

HAND TAP SERIES



IHT	HT-1
HT	HT-3
HT LH	HT-18
LS-HT	HT-21
LS-HT LH	HT-29
LS-HT V	HT-31
SU-HT	HT-33
FC-HT	HT-36
FC-O	HT-38

LA-HT	HT-40
LA-O	HT-42
AXE-HT	HT-45
MG-HT	HT-47
AL-HT	HT-48
PL1	HT-51
MC-HT	HT-52
EH-HT	HT-55

IHT

Hand Taps for General Purpose

Specification



Recommended Tapping Speeds depending on Materials



For icon explanation, refer to P.24

Product features

- IHT is for hand tapping and for re-threading, and is used for both through hole and blind hole.
- Use for threading of the iron (SPC or SS400) products used in our daily life.
- Surface treated. Oxidization, the most suitable surface treatment for iron products.
- Suitable for internal thread cutting in small quantity, such as tapping of test pieces.
- The 5 thread chamfer is recommended for through holes and 2 thread chamfer is recommended for blind holes.



Through hole = 5 thread type



Blind hole = 2 thread type



How to use IHT

- Start tapping after boring holes corresponding to the thread size by using drills (note: For drill sizes, refer to drill sizes shown in the bored hole size table.)
- On Hand Tapping, operate tapping in an upright position parallel to bored holes by using tap wrenches.
- During tapping, please use tapping oil.



When hand tapping, always use tap wrench



Machine tapping with drilling machine

Table for bored and drilled hole sizes

unit: mm

Size	Minor diameter of internal thread size			Drill size	Thread engagement
	Minimum tolerance	Maximum tolerance			
		6H (2nd class)	7H (3rd class)		
M3 × 0.5	2.459	2.599	2.639	2.6 (2.5)	74% (92%)
M4 × 0.7	3.242	3.422	3.466	3.4 (3.3)	79% (92%)
M5 × 0.8	4.134	4.344	4.384	4.3 (4.2)	81% (92%)
M6 × 1	4.917	5.153	5.217	5.1 (5.0)	83% (92%)
M8 × 1.25	6.647	6.912	6.982	6.9 (6.8)	91% (89%)
M10 × 1.5	8.376	8.676	8.751	8.6 (8.5)	86% (92%)

note1) Recommended drill sizes shown in this table are for internal threads of 7H class (3rd class), and are selected from the standard drills available in the market.

note2) Drill sizes shown in brackets in this table are for such case as the drilling has oversize cutting tendency or for internal threads of 6H class (2nd class).

[Related products]

Shank adjuster

- For deep hole tapings, please use shank adjusters.
- There is only a one touch motion required to detach and attach the I series taps (IHT/ISP/IPO) from or to the shank adjuster.

*For details of shank adjuster, refer to P.296

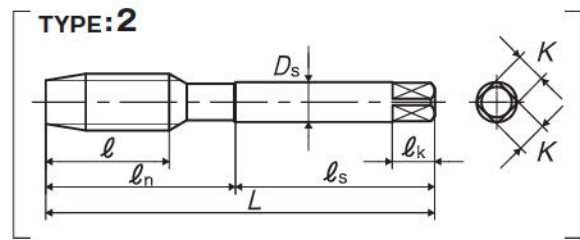
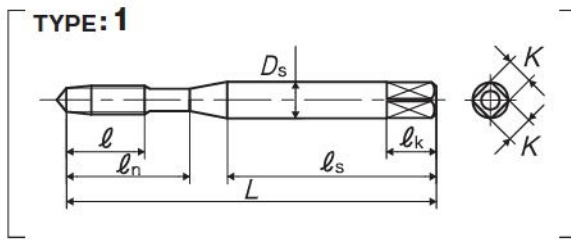


Blister Pack



Obtainable from
Video site shown in right

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



Segment : 1A

Size	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads												
M3 × 0.5	HI73.0G5	5P	46	9	14	26	4	3.2	6	3	1	○
	HI73.0G2	2P										
M4 × 0.7	HI74.0I5	5P	52	11	17	29	5	4	7	3	1	○
	HI74.0I2	2P										
M5 × 0.8	HI75.0K5	5P	60	13	22	33	5.5	4.5	7	3	1	○
	HI75.0K2	2P										
M6 × 1	HI76.0M5	5P	62	15	26	33	6	4.5	7	3	1	○
	HI76.0M2	2P										
M8 × 1.25	HI78.0N5	5P	70	19	-	36	6.2	5	8	3	2	○
	HI78.0N2	2P										
M10 × 1.5	HI701005	5P	75	23	-	38	7	5.5	8	3	2	○
	HI701002	2P										

Blister Pack

Size	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads												
M3 × 0.5	HI73.0G5BP	5P	46	9	14	26	4	3.2	6	3	1	○
	HI73.0G2BP	2P										
M4 × 0.7	HI74.0I5BP	5P	52	11	17	29	5	4	7	3	1	○
	HI74.0I2BP	2P										
M5 × 0.8	HI75.0K5BP	5P	60	13	22	33	5.5	4.5	7	3	1	○
	HI75.0K2BP	2P										
M6 × 1	HI76.0M5BP	5P	62	15	26	33	6	4.5	7	3	1	○
	HI76.0M2BP	2P										
M8 × 1.25	HI78.0N5BP	5P	70	19	-	36	6.2	5	8	3	2	○
	HI78.0N2BP	2P										
M10 × 1.5	HI701005BP	5P	75	23	-	38	7	5.5	8	3	2	○
	HI701002BP	2P										

HT

Hand Taps Specification

HSS



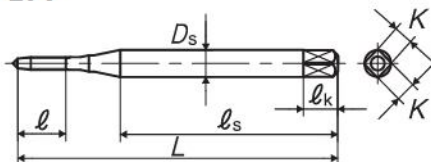
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

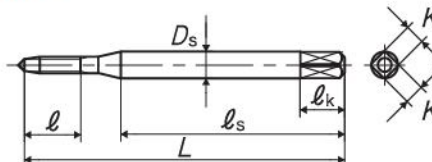
For icon explanation, refer to P.24



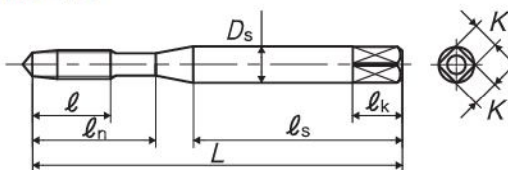
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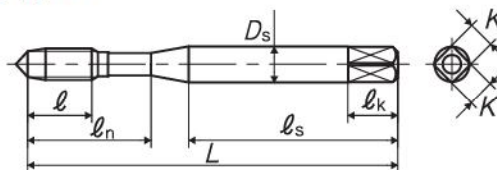
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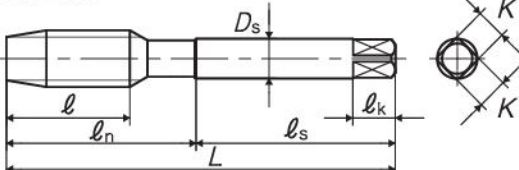
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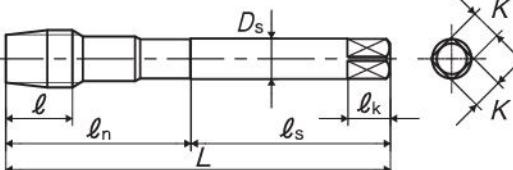
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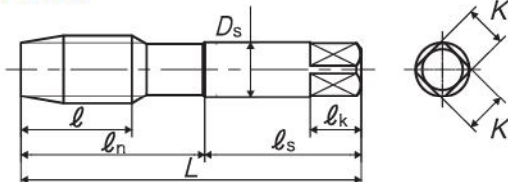
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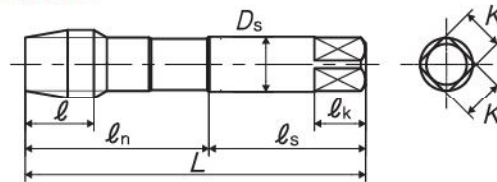
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TYPE:7



TYPE:8



HT Hand Taps

Oversize
Segment : 1A

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Metric Threads													
M1 × 0.25	P1	TNMP1.0B5	5P	36	4.5	-	24	3	2.5	5	3	1	○
		TNMP1.0B1	1.5P										
M1 × 0.2	P1	TNMP1.0A5	5P	36	3.6	-	24	3	2.5	5	3	1	△
		TNMP1.0A1	1.5P										
M1.1 × 0.25	P1	TNMP1.1B5	5P	36	4.5	-	24	3	2.5	5	3	1	○
		TNMP1.1B1	1.5P										
M1.1 × 0.2	P1	TNMP1.1A5	5P	36	3.6	-	24	3	2.5	5	3	1	△
		TNMP1.1A1	1.5P										
M1.2 × 0.25	P1	TNMP1.2B5	5P	36	4.5	-	24	3	2.5	5	3	1	○
		TNMP1.2B1	1.5P										
	P3	TNMR1.2B5	5P										△
		TNMR1.2B1	1.5P										
M1.2 × 0.2	P1	TNMP1.2A5	5P	36	3.6	-	24	3	2.5	5	3	1	△
		TNMP1.2A1	1.5P										
M1.4 × 0.3	P1	TNMP1.4C5	5P	36	5.4	-	24	3	2.5	5	3	1	◎
		TNMP1.4C1	1.5P										
	P3	TNMR1.4C5	5P										△
		TNMR1.4C1	1.5P										
M1.4 × 0.2	P1	TNMP1.4A5	5P	36	3.6	-	24	3	2.5	5	3	1	△
		TNMP1.4A1	1.5P										
M1.6 × 0.35	P2	TNMQ1.6D5	5P	36	6.3	-	24	3	2.5	5	3	2	◎
		TNMQ1.6D1	1.5P										
M1.6 × 0.2	P1	TNMP1.6A5	5P	36	3.6	-	24	3	2.5	5	3	2	△
		TNMP1.6A1	1.5P										
M1.7 × 0.35	P1	TNMP1.7D5	5P	36	6.3	-	24	3	2.5	5	3	2	◎
		TNMP1.7D1	1.5P										
	P3	TNMR1.7D5	5P										△
		TNMR1.7D1	1.5P										
M1.7 × 0.2	P1	TNMP1.7A5	5P	36	3.6	-	24	3	2.5	5	3	2	△
		TNMP1.7A1	1.5P										
M1.8 × 0.35	P2	TNMQ1.8D5	5P	42	6.3	-	27	3	2.5	5	3	2	△
		TNMQ1.8D1	1.5P										
M1.8 × 0.2	P1	TNMP1.8A5	5P	42	3.6	-	27	3	2.5	5	3	2	△
		TNMP1.8A1	1.5P										
M2 × 0.4	P1	TNMP2.0E5	5P	42	7.2	12	27	3	2.5	5	3	3	◎
		TNMP2.0E1	1.5P										
	P3	TNMR2.0E5	5P										○
		TNMR2.0E1	1.5P										
	P4	TNMS2.0E5	5P										△
		TNMS2.0E1	1.5P										
M2 × 0.25	P1	TNMP2.0B5	5P	42	4.5	12	27	3	2.5	5	3	4	○
		TNMP2.0B1	1.5P										
M2.2 × 0.45	P2	TNMQ2.2F5	5P	42	8.1	12	27	3	2.5	5	3	3	○
		TNMQ2.2F1	1.5P										
M2.2 × 0.25	P1	TNMP2.2B5	5P	42	4.5	12	27	3	2.5	5	3	4	△
		TNMP2.2B1	1.5P										
M2.3 × 0.4	P1	TNMP2.3E5	5P	42	7.2	12	27	3	2.5	5	3	3	○
		TNMP2.3E1	1.5P										

Hand Tap Series

HT Hand Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M2.3 × 0.4	P3	TNMR2.3E5	5P	42	7.2	12	27	3	2.5	5	3	3	△
			TNMR2.3E1	1.5P										
		P4	TNMS2.3E5	5P										
			TNMS2.3E1	1.5P										
Spiral Fluted Taps (for through hole)	M2.3 × 0.25	P1	TNMP2.3B5	5P	42	4.5	12	27	3	2.5	5	3	4	△
			TNMP2.3B1	1.5P										
Spiral Pointed Taps (for through hole)	M2.5 × 0.45	P2	TNMQ2.5F5	5P	46	8.1	14	29	3	2.5	5	3	3	◎
			TNMQ2.5F1	1.5P										
		P3	TNMR2.5F5	5P										○
			TNMR2.5F1	1.5P										
		P4	TNMS2.5F5	5P										△
			TNMS2.5F1	1.5P										
Cemented Carbide Taps	M2.5 × 0.35	P2	TNMQ2.5D5	5P	46	6.3	14	29	3	2.5	5	3	4	△
			TNMQ2.5D1	1.5P										
	M2.6 × 0.45	P1	TNMP2.6F5	5P	46	8.1	14	29	3	2.5	5	3	3	◎
			TNMP2.6F1	1.5P										
		P3	TNMR2.6F5	5P										○
			TNMR2.6F1	1.5P										
		P4	TNMS2.6F5	5P										△
			TNMS2.6F1	1.5P										
Roll Taps	M2.6 × 0.35	P2	TNMQ2.6D5	5P	46	6.3	14	29	3	2.5	5	3	4	△
			TNMQ2.6D1	1.5P										
Special Thread Taps Simple Inspection Tools	M3 × 0.5	P2	TNMQ3.0G5	5P	46	9	14	26	4	3.2	6	3	3	◎
			TNMQ3.0G1	1.5P										
		P3	TNMR3.0G5	5P										○
			TNMR3.0G1	1.5P										
		P4	TNMS3.0G5	5P										△
			TNMS3.0G1	1.5P										
		P5	TNMT3.0G5	5P										△
			TNMT3.0G1	1.5P										
Pipe Taps	3M0.6	P2	TNMQ3.0H5	5P	46	9	14	26	4	3.2	6	3	3	○
			TNMQ3.0H1	1.5P										
Thread Mills	M3 × 0.35	P2	TNMQ3.0D5	5P	46	6.5	14	26	4	3.2	6	3	4	○
			TNMQ3.0D1	1.5P										
Dies	M3.5 × 0.6	P2	TNMQ3.5H5	5P	52	11	16	29	5	4	7	3	3	○
			TNMQ3.5H1	1.5P										
		P3	TNMR3.5H5	5P										△
			TNMR3.5H1	1.5P										
		P4	TNMS3.5H5	5P										△
			TNMS3.5H1	1.5P										
	M3.5 × 0.35	P2	TNMQ3.5D5	5P	52	6.5	16	29	5	4	7	3	4	○
			TNMQ3.5D1	1.5P										
Center Drills	M4 × 0.7	P2	TNMQ4.0I5	5P	52	11	17	29	5	4	7	3	3	◎
			TNMQ4.0I1	1.5P										
		P3	TNMR4.0I53	5P										○
			TNMR4.0I13	1.5P										
		P4	TNMS4.0I53	5P										△
			TNMS4.0I13	1.5P										
Centering Tools		P5	TNMT4.0I53	5P										△
			TNMT4.0I13	1.5P										

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

HT Hand Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock												
M4 × 0.7	P5	TNMT4.0I5 TNMT4.0I1	5P 1.5P	52	11	17	29	5	4	7	4	3	△												
4M0.75	P2	TNMQ4.0J53 TNMQ4.0J13 TNMQ4.0J5 TNMQ4.0J1	5P 1.5P 5P 1.5P	52	11	17	29	5	4	7	3 4	3	△ ○												
M4 × 0.5	P2	TNMQ4.0G5 TNMQ4.0G1	5P 1.5P	52	9	17	29	5	4	7	4	4	○												
M4.5 × 0.75	P2	TNMQ4.5J5 TNMQ4.5J1	5P 1.5P	60	13	21	33	5.5	4.5	7	4	3	○												
M4.5 × 0.5	P2	TNMQ4.5G5 TNMQ4.5G1	5P 1.5P	60	9	21	33	5.5	4.5	7	4	4	△												
M5 × 0.8	P3	TNMR5.0K5 TNMR5.0K1	5P 1.5P	60	13	22	33	5.5	4.5	7	3	3	◎												
	P4	TNMS5.0K53 TNMS5.0K13 TNMS5.0K5 TNMS5.0K1	5P 1.5P 5P 1.5P								4		3	△											
	P5	TNMT5.0K53 TNMT5.0K13 TNMT5.0K5 TNMT5.0K1	5P 1.5P 5P 1.5P								4		3	△											
5M0.9	P2	TNMQ5.0L53 TNMQ5.0L13 TNMQ5.0L5 TNMQ5.0L1	5P 1.5P 5P 1.5P	60	13	22	33	5.5	4.5	7	3 4	3	△ ○												
M5 × 0.75	P2	TNMQ5.0J5 TNMQ5.0J1	5P 1.5P	60	13	22	33	5.5	4.5	7	4	3	△												
M5 × 0.5	P2	TNMQ5.0G5 TNMQ5.0G1	5P 1.5P	60	9	22	33	5.5	4.5	7	4	4	○												
	P3	TNMR5.0G5 TNMR5.0G1	5P 1.5P										△												
M5.5 × 0.9	P2	TNMQ5.5L5 TNMQ5.5L1	5P 1.5P	62	15	26	33	6	4.5	7	4	3	△												
M5.5 × 0.75	P2	TNMQ5.5J5 TNMQ5.5J1	5P 1.5P	62	15	26	33	6	4.5	7	4	3	△												
M5.5 × 0.5	P2	TNMQ5.5G5 TNMQ5.5G1	5P 1.5P	62	9	26	33	6	4.5	7	4	4	△												
M6 × 1	P2	TNMQ6.0M5 TNMQ6.0M1	5P 1.5P	62	15	26	33	6	4.5	7	3	3	◎												
	P3	TNMR6.0M53 TNMR6.0M13	5P 1.5P										19	28					4	○					
	P4	TNMS6.0M53 TNMS6.0M13 TNMS6.0M5 TNMS6.0M1	5P 1.5P 5P 1.5P		15	26					3										△				
	P5	TNMT6.0M53 TNMT6.0M13 TNMT6.0M5 TNMT6.0M1	5P 1.5P 5P 1.5P		15	26					3		△												

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

Hand Tap Series

HT Hand Taps

Hand Taps	Spiral Pointed Taps (for through hole)			Spiral Fluted Taps (for through hole)			Spiral Fluted Taps (for blind hole)									
	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock		
Cemented Carbide Taps	M6 × 0.75	P2	TNMQ6.0J5	5P	62	15	26	33	6	4.5	7	4	3	○		
			TNMQ6.0J1	1.5P												
		P3	TNMR6.0J5	5P												
			TNMR6.0J1	1.5P										△		
		P4	TNMS6.0J5	5P												
			TNMS6.0J1	1.5P												
	M6 × 0.5	P2	TNMQ6.0G5	5P	62	9	26	33	6	4.5	7	4	4	○		
			TNMQ6.0G1	1.5P												
	M7 × 1	P2	TNMQ7.0M5	5P	70	19	-	36	6.2	5	8	4	5	○		
			TNMQ7.0M1	1.5P												
		P4	TNMS7.0M5	5P												
			TNMS7.0M1	1.5P										△		
	M7 × 0.75	P2	TNMQ7.0J5	5P	70	19	-	36	6.2	5	8	4	5	○		
			TNMQ7.0J1	1.5P												
	M7 × 0.5	P2	TNMQ7.0G5	5P	70	10	-	36	6.2	5	8	4	6	△		
			TNMQ7.0G1	1.5P												
	Roll Taps	M8 × 1.25	P3	TNMR8.0N5	5P	70	19	-	36	6.2	5	8	3	5	◎	
				TNMR8.0N1	1.5P											
				TNMR8.0N5F	5P								4			
				TNMR8.0N1F	1.5P											
			P4	TNMS8.0N5F	5P									○		
				TNMS8.0N1F	1.5P											
	Special Thread Taps Simple Inspection Tools	M8 × 1	P2	TNMQ8.0M5	5P	70	19	-	36	6.2	5	8	4	5	○	
				TNMQ8.0M1	1.5P											
P4			TNMS8.0M5	5P	△											
			TNMS8.0M1	1.5P												
Pipe Taps	M8 × 0.75	P2	TNMQ8.0J5	5P	70	19	-	36	6.2	5	8	4	5	○		
			TNMQ8.0J1	1.5P												
Thread Mills	M8 × 0.5	P2	TNMQ8.0G5	5P	70	10	-	36	6.2	5	8	4	6	○		
			TNMQ8.0G1	1.5P												
Dies	M9 × 1.25	P3	TNMR9.0N5	5P	75	23	-	38	7	5.5	8	4	5	△		
			TNMR9.0N1	1.5P												
Center Drills	M9 × 1	P2	TNMQ9.0M5	5P	75	23	-	38	7	5.5	8	4	5	○		
			TNMQ9.0M1	1.5P												
Centering Tools	M9 × 0.75	P2	TNMQ9.0J5	5P	75	13	-	38	7	5.5	8	4	6	○		
			TNMQ9.0J1	1.5P												
	M9 × 0.5	P2	TNMQ9.0G5	5P	75	11	-	38	7	5.5	8	4	6	△		
			TNMQ9.0G1	1.5P												
	M10 × 1.5	P3	TNMR01005T	5P	75	23	-	38	7	5.5	8	3	5	○		
			TNMR01001T	1.5P												
			TNMR01005	5P								4		◎		
			TNMR01001	1.5P												
		P4	TNMS01005	5P									△			
			TNMS01001	1.5P												
	M10 × 1.25	P3	TNMR010N5	5P	75	23	-	38	7	5.5	8	4	5	◎		
			TNMR010N1	1.5P												
		P4	TNMS010N5	5P										△		
			TNMS010N1	1.5P												
	M10 × 1	P3	TNMR010M5	5P	75	23	-	38	7	5.5	8	4	5	◎		
			TNMR010M1	1.5P												

