

CEMENTED CARBIDE TAP SERIES



<u>N-CT LA</u>	<u>CT-1</u>
<u>N-CT FC</u>	<u>CT-4</u>
<u>LS-N-CT</u>	<u>CT-8</u>
<u>N-CT-SP</u>	<u>CT-9</u>
<u>N-CT-PO</u>	<u>CT-10</u>
<u>MC-AD-CT</u>	<u>CT-11</u>

<u>EH-CT</u>	<u>CT-13</u>
<u>UH-CT</u>	<u>CT-15</u>
<u>HFACT-P</u>	<u>CT-17</u>
<u>HFACT-B</u>	<u>CT-18</u>
<u>HFICT-P</u>	<u>CT-19</u>
<u>HFICT-B</u>	<u>CT-20</u>

N-CT LA

Carbide Taps for Light Alloys

Specification



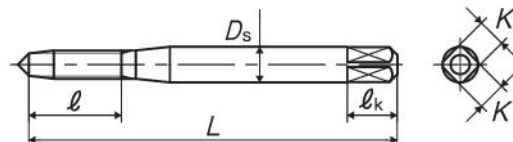
■N-CT LA is the carbide tap suitable for tapping aluminum castings (AC), aluminum die castings (ADC), and zinc diecastings (ZDC). For volume production.

Recommended Tapping Speeds depending on Materials

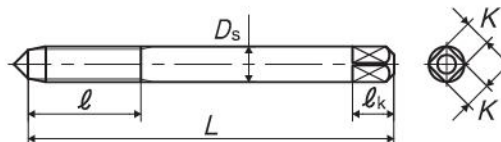
Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
10~20 (m/min)	10~20 (m/min)

For icon explanation, refer to P.24

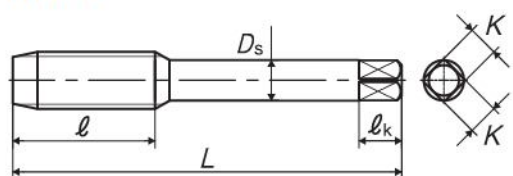
TYPE:1



TYPE:2



TYPE:3



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	Type	Stock
For Metric Threads												
M1.4 × 0.3	P3	TCNR1.4C3A	3P	34	7	-	3	2.5	5	3	1	△
		TCNR1.4C1A	1.5P									
M1.6 × 0.35	P3	TCNR1.6D3A	3P	36	8	-	3	2.5	5	3	1	△
		TCNR1.6D1A	1.5P									
M1.7 × 0.35	P3	TCNR1.7D3A	3P	36	8	-	3	2.5	5	3	1	△
		TCNR1.7D1A	1.5P									
M2 × 0.4	P3	TCNR2.0E3A	3P	40	8	-	3	2.5	5	3	1	○
		TCNR2.0E1A	1.5P									
M2.2 × 0.45	P3	TCNR2.2F3A	3P	42	9.5	-	3	2.5	5	3	1	△
		TCNR2.2F1A	1.5P									
M2.3 × 0.4	P3	TCNR2.3E3A	3P	42	8	-	3	2.5	5	3	1	△
		TCNR2.3E1A	1.5P									
M2.5 × 0.45	P3	TCNR2.5F3A	3P	44	9.5	-	3	2.5	5	3	1	△
		TCNR2.5F1A	1.5P									
M3 × 0.5	P3	TCNR3.0G3A	3P	46	11	-	4	3.2	6	3	1	○
		TCNR3.0G1A	1.5P									
M3.5 × 0.6	P3	TCNR3.5H3A	3P	48	11	-	4	3.2	6	3	1	△
		TCNR3.5H1A	1.5P									
M4 × 0.7	P3	TCNR4.0I3A	3P	52	13	-	5	4	7	3	1	○
		TCNR4.0I1A	1.5P									
M4 × 0.5	P3	TCNR4.0G3A	3P	52	11	-	5	4	7	3	1	△
		TCNR4.0G1A	1.5P									

