parallel Pipe Threads, for Cast Irons

Specification



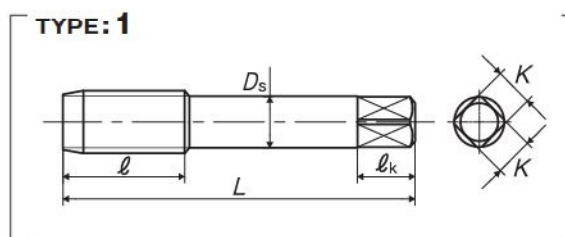
■FC-PF is suitable for hard and abrasive materials such as cast irons.



Recommended Tapping Speeds depending on Materials

Cast Irons 鑄鉄	Ductile cast Irons 強靱鑄鉄
5~10 (m/min)	5~10 (m/min)

For icon explanation, refer to P.24



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	Stock
For Pipe Threads												
PF 1/8-28	II	FCPF02K	3.5P	9.728	55	19	8	6	9	4	1	△
PF 1/4-19	II	FCPF04-	3.5P	13.157	62	28	11	9	12	4	1	△
PF 3/8-19	II	FCPF06-	3.5P	16.662	65	28	14	11	14	4	1	△
PF 1/2-14	II	FCPF08Q	3.5P	20.955	80	35	18	14	17	4	1	△
PF 3/4-14	II	FCPF12Q	3.5P	26.441	85	35	23	17	20	4	1	△
PF 1 -11	II	FCPF16U	3.5P	33.249	95	45	26	21	24	4	1	△
PF 1 1/4-11	II	FCPF20U	3.5P	41.910	105	45	32	26	30	4	1	△
PF 1 1/2-11	II	FCPF24U	3.5P	47.803	110	45	38	29	32	6	1	△
PF 2 -11	II	FCPF32U	3.5P	59.614	120	50	46	35	38	6	1	△

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

CT-PF

Carbide Taps for Parallel Pipe Threads

Specification



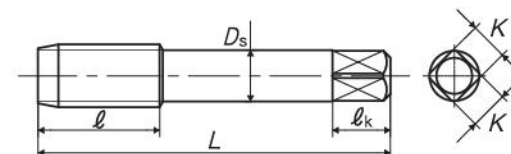
■CT-PF is suitable for hard and abrasive materials such as cast irons.

Recommended Tapping Speeds depending on Materials

Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄	Brass castings 黄銅鑄物
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

For icon explanation, refer to P.24

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	Stock
For Pipe Threads												
PF 1/8-28	II	TCPF02K	3.5P	9.728	55	19	8	6	9	4	1	△
PF 1/4-19	II	TCPF04-	3.5P	13.157	62	28	11	9	12	4	1	△
PF 3/8-19	II	TCPF06-	3.5P	16.662	65	28	14	11	14	4	1	△
PF 1/2-14	II	TCPF08Q	3.5P	20.955	80	35	18	14	17	4	1	△
PF 3/4-14	II	TCPF12Q	3.5P	26.441	85	35	23	17	20	4	1	△
PF 1 -11	II	TCPF16U	3.5P	33.249	95	45	26	21	24	4	1	△

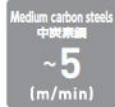
Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

NPT

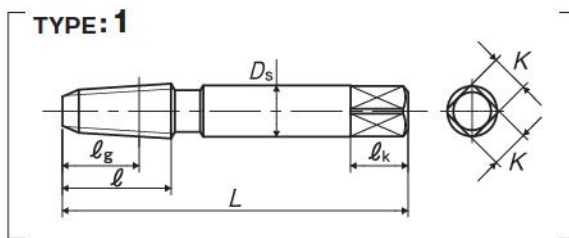
Hand Taps for American Taper Pipe Threads Specification