HT Hand Taps

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M10 × 1	P4	TNMS010M5	5P	75	23	-	38	7	5.5	8	4	5	△
		TNMS010M1	1.5P										
M10 × 0.75	P3	TNMR010J5	5P	75	13	-	38	7	5.5	8	4	6	○
		TNMR010J1	1.5P										
M10 × 0.5	P2	TNMQ010G5	5P	75	11	-	38	7	5.5	8	4	6	○
		TNMQ010G1	1.5P										
M11 × 1.5	P4	TNMS011O5	5P	82	26	-	42	8.5	6.5	9	4	5	△
		TNMS011O1	1.5P										
M11 × 1.25	P3	TNMR011N5	5P	82	26	-	42	8.5	6.5	9	4	5	△
		TNMR011N1	1.5P										
M11 × 1	P3	TNMR011M5	5P	82	26	-	42	8.5	6.5	9	4	5	○
		TNMR011M1	1.5P										
M11 × 0.75	P3	TNMR011J5	5P	82	14	-	42	8.5	6.5	9	4	6	△
		TNMR011J1	1.5P										
M11 × 0.5	P2	TNMQ011G5	5P	82	12	-	42	8.5	6.5	9	4	6	△
		TNMQ011G1	1.5P										
M12 × 1.75	P3	TNMR012P5	5P	82	26	-	42	8.5	6.5	9	4	5	◎
		TNMR012P1	1.5P										
	P4	TNMS012P5	5P										△
		TNMS012P1	1.5P										
M12 × 1.5	P3	TNMR012O5	5P	82	26	-	42	8.5	6.5	9	4	5	◎
		TNMR012O1	1.5P										
	P4	TNMS012O5	5P										△
		TNMS012O1	1.5P										
M12 × 1.25	P4	TNMS012N5	5P	82	26	-	42	8.5	6.5	9	4	5	◎
		TNMS012N1	1.5P										
M12 × 1	P3	TNMR012M5	5P	82	26	-	42	8.5	6.5	9	4	5	◎
		TNMR012M1	1.5P										
M12 × 0.75	P3	TNMR012J5	5P	82	14	-	42	8.5	6.5	9	4	6	△
		TNMR012J1	1.5P										
M12 × 0.5	P2	TNMQ012G5	5P	82	12	-	42	8.5	6.5	9	4	6	○
		TNMQ012G1	1.5P										
M13 × 1.75	P3	TNMR013P5	5P	88	26	-	45	10.5	8	11	4	5	△
		TNMR013P1	1.5P										
M13 × 1.5	P3	TNMR013O5	5P	88	26	-	45	10.5	8	11	4	5	△
		TNMR013O1	1.5P										
M13 × 1.25	P4	TNMS013N5	5P	88	26	-	45	10.5	8	11	4	5	△
		TNMS013N1	1.5P										
M13 × 1	P3	TNMR013M5	5P	88	26	-	45	10.5	8	11	4	5	○
		TNMR013M1	1.5P										
M13 × 0.75	P3	TNMR013J5	5P	88	14	-	45	10.5	8	11	4	6	△
		TNMR013J1	1.5P										
M13 × 0.5	P2	TNMQ013G5	5P	88	12	-	45	10.5	8	11	4	6	△
		TNMQ013G1	1.5P										
M14 × 2	P3	TNMR014Q5	5P	88	26	-	45	10.5	8	11	4	5	◎
		TNMR014Q1	1.5P										
	P4	TNMS014Q5	5P										△
		TNMS014Q1	1.5P										
M14 × 1.5	P3	TNMR014O5	5P	88	26	-	45	10.5	8	11	4	5	◎
		TNMR014O1	1.5P										

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

Hand Tap Series

HT Hand Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M14 × 1.5	P4	TNMS01405	5P	88	26	-	45	10.5	8	11	4	5	△
			TNMS01401	1.5P										
Spiral Fluted Taps (for through hole)	M14 × 1.25	P4	TNMS014N5	5P	88	26	-	45	10.5	8	11	4	5	○
			TNMS014N1	1.5P										
Spiral Fluted Taps (for through hole)	M14 × 1	P3	TNMR014M5	5P	88	26	-	45	10.5	8	11	4	5	○
			TNMR014M1	1.5P										
		P4	TNMS014M5	5P										△
			TNMS014M1	1.5P										
Spiral Pointed Taps (for through hole)	M14 × 0.75	P3	TNMR014J5	5P	88	15	-	45	10.5	8	11	4	6	△
			TNMR014J1	1.5P										
Spiral Pointed Taps (for through hole)	M14 × 0.5	P2	TNMQ014G5	5P	88	12	-	45	10.5	8	11	4	6	○
			TNMQ014G1	1.5P										
Cemented Carbide Taps	M15 × 2	P3	TNMR015Q5	5P	95	26	-	48	12.5	10	13	4	5	△
			TNMR015Q1	1.5P										
Cemented Carbide Taps	M15 × 1.5	P3	TNMR015O5	5P	95	26	-	48	12.5	10	13	4	5	○
			TNMR015O1	1.5P										
Cemented Carbide Taps	M15 × 1.25	P4	TNMS015N5	5P	95	26	-	48	12.5	10	13	4	5	△
			TNMS015N1	1.5P										
Cemented Carbide Taps	M15 × 1	P3	TNMR015M5	5P	95	26	-	48	12.5	10	13	4	5	○
			TNMR015M1	1.5P										
Roll Taps	M15 × 0.75	P3	TNMR015J5	5P	95	15	-	48	12.5	10	13	4	6	△
			TNMR015J1	1.5P										
Roll Taps	M15 × 0.5	P2	TNMQ015G5	5P	95	13	-	48	12.5	10	13	4	6	△
			TNMQ015G1	1.5P										
Special Thread Taps Simple Inspection Tools	M16 × 2	P3	TNMR016Q5	5P	95	26	-	48	12.5	10	13	4	5	◎
			TNMR016Q1	1.5P										
		P4	TNMS016Q5	5P										△
			TNMS016Q1	1.5P										
Pipe Taps	M16 × 1.5	P3	TNMR016O5	5P	95	26	-	48	12.5	10	13	4	5	◎
			TNMR016O1	1.5P										
		P4	TNMS016O5	5P										△
			TNMS016O1	1.5P										
Thread Mills	M16 × 1.25	P4	TNMS016N5	5P	95	26	-	48	12.5	10	13	4	5	△
			TNMS016N1	1.5P										
Dies	M16 × 1	P3	TNMR016M5	5P	95	26	-	48	12.5	10	13	4	5	○
			TNMR016M1	1.5P										
		P4	TNMS016M5	5P										△
			TNMS016M1	1.5P										
Dies	M16 × 0.5	P2	TNMQ016G5	5P	95	13	-	48	12.5	10	13	4	6	△
			TNMQ016G1	1.5P										
Center Drills	M17 × 1.5	P4	TNMS017O5	5P	100	33	-	51	14	11	14	4	5	△
			TNMS017O1	1.5P										
Center Drills	M17 × 1	P3	TNMR017M5	5P	100	18	-	51	14	11	14	4	6	○
			TNMR017M1	1.5P										
Centering Tools	M18 × 2.5	P4	TNMS018R5	5P	100	33	-	51	14	11	14	4	5	○
			TNMS018R1	1.5P										
		P5	TNMT018R5	5P										△
			TNMT018R1	1.5P										
Centering Tools	M18 × 2	P4	TNMS018Q5	5P	100	33	-	51	14	11	14	4	5	○
			TNMS018Q1	1.5P										

HT-9

160

Think threads with
YAMAWA

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

HT Hand Taps

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M18 × 1.5	P3	TNMR01805	5P	100	33	-	51	14	11	14	4	5	⊙
		TNMR01801	1.5P										
	P4	TNMS01805	5P										△
		TNMS01801	1.5P										
M18 × 1	P3	TNMR018M5	5P	100	18	-	51	14	11	14	4	6	○
		TNMR018M1	1.5P										
M18 × 0.5	P2	TNMQ018G5	5P	100	13	-	51	14	11	14	4	6	△
		TNMQ018G1	1.5P										
M19 × 1.5	P3	TNMR01905	5P	105	33	-	50	15	12	15	4	7	△
		TNMR01901	1.5P										
M19 × 1	P3	TNMR019M5	5P	105	18	-	50	15	12	15	4	8	△
		TNMR019M1	1.5P										
M20 × 2.5	P4	TNMS020R5	5P	105	33	-	50	15	12	15	4	7	⊙
		TNMS020R1	1.5P										
	P5	TNMT020R5	5P										△
		TNMT020R1	1.5P										
M20 × 2	P4	TNMS020Q5	5P	105	33	-	50	15	12	15	4	7	○
		TNMS020Q1	1.5P										
M20 × 1.5	P3	TNMR02005	5P	105	33	-	50	15	12	15	4	7	⊙
		TNMR02001	1.5P										
	P4	TNMS02005	5P										△
		TNMS02001	1.5P										
M20 × 1	P3	TNMR020M5	5P	105	18	-	50	15	12	15	4	8	○
		TNMR020M1	1.5P										
M22 × 2.5	P4	TNMS022R5	5P	115	33	-	55	17	13	16	4	7	○
		TNMS022R1	1.5P										
M22 × 2	P4	TNMS022Q5	5P	115	33	-	55	17	13	16	4	7	○
		TNMS022Q1	1.5P										
M22 × 1.5	P3	TNMR02205	5P	115	33	-	55	17	13	16	4	7	⊙
		TNMR02201	1.5P										
M22 × 1	P3	TNMR022M5	5P	115	19	-	55	17	13	16	4	8	○
		TNMR022M1	1.5P										
M24 × 3	P4	TNMS024S5	5P	120	39	-	55	19	15	18	4	7	⊙
		TNMS024S1	1.5P										
M24 × 2	P4	TNMS024Q5	5P	120	39	-	55	19	15	18	4	7	○
		TNMS024Q1	1.5P										
M24 × 1.5	P3	TNMR02405	5P	120	39	-	55	19	15	18	4	7	⊙
		TNMR02401	1.5P										
M24 × 1	P3	TNMR024M5	5P	120	19	-	55	19	15	18	4	8	○
		TNMR024M1	1.5P										
M25 × 3	P4	TNMS025S5	5P	125	39	-	58	19	15	18	4	7	△
		TNMS025S1	1.5P										
M25 × 2	P4	TNMS025Q5	5P	125	39	-	58	19	15	18	4	7	○
		TNMS025Q1	1.5P										
M25 × 1.5	P3	TNMR02505	5P	125	39	-	58	19	15	18	4	7	○
		TNMR02501	1.5P										
M25 × 1	P3	TNMR025M5	5P	125	20	-	58	19	15	18	4	8	○
		TNMR025M1	1.5P										
M26 × 3	P4	TNMS026S5	5P	130	39	-	60	20	15	18	4	7	△
		TNMS026S1	1.5P										

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

Hand Tap Series

HT Hand Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M26 × 2	P4	TNMS026Q5	5P	130	39	-	60	20	15	18	4	7	△
			TNMS026Q1	1.5P										
Spiral Fluted Taps (for through hole)	M26 × 1.5	P3	TNMR026O5	5P	130	39	-	60	20	15	18	4	7	○
			TNMR026O1	1.5P										
Spiral Pointed Taps (for through hole)	M27 × 3	P4	TNMS027S5	5P	130	39	-	60	20	15	18	4	7	○
			TNMS027S1	1.5P										
Hand Taps	M27 × 2	P5	TNMT027Q5	5P	130	39	-	60	20	15	18	4	7	○
			TNMT027Q1	1.5P										
Cemented Carbide Taps	M27 × 1.5	P3	TNMR027O5	5P	130	39	-	60	20	15	18	4	7	○
			TNMR027O1	1.5P										
Roll Taps	M27 × 1	P3	TNMR027M5	5P	130	20	-	60	20	15	18	4	8	○
			TNMR027M1	1.5P										
Special Thread Taps Simple Inspection Tools	M28 × 3	P4	TNMS028S5	5P	135	46	-	62	23	17	20	4	7	△
			TNMS028S1	1.5P										
Pipe Taps	M28 × 2	P4	TNMS028Q5	5P	135	46	-	62	23	17	20	4	7	○
			TNMS028Q1	1.5P										
Thread Mills	M28 × 1.5	P3	TNMR028O5	5P	135	46	-	62	23	17	20	4	7	○
			TNMR028O1	1.5P										
Dies	M28 × 1	P3	TNMR028M5	5P	135	20	-	62	23	17	20	4	8	○
			TNMR028M1	1.5P										
Center Drills	M30 × 3.5	P4	TNMS030T5	5P	135	46	-	62	23	17	20	4	7	◎
			TNMS030T1	1.5P										
Centering Tools	M30 × 3	P5	TNMT030S5	5P	135	46	-	62	23	17	20	4	7	○
			TNMT030S1	1.5P										
	M30 × 2	P4	TNMS030Q5	5P	135	46	-	62	23	17	20	4	7	◎
			TNMS030Q1	1.5P										
	M30 × 1.5	P3	TNMR030O5	5P	135	46	-	62	23	17	20	4	7	◎
			TNMR030O1	1.5P										
	M30 × 1	P3	TNMR030M5	5P	135	21	-	62	23	17	20	4	8	○
			TNMR030M1	1.5P										
	M32 × 2	P4	TNMS032Q5	5P	145	46	-	67	24	19	22	4	7	△
			TNMS032Q1	1.5P										
	M32 × 1.5	P4	TNMS032O5	5P	145	46	-	67	24	19	22	4	7	△
			TNMS032O1	1.5P										
	M32 × 1	P3	TNMR032M5	5P	145	21	-	67	24	19	22	4	8	△
			TNMR032M1	1.5P										
	M33 × 3.5	P4	TNMS033T5	5P	145	46	-	67	25	19	22	4	7	○
			TNMS033T1	1.5P										
	M33 × 3	P5	TNMT033S5	5P	145	46	-	67	25	19	22	4	7	△
			TNMT033S1	1.5P										
	M33 × 2	P4	TNMS033Q5	5P	145	46	-	67	25	19	22	4	7	△
			TNMS033Q1	1.5P										
	M33 × 1.5	P4	TNMS033O5	5P	145	46	-	67	25	19	22	4	7	△
			TNMS033O1	1.5P										
	M33 × 1	P3	TNMR033M5	5P	145	21	-	67	25	19	22	4	8	△
			TNMR033M1	1.5P										
	M34 × 2	P4	TNMS034Q5	5P	155	52	-	71	28	21	24	4	7	△
			TNMS034Q1	1.5P										
	M34 × 1.5	P4	TNMS034O5	5P	155	26	-	71	28	21	24	4	8	△
			TNMS034O1	1.5P										

HT Hand Taps

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M34 × 1	P3	TNMR034M5	5P	155	26	-	71	28	21	24	4	8	△
		TNMR034M1	1.5P										
M35 × 2	P5	TNMT035Q5	5P	155	52	-	71	28	21	24	4	7	△
		TNMT035Q1	1.5P										
M35 × 1.5	P4	TNMS035O5	5P	155	26	-	71	28	21	24	4	8	△
		TNMS035O1	1.5P										
M36 × 4	P5	TNMT036U5	5P	155	52	-	71	28	21	24	4	7	◎
		TNMT036U1	1.5P										
M36 × 3	P5	TNMT036S5	5P	155	52	-	71	28	21	24	4	7	△
		TNMT036S1	1.5P										
M36 × 2	P4	TNMS036Q5	5P	155	52	-	71	28	21	24	4	7	△
		TNMS036Q1	1.5P										
M36 × 1.5	P4	TNMS036O5	5P	155	26	-	71	28	21	24	4	8	△
		TNMS036O1	1.5P										
M36 × 1	P3	TNMR036M5	5P	155	26	-	71	28	21	24	4	8	△
		TNMR036M1	1.5P										
M37 × 1.5	P4	TNMS037O5	5P	165	26	-	76	30	23	26	4	8	△
		TNMS037O1	1.5P										
M38 × 2	P4	TNMS038Q5	5P	165	52	-	76	30	23	26	4	7	△
		TNMS038Q1	1.5P										
M38 × 1.5	P4	TNMS038O5	5P	165	26	-	76	30	23	26	4	8	△
		TNMS038O1	1.5P										
M38 × 1	P3	TNMR038M5	5P	165	26	-	76	30	23	26	4	8	△
		TNMR038M1	1.5P										
M39 × 4	P5	TNMT039U5	5P	165	52	-	76	30	23	26	4	7	○
		TNMT039U1	1.5P										
M39 × 3	P5	TNMT039S5	5P	165	52	-	76	30	23	26	4	7	△
		TNMT039S1	1.5P										
M39 × 2	P5	TNMT039Q5	5P	165	52	-	76	30	23	26	4	7	△
		TNMT039Q1	1.5P										
M39 × 1.5	P4	TNMS039O5	5P	165	26	-	76	30	23	26	4	8	△
		TNMS039O1	1.5P										
M39 × 1	P3	TNMR039M5	5P	165	26	-	76	30	23	26	4	8	△
		TNMR039M1	1.5P										
M40 × 4	P5	TNMT040U5	5P	175	59	-	81	32	26	30	4	7	△
		TNMT040U1	1.5P										
M40 × 3	P5	TNMT040S5	5P	175	59	-	81	32	26	30	4	7	△
		TNMT040S1	1.5P										
M40 × 2	P4	TNMS040Q5	5P	175	59	-	81	32	26	30	4	7	△
		TNMS040Q1	1.5P										
M40 × 1.5	P4	TNMS040O5	5P	175	27	-	81	32	26	30	4	8	△
		TNMS040O1	1.5P										
M42 × 4.5	P5	TNMT042V5	5P	175	59	-	81	32	26	30	4	7	○
		TNMT042V1	1.5P										
M42 × 4	P6	TNMT042U5	5P	175	59	-	81	32	26	30	4	7	△
		TNMT042U1	1.5P										
M42 × 3	P5	TNMT042S5	5P	175	59	-	81	32	26	30	4	7	△
		TNMT042S1	1.5P										
M42 × 2	P4	TNMS042Q5	5P	175	59	-	81	32	26	30	4	7	△
		TNMS042Q1	1.5P										