N-CT LA Carbide Taps for Light Alloys

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)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M5 × 0.8	P3	TCNR5.0K3A	3P	60	16	-	5.5	4.5	7	3	1	○
		TCNR5.0K1A	1.5P									
M5 × 0.5	P3	TCNR5.0G3A	3P	52	11	-	5.5	4.5	7	3	1	△
		TCNR5.0G1A	1.5P									
M6 × 1	P3	TCNR6.0M3A	3P	62	19	-	6	4.5	7	3	2	○
		TCNR6.0M1A	1.5P									
M6 × 0.75	P3	TCNR6.0J3A	3P	62	13	-	6	4.5	7	3	2	△
		TCNR6.0J1A	1.5P									
M6 × 0.5	P3	TCNR6.0G3A	3P	55	11	-	6	4.5	7	3	2	△
		TCNR6.0G1A	1.5P									
M7 × 1	P3	TCNR7.0M3A	3P	65	19	-	6.2	5	8	3	3	△
		TCNR7.0M1A	1.5P									
M7 × 0.75	P3	TCNR7.0J3A	3P	62	13	-	6.2	5	8	3	3	△
		TCNR7.0J1A	1.5P									
M8 × 1.25	P3	TCNR8.0N3A	3P	70	22	-	6.2	5	8	3	3	○
		TCNR8.0N1A	1.5P									
M8 × 1	P3	TCNR8.0M3A	3P	70	19	-	6.2	5	8	3	3	○
		TCNR8.0M1A	1.5P									
M8 × 0.75	P3	TCNR8.0J3A	3P	62	13	-	6.2	5	8	3	3	△
		TCNR8.0J1A	1.5P									
M10 × 1.5	P3	TCNR01003A	3P	75	24	-	7	5.5	8	3	3	△
		TCNR01001A	1.5P									
M10 × 1.25	P3	TCNR010N3A	3P	75	22	-	7	5.5	8	3	3	○
		TCNR010N1A	1.5P									
	P4	TCNS010N3A	3P									△
		TCNS010N1A	1.5P									
M10 × 1	P3	TCNR010M3A	3P	70	19	-	7	5.5	8	3	3	△
		TCNR010M1A	1.5P									
M12 × 1.75	P3	TCNR012P3A	3P	82	30	-	8.5	6.5	9	3	3	△
		TCNR012P1A	1.5P									
M12 × 1.5	P3	TCNR012O3A	3P	82	24	-	8.5	6.5	9	3	3	△
		TCNR012O1A	1.5P									
	P4	TCNS012O3A	3P									
		TCNS012O1A	1.5P									
M12 × 1.25	P3	TCNR012N3A	3P	80	22	-	8.5	6.5	9	3	3	○
		TCNR012N1A	1.5P									
	P4	TCNS012N3A	3P									△
		TCNS012N1A	1.5P									
M12 × 1	P3	TCNR012M3A	3P	70	19	-	8.5	6.5	9	3	3	△
		TCNR012M1A	1.5P									
M14 × 2	P3	TCNR014Q3A	3P	88	30	-	10.5	8	11	4	3	△
		TCNR014Q1A	1.5P									
	P4	TCNS014Q3A	3P									
		TCNS014Q1A	1.5P									
M14 × 1.5	P3	TCNR014O3A	3P	88	24	-	10.5	8	11	4	3	△
		TCNR014O1A	1.5P									
	P4	TCNS014O3A	3P									
		TCNS014O1A	1.5P									
M16 × 2	P4	TCNS016Q3A	3P	95	30	-	12.5	10	13	4	3	△
		TCNS016Q1A	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

Cemented Carbide Tap Series

N-CT LA Carbide Taps for Light Alloys

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M16 × 1.5	P3	TCNR01603A	3P	95	24	-	12.5	10	13	4	3	△
		TCNR01601A	1.5P									
	P4	TCNS01603A	3P									
		TCNS01601A	1.5P									
M18 × 2.5	P4	TCNS018R3A	3P	100	35	-	14	11	14	4	3	△
		TCNS018R1A	1.5P									
M18 × 1.5	P4	TCNS01803A	3P	95	24	-	14	11	14	4	3	△
		TCNS01801A	1.5P									
M20 × 2.5	P4	TCNS020R3A	3P	105	35	-	15	12	15	4	3	△
		TCNS020R1A	1.5P									
M20 × 1.5	P4	TCNS02003A	3P	95	24	-	15	12	15	4	3	△
		TCNS02001A	1.5P									

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓn (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Helical Coil Wire Screw Thread Inserts, for Metric Threads													
STI M3 × 0.5	1b	TW3.0G1LWB5	5P	3.65	52	13	-	5	4	7	3	1	△
		TW3.0G1LWBA	1.5P										
STI M4 × 0.7	1b	TW4.0I1LWB5	5P	4.909	60	16	-	5.5	4.5	7	3	1	△
		TW4.0I1LWBA	1.5P										
STI M5 × 0.8	1b	TW5.0K1LWB5	5P	6.039	62	19	-	6	4.5	7	3	2	△
		TW5.0K1LWBA	1.5P										
STI M6 × 1	1b	TW6.0M1LWB5	5P	7.299	65	19	-	6.2	5	8	4	3	△
		TW6.0M1LWBA	1.5P										
STI M8 × 1.25	1b	TW8.0N1LWB5	5P	9.624	75	24	-	7	5.5	8	4	3	△
		TW8.0N1LWBA	1.5P										
STI M10 × 1.5	1b	TW01001LWB5	5P	11.948	82	30	-	8.5	6.5	9	4	3	△
		TW01001LWBA	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

CT-3

212

Think threads with
YAMAWA

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

N-CT FC

Carbide Taps for Cast Irons
Specification



Recommended Tapping Speeds depending on Materials

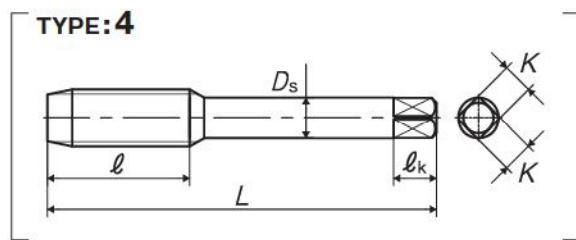
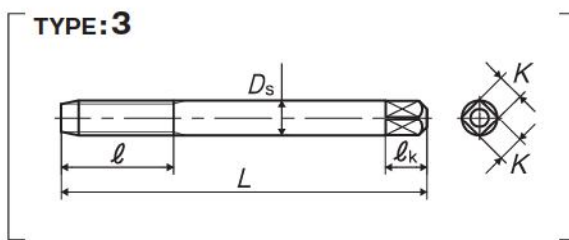
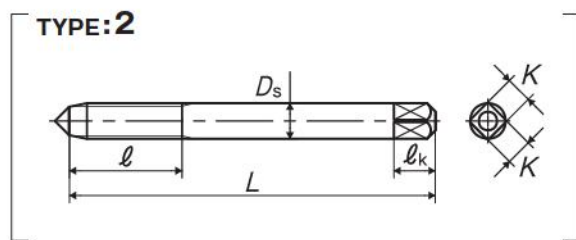
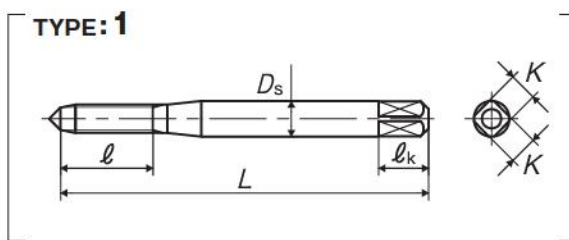
Cast Irons 鑄鉄	Ductile cast Irons 強靱鑄鉄	Brass castings 黄銅鑄物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