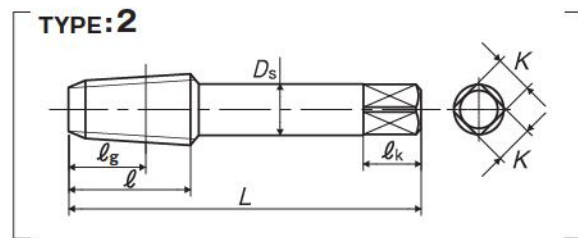
Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For American Pipe Threads													
NPT 1/16-27	ANSI G	TNPT01L	3P	7.770	54	17	12	8	6	9	4	1	○
NPT 1/8-27	ANSI G	TNPT02L	3P	10.117	55	19	12.05	8	6	9	4	2	○
NPT 1/4-18	ANSI G	TNPT040	3P	13.426	62	28	17.45	11	9	12	4	2	○
NPT 3/8-18	ANSI G	TNPT060	3P	16.866	65	28	17.65	14	11	14	4	2	○
NPT 1/2-14	ANSI G	TNPT08Q	3P	20.980	80	35	22.85	18	14	17	4	2	○
NPT 3/4-14	ANSI G	TNPT12Q	3P	26.325	85	35	22.95	23	17	20	4	2	○
NPT 1-11.5	ANSI G	TNPT16T	3P	32.934	95	45	27.4	26	21	24	5	2	○
NPT 1 1/4-11.5	ANSI G	TNPT20T	3P	41.689	105	45	28.1	32	26	30	5	2	△
NPT 1 1/2-11.5	ANSI G	TNPT24T	3P	47.760	110	45	28.4	38	29	32	6	2	△
NPT 2-11.5	ANSI G	TNPT32T	3P	59.797	120	50	28	46	35	38	6	2	△
NPT 2 1/2-8	ANSI G	TNPT40X	3P	72.273	145	65	40.8	55	41	44	8	2	△
NPT 3-8	ANSI G	TNPT48X	3P	88.184	155	65	42.95	65	50	52	8	2	△

S-NPT

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

Specification

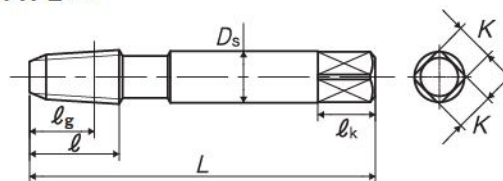


Recommended Tapping Speeds depending on Materials

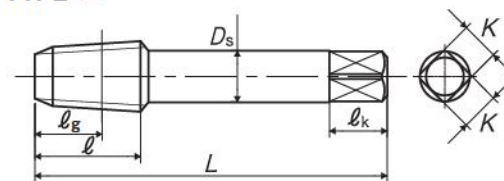


For icon explanation, refer to P.24

TYPE:1



TYPE:2



Segment : 1G

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_g (mm)	D_s (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For American Pipe Threads													
NPT 1/16-27	ANSI G	TSNPT01L	3P	7.770	54	14	10.1	8	6	9	4	1	△
NPT 1/8-27	ANSI G	TSNPT02L	3P	10.117	55	16.5	10.5	8	6	9	4	2	△
NPT 1/4-18	ANSI G	TSNPT040	3P	13.426	62	19.5	12.5	11	9	12	4	2	△
NPT 3/8-18	ANSI G	TSNPT060	3P	16.866	65	21	14	14	11	14	4	2	△
NPT 1/2-14	ANSI G	TSNPT08Q	3P	20.980	80	27	17	18	14	17	4	2	△
NPT 3/4-14	ANSI G	TSNPT12Q	3P	26.325	85	29	19	23	17	20	4	2	△
NPT 1-11.5	ANSI G	TSNPT16T	3P	32.934	95	35	22	26	21	24	5	2	△
NPT 1 1/4-11.5	ANSI G	TSNPT20T	3P	41.689	105	37.5	24.5	32	26	30	5	2	△
NPT 1 1/2-11.5	ANSI G	TSNPT24T	3P	47.760	110	38.5	25.5	38	29	32	6	2	△
NPT 2-11.5	ANSI G	TSNPT32T	3P	59.797	120	42.5	27.5	46	35	38	6	2	△