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

Hand Tap Series

HT Hand Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
	M42 × 1.5	P4	TNMS04205 TNMS04201	5P 1.5P	175	27	-	81	32	26	30	4	8	△
Spiral Fluted Taps (for blind hole)	M44 × 4	P6	TNMU044U5	5P	180	59	-	83	35	26	30	4	7	△
			TNMU044U1	1.5P										
Spiral Fluted Taps (for through hole)	M44 × 3	P5	TNMT044S5	5P	180	59	-	83	35	26	30	4	7	△
			TNMT044S1	1.5P										
Spiral Pointed Taps (for through hole)	M44 × 2	P4	TNMS044Q5	5P	180	59	-	83	35	26	30	4	7	△
			TNMS044Q1	1.5P										
Spiral Pointed Taps (for through hole)	M44 × 1.5	P4	TNMS044O5	5P	180	27	-	83	35	26	30	4	8	△
			TNMS044O1	1.5P										
Hand Taps	M45 × 4.5	P5	TNMT045V5	5P	180	59	-	83	35	26	30	4	7	○
			TNMT045V1	1.5P										
Hand Taps	M45 × 4	P6	TNMU045U5	5P	180	59	-	83	35	26	30	4	7	△
			TNMU045U1	1.5P										
Hand Taps	M45 × 3	P5	TNMT045S5	5P	180	59	-	83	35	26	30	4	7	△
			TNMT045S1	1.5P										
Cemented Carbide Taps	M45 × 2	P4	TNMS045Q5	5P	180	59	-	83	35	26	30	4	7	△
			TNMS045Q1	1.5P										
Cemented Carbide Taps	M45 × 1.5	P4	TNMS045O5	5P	180	27	-	83	35	26	30	4	8	△
			TNMS045O1	1.5P										
Roll Taps	M45 × 1	P3	TNMR045M5	5P	180	27	-	83	35	26	30	4	8	△
			TNMR045M1	1.5P										
Roll Taps	M46 × 1.5	P4	TNMS046O5	5P	185	28	-	85	38	29	32	4	8	△
			TNMS046O1	1.5P										
Special Thread Taps Simple Inspection Tools	M48 × 5	P5	TNMT048W5	5P	185	65	-	85	38	29	32	4	7	○
			TNMT048W1	1.5P										
Special Thread Taps Simple Inspection Tools	M48 × 4	P6	TNMU048U5	5P	185	65	-	85	38	29	32	4	7	△
			TNMU048U1	1.5P										
Pipe Taps	M48 × 3	P6	TNMT048S5	5P	185	65	-	85	38	29	32	4	7	△
			TNMT048S1	1.5P										
Pipe Taps	M48 × 2	P4	TNMS048Q5	5P	185	65	-	85	38	29	32	4	7	△
			TNMS048Q1	1.5P										
Thread Mills	M48 × 1.5	P4	TNMS048O5	5P	185	28	-	85	38	29	32	4	8	△
			TNMS048O1	1.5P										
Thread Mills	For Unified Threads													
	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Dies	No.0-80UNF	P1	TNMPUN0B5	5P	36	6.3	-	24	3	2.5	5	3	2	○
			TNMPUN0B1	1.5P										
Dies	No.1-64UNC	P1	TNMPUN1D5	5P	42	7.2	-	27	3	2.5	5	3	2	△
			TNMPUN1D1	1.5P										
Center Drills	No.1-72UNF	P1	TNMPUN1C5	5P	42	7.2	-	27	3	2.5	5	3	2	○
			TNMPUN1C1	1.5P										
Center Drills	No.2-56UNC	P1	TNMPUN2E5	5P	42	8.1	12	27	3	2.5	5	3	3	○
			TNMPUN2E1	1.5P										
Centering Tools	No.2-64UNF	P1	TNMPUN2D5	5P	42	8.1	12	27	3	2.5	5	3	3	△
			TNMPUN2D1	1.5P										
Centering Tools	No.3-48UNC	P1	TNMPUN3F5	5P	46	8.1	14	29	3	2.5	5	3	3	△
			TNMPUN3F1	1.5P										
Centering Tools	No.3-56UNF	P1	TNMPUN3E5	5P	46	8.1	14	29	3	2.5	5	3	3	△
			TNMPUN3E1	1.5P										

HT-13



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

HT Hand Taps

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
No.4-40UNC	P2	TNMQU4H5	5P	46	9	14	26	4	3.2	6	3	3	○
		TNMQU4H1	1.5P										△
	P3	TNMRUN4H5	5P										
		TNMRUN4H1	1.5P										
No.4-48UNF	P1	TNMPUN4F5	5P	46	9	14	26	4	3.2	6	3	3	△
		TNMPUN4F1	1.5P										
	P3	TNMRUN4F5	5P										
		TNMRUN4F1	1.5P										
No.5-40UNC	P2	TNMQU5H5	5P	52	11	16	29	5	4	7	3	3	△
		TNMQU5H1	1.5P										
	P3	TNMRUN5H5	5P										
		TNMRUN5H1	1.5P										
No.5-44UNF	P1	TNMPUN5G5	5P	52	11	16	29	5	4	7	3	3	△
		TNMPUN5G1	1.5P										
	P3	TNMRUN5G5	5P										
		TNMRUN5G1	1.5P										
No.6-32UNC	P2	TNMQU6J5	5P	52	11	16	29	5	4	7	3	3	○
		TNMQU6J1	1.5P										
	P3	TNMRUN6J5	5P										△
		TNMRUN6J1	1.5P										
No.6-40UNF	P2	TNMQU6H5	5P	52	11	16	29	5	4	7	3	3	△
		TNMQU6H1	1.5P										
	P3	TNMRUN6H5	5P										
		TNMRUN6H1	1.5P										
No.8-32UNC	P2	TNMQU8J5	5P	60	13	21	33	5.5	4.5	7	4	3	○
		TNMQU8J1	1.5P										
	P3	TNMRUN8J5	5P										△
		TNMRUN8J1	1.5P										
No.8-36UNF	P2	TNMQU8I5	5P	60	13	21	33	5.5	4.5	7	4	3	△
		TNMQU8I1	1.5P										
	P3	TNMRUN8I5	5P										
		TNMRUN8I1	1.5P										
No.10-24UNC	P2	TNMQUAM5	5P	60	13	22	33	5.5	4.5	7	4	3	○
		TNMQUAM1	1.5P										
	P3	TNMRUNAM5	5P										△
		TNMRUNAM1	1.5P										
No.10-32UNF	P2	TNMQUAJ5	5P	60	13	22	33	5.5	4.5	7	4	3	○
		TNMQUAJ1	1.5P										
	P3	TNMRUNAJ5	5P										△
		TNMRUNAJ1	1.5P										
No.12-24UNC	P2	TNMQU5CM5	5P	62	15	26	33	6	4.5	7	4	3	△
		TNMQU5CM1	1.5P										
	P3	TNMRUNCM5	5P										
No.12-28UNF	P2	TNMQU5CK5	5P	62	15	26	33	6	4.5	7	4	3	△
		TNMQU5CK1	1.5P										
	P3	TNMRUNCK5	5P										△
		TNMRUNCK1	1.5P										
No.12-32UNEF	P2	TNMQU5CJ5	5P	62	15	26	33	6	4.5	7	4	3	△
		TNMQU5CJ1	1.5P										
1/4-20UNC	P2	TNMQU04N5	5P	62	15	26	33	6	4.5	7	4	3	○

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

Hand Tap Series

HT Hand Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	1/4-20UNC	P2	TNMQU04N1	1.5P	62	15	26	33	6	4.5	7	4	3	○
	1/4-28UNF	P2	TNMQU04K5 TNMQU04K1	5P 1.5P	62	15	26	33	6	4.5	7	4	3	○
Spiral Fluted Taps (for through hole)	1/4-32UNEF	P2	TNMQU04J5 TNMQU04J1	5P 1.5P	62	15	26	33	6	4.5	7	4	3	△
	5/16-18UNC	P3	TNMRU05O5 TNMRU05O1	5P 1.5P	70	19	-	36	6.2	5	8	4	5	○
Spiral Pointed Taps (for through hole)	5/16-24UNF	P2	TNMQU05M5 TNMQU05M1	5P 1.5P	70	19	-	36	6.2	5	8	4	5	○
	5/16-32UNEF	P2	TNMQU05J5 TNMQU05J1	5P 1.5P	70	19	-	36	6.2	5	8	4	5	△
Hand Taps	3/8-16UNC	P3	TNMRU06P5 TNMRU06P1	5P 1.5P	75	23	-	38	7	5.5	8	4	5	○
	3/8-24UNF	P3	TNMRU06M5 TNMRU06M1	5P 1.5P	75	23	-	38	7	5.5	8	4	5	○
Cemented Carbide Taps	3/8-32UNEF	P2	TNMQU06J5 TNMQU06J1	5P 1.5P	75	13	-	38	7	5.5	8	4	6	△
	7/16-14UNC	P3	TNMRU07Q5 TNMRU07Q1	5P 1.5P	82	26	-	42	8.5	6.5	9	4	5	○
Roll Taps	7/16-20UNF	P3	TNMRU07N5 TNMRU07N1	5P 1.5P	82	26	-	42	8.5	6.5	9	4	5	○
	7/16-28UNEF	P2	TNMQU07K5 TNMQU07K1	5P 1.5P	82	26	-	42	8.5	6.5	9	4	5	△
Special Thread Taps Simple Inspection Tools	1/2-13UNC	P3	TNMRU08R5 TNMRU08R1	5P 1.5P	88	26	-	45	10.5	8	11	4	5	○
	1/2-20UNF	P3	TNMRU08N5 TNMRU08N1	5P 1.5P	88	26	-	45	10.5	8	11	4	5	○
Pipe Taps	1/2-28UNEF	P2	TNMQU08K5 TNMQU08K1	5P 1.5P	88	26	-	45	10.5	8	11	4	5	△
	9/16-12UNC	P3	TNMRU09S5 TNMRU09S1	5P 1.5P	95	26	-	48	12.5	10	13	4	5	△
Thread Mills	9/16-18UNF	P3	TNMRU09O5 TNMRU09O1	5P 1.5P	95	26	-	48	12.5	10	13	4	5	○
	5/8-11UNC	P4	TNMSU10U5 TNMSU10U1	5P 1.5P	95	26	-	48	12.5	10	13	4	5	○
Dies	5/8-18UNF	P3	TNMRU10O5 TNMRU10O1	5P 1.5P	95	26	-	48	12.5	10	13	4	5	○
	5/8-24UNEF	P3	TNMRU10M5 TNMRU10M1	5P 1.5P	95	26	-	48	12.5	10	13	4	5	△
Center Drills	3/4-10UNC	P4	TNMSU12V5 TNMSU12V1	5P 1.5P	105	33	-	50	15	12	15	4	7	○
	3/4-16UNF	P3	TNMRU12P5 TNMRU12P1	5P 1.5P	105	33	-	50	15	12	15	4	7	○
Centering Tools	3/4-20UNEF	P3	TNMRU12N5 TNMRU12N1	5P 1.5P	105	33	-	50	15	12	15	4	7	△
	7/8-9UNC	P4	TNMSU14W5 TNMSU14W1	5P 1.5P	115	33	-	55	17	13	16	4	7	○
	7/8-14UNF	P4	TNMSU14Q5 TNMSU14Q1	5P 1.5P	115	33	-	55	17	13	16	4	7	○
	7/8-20UNEF	P3	TNMRU14N5	5P	115	33	-	55	17	13	16	4	7	△

HT-15



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

HT Hand Taps

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
7/8-20UNEF	P3	TNMRU14N1	1.5P	115	33	-	55	17	13	16	4	7	△
1 -8UNC	P4	TNMSU16X5	5P	125	39	-	58	19	15	18	4	7	○
		TNMSU16X1	1.5P										
1 -12UNF	P4	TNMSU16S5	5P	125	39	-	58	19	15	18	4	7	○
		TNMSU16S1	1.5P										
1 -14UNS	P4	TNMSU16Q5	5P	125	39	-	58	19	15	18	4	7	△
		TNMSU16Q1	1.5P										
1 -20UNEF	P3	TNMRU16N5	5P	125	39	-	58	19	15	18	4	7	△
		TNMRU16N1	1.5P										
1 1/8-7UNC	P5	TNMTU18Y5	5P	135	46	-	62	23	17	20	4	7	△
		TNMTU18Y1	1.5P										
1 1/4-7UNC	P5	TNMTU20Y5	5P	145	46	-	67	24	19	22	4	7	△
		TNMTU20Y1	1.5P										
1 1/4-8UN	P5	TNMTU20X5	5P	145	46	-	67	24	19	22	4	7	△
		TNMTU20X1	1.5P										
1 1/4-12UNF	P4	TNMSU20S5	5P	145	46	-	67	24	19	22	4	7	△
		TNMSU20S1	1.5P										
1 3/8-6UNC	P5	TNMTU22Z5	5P	155	52	-	71	28	21	24	4	7	△
		TNMTU22Z1	1.5P										
1 3/8-8UN	P5	TNMTU22X5	5P	155	52	-	71	28	21	24	4	7	△
		TNMTU22X1	1.5P										
1 3/8-12UNF	P4	TNMSU22S5	5P	155	52	-	71	28	21	24	4	7	△
		TNMSU22S1	1.5P										
1 1/2-6UNC	P5	TNMTU24Z5	5P	165	52	-	76	30	23	26	4	7	△
		TNMTU24Z1	1.5P										
1 1/2-12UNF	P4	TNMSU24S5	5P	165	52	-	76	30	23	26	4	7	△
		TNMSU24S1	1.5P										
1 3/4-5UNC	P6	TNMTU28O5	5P	180	59	-	83	35	26	30	4	7	△
		TNMTU28O1	1.5P										
1 3/4-12UN	P4	TNMSU28S5	5P	180	59	-	83	35	26	30	4	7	△
		TNMSU28S1	1.5P										
For Screw Threads used on Sewing Machines													
Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
1/16SM80	P1	TNMPS04B5	5P	36	6.3	-	24	3	2.5	5	3	2	△
		TNMPS04B1	1.5P										
5/64SM64	P1	TNMPS05D5	5P	42	7.2	12	27	3	2.5	5	3	3	△
		TNMPS05D1	1.5P										
3/32SM56	P1	TNMPS06E5	5P	46	8.1	14	29	3	2.5	5	3	3	△
		TNMPS06E1	1.5P										
3/32SM100	P1	TNMPS06A5	5P	46	3.4	14	29	3	2.5	5	3	4	△
		TNMPS06A1	1.5P										
1/8SM40	P2	TNMQS08H5	5P	52	11	16	29	5	4	7	3	3	△
		TNMQS08H1	1.5P										
1/8SM44	P2	TNMQS08G5	5P	52	11	16	29	5	4	7	3	3	△
		TNMQS08G1	1.5P										
9/64SM40	P2	TNMQS09H5	5P	52	11	17	29	5	4	7	3	3	△
		TNMQS09H1	1.5P										
11/64SM40	P2	TNMQS11H5	5P	60	13	21	33	5.5	4.5	7	4	3	△
		TNMQS11H1	1.5P										
3/16SM24	P2	TNMQS12M5	5P	60	13	21	33	5.5	4.5	7	4	3	△

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

HT Hand Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
3/16SM24	P2	TNMQS12M1	1.5P	60	13	21	33	5.5	4.5	7	4	3	△
3/16SM28	P2	TNMQS12K5	5P	60	13	21	33	5.5	4.5	7	4	3	△
		TNMQS12K1	1.5P										
3/16SM32	P2	TNMQS12J5	5P	60	13	21	33	5.5	4.5	7	4	3	△
		TNMQS12J1	1.5P										
3/16SM40	P2	TNMQS12H5	5P	60	13	21	33	5.5	4.5	7	4	3	△
		TNMQS12H1	1.5P										
15/64SM28	P2	TNMQS15K5	5P	62	15	26	33	6	4.5	7	4	3	△
		TNMQS15K1	1.5P										

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

HT LH

Hand Taps for Left Hand Threads

Specification

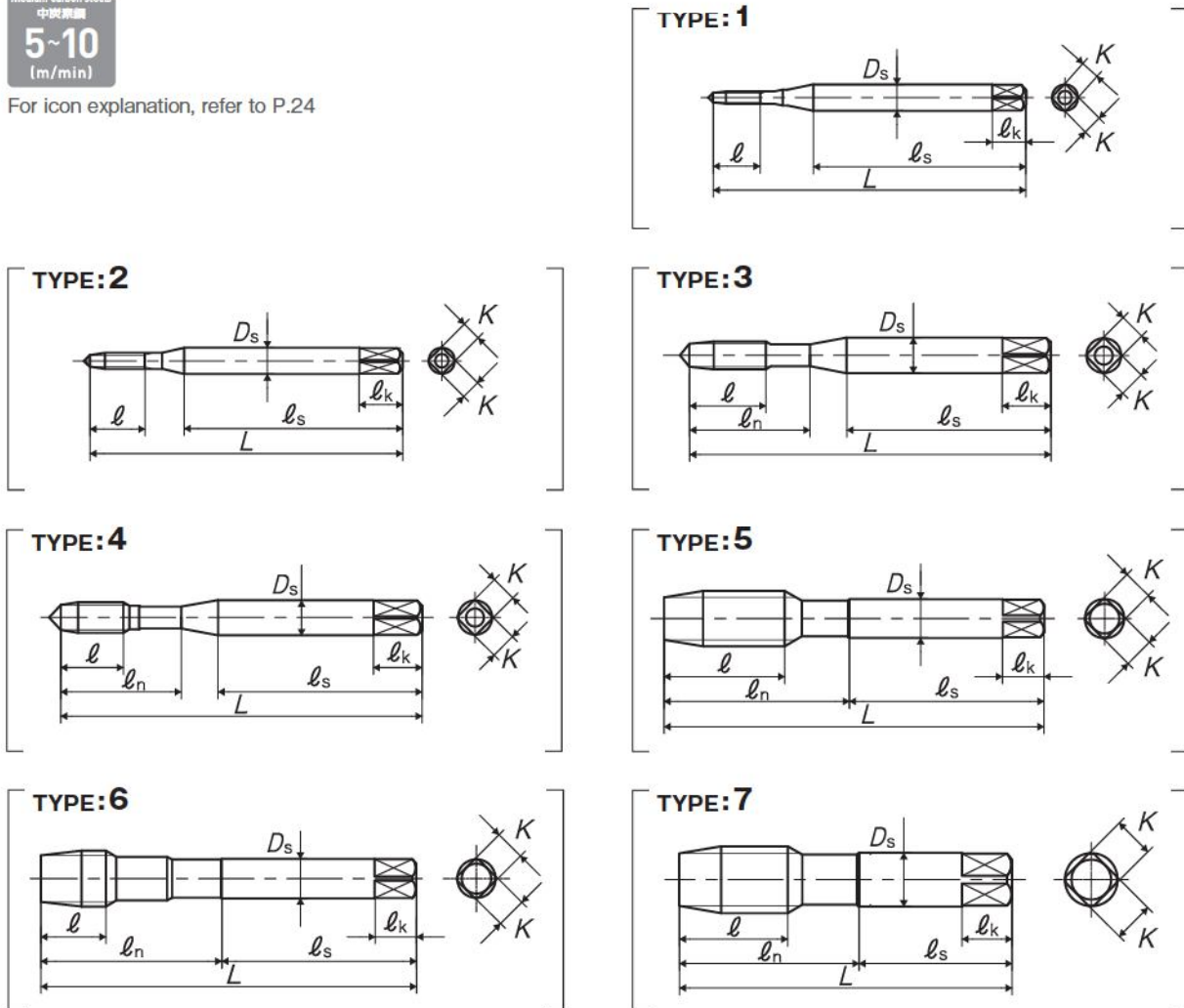


Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

For icon explanation, refer to P.24

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



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M1 × 0.25	P1	TNMP1.0B5-L	5P	36	4.5	-	24	3	2.5	5	3	1	△
		TNMP1.0B1-L	1.5P										
M1.2 × 0.25	P1	TNMP1.2B5-L	5P	36	4.5	-	24	3	2.5	5	3	1	△
		TNMP1.2B1-L	1.5P										
M1.4 × 0.3	P1	TNMP1.4C5-L	5P	36	5.4	-	24	3	2.5	5	3	1	△
		TNMP1.4C1-L	1.5P										
M1.6 × 0.35	P2	TNMQ1.6D5-L	5P	36	6.3	-	24	3	2.5	5	3	2	△
		TNMQ1.6D1-L	1.5P										