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	ℓn	ℓs	Ds	K	ℓk



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



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Metric Threads												
M1.4 × 0.3	P3	TCNR1.4C3	3P	34	7	-	3	2.5	5	3	1	△
		TCNR1.4C1	1.5P									
M1.6 × 0.35	P3	TCNR1.6D3	3P	36	8	-	3	2.5	5	3	1	△
		TCNR1.6D1	1.5P									
M1.7 × 0.35	P3	TCNR1.7D3	3P	36	8	-	3	2.5	5	3	1	△
		TCNR1.7D1	1.5P									
M2 × 0.4	P3	TCNR2.0E3	3P	40	8	-	3	2.5	5	3	1	○
		TCNR2.0E1	1.5P									
M2.2 × 0.45	P3	TCNR2.2F3	3P	42	9.5	-	3	2.5	5	3	1	△
		TCNR2.2F1	1.5P									
M2.3 × 0.4	P3	TCNR2.3E3	3P	42	8	-	3	2.5	5	3	1	△
		TCNR2.3E1	1.5P									
M2.5 × 0.45	P3	TCNR2.5F3	3P	44	9.5	-	3	2.5	5	3	1	△
		TCNR2.5F1	1.5P									
M2.6 × 0.45	P3	TCNR2.6F3	3P	44	9.5	-	3	2.5	5	3	1	○
		TCNR2.6F1	1.5P									
M3 × 0.5	P3	TCNR3.0G3	3P	46	11	-	4	3.2	6	3	1	◎
		TCNR3.0G1	1.5P									
M3 × 0.35	P3	TCNR3.0D3	3P	46	8	-	4	3.2	6	3	1	△

◎=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 Fluted 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

CT-4

213

Cemented Carbide Tap Series

N-CT FC Carbide Taps for Cast Irons

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M3 × 0.35	P3	TCNR3.0D1	1.5P	46	8	-	4	3.2	6	3	1	△
	M3.5 × 0.6	P3	TCNR3.5H3 TCNR3.5H1	3P 1.5P	48	11	-	4	3.2	6	3	1	○
Spiral Fluted Taps (for through hole)	M4 × 0.7	P3	TCNR4.0I3 TCNR4.0I1	3P 1.5P	52	13	-	5	4	7	4	1	◎
	M4 × 0.5	P3	TCNR4.0G3 TCNR4.0G1	3P 1.5P	52	11	-	5	4	7	4	1	△
Spiral Pointed Taps (for through hole)	M5 × 0.8	P3	TCNR5.0K3 TCNR5.0K1	3P 1.5P	60	16	-	5.5	4.5	7	4	1	◎
	M5 × 0.5	P3	TCNR5.0G3 TCNR5.0G1	3P 1.5P	52	11	-	5.5	4.5	7	4	1	△
Hand Taps	M6 × 1	P3	TCNR6.0M3	3P	62	19	-	6	4.5	7	4	2	◎
			TCNR6.0M3F									3	
			TCNR6.0M1	1.5P								2	
			TCNR6.0M1F									3	
Cemented Carbide Taps	M6 × 0.75	P3	TCNR6.0J3 TCNR6.0J1	3P 1.5P	62	13	-	6	4.5	7	4	2	○
	M6 × 0.5	P3	TCNR6.0G3 TCNR6.0G1	3P 1.5P	55	11	-	6	4.5	7	4	2	△
Roll Taps	M7 × 1	P3	TCNR7.0M3 TCNR7.0M1	3P 1.5P	65	19	-	6.2	5	8	4	4	○
	M7 × 0.75	P3	TCNR7.0J3 TCNR7.0J1	3P 1.5P	62	13	-	6.2	5	8	4	4	△
Special Thread Taps Simple Inspection Tools	M8 × 1.25	P3	TCNR8.0N3	3P	70	22	-	6.2	5	8	4	4	◎
			TCNR8.0N1	1.5P									△
		P4	TCNS8.0N3	3P									
			TCNS8.0N1	1.5P									
Pipe Taps	M8 × 1	P3	TCNR8.0M3 TCNR8.0M1	3P 1.5P	70	19	-	6.2	5	8	4	4	○
	M8 × 0.75	P3	TCNR8.0J3 TCNR8.0J1	3P 1.5P	62	13	-	6.2	5	8	4	4	△
Thread Mills	M10 × 1.5	P3	TCNR01003	3P	75	24	-	7	5.5	8	4	4	◎
			TCNR01001	1.5P									△
		P4	TCNS01003	3P									
			TCNS01001	1.5P									
Dies	M10 × 1.25	P3	TCNR010N3	3P	75	22	-	7	5.5	8	4	4	○
			TCNR010N1	1.5P									△
		P4	TCNS010N3	3P									
			TCNS010N1	1.5P									
Center Drills	M10 × 1	P3	TCNR010M3	3P	70	19	-	7	5.5	8	4	4	○
			TCNR010M1	1.5P									△
		P4	TCNS010M3	3P									
			TCNS010M1	1.5P									
Centering Tools	M12 × 1.75	P3	TCNR012P3	3P	82	30	-	8.5	6.5	9	4	4	◎
			TCNR012P1	1.5P									○
		P4	TCNS012P3	3P									
			TCNS012P1	1.5P									
	M12 × 1.5	P3	TCNR01203	3P	82	24	-	8.5	6.5	9	4	4	○
			TCNR01201	1.5P									△
			TCNS01203	3P									