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

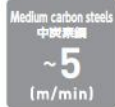
LS-NPT

Long Shank Hand Taps for American Taper Pipe Threads

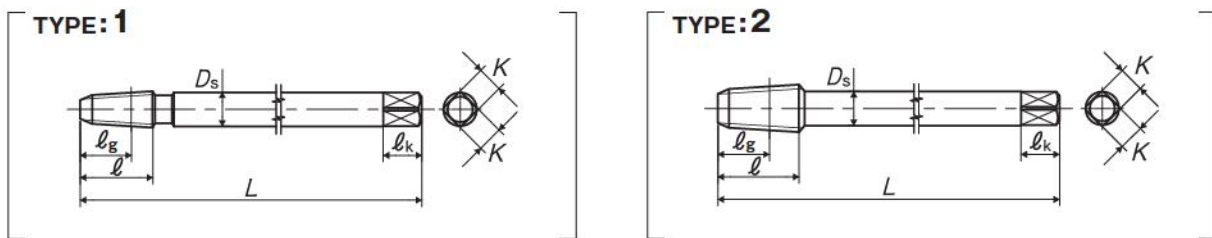
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For American Pipe Threads													
NPT 1/16-27	ANSI G	TNPT01LL10	3P	7.770	100	17	12	8	6	9	4	1	△
NPT 1/8-27	ANSI G	TNPT02LL10	3P	10.117	100	19	12.05	8	6	9	4	2	△
		TNPT02LL15			150								
NPT 1/4-18	ANSI G	TNPT04QL10	3P	13.426	100	28	17.45	11	9	12	4	2	△
		TNPT04QL15			150								
NPT 3/8-18	ANSI G	TNPT06QL10	3P	16.866	100	28	17.65	14	11	14	4	2	△
		TNPT06QL15			150								
NPT 1/2-14	ANSI G	TNPT08QL15	3P	20.980	150	35	22.85	18	14	17	4	2	△
NPT 3/4-14	ANSI G	TNPT12QL15	3P	26.325	150	35	22.95	23	17	20	4	2	△
NPT 1 -11.5	ANSI G	TNPT16TL15	3P	32.934	150	45	27.4	26	21	24	5	2	△

SP-NPT

Spiral Fluted Taps for American Taper Pipe Threads

Specification

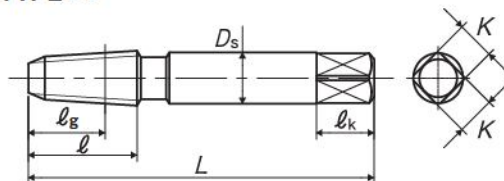


Recommended Tapping Speeds depending on Materials

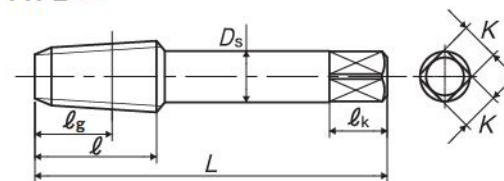
Low carbon steels
低炭素鋼
~5
(m/min)

For icon explanation, refer to P.24

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	Stock
For American Pipe Threads													
NPT 1/16-27	ANSI G	SNPT01L	2.5P	7.770	54	17	12	8	6	9	3	1	△
NPT 1/8-27	ANSI G	SNPT02L	2.5P	10.117	55	19	12.05	8	6	9	3	2	△
NPT 1/4-18	ANSI G	SNPT040	2.5P	13.426	62	28	17.45	11	9	12	3	2	△
NPT 3/8-18	ANSI G	SNPT060	2.5P	16.866	65	28	17.65	14	11	14	3	2	△
NPT 1/2-14	ANSI G	SNPT08Q	2.5P	20.980	80	35	22.85	18	14	17	4	2	△
NPT 3/4-14	ANSI G	SNPT12Q	2.5P	26.325	85	35	22.95	23	17	20	4	2	△
NPT 1 -11.5	ANSI G	SNPT16T	2.5P	32.934	95	45	27.4	26	21	24	4	2	△