Hand Tap Series

HT LH Hand Taps for Left Hand Threads

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M1.7 × 0.35	P1	TNMP1.7D5-L	5P	36	6.3	-	24	3	2.5	5	3	2	△
			TNMP1.7D1-L	1.5P										
Spiral Fluted Taps (for through hole)	M2 × 0.4	P1	TNMP2.0E5-L	5P	42	7.2	12	27	3	2.5	5	3	3	△
			TNMP2.0E1-L	1.5P										
Spiral Fluted Taps (for through hole)	M2.3 × 0.4	P1	TNMP2.3E5-L	5P	42	7.2	12	27	3	2.5	5	3	3	△
			TNMP2.3E1-L	1.5P										
Spiral Pointed Taps (for through hole)	M2.5 × 0.45	P2	TNMQ2.5F5-L	5P	46	8.1	14	29	3	2.5	5	3	3	△
			TNMQ2.5F1-L	1.5P										
Spiral Pointed Taps (for through hole)	M2.6 × 0.45	P1	TNMP2.6F5-L	5P	46	8.1	14	29	3	2.5	5	3	3	△
			TNMP2.6F1-L	1.5P										
Hand Taps	M3 × 0.5	P2	TNMQ3.0G5-L	5P	46	9	14	26	4	3.2	6	3	3	○
			TNMQ3.0G1-L	1.5P										
Cemented Carbide Taps	3M0.6	P2	TNMQ3.0H5-L	5P	46	9	14	26	4	3.2	6	3	3	△
			TNMQ3.0H1-L	1.5P										
Hand Taps	M3 × 0.35	P2	TNMQ3.0D5-L	5P	46	6.5	14	26	4	3.2	6	3	4	△
			TNMQ3.0D1-L	1.5P										
Hand Taps	M3.5 × 0.6	P2	TNMQ3.5H5-L	5P	52	11	16	29	5	4	7	3	3	△
			TNMQ3.5H1-L	1.5P										
Roll Taps	M4 × 0.7	P2	TNMQ4.0I5-L	5P	52	11	17	29	5	4	7	4	3	○
			TNMQ4.0I1-L	1.5P										
Roll Taps	4M0.75	P2	TNMQ4.0J5-L	5P	52	11	17	29	5	4	7	4	3	△
			TNMQ4.0J1-L	1.5P										
Roll Taps	M4 × 0.5	P2	TNMQ4.0G5-L	5P	52	9	17	29	5	4	7	4	4	△
			TNMQ4.0G1-L	1.5P										
Special Thread Taps Simple Inspection Tools	M5 × 0.8	P3	TNMR5.0K5-L	5P	60	13	22	33	5.5	4.5	7	4	3	○
			TNMR5.0K1-L	1.5P										
Special Thread Taps Simple Inspection Tools	5M0.9	P2	TNMQ5.0L5-L	5P	60	13	22	33	5.5	4.5	7	4	3	△
			TNMQ5.0L1-L	1.5P										
Pipe Taps	M5 × 0.5	P2	TNMQ5.0G5-L	5P	60	9	22	33	5.5	4.5	7	4	4	△
			TNMQ5.0G1-L	1.5P										
Pipe Taps	M6 × 1	P2	TNMQ6.0M5-L	5P	62	15	26	33	6	4.5	7	4	3	○
			TNMQ6.0M1-L	1.5P										
Thread Mills	M6 × 0.75	P2	TNMQ6.0J5-L	5P	62	15	26	33	6	4.5	7	4	3	△
			TNMQ6.0J1-L	1.5P										
Thread Mills	M6 × 0.5	P2	TNMQ6.0G5-L	5P	62	9	26	33	6	4.5	7	4	4	△
			TNMQ6.0G1-L	1.5P										
Dies	M7 × 0.75	P2	TNMQ7.0J5-L	5P	70	19	-	36	6.2	5	8	4	5	△
			TNMQ7.0J1-L	1.5P										
Dies	M8 × 1.25	P3	TNMR8.0N5-L	5P	70	19	-	36	6.2	5	8	4	5	○
			TNMR8.0N1-L	1.5P										
Center Drills	M8 × 1	P2	TNMQ8.0M5-L	5P	70	19	-	36	6.2	5	8	4	5	△
			TNMQ8.0M1-L	1.5P										
Center Drills	M8 × 0.75	P2	TNMQ8.0J5-L	5P	70	19	-	36	6.2	5	8	4	5	△
			TNMQ8.0J1-L	1.5P										
Centering Tools	M8 × 0.5	P2	TNMQ8.0G5-L	5P	70	10	-	36	6.2	5	8	4	6	△
			TNMQ8.0G1-L	1.5P										
Centering Tools	M9 × 1	P2	TNMQ9.0M5-L	5P	75	23	-	38	7	5.5	8	4	5	△
			TNMQ9.0M1-L	1.5P										
Centering Tools	M9 × 0.75	P2	TNMQ9.0J5-L	5P	75	13	-	38	7	5.5	8	4	6	△
			TNMQ9.0J1-L	1.5P										

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

HT LH Hand Taps for Left Hand Threads

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M10 × 1.5	P3	TNMR01005-L	5P	75	23	-	38	7	5.5	8	4	5	○
		TNMR01001-L	1.5P										
M10 × 1.25	P3	TNMR010N5-L	5P	75	23	-	38	7	5.5	8	4	5	○
		TNMR010N1-L	1.5P										
M10 × 1	P3	TNMR010M5-L	5P	75	23	-	38	7	5.5	8	4	5	△
		TNMR010M1-L	1.5P										
M11 × 1.25	P3	TNMR011N5-L	5P	82	26	-	42	8.5	6.5	9	4	5	△
		TNMR011N1-L	1.5P										
M11 × 1	P3	TNMR011M5-L	5P	82	26	-	42	8.5	6.5	9	4	5	△
		TNMR011M1-L	1.5P										
M12 × 1.75	P3	TNMR012P5-L	5P	82	26	-	42	8.5	6.5	9	4	5	○
		TNMR012P1-L	1.5P										
M12 × 1.5	P3	TNMR01205-L	5P	82	26	-	42	8.5	6.5	9	4	5	○
		TNMR01201-L	1.5P										
M12 × 1.25	P4	TNMS012N5-L	5P	82	26	-	42	8.5	6.5	9	4	5	○
		TNMS012N1-L	1.5P										
M12 × 1	P3	TNMR012M5-L	5P	82	26	-	42	8.5	6.5	9	4	5	△
		TNMR012M1-L	1.5P										
M14 × 2	P3	TNMR014Q5-L	5P	88	26	-	45	10.5	8	11	4	5	○
		TNMR014Q1-L	1.5P										
M14 × 1.5	P3	TNMR01405-L	5P	88	26	-	45	10.5	8	11	4	5	○
		TNMR01401-L	1.5P										
M14 × 1	P3	TNMR014M5-L	5P	88	26	-	45	10.5	8	11	4	5	△
		TNMR014M1-L	1.5P										
M16 × 2	P3	TNMR016Q5-L	5P	95	26	-	48	12.5	10	13	4	5	○
		TNMR016Q1-L	1.5P										
M16 × 1.5	P3	TNMR01605-L	5P	95	26	-	48	12.5	10	13	4	5	○
		TNMR01601-L	1.5P										
M16 × 1	P3	TNMR016M5-L	5P	95	26	-	48	12.5	10	13	4	5	△
		TNMR016M1-L	1.5P										
M18 × 2.5	P4	TNMS018R5-L	5P	100	33	-	51	14	11	14	4	5	△
		TNMS018R1-L	1.5P										
M18 × 1.5	P3	TNMR01805-L	5P	100	33	-	51	14	11	14	4	5	○
		TNMR01801-L	1.5P										
M20 × 2.5	P4	TNMS020R5-L	5P	105	33	-	50	15	12	15	4	7	○
		TNMS020R1-L	1.5P										
M20 × 1.5	P3	TNMR02005-L	5P	105	33	-	50	15	12	15	4	7	○
		TNMR02001-L	1.5P										
M22 × 2.5	P4	TNMS022R5-L	5P	115	33	-	55	17	13	16	4	7	△
		TNMS022R1-L	1.5P										
M24 × 3	P4	TNMS024S5-L	5P	120	39	-	55	19	15	18	4	7	○
		TNMS024S1-L	1.5P										
M30 × 3.5	P4	TNMS030T5-L	5P	135	46	-	62	23	17	20	4	7	○
		TNMS030T1-L	1.5P										

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

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

LS-HT

Long Shank Hand Taps

Specification



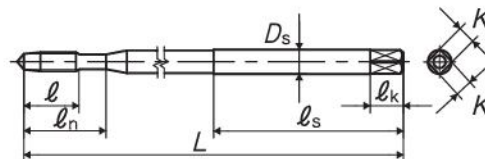
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

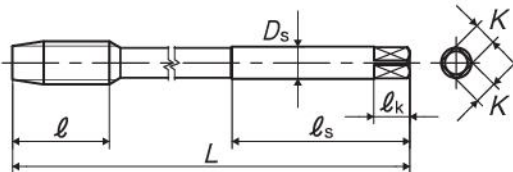
For icon explanation, refer to P.24



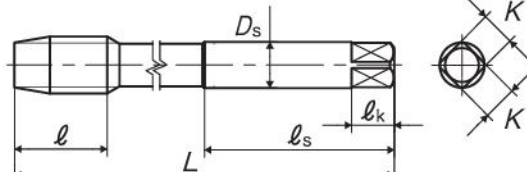
TYPE:1



TYPE:2



TYPE:3



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M2 × 0.4	P1	TNMP2.0E507	5P	70	7.2	12	55	3	2.5	5	3	1	△
		TNMP2.0E107	1.5P										
M2.3 × 0.4	P1	TNMP2.3E507	5P	70	7.2	12	55	3	2.5	5	3	1	△
		TNMP2.3E107	1.5P										
M2.5 × 0.45	P1	TNMP2.5F507	5P	70	8.1	14	53	3	2.5	5	3	1	△
		TNMP2.5F107	1.5P										
M2.6 × 0.45	P1	TNMP2.6F507	5P	70	8.1	14	53	3	2.5	5	3	1	△
		TNMP2.6F107	1.5P										
M3 × 0.5	P1	TNMP3.0G507	5P	70	9	14	50	4	3.2	6	3	1	△
		TNMP3.0G510		100			40						⊙
		TNMP3.0G512		120									△
		TNMP3.0G515	150	50			40						△
		TNMP3.0G107	70										⊙
		TNMP3.0G110	100										⊙
	P3	TNMP3.0G112	1.5P	120			40						△
		TNMP3.0G115	150										
		TNMR3.0G510	5P	100									
		TNMR3.0G515	150										
		TNMR3.0G110	1.5P	100									
		TNMR3.0G115	150										
M4 × 0.7	P2	TNMQ4.0I507	5P	70	11	17	47	5	4	7	3	1	△
		TNMQ4.0I510		100			40						⊙
		TNMQ4.0I512		120									△

LS-HT Long Shank Hand Taps

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock						
M4 × 0.7	P2	TNMQ4.0I515	5P	150	11	17	40	5	4	7	3	1	⊙						
		TNMQ4.0I107	1.5P	70			47						△						
		TNMQ4.0I110		100			⊙												
		TNMQ4.0I112		120			△												
		TNMQ4.0I115		150			⊙												
	P3	TNMR4.0I510	5P	100			40											△	
		TNMR4.0I515	150																
		TNMR4.0I110	100																
		TNMR4.0I115	1.5P	150															
M5 × 0.8	P2	TNMQ5.0K507	5P	70	13	22	43	5.5	4.5	7	3	1	△						
		TNMQ5.0K510		100			40						⊙						
		TNMQ5.0K512		120									△						
		TNMQ5.0K515		150									⊙						
		TNMQ5.0K107	1.5P	70									43	△					
		TNMQ5.0K110		100			⊙												
		TNMQ5.0K112		120			△												
		TNMQ5.0K115		150			⊙												
	P3	TNMR5.0K510	5P	100			40											△	
		TNMR5.0K515	150																
		TNMR5.0K110	100																
		TNMR5.0K115	1.5P	150															
M6 × 1	P2	TNMQ6.0M510	5P	100	15	26	40	6	4.5	7	3	1	⊙						
		TNMQ6.0M512		120									○						
		TNMQ6.0M515		150									⊙						
		TNMQ6.0M520		200									△						
		TNMQ6.0M110	1.5P	100									⊙						
		TNMQ6.0M112		120									○						
		TNMQ6.0M115		150									⊙						
		TNMQ6.0M120		200									△						
	P3	TNMR6.0M510	5P	100															
		TNMR6.0M515	150																
		TNMR6.0M110	100																
		TNMR6.0M115	1.5P	150															
M8 × 1.25	P2	TNMQ8.0N510	5P	100	19	-	50	6.2	5	8	4	2	⊙						
		TNMQ8.0N512		120									○						
		TNMQ8.0N515		150									⊙						
		TNMQ8.0N520		200									○						
		TNMQ8.0N110	1.5P	100									⊙						
		TNMQ8.0N112		120									○						
		TNMQ8.0N115		150									⊙						
		TNMQ8.0N120		200									○						
	P3	TNMR8.0N510	5P	100									△						
		TNMR8.0N515		150															
		TNMR8.0N520		200															
		TNMR8.0N110	1.5P	100															
		TNMR8.0N115		150															
		TNMR8.0N120		200															
M8 × 1	P2	TNMQ8.0M510	5P	100	19	-	50	6.2	5	8	4	2	△						
		TNMQ8.0M512		120															
		TNMQ8.0M515		150															

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

Hand Tap Series

LS-HT Long Shank Hand Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M8 × 1	P2	TNMQ8.0M110	1.5P	100	19	-	50	6.2	5	8	4	2	△
		TNMQ8.0M112		120									
		TNMQ8.0M115		150									
M10 × 1.5	P2	TNMQ0100510	5P	100	23	-	50	7	5.5	8	4	2	○
		TNMQ0100512		120									◎
		TNMQ0100515		150									○
		TNMQ0100520		200									△
		TNMQ0100525		250									△
		TNMQ0100110	1.5P	100									○
		TNMQ0100112		120									○
		TNMQ0100115		150									◎
		TNMQ0100120		200									○
		TNMQ0100125		250									○
	P3	TNMR0100510	5P	100									△
		TNMR0100515		150									
		TNMR0100110	1.5P	100									
		TNMR0100115		150									
	P4	TNMS0100510	5P	100									△
		TNMS0100515		150									
		TNMS0100110	1.5P	100									
		TNMS0100115		150									
M10 × 1.25	P2	TNMQ010N510	5P	100	23	-	50	7	5.5	8	4	2	○
		TNMQ010N512		120									△
		TNMQ010N515		150									△
		TNMQ010N520		200									△
		TNMQ010N110	1.5P	100									○
		TNMQ010N112		120									○
		TNMQ010N115		150									○
		TNMQ010N120		200									○
	P3	TNMR010N510	5P	100									△
		TNMR010N110	1.5P	100									
	P4	TNMS010N510	5P	150									△
		TNMS010N515		150									
		TNMS010N110	1.5P	100									
		TNMS010N115		150									
M10 × 1	P2	TNMQ010M510	5P	100	23	-	50	7	5.5	8	4	2	△
		TNMQ010M512		120									
		TNMQ010M515		150									
		TNMQ010M110	1.5P	100									
		TNMQ010M112		120									
		TNMQ010M115		150									
M12 × 1.75	P2	TNMQ012P510	5P	100	26	-	50	8.5	6.5	9	4	2	○
		TNMQ012P512		120									○
		TNMQ012P515		150									◎
		TNMQ012P520		200									○
		TNMQ012P525		250									△
		TNMQ012P110	1.5P	100									○
		TNMQ012P112		120									○
		TNMQ012P115		150									◎
		TNMQ012P120		200									○
		TNMQ012P125		250									○

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

LS-HT Long Shank Hand Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M12 × 1.75	P2	TNMQ012P125	1.5P	250									
	P3	TNMR012P515	5P										
		TNMR012P115	1.5P	150									
	P4	TNMS012P515	5P		26	-	50	8.5	6.5	9	4	2	△
		TNMS012P520		200									
		TNMS012P115	1.5P	150									
		TNMS012P120		200									
M12 × 1.5	P2	TNMQ0120510		100									
		TNMQ0120512	5P	120									
		TNMQ0120515		150									
		TNMQ0120520		200									
		TNMQ0120110		100									
		TNMQ0120112	1.5P	120	26	-	50	8.5	6.5	9	4	2	△
		TNMQ0120115		150									
	P4	TNMQ0120120		200									
		TNMS0120515	5P	150									
		TNMS0120520		200									
		TNMS0120115	1.5P	150									
		TNMS0120120		200									
M12 × 1.25	P2	TNMQ012N510		100									○
		TNMQ012N512	5P	120									△
		TNMQ012N515		150									○
		TNMQ012N520		200									△
		TNMQ012N110		100									○
		TNMQ012N112	1.5P	120	26	-	50	8.5	6.5	9	4	2	△
		TNMQ012N115		150									○
	P4	TNMQ012N120		200									
		TNMS012N515	5P	150									△
		TNMS012N520		200									
		TNMS012N115	1.5P	150									
		TNMS012N120		200									
M12 × 1	P2	TNMQ012M510	5P	100	26	-	50	8.5	6.5	9	4	2	△
		TNMQ012M515		150									
		TNMQ012M110	1.5P	100									
		TNMQ012M115		150									
M14 × 2	P2	TNMQ014Q512		120									△
		TNMQ014Q515	5P	150									○
		TNMQ014Q520		200									
		TNMQ014Q525		250									△
		TNMQ014Q112		120	26	-	60	10.5	8	11	4	2	○
		TNMQ014Q115	1.5P	150									
		TNMQ014Q120		200									
	P3	TNMQ014Q125		250									△
		TNMR014Q515	5P	150									
M14 × 1.5	P2	TNMR014Q115	1.5P										
		TNMQ0140512		120									△
		TNMQ0140515	5P	150									○
		TNMQ0140520		200	26	-	60	10.5	8	11	4	2	△
		TNMQ0140112	1.5P	120									○
		TNMQ0140115		150									○

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

Hand Tap Series

LS-HT Long Shank Hand Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M14 × 1.5	P2	TNMQ0140120	1.5P	200	26	-	60	10.5	8	11	4	2	△
	M14 × 1	P2	TNMQ014M515 TNMQ014M115	5P 1.5P	150	26	-	60	10.5	8	11	4	2	△
Spiral Fluted Taps (for through hole)	M16 × 2	P2	TNMQ016Q515		150	26	-	60	12.5	10	13	4	2	○
			TNMQ016Q520	5P	200									○
			TNMQ016Q525		250									△
			TNMQ016Q115		150									○
			TNMQ016Q120	1.5P	200									○
			TNMQ016Q125		250									
Spiral Pointed Taps (for through hole)		P3	TNMR016Q515 TNMR016Q115	5P 1.5P	150									△
Hand Taps	M16 × 1.5	P2	TNMQ016Q515	5P	150	26	-	60	12.5	10	13	4	2	○
			TNMQ016Q520		200									△
			TNMQ016Q115	1.5P	150									○
			TNMQ016Q120		200									△
Cemented Carbide Taps	M16 × 1	P2	TNMQ016M515 TNMQ016M115	5P 1.5P	150	26	-	60	12.5	10	13	4	2	△
Roll Taps	M18 × 2.5	P3	TNMR018R515		150	33	-	70	14	11	14	4	2	△
			TNMR018R520	5P	200									
			TNMR018R525		250									
			TNMR018R115		150									
			TNMR018R120	1.5P	200									
			TNMR018R125		250									
		P4	TNMS018R515 TNMS018R115	5P 1.5P	150									
Special Thread Taps Simple Inspection Tools	M18 × 2	P3	TNMR018Q520 TNMR018Q120	5P 1.5P	200	33	-	70	14	11	14	4	2	△
Pipe Taps	M18 × 1.5	P2	TNMQ018Q515	5P	150	33	-	70	14	11	14	4	2	○
			TNMQ018Q520		200									△
			TNMQ018Q115	1.5P	150									○
			TNMQ018Q120		200									△
Thread Mills	M20 × 2.5	P3	TNMR020R515		150	33	-	70	15	12	15	4	3	○
			TNMR020R520	5P	200									△
			TNMR020R525		250									
			TNMR020R115		150									○
			TNMR020R120	1.5P	200									
			TNMR020R125		250									
Dies		P4	TNMS020R515 TNMS020R115	5P 1.5P	150									△
Center Drills	M20 × 1.5	P3	TNMR020Q515	5P	150	33	-	70	15	12	15	4	3	○
			TNMR020Q520		200									△
			TNMR020Q115	1.5P	150									○
			TNMR020Q120		200									
		P4	TNMS020Q515	5P	150									△
			TNMS020Q115	1.5P										
Centering Tools	M22 × 2.5	P3	TNMR022R515		150	33	-	70	17	13	16	4	3	△
			TNMR022R520	5P	200									
			TNMR022R525		250									
			TNMR022R115	1.5P	150									
			TNMR022R120		200									

LS-HT Long Shank Hand Taps

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M22 × 2.5	P3	TNMR022R125	1.5P	250									
	P4	TNMS022R515	5P	150	33	-	70	17	13	16	4	3	△
		TNMS022R115	1.5P										
M22 × 1.5	P3	TNMR0220515	5P	150	33	-	70	17	13	16	4	3	△
		TNMR0220520		200									
		TNMR0220115	1.5P	150									
		TNMR0220120		200									
M24 × 3	P3	TNMR024S515	5P	150	39	-	80	19	15	18	4	3	○
		TNMR024S520		200									△
		TNMR024S525		250									△
		TNMR024S115	1.5P	150									○
		TNMR024S120		200									△
		TNMR024S125		250									△
	P4	TNMS024S515	5P	150									△
		TNMS024S115	1.5P	150									△
M24 × 2	P3	TNMR024Q520	5P	200	39	-	80	19	15	18	4	3	△
		TNMR024Q120	1.5P										
M24 × 1.5	P3	TNMR0240515	5P	150	39	-	80	19	15	18	4	3	○
		TNMR0240520		200									△
		TNMR0240115	1.5P	150									○
		TNMR0240120		200									△
M27 × 3	P3	TNMR027S520	5P	200	39	-	80	20	15	18	4	3	△
		TNMR027S525		250									
		TNMR027S120	1.5P	200									
		TNMR027S125		250									
M27 × 2	P3	TNMR027Q525	5P	250	39	-	80	20	15	18	4	3	△
		TNMR027Q125	1.5P										
M27 × 1.5	P3	TNMR0270520	5P	200	39	-	80	20	15	18	4	3	△
		TNMR0270525		250									
		TNMR0270120	1.5P	200									
		TNMR0270125		250									
M30 × 3.5	P4	TNMS030T520	5P	200	46	-	80	23	17	20	4	3	△
		TNMS030T525		250									
		TNMS030T530		300									
		TNMS030T120	1.5P	200									
		TNMS030T125		250									
		TNMS030T130		300									
M30 × 3	P3	TNMR030S525	5P	250	46	-	80	23	17	20	4	3	△
		TNMR030S125	1.5P										
M30 × 2	P3	TNMR030Q520	5P	200	46	-	80	23	17	20	4	3	△
		TNMR030Q525		250									
		TNMR030Q120	1.5P	200									
		TNMR030Q125		250									
M30 × 1.5	P3	TNMR0300520	5P	200	46	-	80	23	17	20	4	3	△
		TNMR0300525		250									
		TNMR0300120	1.5P	200									
		TNMR0300125		250									