N-CT FC Carbide Taps for Cast Irons

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)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M12 × 1.5	P4	TCNS01201	1.5P	82	24	-	8.5	6.5	9	4	4	△
M12 × 1.25	P3	TCNR012N3	3P	80	22	-	8.5	6.5	9	4	4	○
		TCNR012N1	1.5P									△
	P4	TCNS012N3	3P									△
		TCNS012N1	1.5P									△
M12 × 1	P3	TCNR012M3	3P	70	19	-	8.5	6.5	9	4	4	△
		TCNR012M1	1.5P									△
	P4	TCNS012M3	3P									△
		TCNS012M1	1.5P									△
M14 × 2	P3	TCNR014Q3	3P	88	30	-	10.5	8	11	4	4	△
		TCNR014Q1	1.5P									△
	P4	TCNS014Q3	3P									○
		TCNS014Q1	1.5P									○
M14 × 1.5	P3	TCNR014Q3	3P	88	24	-	10.5	8	11	4	4	○
		TCNR014Q1	1.5P									△
	P4	TCNS014Q3	3P									△
		TCNS014Q1	1.5P									△
M14 × 1.25	P3	TCNR014N3	3P	88	22	-	10.5	8	11	4	4	△
		TCNR014N1	1.5P									△
	P4	TCNS014N3	3P									△
		TCNS014N1	1.5P									△
M14 × 1	P3	TCNR014M3	3P	70	19	-	10.5	8	11	4	4	△
		TCNR014M1	1.5P									△
	P4	TCNS014M3	3P									△
		TCNS014M1	1.5P									△
M16 × 2	P4	TCNS016Q3	3P	95	30	-	12.5	10	13	4	4	○
		TCNS016Q1	1.5P									○
M16 × 1.5	P3	TCNR016Q3	3P	95	24	-	12.5	10	13	4	4	△
		TCNR016Q1	1.5P									△
	P4	TCNS016Q3	3P									○
		TCNS016Q1	1.5P									○
M16 × 1	P4	TCNS016M3	3P	75	19	-	12.5	10	13	4	4	○
		TCNS016M1	1.5P									○
M18 × 2.5	P4	TCNS018R3	3P	100	35	-	14	11	14	4	4	△
		TCNS018R1	1.5P									△
M18 × 1.5	P4	TCNS018Q3	3P	95	24	-	14	11	14	4	4	○
		TCNS018Q1	1.5P									○
M20 × 2.5	P4	TCNS020R3	3P	105	35	-	15	12	15	4	4	○
		TCNS020R1	1.5P									○
M20 × 1.5	P4	TCNS020Q3	3P	95	24	-	15	12	15	4	4	○
		TCNS020Q1	1.5P									○
M22 × 2.5	P4	TCNS022R3	3P	115	35	-	17	13	16	4	4	△
		TCNS022R1	1.5P									△
M22 × 1.5	P4	TCNS022Q3	3P	95	24	-	17	13	16	4	4	△
		TCNS022Q1	1.5P									△
M24 × 3	P4	TCNS024S3	3P	120	35	-	19	15	18	4	4	△
		TCNS024S1	1.5P									△
M24 × 1.5	P4	TCNS024Q3	3P	95	24	-	19	15	18	4	4	△
		TCNS024Q1	1.5P									△

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Hand Taps
(for through hole)

Cemented Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

Cemented Carbide Tap Series

N-CT FC Carbide Taps for Cast Irons

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	For Unified Threads												
Spiral Fluted Taps (for through hole)	No.4-40UNC	P3	TCNRUN4H3	3P	44	9.5	-	3	2.5	5	3	1	△
			TCNRUN4H1	1.5P									
Spiral Fluted Taps (for through hole)	No.4-48UNF	P3	TCNRUN4F3	3P	44	9.5	-	3	2.5	5	3	1	△
			TCNRUN4F1	1.5P									
Spiral Pointed Taps (for through hole)	No.5-40UNC	P3	TCNRUN5H3	3P	46	9.5	-	4	3.2	6	3	1	△
			TCNRUN5H1	1.5P									
Spiral Pointed Taps (for through hole)	No.6-32UNC	P3	TCNRUN6J3	3P	48	11	-	4	3.2	6	3	1	△
			TCNRUN6J1	1.5P									
Spiral Pointed Taps (for through hole)	No.8-32UNC	P3	TCNRUN8J3	3P	52	11	-	5	4	7	4	1	△
			TCNRUN8J1	1.5P									
Hand Taps	No.10-24UNC	P3	TCNRUNAM3	3P	60	16	-	5.5	4.5	7	4	1	△
			TCNRUNAM1	1.5P									
Hand Taps	No.10-32UNF	P3	TCNRUNAJ3	3P	60	11	-	5.5	4.5	7	4	1	△
			TCNRUNAJ1	1.5P									
Cemented Carbide Taps	1/4-20UNC	P3	TCNRU04N3	3P	62	19	-	6	4.5	7	4	2	△
			TCNRU04N1	1.5P									
Cemented Carbide Taps	1/4-28UNF	P3	TCNRU04K3	3P	62	16	-	6	4.5	7	4	2	△
			TCNRU04K1	1.5P									
Roll Taps	5/16-18UNC	P3	TCNRU05O3	3P	70	22	-	6.1	5	8	4	4	△
			TCNRU05O1	1.5P									
Roll Taps	5/16-24UNF	P3	TCNRU05M3	3P	70	16	-	6.1	5	8	4	4	△
			TCNRU05M1	1.5P									
Roll Taps	3/8-16UNC	P3	TCNRU06P3	3P	75	24	-	7	5.5	8	4	4	△
			TCNRU06P1	1.5P									
Special Thread Taps Simple Inspection Tools	3/8-24UNF	P3	TCNRU06M3	3P	75	16	-	7	5.5	8	4	4	△
			TCNRU06M1	1.5P									
Special Thread Taps Simple Inspection Tools	7/16-14UNC	P3	TCNRU07Q3	3P	80	24	-	8	6	9	4	4	△
			TCNRU07Q1	1.5P									
Pipe Taps	7/16-20UNF	P3	TCNRU07N3	3P	80	19	-	8	6	9	4	4	△
			TCNRU07N1	1.5P									
Pipe Taps	1/2-13UNC	P3	TCNRU08R3	3P	85	30	-	9	7	10	4	4	△
			TCNRU08R1	1.5P									
Thread Mills	1/2-20UNF	P3	TCNRU08N3	3P	85	19	-	9	7	10	4	4	△
			TCNRU08N1	1.5P									
Thread Mills	5/8-11UNC	P4	TCNSU10U3	3P	95	30	-	12	9	12	4	4	△
			TCNSU10U1	1.5P									
Dies	5/8-18UNF	P4	TCNSU10O3	3P	95	22	-	12	9	12	4	4	△
			TCNSU10O1	1.5P									
Dies	3/4-10UNC	P4	TCNSU12V3	3P	105	35	-	14	11	14	4	4	△
			TCNSU12V1	1.5P									
Center Drills	3/4-16UNF	P4	TCNSU12P3	3P	95	24	-	14	11	14	4	4	△
			TCNSU12P1	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