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

LS-SP-S-NPT



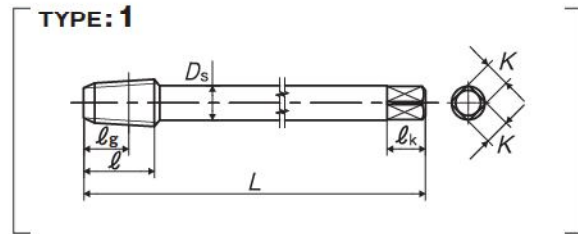
Long Shank Spiral Fluted Taps for American Taper Pipe Threads, Short (ℓg) Type Specification



Recommended Tapping Speeds depending on Materials

Low carbon steels
RED BROWN
~5
(m/min)

For icon explanation, refer to P.24



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	Stock
For American Pipe Threads													
NPT 1/8-27	ANSI G	SSNPT02LL10	2.5P	10.117	100	16.5	10.5	8	6	9	3	1	△
NPT 1/4-18	ANSI G	SSNPT04OL15	2.5P	13.426	150	19.5	12.5	11	9	12	3	1	△
NPT 3/8-18	ANSI G	SSNPT06OL15	2.5P	16.866	150	21	14	14	11	14	3	1	△
NPT 1/2-14	ANSI G	SSNPT08QL15	2.5P	20.980	150	27	17	18	14	17	4	1	△
NPT 3/4-14	ANSI G	SSNPT12QL15	2.5P	26.325	150	29	19	23	17	20	4	1	△

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

INT-NPT

Interrupted Taps for American Taper Pipe Threads

Specification

HSS

OX

Oxide



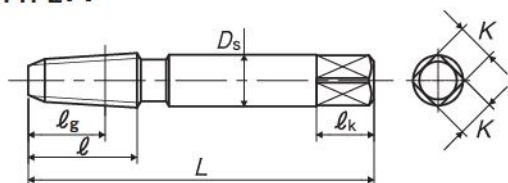
■INT-NPT having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque. INT-NPT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

Recommended Tapping Speeds depending on Materials

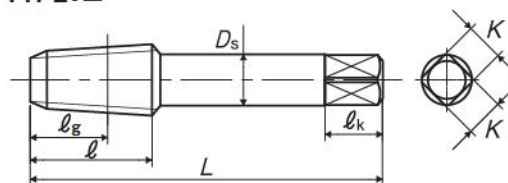
Stainless steels
ステンレス鋼
~5
(m/min)

For icon explanation, refer to P.24

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	Stock
For American Pipe Threads													
NPT 1/16-27	ANSI G	TINPT01L	3P	7.770	54	17	12	8	6	9	3	1	△
NPT 1/8-27	ANSI G	TINPT02L	3P	10.117	55	19	12.05	8	6	9	5	2	△
NPT 1/4-18	ANSI G	TINPT040	3P	13.426	62	28	17.45	11	9	12	5	2	△
NPT 3/8-18	ANSI G	TINPT060	3P	16.866	65	28	17.65	14	11	14	5	2	△
NPT 1/2-14	ANSI G	TINPT08Q	3P	20.980	80	35	22.85	18	14	17	5	2	△
NPT 3/4-14	ANSI G	TINPT12Q	3P	26.325	85	35	22.95	23	17	20	5	2	△
NPT 1-11.5	ANSI G	TINPT16T	3P	32.934	95	45	27.4	26	21	24	5	2	△
NPT 1 1/4-11.5	ANSI G	TINPT20T	3P	41.689	105	45	28.1	32	26	30	5	2	△
NPT 1 1/2-11.5	ANSI G	TINPT24T	3P	47.760	110	45	28.4	38	29	32	7	2	△
NPT 2-11.5	ANSI G	TINPT32T	3P	59.797	120	50	28	46	35	38	7	2	△