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

Hand Tap Series

LS-HT Long Shank Hand Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Unified Threads													
1/4-20UNC	P2	TNMQU04N515	5P	150	15	26	40	6	4.5	7	3	1	△
		TNMQU04N520		200									
		TNMQU04N115	1.5P	150									
		TNMQU04N120		200									
1/4-28UNF	P2	TNMQU04K515	5P	150	15	26	40	6	4.5	7	3	1	△
		TNMQU04K520		200									
		TNMQU04K115	1.5P	150									
		TNMQU04K120		200									
5/16-18UNC	P2	TNMQU05O515	5P	150	19	-	50	6.2	5	8	4	2	△
		TNMQU05O520		200									
		TNMQU05O115	1.5P	150									
		TNMQU05O120		200									
5/16-24UNF	P2	TNMQU05M515	5P	150	19	-	50	6.2	5	8	4	2	△
		TNMQU05M520		200									
		TNMQU05M115	1.5P	150									
		TNMQU05M120		200									
3/8-16UNC	P2	TNMQU06P515	5P	150	23	-	50	7	5.5	8	4	2	△
		TNMQU06P520		200									
		TNMQU06P115	1.5P	150									
		TNMQU06P120		200									
3/8-24UNF	P2	TNMQU06M515	5P	150	23	-	50	7	5.5	8	4	2	△
		TNMQU06M520		200									
		TNMQU06M115	1.5P	150									
		TNMQU06M120		200									
7/16-14UNC	P3	TNMRU07Q515	5P	150	26	-	50	8.5	6.5	9	4	2	△
		TNMRU07Q115	1.5P	150									
7/16-20UNF	P2	TNMQU07N515	5P	150	26	-	50	8.5	6.5	9	4	2	△
		TNMQU07N520		200									
		TNMQU07N115	1.5P	150									
		TNMQU07N120		200									
1/2-13UNC	P3	TNMRU08R515	5P	150	26	-	60	10.5	8	11	4	2	△
		TNMRU08R520		200									
		TNMRU08R115	1.5P	150									
		TNMRU08R120		200									
1/2-20UNF	P2	TNMQU08N515	5P	150	26	-	60	10.5	8	11	4	2	△
		TNMQU08N520		200									
		TNMQU08N115	1.5P	150									
		TNMQU08N120		200									
9/16-18UNF	P2	TNMQU09O515	5P	150	26	-	60	12.5	10	13	4	2	△
		TNMQU09O115	1.5P	150									
5/8-11UNC	P3	TNMRU10U515	5P	150	26	-	60	12.5	10	13	4	2	△
		TNMRU10U520		200									
		TNMRU10U115	1.5P	150									
		TNMRU10U120		200									
5/8-18UNF	P2	TNMQU10O515	5P	150	26	-	60	12.5	10	13	4	2	△
		TNMQU10O115	1.5P	150									
3/4-10UNC	P3	TNMRU12V515	5P	150	33	-	70	15	12	15	4	3	△
		TNMRU12V520		200									
		TNMRU12V115	1.5P	150									

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

LS-HT Long Shank Hand Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
3/4-10UNC	P3	TNMRU12V120	1.5P	200	33	-	70	15	12	15	4	3	△
3/4-16UNF	P3	TNMRU12P515	5P	150	33	-	70	15	12	15	4	3	△
		TNMRU12P115	1.5P										
7/8-9UNC	P3	TNMRU14W520	5P	200	33	-	70	17	13	16	4	3	△
		TNMRU14W120	1.5P										
1 -8UNC	P3	TNMRU16X515	5P	150	39	-	80	19	15	18	4	3	△
		TNMRU16X520		200									
		TNMRU16X115	1.5P	150									
		TNMRU16X120		200									

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

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(for through hole)

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(for through hole)

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(for through hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

LS-HT LH

Long Shank Hand Taps for Left Hand Threads

Specification



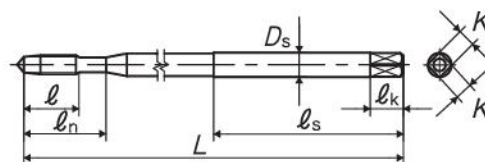
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

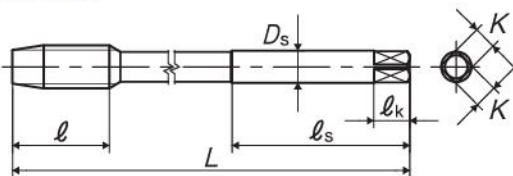
For icon explanation, refer to P.24



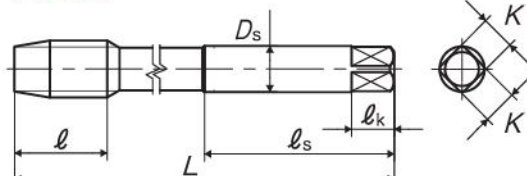
TYPE:1



TYPE:2



TYPE:3



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	l (mm)	l _n (mm)	l _s (mm)	D _s (mm)	K (mm)	l _k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M3 × 0.5	P1	TNMP3.0G510L	5P	100	9	14	40	4	3.2	6	3	1	△
		TNMP3.0G110L	1.5P										
M4 × 0.7	P2	TNMQ4.0I510L	5P	100	11	17	40	5	4	7	3	1	△
		TNMQ4.0I110L	1.5P										
M5 × 0.8	P2	TNMQ5.0K510L	5P	100	13	22	40	5.5	4.5	7	3	1	△
		TNMQ5.0K110L	1.5P										
M6 × 1	P2	TNMQ6.0M510L	5P	100	15	26	40	6	4.5	7	3	1	△
		TNMQ6.0M515L		150									
		TNMQ6.0M110L	1.5P	100									
		TNMQ6.0M115L		150									
M8 × 1.25	P2	TNMQ8.0N510L	5P	100	19	-	50	6.2	5	8	4	2	△
		TNMQ8.0N515L		150									
		TNMQ8.0N110L	1.5P	100									
		TNMQ8.0N115L		150									
M10 × 1.5	P2	TNMQ0100510L	5P	100	23	-	50	7	5.5	8	4	2	△
		TNMQ0100515L		150									
		TNMQ0100110L	1.5P	100									
		TNMQ0100115L		150									
M10 × 1.25	P2	TNMQ010N515L	5P	150	23	-	50	7	5.5	8	4	2	△
		TNMQ010N115L	1.5P										
M12 × 1.75	P2	TNMQ012P515L	5P	150	26	-	50	8.5	6.5	9	4	2	△
		TNMQ012P115L	1.5P										
M12 × 1.5	P2	TNMQ0120515L	5P	150	26	-	50	8.5	6.5	9	4	2	△

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

LS-HT LH Long Shank Hand Taps for Left Hand Threads

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M12 × 1.5	P2	TNMQ0120115L	1.5P	150	26	-	50	8.5	6.5	9	4	2	△
M12 × 1.25	P2	TNMQ012N515L	5P	150	26	-	50	8.5	6.5	9	4	2	△
		TNMQ012N115L	1.5P										
M14 × 2	P2	TNMQ014Q515L	5P	150	26	-	60	10.5	8	11	4	2	△
		TNMQ014Q115L	1.5P										
M14 × 1.5	P2	TNMQ014Q515L	5P	150	26	-	60	10.5	8	11	4	2	△
		TNMQ014Q115L	1.5P										
M16 × 2	P2	TNMQ016Q515L	5P	150	26	-	60	12.5	10	13	4	2	△
		TNMQ016Q520L		200									
		TNMQ016Q115L	1.5P	150									
		TNMQ016Q120L		200									
M16 × 1.5	P2	TNMQ016Q515L	5P	150	26	-	60	12.5	10	13	4	2	△
		TNMQ016Q115L	1.5P										
M18 × 2.5	P3	TNMR018R515L	5P	150	33	-	70	14	11	14	4	2	△
		TNMR018R115L	1.5P										
M18 × 1.5	P2	TNMQ018Q515L	5P	150	33	-	70	14	11	14	4	2	△
		TNMQ018Q115L	1.5P										
M20 × 2.5	P3	TNMR020R515L	5P	150	33	-	70	15	12	15	4	3	△
		TNMR020R520L		200									
		TNMR020R115L	1.5P	150									
		TNMR020R120L		200									
M20 × 1.5	P3	TNMR020Q515L	5P	150	33	-	70	15	12	15	4	3	△
		TNMR020Q520L		200									
		TNMR020Q115L	1.5P	150									
		TNMR020Q120L		200									
M22 × 2.5	P3	TNMR022R515L	5P	150	33	-	70	17	13	16	4	3	△
		TNMR022R520L		200									
		TNMR022R115L	1.5P	150									
		TNMR022R120L		200									
M24 × 3	P3	TNMR024S515L	5P	150	39	-	80	19	15	18	4	3	△
		TNMR024S520L		200									
		TNMR024S115L	1.5P	150									
		TNMR024S120L		200									
M27 × 3	P3	TNMR027S520L	5P	200	39	-	80	20	15	18	4	3	△
		TNMR027S120L	1.5P										
M30 × 3.5	P4	TNMS030T520L	5P	200	46	-	80	23	17	20	4	3	△
		TNMS030T120L	1.5P										

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-HT V

Long Shank Hand Taps, Coated
Specification



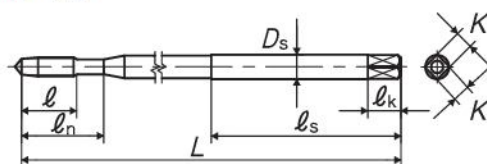
■ Adopting the optimum coating for the tapping condition.

Recommended Tapping Speeds depending on Materials

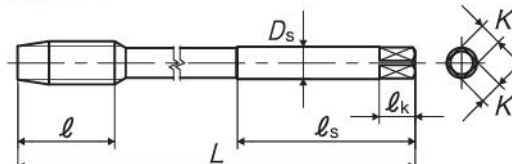
High carbon steels
高炭素鋼
10~20
(m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	l (mm)	l _n (mm)	l _s (mm)	D _s (mm)	K (mm)	l _k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M3 × 0.5	P1	TNMP3.0G510V	5P	100	9	14	40	4	3.2	6	3	1	△
		TNMP3.0G110V	1.5P										
M4 × 0.7	P2	TNMQ4.0I510V	5P	100	11	17	40	5	4	7	3	1	△
		TNMQ4.0I110V	1.5P										
M5 × 0.8	P2	TNMQ5.0K510V	5P	100	13	22	40	5.5	4.5	7	3	1	△
		TNMQ5.0K110V	1.5P										
M6 × 1	P2	TNMQ6.0M510V	5P	100	15	26	40	6	4.5	7	3	1	△
		TNMQ6.0M515V		150									
		TNMQ6.0M110V	1.5P	100									
		TNMQ6.0M115V		150									
M8 × 1.25	P2	TNMQ8.0N510V	5P	100	19	-	50	6.2	5	8	4	2	△
		TNMQ8.0N515V		150									
		TNMQ8.0N110V	1.5P	100									
		TNMQ8.0N115V		150									
M10 × 1.5	P2	TNMQ0100510V	5P	100	23	-	50	7	5.5	8	4	2	△
		TNMQ0100515V		150									
		TNMQ0100110V	1.5P	100									
		TNMQ0100115V		150									
M10 × 1.25	P2	TNMQ010N510V	5P	100	23	-	50	7	5.5	8	4	2	△
		TNMQ010N515V		150									
		TNMQ010N110V	1.5P	100									
		TNMQ010N115V		150									
M12 × 1.75	P2	TNMQ012P510V	5P	100	26	-	50	8.5	6.5	9	4	2	△
		TNMQ012P515V		150									
		TNMQ012P110V	1.5P	100									
		TNMQ012P115V		150									
M12 × 1.5	P2	TNMQ0120510V	5P	100	26	-	50	8.5	6.5	9	4	2	△

LS-HT V Long Shank Hand Taps, Coated

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M12 × 1.5	P2	TNMQ0120515V	5P	150	26	-	50	8.5	6.5	9	4	2	△
		TNMQ0120110V	1.5P	100									
		TNMQ0120115V		150									
M12 × 1.25	P2	TNMQ012N510V	5P	100	26	-	50	8.5	6.5	9	4	2	△
		TNMQ012N515V	1.5P	150									
		TNMQ012N110V		100									
		TNMQ012N115V		150									

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-HT

Hand Taps for Stainless Steels

Specification

HSS

OX
Oxide



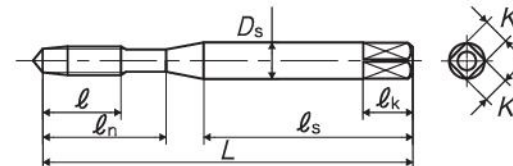
■SU-HT is the hand tap suitable for stainless steels which are sticky and tend to work-harden as well as chrome steel and molybdenum steels.

Recommended Tapping Speeds depending on Materials

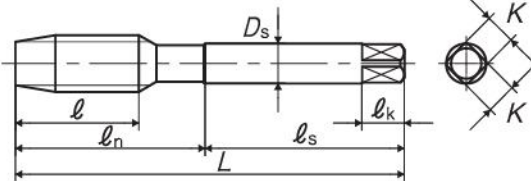
Stainless steels
ステンレス鋼
~5
(m/min)

For icon explanation, refer to P.24

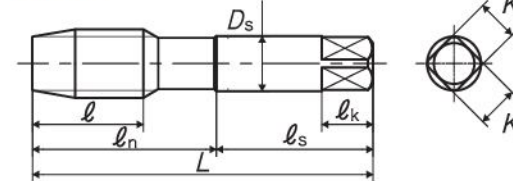
TYPE:1



TYPE:2



TYPE:3



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	Type	Stock
For Metric Threads													
M2 × 0.4	P2	TUMQ2.0E4	4P	42	7.2	12	27	3	2.5	5	3	1	○
		TUMQ2.0E1	1.5P										
M2.3 × 0.4	P2	TUMQ2.3E4	4P	42	7.2	12	27	3	2.5	5	3	1	△
		TUMQ2.3E1	1.5P										
M2.5 × 0.45	P2	TUMQ2.5F4	4P	46	8.1	14	29	3	2.5	5	3	1	△
		TUMQ2.5F1	1.5P										
M2.6 × 0.45	P2	TUMQ2.6F4	4P	46	8.1	14	29	3	2.5	5	3	1	△
		TUMQ2.6F1	1.5P										
M3 × 0.5	P2	TUMQ3.0G4	4P	46	9	14	26	4	3.2	6	3	1	◎
		TUMQ3.0G1	1.5P										
M3.5 × 0.6	P2	TUMQ3.5H4	4P	52	11	16	29	5	4	7	3	1	△
		TUMQ3.5H1	1.5P										
M4 × 0.7	P2	TUMQ4.0I4	4P	52	11	17	29	5	4	7	3	1	◎
		TUMQ4.0I1	1.5P										
M5 × 0.8	P2	TUMQ5.0K4	4P	60	13	22	33	5.5	4.5	7	3	1	◎
		TUMQ5.0K1	1.5P										
M6 × 1	P2	TUMQ6.0M4	4P	62	15	26	33	6	4.5	7	3	1	◎
		TUMQ6.0M1	1.5P										
M6 × 0.75	P2	TUMQ6.0J4	4P	62	15	26	33	6	4.5	7	3	1	△
		TUMQ6.0J1	1.5P										
M8 × 1.25	P3	TUMR8.0N4	4P	70	19	-	36	6.2	5	8	3 4	2	◎
		TUMR8.0N1	1.5P										
M8 × 1	P3	TUMR8.0M4	4P	70	19	-	36	6.2	5	8	3 4	2	△
		TUMR8.0M1	1.5P										

HT-33

Think threads with
YAMAWA

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

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

SU-HT Hand Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M10 × 1.5	P3	TUMR01004	4P	75	23	-	38	7	5.5	8	3	2	◎
		TUMR01001	1.5P								4		
M10 × 1.25	P3	TUMR010N4	4P	75	23	-	38	7	5.5	8	3	2	△
		TUMR010N1	1.5P								4		
M10 × 1	P3	TUMR010M4	4P	75	23	-	38	7	5.5	8	3	2	△
		TUMR010M1	1.5P								4		
M12 × 1.75	P4	TUMS012P4	4P	82	26	-	42	8.5	6.5	9	3	2	◎
		TUMS012P1	1.5P								4		
M12 × 1.5	P3	TUMR01204	4P	82	26	-	42	8.5	6.5	9	3	2	△
		TUMR01201	1.5P								4		
M12 × 1.25	P4	TUMS012N4	4P	82	26	-	42	8.5	6.5	9	3	2	△
		TUMS012N1	1.5P								4		
M12 × 1	P3	TUMR012M4	4P	82	26	-	42	8.5	6.5	9	3	2	△
		TUMR012M1	1.5P								4		
M14 × 2	P4	TUMS014Q4	4P	88	26	-	45	10.5	8	11	4	2	△
		TUMS014Q1	1.5P										
M14 × 1.5	P3	TUMR01404	4P	88	26	-	45	10.5	8	11	4	2	△
		TUMR01401	1.5P										
M14 × 1.25	P3	TUMR014N4	4P	88	26	-	45	10.5	8	11	4	2	△
		TUMR014N1	1.5P										
M14 × 1	P3	TUMR014M4	4P	88	26	-	45	10.5	8	11	4	2	△
		TUMR014M1	1.5P										
M16 × 2	P4	TUMS016Q4	4P	95	26	-	48	12.5	10	13	4	2	○
		TUMS016Q1	1.5P										
M16 × 1.5	P3	TUMR01604	4P	95	26	-	48	12.5	10	13	4	2	△
		TUMR01601	1.5P										
M16 × 1	P3	TUMR016M4	4P	95	26	-	48	12.5	10	13	4	2	△
		TUMR016M1	1.5P										
M18 × 2.5	P4	TUMS018R4	4P	100	33	-	51	14	11	14	4	2	△
		TUMS018R1	1.5P										
M18 × 1.5	P4	TUMS01804	4P	100	33	-	51	14	11	14	4	2	△
		TUMS01801	1.5P										
M20 × 2.5	P4	TUMS020R4	4P	105	33	-	50	15	12	15	4	3	○
		TUMS020R1	1.5P										
M20 × 1.5	P4	TUMS02004	4P	105	33	-	50	15	12	15	4	3	△
		TUMS02001	1.5P										
M22 × 2.5	P4	TUMS022R4	4P	115	33	-	55	17	13	16	4	3	△
		TUMS022R1	1.5P										
M22 × 1.5	P4	TUMS02204	4P	115	33	-	55	17	13	16	4	3	△
		TUMS02201	1.5P										
M24 × 3	P4	TUMS024S4	4P	120	39	-	55	19	15	18	4	3	△
		TUMS024S1	1.5P										
M24 × 1.5	P4	TUMS02404	4P	120	39	-	55	19	15	18	4	3	△
		TUMS02401	1.5P										
M27 × 3	P4	TUMS027S4	4P	130	39	-	60	20	15	18	4	3	△
		TUMS027S1	1.5P										
M27 × 1.5	P4	TUMS02704	4P	130	39	-	60	20	15	18	4	3	△
		TUMS02701	1.5P										
M30 × 3.5	P5	TUMT030T4	4P	135	46	-	62	23	17	20	4	3	△
		TUMT030T1	1.5P										