LS-N-CT

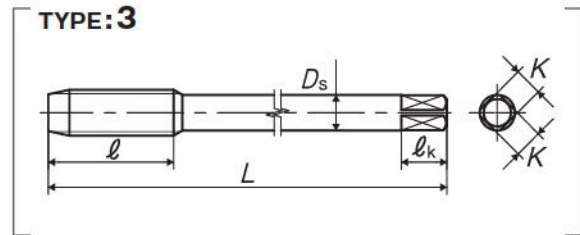
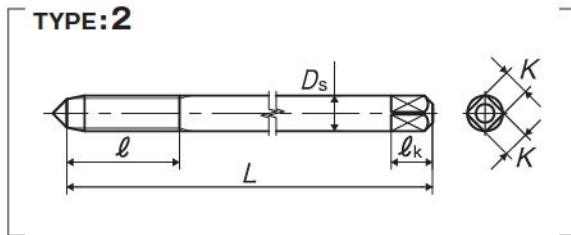
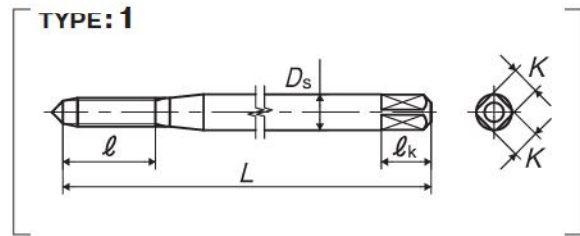
Long Shank Carbide Taps
Specification



Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to P.24



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Metric Threads												
M3 × 0.5	P3	-	3P 1.5P	100	11	-	4	3.2	6	3	1	△
M4 × 0.7	P3	-	3P 1.5P	100	13	-	5	4	7	4	1	△
M5 × 0.8	P3	-	3P 1.5P	100	16	-	5.5	4.5	7	4	1	△
M6 × 1	P3	-	3P 1.5P	100	19	-	6	4.5	7	4	2	△
M8 × 1.25	P3	-	3P 1.5P	100	22	-	6.2	5	8	4	3	△
M10 × 1.5	P3	-	3P 1.5P	100	24	-	7	5.5	8	4	3	△

N-CT-SP

Spiral Fluted Carbide Taps

Specification

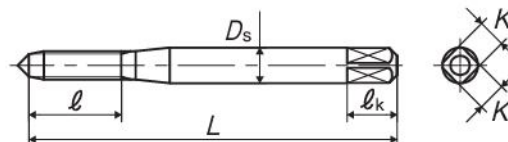


Recommended Tapping Speeds depending on Materials

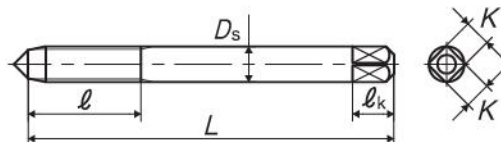
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
10~20 (m/min)	10~20 (m/min)	10~20 (m/min)

For icon explanation, refer to P.24

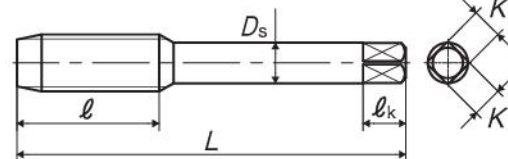
TYPE:1



TYPE:2



TYPE:3



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	Type	Stock
For Metric Threads												
M3 × 0.5	P3	-	2.5P	46	11	-	4	3.2	6	3	1	△
M4 × 0.7	P3	-	2.5P	52	13	-	5	4	7	3	1	△
M5 × 0.8	P3	-	2.5P	60	16	-	5.5	4.5	7	3	1	△
M6 × 1	P3	-	2.5P	62	19	-	6	4.5	7	3	2	△
M8 × 1.25	P3	-	2.5P	70	22	-	6.2	5	8	3	3	△
M10 × 1.5	P3	-	2.5P	75	24	-	7	5.5	8	3	3	△
M10 × 1.25	P3	-	2.5P	75	22	-	7	5.5	8	3	3	△
M12 × 1.75	P4	-	2.5P	82	30	-	8.5	6.5	9	3	3	△
M12 × 1.25	P4	-	2.5P	80	22	-	8.5	6.5	9	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