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

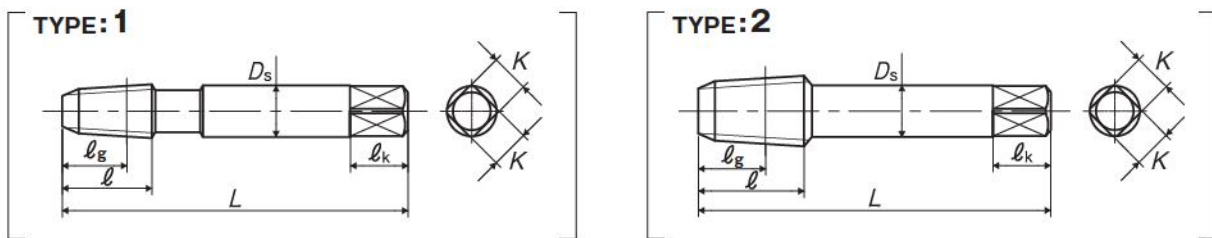


■INT-S-NPT is the tap with short thread portion, and, having low left-hand spiral flutes and having every other thread ground off, reduces cutting torque. INT-S-NPT is suitable for such sticky materials as stainless steels and chrome molybdenum steels.

Recommended Tapping Speeds depending on Materials

Stainless steels
ステンレス鋼
~5
(m/min)

For icon explanation, refer to P.24



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	Stock
For American Pipe Threads													
NPT 1/16-27	ANSI G	TISNT01L	3P	7.770	54	14	10.1	8	6	9	3	1	△
NPT 1/8-27	ANSI G	TISNT02L	3P	10.117	55	16.5	10.5	8	6	9	5	2	△
NPT 1/4-18	ANSI G	TISNT040	3P	13.426	62	19.5	12.5	11	9	12	5	2	△
NPT 3/8-18	ANSI G	TISNT060	3P	16.866	65	21	14	14	11	14	5	2	△
NPT 1/2-14	ANSI G	TISNT08Q	3P	20.980	80	27	17	18	14	17	5	2	△
NPT 3/4-14	ANSI G	TISNT12Q	3P	26.325	85	29	19	23	17	20	5	2	△
NPT 1 -11.5	ANSI G	TISNT16T	3P	32.934	95	35	22	26	21	24	5	2	△
NPT 1 1/4-11.5	ANSI G	TISNT20T	3P	41.689	105	37.5	24.5	32	26	30	5	2	△
NPT 1 1/2-11.5	ANSI G	TISNT24T	3P	47.760	110	38.5	25.5	38	29	32	7	2	△
NPT 2 -11.5	ANSI G	TISNT32T	3P	59.797	120	42.5	27.5	46	35	38	7	2	△