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

Hand Tap Series

SU-HT Hand Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M30 × 1.5	P4	TUMS03004	4P	135	46	-	62	23	17	20	4	3	△
		TUMS03001	1.5P										
For Unified Threads													
Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
1/4-20UNC	P2	TUMQU04N4	4P	62	15	26	33	6	4.5	7	3	1	△
		TUMQU04N1	1.5P										
1/4-28UNF	P2	TUMQU04K4	4P	62	15	26	33	6	4.5	7	3	1	△
		TUMQU04K1	1.5P										
5/16-18UNC	P3	TUMRU05O4	4P	70	19	-	36	6.2	5	8	3	2	△
		TUMRU05O1	1.5P								4		
5/16-24UNF	P2	TUMQU05M4	4P	70	19	-	36	6.2	5	8	3	2	△
		TUMQU05M1	1.5P								4		
3/8-16UNC	P3	TUMRU06P4	4P	75	23	-	38	7	5.5	8	3	2	△
		TUMRU06P1	1.5P								4		
3/8-24UNF	P2	TUMQU06M4	4P	75	23	-	38	7	5.5	8	3	2	△
		TUMQU06M1	1.5P								4		
7/16-14UNC	P3	TUMRU07Q4	4P	82	26	-	42	8.5	6.5	9	3	2	△
		TUMRU07Q1	1.5P								4		
7/16-20UNF	P3	TUMRU07N4	4P	82	26	-	42	8.5	6.5	9	3	2	△
		TUMRU07N1	1.5P								4		
1/2-13UNC	P3	TUMRU08R4	4P	88	26	-	45	10.5	8	11	3	2	△
		TUMRU08R1	1.5P								4		
1/2-20UNF	P3	TUMRU08N4	4P	88	26	-	45	10.5	8	11	3	2	△
		TUMRU08N1	1.5P								4		
5/8-11UNC	P3	TUMRU10U4	4P	95	26	-	48	12.5	10	13	4	2	△
		TUMRU10U1	1.5P										
5/8-18UNF	P3	TUMRU10O4	4P	95	26	-	48	12.5	10	13	4	2	△
		TUMRU10O1	1.5P										
3/4-10UNC	P4	TUMSU12V4	4P	105	33	-	50	15	12	15	4	3	△
		TUMSU12V1	1.5P										
3/4-16UNF	P3	TUMRU12P4	4P	105	33	-	50	15	12	15	4	3	△
		TUMRU12P1	1.5P										
For Whitworth Threads													
Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
1/4W20	P3	TUMRW04N4	4P	62	15	26	33	6	4.5	7	3	1	△
		TUMRW04N1	1.5P										
5/16W18	P3	TUMRW05O4	4P	70	19	-	36	6.2	5	8	3	2	△
		TUMRW05O1	1.5P								4		
3/8W16	P3	TUMRW06P4	4P	75	23	-	38	7	5.5	8	3	2	△
		TUMRW06P1	1.5P								4		
7/16W14	P3	TUMRW07Q4	4P	82	26	-	42	8.5	6.5	9	3	2	△
		TUMRW07Q1	1.5P								4		
1/2W12	P3	TUMRW08S4	4P	88	26	-	45	10.5	8	11	3	2	△
		TUMRW08S1	1.5P								4		
5/8W11	P3	TUMRW10U4	4P	95	26	-	48	12.5	10	13	4	2	△
		TUMRW10U1	1.5P										
3/4W10	P4	TUMSW12V4	4P	105	33	-	50	15	12	15	4	3	△
		TUMSW12V1	1.5P										

FC-HT

Hand Taps for Cast Irons

Specification



Recommended Tapping Speeds depending on Materials

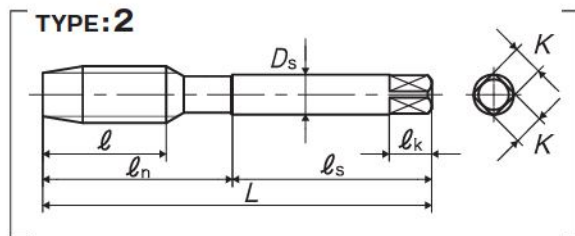
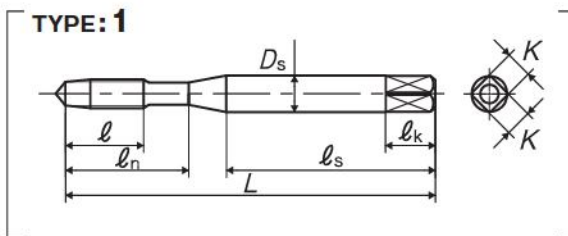
Cast Irons
铸铁
5~10
(m/min)

For icon explanation, refer to P.24

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



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



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M3 × 0.5	P3	TY3.0GRAEN5	5P	46	9	14	26	4	3.2	6	3	1	○
		TY3.0GRAENA	1.5P										
M3.5 × 0.6	P3	TY3.5HRAEN5	5P	52	11	16	29	5	4	7	3	1	△
		TY3.5HRAENA	1.5P										
M4 × 0.7	P3	TY4.0IRAEN5	5P	52	11	17	29	5	4	7	3	1	○
		TY4.0IRAENA	1.5P										
M5 × 0.8	P3	TY5.0KRAEN5	5P	60	13	22	33	5.5	4.5	7	3	1	○
		TY5.0KRAENA	1.5P										
M6 × 1	P3	TY6.0MRAEN5	5P	62	15	26	33	6	4.5	7	3	1	◎
		TY6.0MRAENA	1.5P										
M8 × 1.25	P3	TY8.0NRAEN5	5P	70	19	-	36	6.2	5	8	3	2	◎
		TY8.0NRAENA	1.5P										
M8 × 1	P3	TY8.0MRAEN5	5P	70	19	-	36	6.2	5	8	3	2	△
		TY8.0MRAENA	1.5P										
M10 × 1.5	P4	TY0100SAEN5	5P	75	23	-	38	7	5.5	8	4	2	◎
		TY0100SAENA	1.5P										
M10 × 1.25	P3	TY010NRAEN5	5P	75	23	-	38	7	5.5	8	4	2	◎
		TY010NRAENA	1.5P										
M10 × 1	P3	TY010MRAEN5	5P	75	23	-	38	7	5.5	8	4	2	○
		TY010MRAENA	1.5P										
M12 × 1.75	P4	TY012PSAEN5	5P	82	26	-	42	8.5	6.5	9	4	2	◎
		TY012PSAENA	1.5P										
M12 × 1.5	P4	TY0120SAEN5	5P	82	26	-	42	8.5	6.5	9	4	2	○
		TY0120SAENA	1.5P										
M12 × 1.25	P4	TY012NSAEN5	5P	82	26	-	42	8.5	6.5	9	4	2	○
		TY012NSAENA	1.5P										
M12 × 1	P3	TY012MRAEN5	5P	82	26	-	42	8.5	6.5	9	4	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

HT-36

187

FC-HT Hand Taps for Cast Irons

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M12 × 1	P3	TY012MRAENA	1.5P	82	26	-	42	8.5	6.5	9	4	2	△
M14 × 2	P4	TY014QSAEN5	5P	88	26	-	45	10.5	8	11	4	2	○
		TY014QSAENA	1.5P										
M14 × 1.5	P4	TY014QSAEN5	5P	88	26	-	45	10.5	8	11	4	2	○
		TY014QSAENA	1.5P										
M16 × 2	P4	TY016QSAEN5	5P	95	26	-	48	12.5	10	13	4	2	○
		TY016QSAENA	1.5P										
M16 × 1.5	P4	TY016QSAEN5	5P	95	26	-	48	12.5	10	13	4	2	○
		TY016QSAENA	1.5P										
M18 × 2.5	P5	TY018RTAEN5	5P	100	33	-	51	14	11	14	4	2	○
		TY018RTAENA	1.5P										
M18 × 1.5	P4	TY018QSAEN5	5P	100	33	-	51	14	11	14	4	2	○
		TY018QSAENA	1.5P										

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

FC-O

Hand Taps for Cast Irons

Specification



Recommended Tapping Speeds depending on Materials

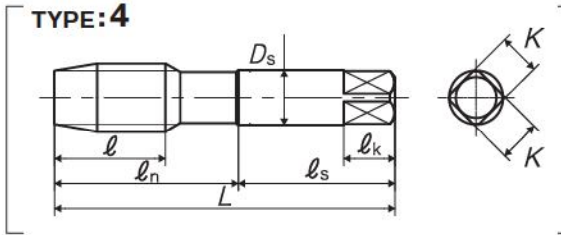
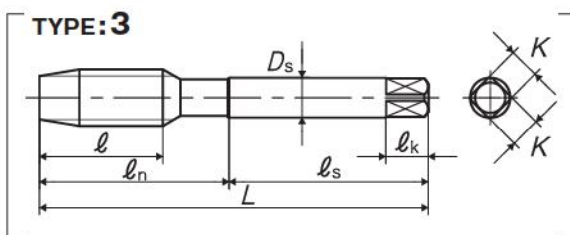
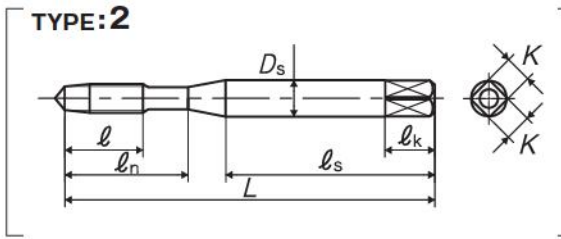
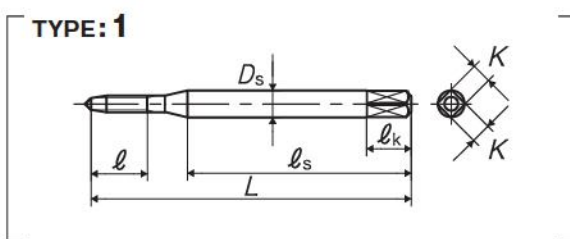
Cast Irons
 铸铁
5~10
 (m/min)

For icon explanation, refer to P.24

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



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



Segment : 1A

Size	Thread limit $D_2 - T_{0.1} - Z$ (+)(μm)	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M1.6 × 0.35	40 ~ 25	TFCM1.6D5	5P	36	6.3	-	24	3	2.5	5	3	1	△
		TFCM1.6D1	1.5P										
M2 × 0.4	40 ~ 25	TFCM2.0E5	5P	42	7.2	12	27	3	2.5	5	3	2	△
		TFCM2.0E1	1.5P										
M2.3 × 0.4	40 ~ 25	TFCM2.3E5	5P	42	7.2	12	27	3	2.5	5	3	2	△
		TFCM2.3E1	1.5P										
M2.5 × 0.45	40 ~ 25	TFCM2.5F5	5P	46	8.1	14	29	3	2.5	5	3	2	△
		TFCM2.5F1	1.5P										
M2.6 × 0.45	40 ~ 25	TFCM2.6F5	5P	46	8.1	14	29	3	2.5	5	3	2	△
		TFCM2.6F1	1.5P										
M3 × 0.5	40 ~ 25	TFCM3.0G5	5P	46	9	14	26	4	3.2	6	3	2	○
		TFCM3.0G1	1.5P										
M3.5 × 0.6	40 ~ 25	TFCM3.5H5	5P	52	11	16	29	5	4	7	3	2	△
		TFCM3.5H1	1.5P										
M4 × 0.7	45 ~ 25	TFCM4.0I5	5P	52	11	17	29	5	4	7	4	2	○
		TFCM4.0I1	1.5P										
M5 × 0.8	50 ~ 30	TFCM5.0K5	5P	60	13	22	33	5.5	4.5	7	4	2	○
		TFCM5.0K1	1.5P										

○=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

HT-38

189

Hand Tap Series

FC-O Hand Taps for Cast Irons

	Size	Thread limit D ₂ -Toℓ-Z (μm) (+)	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M6 × 1	50 ~ 30	TFCM6.0M5	5P	62	15	26	33	6	4.5	7	4	2	◎
			TFCM6.0M1	1.5P										
Spiral Fluted Taps (for through hole)	M8 × 1.25	60 ~ 35	TFCM8.0N5	5P	70	19	-	36	6.2	5	8	4	3	◎
			TFCM8.0N1	1.5P										
Spiral Pointed Taps (for through hole)	M8 × 1	55 ~ 30	TFCM8.0M5	5P	70	19	-	36	6.2	5	8	4	3	△
			TFCM8.0M1	1.5P										
Hand Taps	M10 × 1.5	65 ~ 40	TFCM01005	5P	75	23	-	38	7	5.5	8	4	3	◎
			TFCM01001	1.5P										
Cemented Carbide Taps	M10 × 1.25	60 ~ 35	TFCM010N5	5P	75	23	-	38	7	5.5	8	4	3	◎
			TFCM010N1	1.5P										
Roll Taps	M10 × 1	57 ~ 32	TFCM010M5	5P	75	23	-	38	7	5.5	8	4	3	○
			TFCM010M1	1.5P										
Special Thread Taps Simple Inspection Tools	M12 × 1.75	70 ~ 40	TFCM012P5	5P	82	26	-	42	8.5	6.5	9	4	3	◎
			TFCM012P1	1.5P										
Pipe Taps	M12 × 1.5	70 ~ 40	TFCM01205	5P	82	26	-	42	8.5	6.5	9	4	3	○
			TFCM01201	1.5P										
Thread Mills	M12 × 1.25	70 ~ 40	TFCM012N5	5P	82	26	-	42	8.5	6.5	9	4	3	○
			TFCM012N1	1.5P										
Center Drills	M12 × 1	65 ~ 35	TFCM012M5	5P	82	26	-	42	8.5	6.5	9	4	3	△
			TFCM012M1	1.5P										
Centering Tools	M14 × 2	70 ~ 40	TFCM014Q5	5P	88	26	-	45	10.5	8	11	4	3	○
			TFCM014Q1	1.5P										
	M14 × 1.5	70 ~ 40	TFCM01405	5P	88	26	-	45	10.5	8	11	4	3	○
			TFCM01401	1.5P										
	M16 × 2	70 ~ 40	TFCM016Q5	5P	95	26	-	48	12.5	10	13	4	3	○
			TFCM016Q1	1.5P										
	M16 × 1.5	70 ~ 40	TFCM01605	5P	95	26	-	48	12.5	10	13	4	3	○
			TFCM01601	1.5P										
	M18 × 2.5	80 ~ 45	TFCM018R5	5P	100	33	-	51	14	11	14	4	3	○
			TFCM018R1	1.5P										
	M18 × 1.5	70 ~ 40	TFCM01805	5P	100	33	-	51	14	11	14	4	3	○
			TFCM01801	1.5P										
	M20 × 2.5	80 ~ 45	TFCM020R5	5P	105	33	-	50	15	12	15	4	4	○
			TFCM020R1	1.5P										
	M20 × 1.5	75 ~ 40	TFCM02005	5P	105	33	-	50	15	12	15	4	4	○
			TFCM02001	1.5P										
	M22 × 2.5	80 ~ 45	TFCM022R5	5P	115	33	-	55	17	13	16	4	4	△
			TFCM022R1	1.5P										
	M22 × 1.5	75 ~ 40	TFCM02205	5P	115	33	-	55	17	13	16	4	4	△
			TFCM02201	1.5P										
	M24 × 3	90 ~ 50	TFCM024S5	5P	120	39	-	55	19	15	18	4	4	△
			TFCM024S1	1.5P										
	M24 × 1.5	75 ~ 40	TFCM02405	5P	120	39	-	55	19	15	18	4	4	○
			TFCM02401	1.5P										

LA-HT

Hand Taps for Die Cast Materials

Specification



Recommended Tapping Speeds depending on Materials

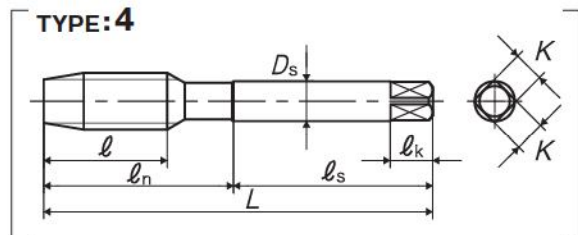
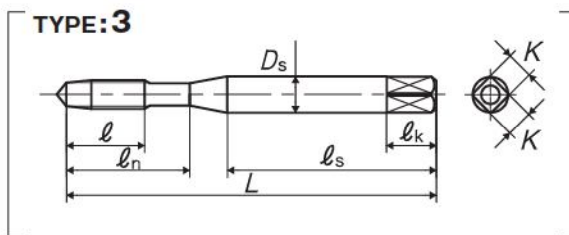
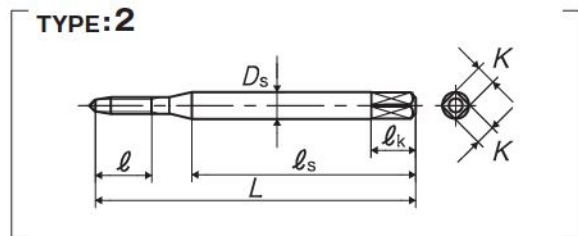
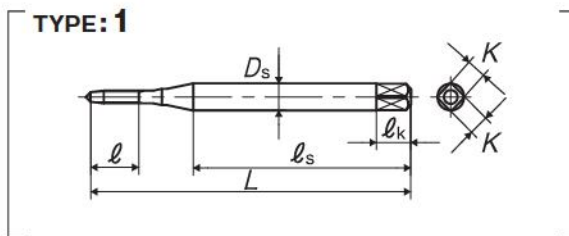
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

For icon explanation, refer to P.24

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



■LA-HT is the oversized tap, and is suitable for the materials tending to shrink, such as aluminum alloy diecastings (ADC) and zinc alloy diecastings (ZDC).



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M1.4 × 0.3	P2	TY1.4CQLEN5	5P	36	5.4	-	24	3	2.5	5	3	1	△
		TY1.4CQLENA	1.5P										
M1.6 × 0.35	P2	TY1.6DQLEN5	5P	36	6.3	-	24	3	2.5	5	3	2	△
		TY1.6DQLENA	1.5P										
M2 × 0.4	P2	TY2.0EQLEN5	5P	42	7.2	12	27	3	2.5	5	3	3	◎
		TY2.0EQLENA	1.5P										
M2.3 × 0.4	P2	TY2.3EQLEN5	5P	42	7.2	12	27	3	2.5	5	3	3	△
		TY2.3EQLENA	1.5P										
M2.5 × 0.45	P2	TY2.5FQLEN5	5P	46	8.1	14	29	3	2.5	5	3	3	○
		TY2.5FQLENA	1.5P										
M2.6 × 0.45	P2	TY2.6FQLEN5	5P	46	8.1	14	29	3	2.5	5	3	3	△
		TY2.6FQLENA	1.5P										
M3 × 0.5	P2	TY3.0GQLEN5	5P	46	9	14	26	4	3.2	6	3	3	○
		TY3.0GQLENA	1.5P										
M3.5 × 0.6	P2	TY3.5HQLEN5	5P	52	11	16	29	5	4	7	3	3	△
		TY3.5HQLENA	1.5P										
M4 × 0.7	P3	TY4.0IRLEN5	5P	52	11	17	29	5	4	7	3	3	○
		TY4.0IRLENA	1.5P										
M5 × 0.8	P3	TY5.0KRLEN5	5P	60	13	22	33	5.5	4.5	7	3	3	○
		TY5.0KRLENA	1.5P										

◎=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

HT-40

LA-HT Hand Taps for Die Cast Materials

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M6 × 1	P3	TY6.0MRLN5	5P	62	15	26	33	6	4.5	7	3	3	◎
		TY6.0MRLNA	1.5P										
M8 × 1.25	P3	TY8.0NRLN5	5P	70	19	-	36	6.2	5	8	3	4	○
		TY8.0NRLNA	1.5P										
M8 × 1	P3	TY8.0MRLN5	5P	70	19	-	36	6.2	5	8	3	4	△
		TY8.0MRLNA	1.5P										
M10 × 1.5	P4	TY0100SLEN5	5P	75	23	-	38	7	5.5	8	4	4	○
		TY0100SLENA	1.5P										
M10 × 1.25	P3	TY010NRLN5	5P	75	23	-	38	7	5.5	8	4	4	○
		TY010NRLNA	1.5P										
M10 × 1	P3	TY010MRLN5	5P	75	23	-	38	7	5.5	8	4	4	△
		TY010MRLNA	1.5P										
M12 × 1.75	P4	TY012PSLEN5	5P	82	26	-	42	8.5	6.5	9	4	4	○
		TY012PSLENA	1.5P										
M12 × 1.5	P4	TY0120SLEN5	5P	82	26	-	42	8.5	6.5	9	4	4	△
		TY0120SLENA	1.5P										
M12 × 1.25	P4	TY012NSLEN5	5P	82	26	-	42	8.5	6.5	9	4	4	△
		TY012NSLENA	1.5P										
M12 × 1	P3	TY012MRLN5	5P	82	26	-	42	8.5	6.5	9	4	4	△
		TY012MRLNA	1.5P										
M14 × 2	P4	TY014QSLEN5	5P	88	26	-	45	10.5	8	11	4	4	△
		TY014QSLENA	1.5P										
M14 × 1.5	P4	TY0140SLEN5	5P	88	26	-	45	10.5	8	11	4	4	○
		TY0140SLENA	1.5P										
M16 × 2	P4	TY016QSLEN5	5P	95	26	-	48	12.5	10	13	4	4	△
		TY016QSLENA	1.5P										
M16 × 1.5	P4	TY0160SLEN5	5P	95	26	-	48	12.5	10	13	4	4	△
		TY0160SLENA	1.5P										

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

LA-O

Hand Taps for Die Cast Materials

Specification



Recommended Tapping Speeds depending on Materials

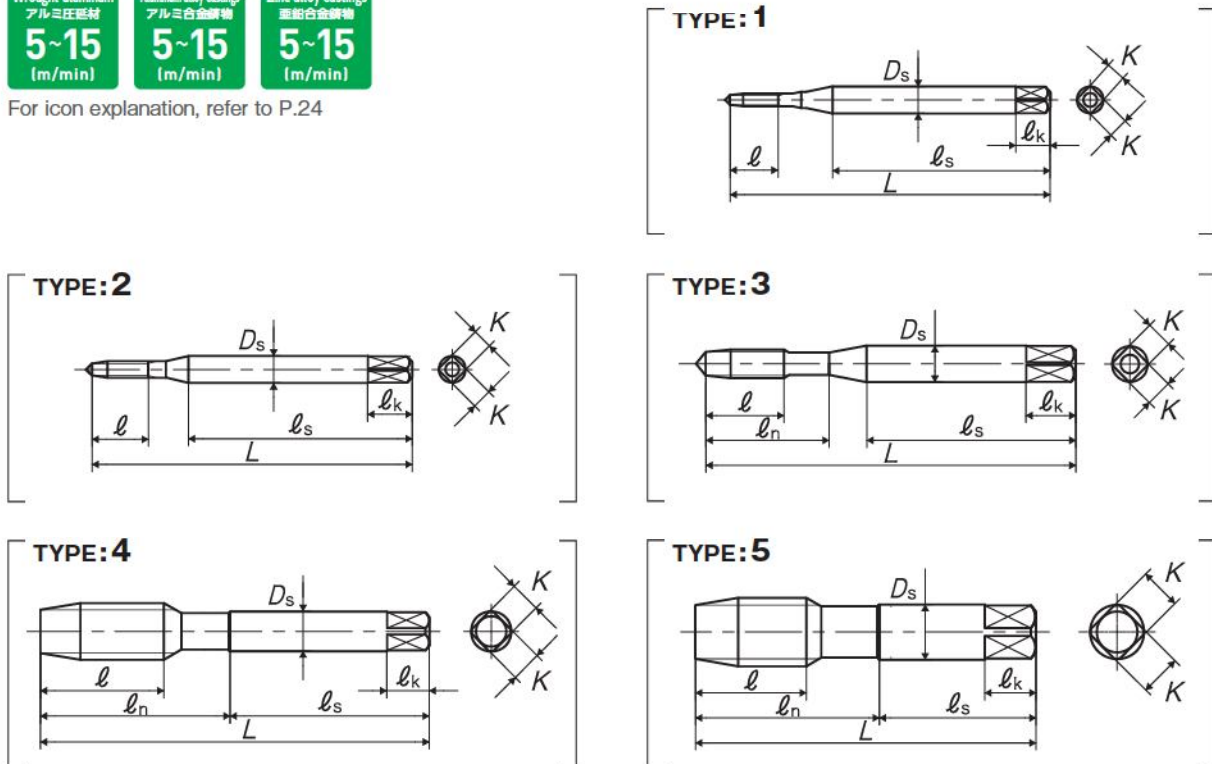
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

For icon explanation, refer to P.24

Overall length	Thread length	Thread+Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_n	ℓ_s	D_s	K	ℓ_k



■LA-O is the oversized tap, and is suitable for the materials tending to shrink, such as aluminum alloy die castings (ADC) and zinc alloy die castings (ZDC).