N-CT-PO

Spiral Pointed Carbide Taps

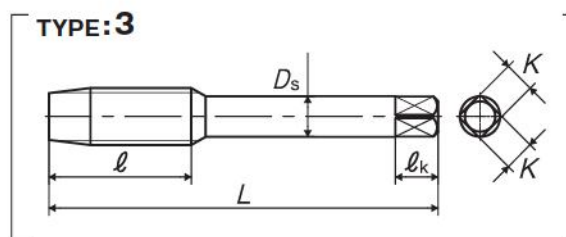
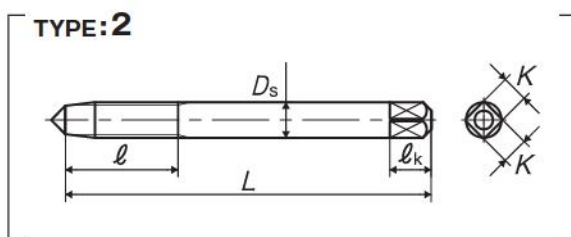
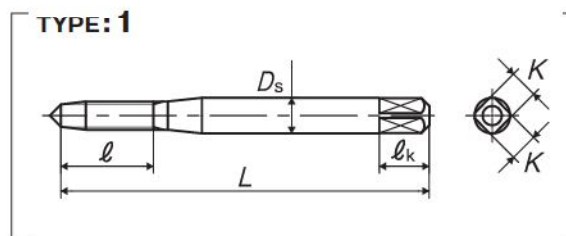
Specification



Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to P.24



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads												
M3 × 0.5	P3	PCNR3.0G	5P	46	11	-	4	3.2	6	3	1	△
M4 × 0.7	P3	PCNR4.0I	5P	52	13	-	5	4	7	3	1	△
M5 × 0.8	P3	PCNR5.0K	5P	60	16	-	5.5	4.5	7	3	1	△
M6 × 1	P3	PCNR6.0M	5P	62	19	-	6	4.5	7	3	2	△
M8 × 1.25	P3	PCNR8.0N	5P	70	22	-	6.2	5	8	3	3	△
M10 × 1.5	P4	PCNS0100	5P	75	24	-	7	5.5	8	3	3	△
M12 × 1.75	P4	PCNS012P	5P	82	30	-	8.5	6.5	9	3	3	△

MC-AD-CT

Carbide Taps with Oil Hole

Specification



Recommended Tapping Speeds depending on Materials

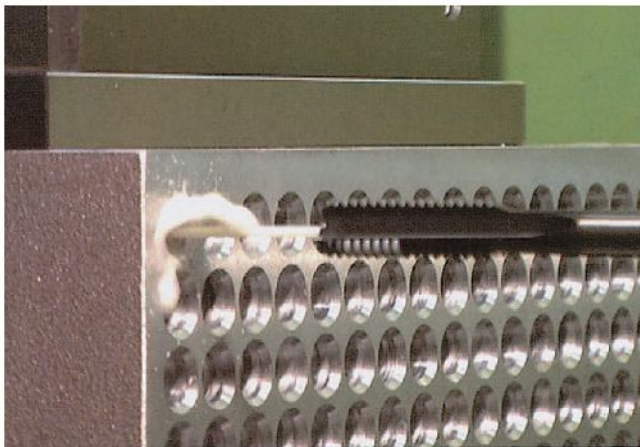
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
30~60 (m/min)	30~60 (m/min)	30~60 (m/min)

For icon explanation, refer to P.24

Product features

- Carbide Taps with Oil Hole suitable for tapping the blind holes of Aluminum alloy castings and Aluminum die castings.
- The combination of unique cutting edge design enabling less damage, ultra fine grain carbide alloys with superior wear resistance and optimal coating results in 5 times longer tool life than the life of conventional special purpose tap for aluminum.
- Having center through hole design to correspond with such cutting condition as inner coolant supply, mist coolant supply and cryogenic dry, MC-AD-CT works quite well in removing remaining chips after boring and in avoiding welding trouble.

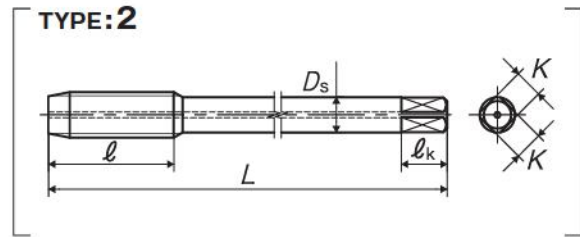
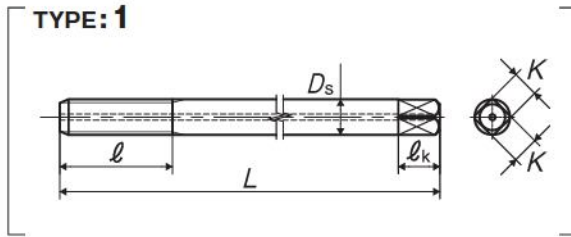
Tapping data



Tapping condition [M6×1]

Work material	ADC12
Hole shape	Blind
Hole depth	14mm
Tapping length	12mm
Machine	Machining center (Horizontal)
Feed	Synchronized feed
Tapping speed	57m/min
Tapping fluid	Water soluble oil
Tool life	240,000 hole~