NPTF

Hand Taps for American Dryseal Taper Pipe Threads
Specification

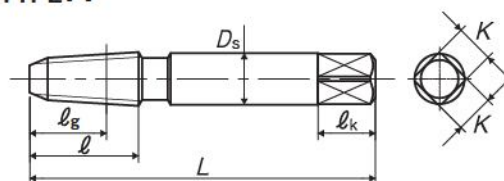


Recommended Tapping Speeds depending on Materials

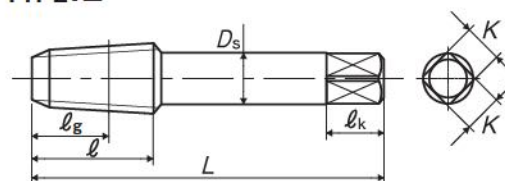


For icon explanation, refer to P.24

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	Stock
For American Pipe Threads													
NPTF 1/16-27	ANSI G	TNTF01L	3P	7.770	54	17	12	8	6	9	4	1	○
NPTF 1/8-27	ANSI G	TNTF02L	3P	10.117	55	19	12.05	8	6	9	4	2	○
NPTF 1/4-18	ANSI G	TNTF040	3P	13.426	62	28	17.45	11	9	12	4	2	○
NPTF 3/8-18	ANSI G	TNTF060	3P	16.866	65	28	17.65	14	11	14	4	2	○
NPTF 1/2-14	ANSI G	TNTF08Q	3P	20.980	80	35	22.85	18	14	17	4	2	○
NPTF 3/4-14	ANSI G	TNTF12Q	3P	26.325	85	35	22.95	23	17	20	4	2	○
NPTF 1-11.5	ANSI G	TNTF16T	3P	32.934	95	45	27.4	26	21	24	5	2	○
NPTF 1 1/4-11.5	ANSI G	TNTF20T	3P	41.689	105	45	28.1	32	26	30	5	2	△
NPTF 1 1/2-11.5	ANSI G	TNTF24T	3P	47.760	110	45	28.4	38	29	32	6	2	△
NPTF 2-11.5	ANSI G	TNTF32T	3P	59.797	120	50	28	46	35	38	6	2	△

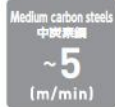
Overall length	Thread length	Position on basic dia.	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	Ds	K	ℓk

LS-NPTF

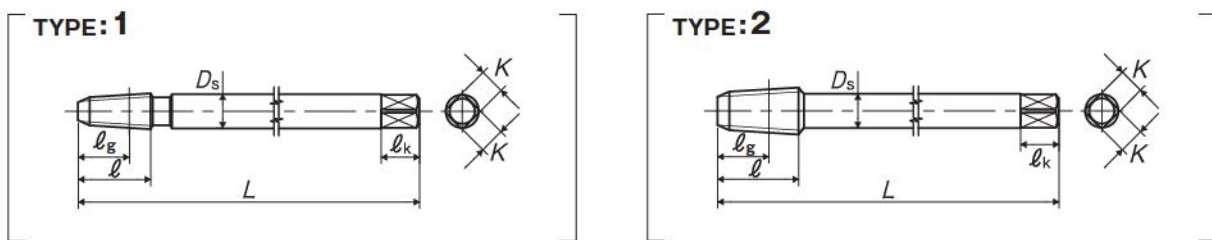
Long Shank Hand Taps for American Dryseal Taper Pipe Threads
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For American Pipe Threads													
NPTF 1/16-27	ANSI G	TNTF01LL10	3P	7.770	100	17	12	8	6	9	4	1	△
NPTF 1/8-27	ANSI G	TNTF02LL10	3P	10.117	100	19	12.05	8	6	9	4	2	△
		TNTF02LL15			150								
NPTF 1/4-18	ANSI G	TNTF04OL10	3P	13.426	100	28	17.45	11	9	12	4	2	△
		TNTF04OL15			150								
NPTF 3/8-18	ANSI G	TNTF06OL10	3P	16.866	100	28	17.65	14	11	14	4	2	△
		TNTF06OL15			150								
NPTF 1/2-14	ANSI G	TNTF08QL15	3P	20.980	150	35	22.85	18	14	17	4	2	△
NPTF 3/4-14	ANSI G	TNTF12QL15	3P	26.325	150	35	22.95	23	17	20	4	2	△
NPTF 1 -11.5	ANSI G	TNTF16TL15	3P	32.934	150	45	27.4	26	21	24	5	2	△

NPS

Hand Taps for American Parallel Pipe Threads

Specification



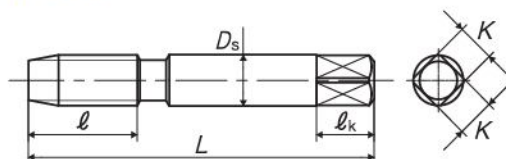
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼類
5~10
(m/min)