Segment : 1A

Size	Thread limit $D_2 - T_{0.01} \cdot Z$ (+)(μm)	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	D_s (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M1.4 × 0.3	36 ~ 21	TLAM1.4C5	5P	36	5.4	-	24	3	2.5	5	3	1	△
		TLAM1.4C1	1.5P										
M1.6 × 0.35	40 ~ 25	TLAM1.6D5	5P	36	6.3	-	24	3	2.5	5	3	2	△
		TLAM1.6D1	1.5P										
M2 × 0.4	40 ~ 25	TLAM2.0E5	5P	42	7.2	12	27	3	2.5	5	3	3	◎
		TLAM2.0E1	1.5P										
M2.3 × 0.4	40 ~ 25	TLAM2.3E5	5P	42	7.2	12	27	3	2.5	5	3	3	△
		TLAM2.3E1	1.5P										
M2.5 × 0.45	40 ~ 25	TLAM2.5F5	5P	46	8.1	14	29	3	2.5	5	3	3	○
		TLAM2.5F1	1.5P										
M2.6 × 0.45	40 ~ 25	TLAM2.6F5	5P	46	8.1	14	29	3	2.5	5	3	3	△
		TLAM2.6F1	1.5P										
M3 × 0.5	40 ~ 25	TLAM3.0G5	5P	46	9	14	26	4	3.2	6	3	3	○
		TLAM3.0G1	1.5P										
M3.5 × 0.6	40 ~ 25	TLAM3.5H5	5P	52	11	16	29	5	4	7	3	3	△

◎=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

HT-42

193

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

LA-O Hand Taps for Die Cast Materials

Size	Thread limit $D_2 - T_{0.01} - Z$ (μm) (+)	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M3.5 × 0.6	40 ~ 25	TLAM3.5H1	1.5P	52	11	16	29	5	4	7	3	3	△
M4 × 0.7	45 ~ 25	TLAM4.0I5	5P	52	11	17	29	5	4	7	3	3	○
		TLAM4.0H1	1.5P										
M5 × 0.8	50 ~ 30	TLAM5.0K5	5P	60	13	22	33	5.5	4.5	7	3	3	○
		TLAM5.0K1	1.5P										
M6 × 1	50 ~ 30	TLAM6.0M5	5P	62	15	26	33	6	4.5	7	3	3	◎
		TLAM6.0M1	1.5P										
M8 × 1.25	65 ~ 40	TLAM8.0N5	5P	70	19	-	36	6.2	5	8	4	4	○
		TLAM8.0N1	1.5P										
M8 × 1	55 ~ 30	TLAM8.0M5	5P	70	19	-	36	6.2	5	8	4	4	△
		TLAM8.0M1	1.5P										
M10 × 1.5	70 ~ 45	TLAM010O5	5P	75	23	-	38	7	5.5	8	4	4	○
		TLAM010O1	1.5P										
M10 × 1.25	65 ~ 40	TLAM010N5	5P	75	23	-	38	7	5.5	8	4	4	○
		TLAM010N1	1.5P										
M10 × 1	57 ~ 32	TLAM010M5	5P	75	23	-	38	7	5.5	8	4	4	△
		TLAM010M1	1.5P										
M12 × 1.75	75 ~ 45	TLAM012P5	5P	82	26	-	42	8.5	6.5	9	4	4	○
		TLAM012P1	1.5P										
M12 × 1.5	75 ~ 45	TLAM012O5	5P	82	26	-	42	8.5	6.5	9	4	4	△
		TLAM012O1	1.5P										
M12 × 1.25	75 ~ 45	TLAM012N5	5P	82	26	-	42	8.5	6.5	9	4	4	△
		TLAM012N1	1.5P										
M12 × 1	65 ~ 35	TLAM012M5	5P	82	26	-	42	8.5	6.5	9	4	4	△
		TLAM012M1	1.5P										
M14 × 2	75 ~ 45	TLAM014Q5	5P	88	26	-	45	10.5	8	11	4	4	△
		TLAM014Q1	1.5P										
M14 × 1.5	75 ~ 45	TLAM014O5	5P	88	26	-	45	10.5	8	11	4	4	○
		TLAM014O1	1.5P										
M16 × 2	75 ~ 45	TLAM016Q5	5P	95	26	-	48	12.5	10	13	4	4	△
		TLAM016Q1	1.5P										
M16 × 1.5	75 ~ 45	TLAM016O5	5P	95	26	-	48	12.5	10	13	4	4	△
		TLAM016O1	1.5P										
M18 × 2.5	85 ~ 50	TLAM018R5	5P	100	33	-	51	14	11	14	4	4	△
		TLAM018R1	1.5P										
M18 × 1.5	75 ~ 45	TLAM018O5	5P	100	33	-	51	14	11	14	4	4	△
		TLAM018O1	1.5P										
M20 × 2.5	85 ~ 50	TLAM020R5	5P	105	33	-	50	15	12	15	4	5	△
		TLAM020R1	1.5P										
M20 × 1.5	80 ~ 45	TLAM020O5	5P	105	33	-	50	15	12	15	4	5	○
		TLAM020O1	1.5P										
M22 × 2.5	85 ~ 50	TLAM022R5	5P	115	33	-	55	17	13	16	4	5	△
		TLAM022R1	1.5P										
M22 × 1.5	80 ~ 45	TLAM022O5	5P	115	33	-	55	17	13	16	4	5	△
		TLAM022O1	1.5P										
M24 × 3	90 ~ 50	TLAM024S5	5P	120	39	-	55	19	15	18	4	5	△
		TLAM024S1	1.5P										
M24 × 1.5	80 ~ 45	TLAM024O5	5P	120	39	-	55	19	15	18	4	5	△
		TLAM024O1	1.5P										

Centering T

AXE-HT

AXE Hand Taps

Specification



Recommended Tapping Speeds depending on Materials

Aluminum alloy castings アルミニウム合金鋳物	Zinc alloy castings 亜鉛合金鋳物
10~20 (m/min)	10~20 (m/min)

For icon explanation, refer to P.24

Product features

- In tapping Aluminum Alloy Castings and the like, AXE-HT realizes the tremendous improvement in its endurance due to the proprietary flute design.
- Special cutting edge design results in little damage on the cutting edge.
Combination of premium powder HSS (featuring high wear resistance and heat resistance) and special coating brings out 5 times longer tool life than previous taps designed for aluminum.
- Cutting edge with little damage restricts both the size change of internal threads and the worsening of surface roughness.
- Most preferable combination of negative rake angle and eccentric relief enables AXE taps to be applicable in wider range of cutting speed, from middle speed to high speed.

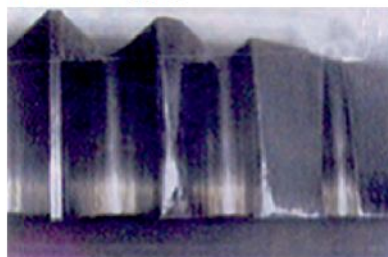
Tapping data

Comparison of tool life between AXE and LA-O (previous product)

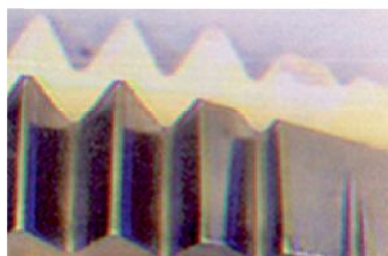
Tap M8×1.25

AXE	HSS-P Special coating
LA-O	HSS-E NI surface treatment
Work material	AC4A-T6 treated
Tapping length	13mm (blind hole)
Tapping speed	10m/min
Machine	Transfer machine
Feed	Lead screw feed
Bored hole	φ6.8
Tapping fluid	Water soluble oil (x30)

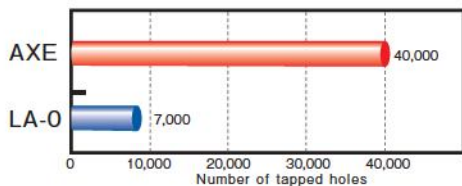
Damage at cutting edge after 7000 holes tapping



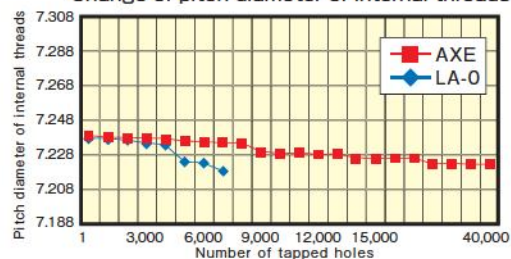
LA-O



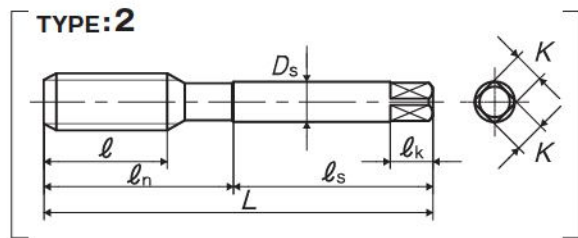
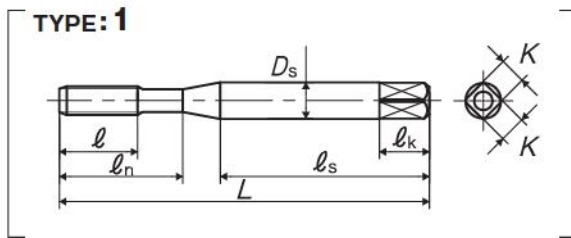
AXE



Change of pitch diameter of internal threads



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



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M6 × 1	P3	TAXEMR6.0M1	1.5P	62	15	26	33	6	4.5	7	3	1	△
M8 × 1.25	P3	TAXEMR8.0N1	1.5P	70	19	-	36	6.2	5	8	4	2	△
M10 × 1.5	P3	TAXEMR01001	1.5P	75	23	-	38	7	5.5	8	4	2	△
M10 × 1.25	P3	TAXEMR010N1	1.5P	75	23	-	38	7	5.5	8	4	2	△
M10 × 1	P3	TAXEMR010M1	1.5P	75	23	-	38	7	5.5	8	4	2	△
M12 × 1.75	P3	TAXEMR012P1	1.5P	82	26	-	42	8.5	6.5	9	4	2	△
M12 × 1.5	P3	TAXEMR01201	1.5P	82	26	-	42	8.5	6.5	9	4	2	△
M12 × 1.25	P3	TAXEMR012N1	1.5P	82	26	-	42	8.5	6.5	9	4	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

MG-HT

Hand Taps with Short Chamfer for Magnesium Alloy Castings

Specification



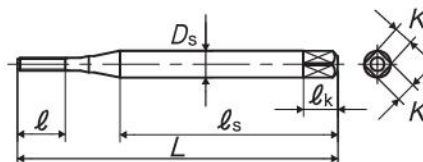
■ Having short chamfer length of less than 1 thread, MG-HT is most suitable for blind holes with little space in the bottom.

Recommended Tapping Speeds depending on Materials

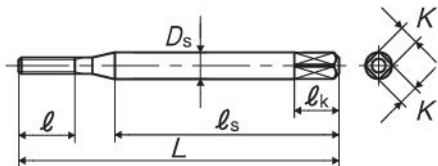
Aluminum alloy castings アルミ合金鋳物	Magnesium alloy castings マグネシウム合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

For icon explanation, refer to P.24

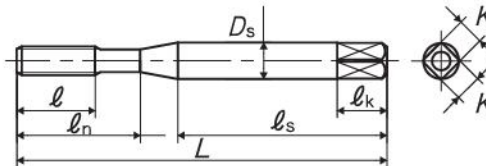
TYPE:1



TYPE:2



TYPE:3



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	l (mm)	l _n (mm)	l _s (mm)	D _s (mm)	K (mm)	l _k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M1.4 × 0.3	P2	TMGMQ1.4C1	1P	36	5.4	-	24	3	2.5	5	3	1	△
M1.6 × 0.35	P2	TMGMQ1.6D1	1P	36	6.3	-	24	3	2.5	5	3	2	△
M1.7 × 0.35	P2	TMGMQ1.7D1	1P	36	6.3	-	24	3	2.5	5	3	2	△
M2 × 0.4	P2	TMGMQ2.0E1	1P	42	7.2	12	27	3	2.5	5	3	3	△
M2.5 × 0.45	P2	TMGMQ2.5F1	1P	46	8.1	14	29	3	2.5	5	3	3	△
M2.6 × 0.45	P2	TMGMQ2.6F1	1P	46	8.1	14	29	3	2.5	5	3	3	△
M3 × 0.5	P2	TMGMQ3.0G1	1P	46	9	14	26	4	3.2	6	3	3	△

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

AL-HT

Hand Taps for Helical Coil Wire Screw Thread Inserts

Specification

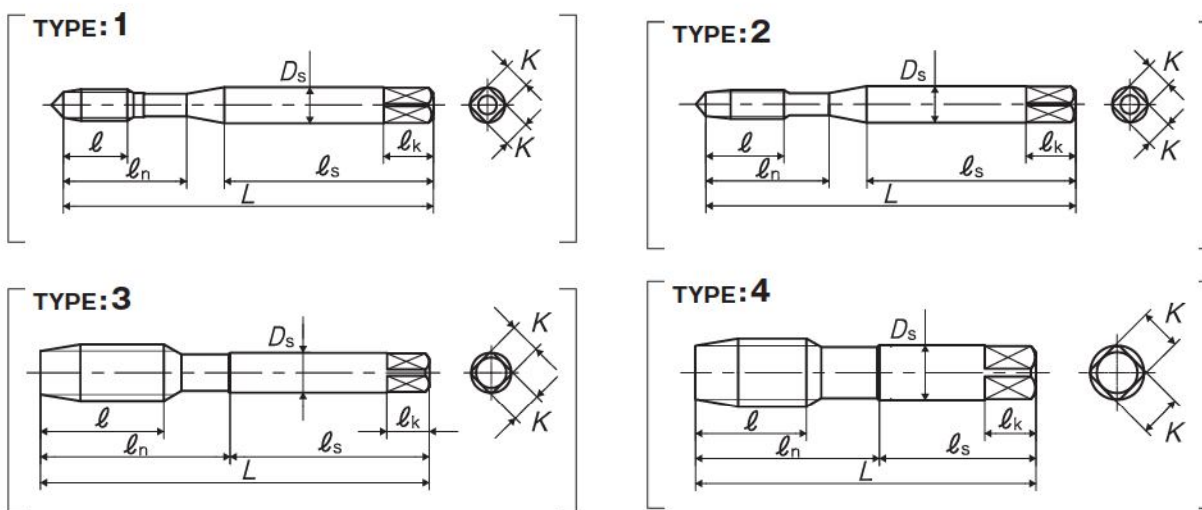


■ Hand tap cutting internal threads for helical coil to enter.

Recommended Tapping Speeds depending on Materials

Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

For icon explanation, refer to P.24



Segment : 1A

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Helical Coil Wire Screw Thread Inserts, for Metric Threads														
STI M2.6 × 0.45	1b	TW2.6F1LEB5	5P	3.185	52	6.8	16	29	5	4	7	3	1	△
		TW2.6F1LEBA	1.5P											
STI M3 × 0.5	1b	TW3.0G1LEB5	5P	3.650	52	7.5	17	29	5	4	7	3	1	◎
		TW3.0G1LEBA	1.5P											
STI M4 × 0.7	1b	TW4.0I1LEB5	5P	4.909	60	13	22	33	5.5	4.5	7	4	2	◎
		TW4.0I1LEBA	1.5P											
STI M5 × 0.8	1b	TW5.0K1LEB5	5P	6.039	62	15	26	33	6	4.5	7	4	2	◎
		TW5.0K1LEBA	1.5P											
STI M6 × 1	1b	TW6.0M1LEB5	5P	7.299	70	19	-	36	6.2	5	8	4	3	◎
		TW6.0M1LEBA	1.5P											
STI M8 × 1.25	1b	TW8.0N1LEB5	5P	9.624	75	23	-	38	7	5.5	8	4	3	◎
		TW8.0N1LEBA	1.5P											
STI M10 × 1.5	1b	TW01001LEB5	5P	11.949	82	26	-	42	8.5	6.5	9	4	3	◎
		TW01001LEBA	1.5P											
STI M10 × 1.25	1b	TW010N1LEB5	5P	11.624	82	26	-	42	8.5	6.5	9	4	3	△
		TW010N1LEBA	1.5P											
STI M10 × 1	1b	TW010M1LEB5	5P	11.299	82	26	-	42	8.5	6.5	9	4	3	△
		TW010M1LEBA	1.5P											
STI M12 × 1.75	1b	TW012P1LEB5	5P	14.273	95	26	-	48	12.5	10	13	4	3	◎