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 : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads												
M6 × 1	P3	MCADR6.0M1	1.5P	100	19	-	6	4.5	7	3	1	△
M8 × 1.25	P3	MCADR8.0N1	1.5P	100	22	-	6.2	5	8	3	2	△
M10 × 1.5	P4	MCADS01001	1.5P	100	24	-	7	5.5	8	3	2	△
M10 × 1.25	P4	MCADS010N1	1.5P	100	22	-	7	5.5	8	3	2	△
M10 × 1	P4	MCADS010M1	1.5P	100	19	-	7	5.5	8	3	2	△
M12 × 1.75	P4	MCADS012P1	1.5P	100	30	-	8.5	6.5	9	3	2	△
M12 × 1.5	P4	MCADS01201	1.5P	100	24	-	8.5	6.5	9	3	2	△
M12 × 1.25	P4	MCADS012N1	1.5P	100	22	-	8.5	6.5	9	3	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

EH-CT

Carbide Taps for Hard Materials

Specification



Recommended Tapping Speeds depending on Materials



45~55HRC

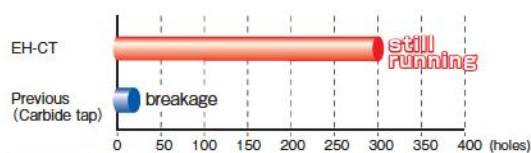
For icon explanation, refer to P.24

Product features

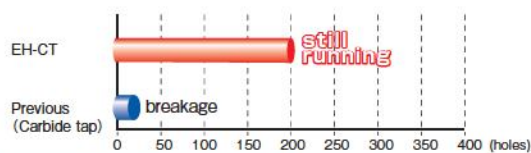
- Most suitable for tapping high hardness steels of 45-55HRC such as steels for hot-forging die (SKS3, SKD11, etc.)
- Ultra fine grain carbide alloys with superior wear resistance and shock resistance are adopted.
- By using the tap blanks in which both the run-out tolerance and the shank concentricity are improved, the high accuracy in screw threads can be obtained.
- For bored hole diameter, maximum of minor diameter tolerance of 6H internal threads is recommended.

Tapping data [M8×1.25]

Tapping data

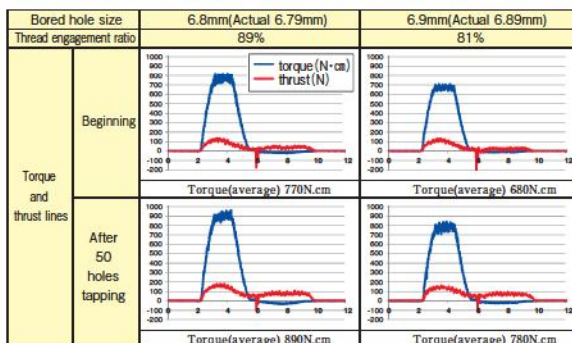


Work material	Type	Hot forged die steel (SKD61)
	Hardness	50HRC
Tapping speed		6m/min
Feed		Full rigid
Tappig fluid		Insoluble oil



Work material	Type	Stainless steel for plastic die (SUS420J2)
	Hardness	52HRC
Tapping speed		6m/min
Feed		Full rigid
Tappig fluid		Insoluble oil

<Torque line in the different bored hole size>



Tapping condition

Work material	DAC (equivalent to SKD61) 50HRC
Tapping speed	6m/min
Feed	Rigid
Tappig fluid	Insoluble oil

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

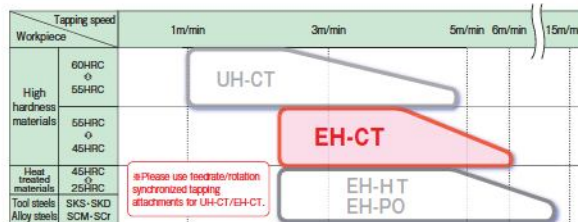
In tapping the material of high hardness, it is recommendable to make the bored hole size as large as possible.

Recommended bored hole size (for reference)

unit : mm

Size	Recommended bored hole size	Minor dia. of JIS 6H class internal screw thread	
		Max. tolerance	Min. tolerance
M3 X0.5	2.55	2.599	2.459
M4 X0.7	3.4	3.422	3.242
M5 X0.8	4.3	4.334	4.134
M6 X1	5.1	5.153	4.917
M8 X1.25	6.9	6.912	6.647
M10X1.5	8.6	8.676	8.376
M12X1.75	10.4	10.441	10.106

Application



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 Tools
Simple Inspection Tools

Pipe Taps

Thread Mills

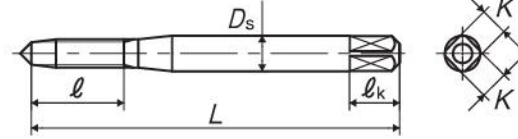
Dies

Center Drills

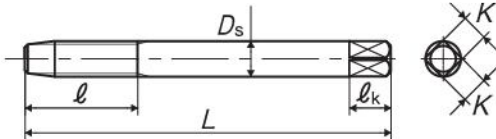
Centering Tools

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

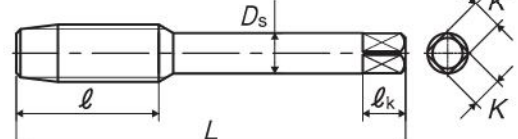
TYPE:1



TYPE:2



TYPE:3



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads												
M3 × 0.5	P3	EHCR3.0G5	5P	46	11	-	4	3.2	6	4	1	○
M4 × 0.7	P3	EHCR4.0I5	5P	52	13	-	5	4	7	4	1	○
M5 × 0.8	P3	EHCR5.0K5	5P	60	16	-	5.5	4.5	7	4	1	○
M6 × 1	P3	EHCR6.0M5	5P	62	19	-	6	4.5	7	5	2	○
M8 × 1.25	P4	EHCS8.0N5	5P	70	22	-	6.2	5	8	5	3	○
M10 × 1.5	P4	EHCS01005	5P	75	24	-	7	5.5	8	5	3	○
M12 × 1.75	P4	EHCS012P5	5P	82	30	-	8.5	6.5	9	5	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