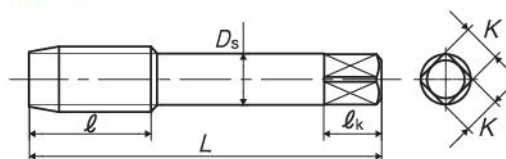
For icon explanation, refer to P.24



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	Stock
For American Pipe Threads												
NPS 1/16-27	ANSI G	TNPS01L	5P	7.770	54	17	8	6	9	4	1	△
NPS 1/8-27	ANSI G	TNPS02L	5P	10.117	55	19	8	6	9	4	2	△
NPS 1/4-18	ANSI G	TNPS040	5P	13.426	62	28	11	9	12	4	2	△
NPS 3/8-18	ANSI G	TNPS060	5P	16.866	65	28	14	11	14	4	2	△
NPS 1/2-14	ANSI G	TNPS08Q	5P	20.980	80	35	18	14	17	4	2	△
NPS 3/4-14	ANSI G	TNPS12Q	5P	26.325	85	35	23	17	20	4	2	△
NPS 1 -11.5	ANSI G	TNPS16T	5P	32.934	95	45	26	21	24	5	2	△
NPS 1 1/4-11.5	ANSI G	TNPS20T	5P	41.689	105	45	32	26	30	5	2	△
NPS 1 1/2-11.5	ANSI G	TNPS24T	5P	47.760	110	45	38	29	32	6	2	△
NPS 2 -11.5	ANSI G	TNPS32T	5P	59.797	120	50	46	35	38	6	2	△

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

NPSF

Hand Taps for American Dryseal Parallel Pipe Threads

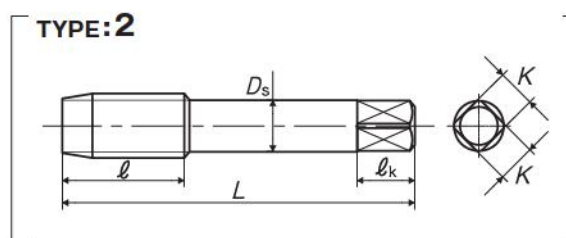
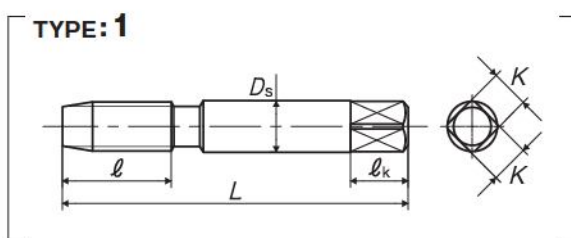
Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24



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	Stock
For American Pipe Threads												
NPSF 1/16-27	ANSI G	TNSF01L	5P	7.770	54	17	8	6	9	4	1	△
NPSF 1/8-27	ANSI G	TNSF02L	5P	10.117	55	19	8	6	9	4	2	△
NPSF 1/4-18	ANSI G	TNSF040	5P	13.426	62	28	11	9	12	4	2	△
NPSF 3/8-18	ANSI G	TNSF060	5P	16.866	65	28	14	11	14	4	2	△
NPSF 1/2-14	ANSI G	TNSF08Q	5P	20.980	80	35	18	14	17	4	2	△
NPSF 3/4-14	ANSI G	TNSF12Q	5P	26.325	85	35	23	17	20	4	2	△
NPSF 1 -11.5	ANSI G	TNSF16T	5P	32.934	95	45	26	21	24	5	2	△
NPSF 1 1/4-11.5	ANSI G	TNSF20T	5P	41.689	105	45	32	26	30	5	2	△
NPSF 1 1/2-11.5	ANSI G	TNSF24T	5P	47.760	110	45	38	29	32	6	2	△
NPSF 2 -11.5	ANSI G	TNSF32T	5P	59.797	120	50	46	35	38	6	2	△