◎=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

HT-48

199

Hand Tap Series

AL-HT Hand Taps for Helical Coil Wire Screw Thread Inserts

	Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	STI M12 × 1.75	1b	TW012P1LEBA	1.5P	14.273	95	26	-	48	12.5	10	13	4	3	◎
	STI M12 × 1.5	1b	TW01201LEB5 TW01201LEBA	5P 1.5P	13.948	88	26	-	45	10.5	8	11	4	3	△
Spiral Fluted Taps (for through hole)	STI M12 × 1.25	1b	TW012N1LEB5 TW012N1LEBA	5P 1.5P	13.624	88	26	-	45	10.5	8	11	4	3	△
	STI M14 × 2	1b	TW014Q1LEB5 TW014Q1LEBA	5P 1.5P	16.598	100	33	-	51	14	11	14	4	3	△
Spiral Pointed Taps (for through hole)	STI M14 × 1.5	1b	TW014O1LEB5 TW014O1LEBA	5P 1.5P	15.948	95	26	-	48	12.5	10	13	4	3	△
	STI M16 × 2	1b	TW016Q1LEB5 TW016Q1LEBA	5P 1.5P	18.598	105	33	-	50	15	12	15	4	4	○
Hand Taps	STI M16 × 1.5	1b	TW016O1LEB5 TW016O1LEBA	5P 1.5P	17.948	100	33	-	51	14	11	14	4	3	△
	STI M18 × 2.5	1b	TW018R1LEB5 TW018R1LEBA	5P 1.5P	21.248	115	33	-	55	17	13	16	4	4	△
Cemented Carbide Taps	STI M18 × 1.5	1b	TW018O1LEB5 TW018O1LEBA	5P 1.5P	19.948	105	33	-	50	15	12	15	4	4	△
	STI M20 × 2.5	1b	TW020R1LEB5 TW020R1LEBA	5P 1.5P	23.248	120	39	-	55	19	15	18	4	4	○
Roll Taps	STI M20 × 1.5	1b	TW020O1LEB5 TW020O1LEBA	5P 1.5P	21.948	115	33	-	55	17	13	16	4	4	△
	STI M22 × 2.5	1b	TW022R1LEB5 TW022R1LEBA	5P 1.5P	25.248	125	39	-	58	19	15	18	4	4	△
Special Thread Taps Simple Inspection Tools	STI M22 × 1.5	1b	TW022O1LEB5 TW022O1LEBA	5P 1.5P	23.948	120	39	-	55	19	15	18	4	4	△
	STI M24 × 3	1b	TW024S1LEB5 TW024S1LEBA	5P 1.5P	27.897	135	46	-	62	23	17	20	4	4	○
Pipe Taps	STI M24 × 1.5	1b	TW024O1LEB5 TW024O1LEBA	5P 1.5P	25.948	130	39	-	60	20	15	18	4	4	△
	For Helical Coil Wire Screw Thread Inserts, for Unified Threads														
	Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Thread Mills	STI No.4-40UNC	1b	TWUN4H1LEB5 TWUN4H1LEBA	5P 1.5P	3.670	52	11	17	29	5	4	7	3	2	△
	STI No.4-48UNF	1b	TWUN4F1LEB5 TWUN4F1LEBA	5P 1.5P	3.532	52	11	17	29	5	4	7	3	2	△
Dies	STI No.5-40UNC	1b	TWUN5H1LEB5 TWUN5H1LEBA	5P 1.5P	4.000	52	11	17	29	5	4	7	3	2	△
	STI No.6-32UNC	1b	TWUN6J1LEB5 TWUN6J1LEBA	5P 1.5P	4.536	60	13	22	33	5.5	4.5	7	3	2	△
Center Drills	STI No.6-40UNF	1b	TWUN6H1LEB5 TWUN6H1LEBA	5P 1.5P	4.330	60	13	22	33	5.5	4.5	7	3	2	△
	STI No.8-32UNC	1b	TWUN8J1LEB5 TWUN8J1LEBA	5P 1.5P	5.197	62	15	26	33	6	4.5	7	4	2	△
Centering Tools	STI No.8-36UNF	1b	TWUN8I1LEB5 TWUN8I1LEBA	5P 1.5P	5.083	62	9.5	26	33	6	4.5	7	4	1	△
	STI No.10-24UNC	1b	TWUNAM1LEB5 TWUNAM1LEBA	5P 1.5P	6.200	62	15	26	33	6	4.5	7	4	2	△
	STI No.10-32UNF	1b	TWUNAJ1LEB5 TWUNAJ1LEBA	5P 1.5P	5.857	62	15	26	33	6	4.5	7	4	2	△

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

AL-HT Hand Taps for Helical Coil Wire Screw Thread Inserts

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
STI No.12-24UNC	1b	TWUNCM1LEB5	5P	6.861	70	19	-	36	6.2	5	8	4	3	△
		TWUNCM1LEBA	1.5P											
STI 1/4-20UNC	1b	TWU04N1LEB5	5P	8.000	70	19	-	36	6.2	5	8	4	3	△
		TWU04N1LEBA	1.5P											
STI 1/4-28UNF	1b	TWU04K1LEB5	5P	7.528	70	19	-	36	6.2	5	8	4	3	△
		TWU04K1LEBA	1.5P											
STI 5/16-18UNC	1b	TWU05O1LEB5	5P	9.771	75	23	-	38	7	5.5	8	4	3	△
		TWU05O1LEBA	1.5P											
STI 5/16-24UNF	1b	TWU05M1LEB5	5P	9.313	75	23	-	38	7	5.5	8	4	3	△
		TWU05M1LEBA	1.5P											
STI 3/8-16UNC	1b	TWU06P1LEB5	5P	11.587	82	26	-	42	8.5	6.5	9	4	3	△
		TWU06P1LEBA	1.5P											
STI 3/8-24UNF	1b	TWU06M1LEB5	5P	10.900	82	26	-	42	8.5	6.5	9	4	3	△
		TWU06M1LEBA	1.5P											
STI 7/16-14UNC	1b	TWU07Q1LEB5	5P	13.469	88	26	-	45	10.5	8	11	4	3	△
		TWU07Q1LEBA	1.5P											
STI 7/16-20UNF	1b	TWU07N1LEB5	5P	12.762	88	26	-	45	10.5	8	11	4	3	△
		TWU07N1LEBA	1.5P											
STI 1/2-13UNC	1b	TWU08R1LEB5	5P	15.238	95	26	-	48	12.5	10	13	4	3	△
		TWU08R1LEBA	1.5P											
STI 1/2-20UNF	1b	TWU08N1LEB5	5P	14.350	95	26	-	48	12.5	10	13	4	3	△
		TWU08N1LEBA	1.5P											
STI 5/8-11UNC	1b	TWU10U1LEB5	5P	18.875	105	33	-	50	15	12	15	4	4	△
		TWU10U1LEBA	1.5P											
STI 5/8-18UNF	1b	TWU10O1LEB5	5P	17.708	100	33	-	51	14	11	14	4	3	△
		TWU10O1LEBA	1.5P											
STI 3/4-16UNF	1b	TWU12P1LEB5	5P	21.112	115	33	-	55	17	13	16	4	4	△
		TWU12P1LEBA	1.5P											

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

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

PL1

Hand Taps for Plastics

Specification

HSS

NI
Nitride



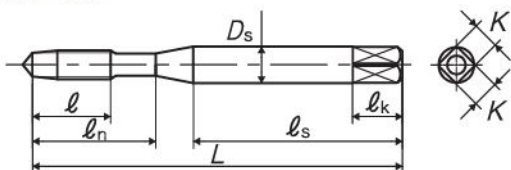
■PL1 is the tap for thermosetting plastic which is specially hard-to-machine material among plastics.

Recommended Tapping Speeds depending on Materials

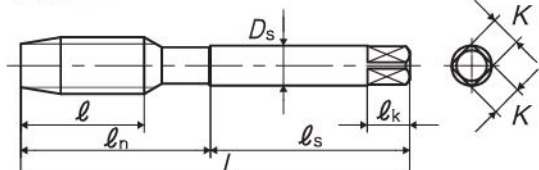
Thermosetting plastic
熱硬化性プラスチック
5~10
(m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	Type	Stock
For Metric Threads													
M2 × 0.4	P4	TPLM2.0E3	3P	42	7.2	12	27	3	2.5	5	3	1	△
M2.3 × 0.4	P4	TPLM2.3E3	3P	42	7.2	12	27	3	2.5	5	3	1	△
M2.5 × 0.45	P4	TPLM2.5F3	3P	46	8.1	14	29	3	2.5	5	3	1	○
M2.6 × 0.45	P4	TPLM2.6F3	3P	46	8.1	14	29	3	2.5	5	3	1	△
M3 × 0.5	P5	TPLM3.0G3	3P	46	9	14	26	4	3.2	6	4	1	○
M3.5 × 0.6	P5	TPLM3.5H3	3P	52	11	16	29	5	4	7	4	1	○
M4 × 0.7	P5	TPLM4.0I3	3P	52	11	17	29	5	4	7	4	1	○
M5 × 0.8	P5	TPLM5.0K3	3P	60	13	22	33	5.5	4.5	7	4	1	○
M6 × 1	P5	TPLM6.0M3	3P	62	15	26	33	6	4.5	7	4	1	△
M8 × 1.25	P6	TPLM8.0N3	3P	70	19	-	36	6.2	5	8	4	2	△

MC-HT

Hand Taps with Internal Coolant Hole Specification



Recommended Tapping Speeds depending on Materials

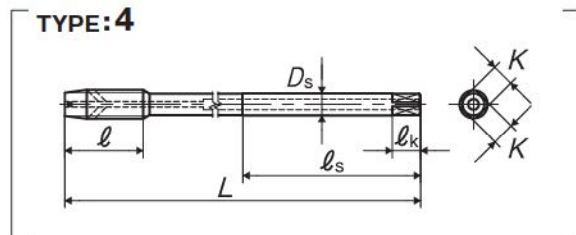
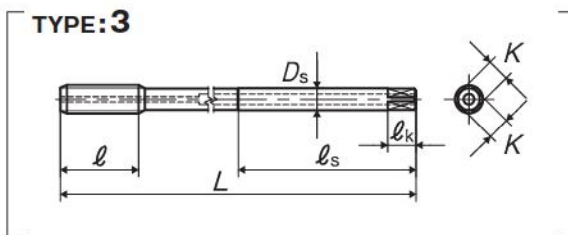
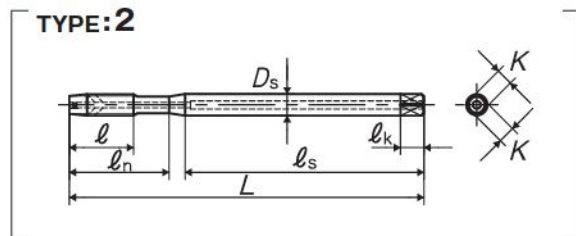
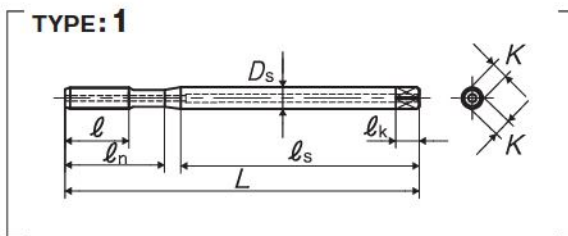
Medium carbon steels
中炭鋼
5~10
(m/min)

For icon explanation, refer to P.24

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



Through internal coolant hole, satisfactory amount of oil is supplied to the exact cutting area. MC-HT hand tap ensures a long tool life and internal threads with good surface finish.



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M6 × 1	P2	ML106.0M5-Q	5P	100	19	28	40	6	4.5	7	4	2	△
		ML156.0M5-Q		150								1	
		ML106.0M1-Q	1.5P	100								1	
		ML156.0M1-Q		150								1	
M8 × 1.25	P2	ML108.0N5-Q	5P	100	22	-	50	6.2	5	8	4	4	△
		ML158.0N5-Q		150								3	
		ML108.0N1-Q	1.5P	100								3	
		ML158.0N1-Q		150								3	
M10 × 1.5	P2	ML1001005-Q	5P	100	24	-	50	7	5.5	8	4	4	△
		ML1501005-Q		150								3	
		ML1001001-Q	1.5P	100								3	
		ML1501001-Q		150								3	
M10 × 1.25	P2	ML10010N5-Q	5P	100	20	-	50	7	5.5	8	4	4	△
		ML15010N5-Q		150								3	
		ML10010N1-Q	1.5P	100								3	
		ML15010N1-Q		150								3	
M12 × 1.75	P2	ML10012P5-Q	5P	100	29	-	50	8.5	6.5	9	4	4	△
		ML15012P5-Q		150								4	
		ML20012P5-Q		200								4	

○=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

Centering Tools

Centering Tools

Centering Tools

HT-52

203

Hand Tap Series

MC-HT Hand Taps with Internal Coolant Hole

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M12 × 1.75	P2	ML10012P1-Q	1.5P	100	29	-	50	8.5	6.5	9	4	3	△
			ML15012P1-Q		150									
			ML20012P1-Q		200									
Spiral Fluted Taps (for through hole)	M12 × 1.5	P2	ML1001205-Q	5P	100	29	-	50	8.5	6.5	9	4	4	△
			ML1501205-Q		150									
			ML2001205-Q		200									
			ML1001201-Q	1.5P	100								3	
			ML1501201-Q		150									
			ML2001201-Q		200									
Spiral Pointed Taps (for through hole)	M12 × 1.25	P2	ML10012N5-Q	5P	100	24	-	50	8.5	6.5	9	4	4	△
			ML15012N5-Q		150									
			ML20012N5-Q		200									
			ML10012N1-Q	1.5P	100								3	
			ML15012N1-Q		150									
			ML20012N1-Q		200									
Cemented Carbide Taps	M14 × 2	P2	ML15014Q5-Q	5P	150	30	-	60	10.5	8	11	4	4	△
			ML20014Q5-Q		200									
			ML15014Q1-Q	1.5P	150								3	
			ML20014Q1-Q		200									
Roll Taps	M14 × 1.5	P2	ML1501405-Q	5P	150	30	-	60	10.5	8	11	4	4	△
			ML2001405-Q		200									
			ML1501401-Q	1.5P	150								3	
			ML2001401-Q		200									
Special Thread Taps Simple Inspection Tools	M16 × 2	P2	ML15016Q5-Q	5P	150	32	-	60	12.5	10	13	4	4	△
			ML20016Q5-Q		200									
			ML15016Q1-Q	1.5P	150								3	
			ML20016Q1-Q		200									
Pipe Taps	M16 × 1.5	P2	ML1501605-Q	5P	150	32	-	60	12.5	10	13	4	4	△
			ML2001605-Q		200									
			ML1501601-Q	1.5P	150								3	
			ML2001601-Q		200									
Thread Mills	M18 × 2.5	P3	ML15018R5-R	5P	150	37	-	70	14	11	14	4	4	△
			ML20018R5-R		200									
			ML15018R1-R	1.5P	150								3	
			ML20018R1-R		200									
Dies	M18 × 1.5	P2	ML1501805-Q	5P	150	29	-	70	14	11	14	4	4	△
			ML2001805-Q		200									
			ML1501801-Q	1.5P	150								3	
			ML2001801-Q		200									
Center Drills	M20 × 2.5	P3	ML15020R5-R	5P	150	37	-	70	15	12	15	4	4	△
			ML20020R5-R		200									
			ML15020R1-R	1.5P	150								3	
			ML20020R1-R		200									
Centering Tools	M20 × 1.5	P3	ML1502005-R	5P	150	29	-	70	15	12	15	4	4	△
			ML2002005-R		200									
			ML1502001-R	1.5P	150								3	
			ML2002001-R		200									
	M22 × 2.5	P3	ML15022R5-R	5P	150	38	-	70	17	13	16	4	4	△
			ML20022R5-R		200									
			ML15022R1-R	1.5P	150								3	

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

MC-HT Hand Taps with Internal Coolant Hole

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M22 × 2.5	P3	ML20022R1-R	1.5P	200	38	-	70	17	13	16	4	3	△
M22 × 1.5	P3	ML1502205-R	5P	150	33	-	70	17	13	16	4	4	△
		ML2002205-R		200								3	
		ML1502201-R	1.5P	150								3	
		ML2002201-R		200								3	
M24 × 3	P3	ML15024S5-R	5P	150	45	-	80	19	15	18	4	4	△
		ML20024S5-R		200								3	
		ML15024S1-R	1.5P	150								3	
		ML20024S1-R		200								3	
M24 × 1.5	P3	ML1502405-R	5P	150	35	-	80	19	15	18	4	4	△
		ML2002405-R		200								3	
		ML1502401-R	1.5P	150								3	
		ML2002401-R		200								3	
M27 × 3	P3	ML20027S5-R	5P	200	45	-	80	20	15	18	4	4	△
		ML20027S1-R	1.5P	200								3	
M27 × 1.5	P3	ML2002705-R	5P	200	37	-	80	20	15	18	4	4	△
		ML2002701-R	1.5P	200								3	
M30 × 3.5	P4	ML20030T5-S	5P	200	48	-	80	23	17	20	4	4	△
		ML20030T1-S	1.5P	200								3	
M30 × 1.5	P3	ML2003005-R	5P	200	37	-	80	23	17	20	4	4	△
		ML2003001-R	1.5P	200								3	

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through 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

EH-HT

Hand Taps for Hard-to-Machine Materials

Specification



■EH-HT 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.

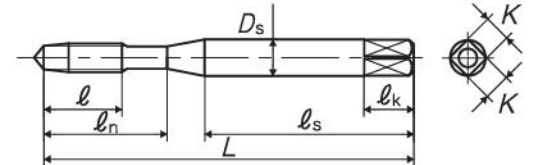
Recommended Tapping Speeds depending on Materials

Thermal refined steels 熱処理鋼	Tool steels 工具鋼
~5 (m/min)	~5 (m/min)

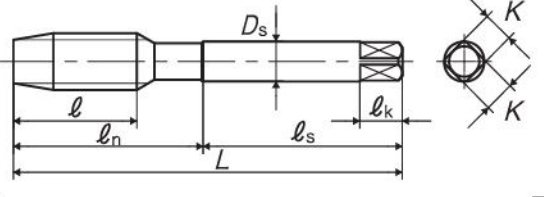
35~45HRC

For icon explanation, refer to P.24

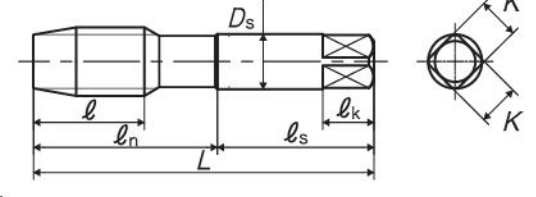
TYPE:1



TYPE:2



TYPE:3



Segment : 1B

Size	Class	Code	Chamfer	L (mm)	l (mm)	l _n (mm)	l _s (mm)	D _s (mm)	K (mm)	l _k (mm)	No. of flutes	Type	Stock
For Metric Threads													
M3 × 0.5	P3	ETHMR3.0G5	5P	46	9	14	26	4	3.2	6	3	1	○
		ETHMR3.0G1	2.5P										
M4 × 0.7	P3	ETHMR4.0I5	5P	52	11	17	29	5	4	7	3	1	○
		ETHMR4.0I1	2.5P										
M5 × 0.8	P3	ETHMR5.0K5	5P	60	13	22	33	5.5	4.5	7	3	1	○
		ETHMR5.0K1	2.5P										
M6 × 1	P3	ETHMR6.0M5	5P	62	15	26	33	6	4.5	7	3	1	○
		ETHMR6.0M1	2.5P										
M8 × 1.25	P4	ETHMS8.0N5	5P	70	19	-	36	6.2	5	8	4	2	○
		ETHMS8.0N1	2.5P										
M10 × 1.5	P4	ETHMS01005	5P	75	23	-	38	7	5.5	8	4	2	○
		ETHMS01001	2.5P										
M10 × 1.25	P4	ETHMS010N5	5P	75	23	-	38	7	5.5	8	4	2	△
		ETHMS010N1	2.5P										
M12 × 1.75	P4	ETHMS012P5	5P	82	26	-	42	8.5	6.5	9	4	2	○
		ETHMS012P1	2.5P										
M12 × 1.5	P4	ETHMS01205	5P	82	26	-	42	8.5	6.5	9	4	2	△
		ETHMS01201	2.5P										
M12 × 1.25	P4	ETHMS012N5	5P	82	26	-	42	8.5	6.5	9	4	2	△
		ETHMS012N1	2.5P										
M14 × 2	P5	ETHMT014Q5	5P	88	26	-	45	10.5	8	11	4	2	△
		ETHMT014Q1	2.5P										
M14 × 1.5	P4	ETHMS01405	5P	88	26	-	45	10.5	8	11	4	2	△
		ETHMS01401	2.5P										

HT-55

206

Think threads with
YAMAWA

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

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

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

EH-HT Hand Taps for Hard-to-Machine Materials

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M16 × 2	P5	ETHMT016Q5	5P	95	26	-	48	12.5	10	13	4	2	○
		ETHMT016Q1	2.5P										
M16 × 1.5	P4	ETHMS01605	5P	95	26	-	48	12.5	10	13	4	2	△
		ETHMS01601	2.5P										
M18 × 2.5	P5	ETHMT018R5	5P	100	33	-	51	14	11	14	4	2	△
		ETHMT018R1	2.5P										
M18 × 1.5	P4	ETHMS01805	5P	100	33	-	51	14	11	14	4	2	△
		ETHMS01801	2.5P										
M20 × 2.5	P5	ETHMT020R5	5P	105	33	-	50	15	12	15	4	3	○
		ETHMT020R1	2.5P										
M20 × 1.5	P4	ETHMS02005	5P	105	33	-	50	15	12	15	4	3	△
		ETHMS02001	2.5P										
M22 × 2.5	P5	ETHMT022R5	5P	115	33	-	55	17	13	16	4	3	△
		ETHMT022R1	2.5P										
M22 × 1.5	P4	ETHMS02205	5P	115	33	-	55	17	13	16	4	3	△
		ETHMS02201	2.5P										
M24 × 3	P5	ETHMT024S5	5P	120	39	-	55	19	15	18	4	3	○
		ETHMT024S1	2.5P										
M24 × 1.5	P4	ETHMS02405	5P	120	39	-	55	19	15	18	4	3	△
		ETHMS02401	2.5P										
M27 × 3	P5	ETHMT027S5	5P	130	39	-	60	20	15	18	4	3	△
		ETHMT027S1	2.5P										
M30 × 3.5	P5	ETHMT030T5	5P	135	46	-	62	23	17	20	4	3	△
		ETHMT030T1	2.5P										

Spiral Fluted Taps
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(for through hole)

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Thread Mills

Dies

Center Drills

Centering Tools