UH-CT

Carbide Taps for Ultra Hard Materials

Specification



Recommended Tapping Speeds depending on Materials

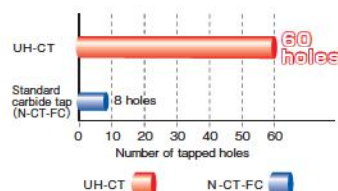


For icon explanation, refer to P.24

Product features

- Ultra fine grain carbide alloys with superior wear resistance and shock resistance are adopted.
- By using the tap blanks in which both the run-out tolerance and the shank concentricity are improved, the high accuracy in screw threads can be obtained.
- Possible for tapping SKD die steels and pre-hardened steels which hardness ranges in 55-60HRC (Maximum hardness 63HRC).
- Thread length should be less than 1.5D. Considering the tool life, the number of chamfer threads is 5.
- For bored hole diameter, maximum of the minor diameter tolerance of 6H internal threads is recommended.

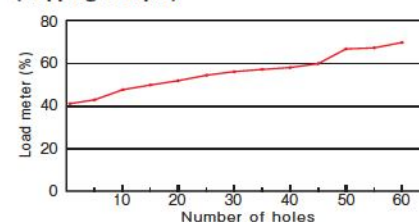
Tapping data



Tapping condition [M8×1.25]

Work material	SKD die steel, heat-treated (60HRC)
Bored hole size	6.9 mm
Tapping length	12mm, through hole
Machine	CNC rigid tapping machine
Tapping speed	1.5m/min (60rpm)
Tapping fluid	insoluble oil (with extreme pressure additive)

(Tapping Torque)



Upper graph shows comparison data in tapping heat-treated SKD die steel by the standard carbide tap (N-CT) and by the carbide tap for high hardness steel (UH-CT). Chipping occurred in 8th tapping with N-CT. 60 hole tapings were obtained with UH-CT.

Note: It is necessary to change the drill much earlier because the damage on the edge of drill is larger when drilling high hardness steels.

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

Upper graph shows the relation between the number of tapped holes and the load meter data of the machine on the tapping test up to 60 holes with UH-CT tap. Percentage of load meter figure tends to increase after tapping 50 holes. This means from this cutting area the damage on the tool's cutting edge becomes larger rapidly. If we continue tapping further from this area, we might have tap breakage. It is important to pay special attention to the number of tapping holes (tool life) from the view point of safety when tapping high hardness steel materials.

Recommended bored hole size (for reference)

unit : mm

Size	Recommended bored hole size	Minor dia. of JIS 6H class internal screw thread	
		Max. tolerance	Min. tolerance
M2 X0.4	1.65	1.679	1.567
M2.5X0.45	2.1	2.138	2.013
M2.6X0.45	2.2	2.238	2.113
M3 X0.5	2.55	2.599	2.459
M4 X0.7	3.4	3.422	3.242
M5 X0.8	4.3	4.334	4.134
M6 X1	5.1	5.153	4.917
M8 X1.25	6.9	6.912	6.647
M10X1.5	8.6	8.676	8.376
M10X1.25	8.9	8.912	8.647
M12X1.75	10.4	10.441	10.106

unit : mm

Size	Recommended bored hole size	Minor dia. of JIS 6H class internal screw thread	
		Max. tolerance	Min. tolerance
M12X1.5	10.6	10.676	10.376
M12X1.25	10.9	10.912	10.647
M14X2	12.2	12.210	11.835
M14X1.5	12.6	12.676	12.376
M16X2	14.2	14.210	13.835
M16X1.5	14.6	14.676	14.376
M18X2.5	15.7	15.744	15.294
M18X1.5	16.6	16.676	16.376
M20X2.5	17.7	17.744	17.294
M20X1.5	18.6	18.676	18.376

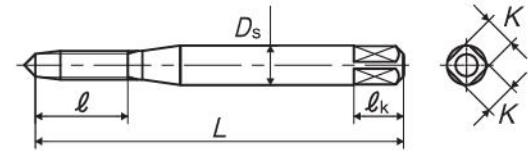
Application

Workpiece	Tapping speed	1m/min	3m/min	5m/min	6m/min	15m/min
High hardness materials	60HRC ○ 55HRC	UH-CT				
	55HRC ○ 45HRC	EH-CT				
Heat treated materials	45HRC ○ 25HRC	EH-HT				
Tool steels	SKS-SKD	EH-PO				
Alloy steels	SCM-SCR					

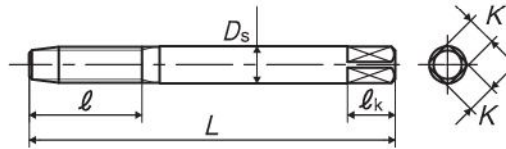
*Please use feedrate/rotation synchronized tapping attachments for UH-CT/EH-CT.

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

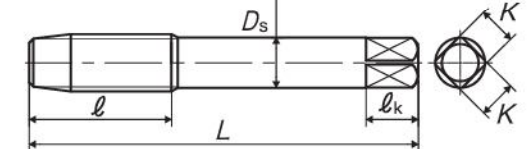
TYPE:1



TYPE:2



TYPE:3



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	Type	Stock
For Metric Threads												
M2 × 0.4	P3	UHCR2.0E5	5P	40	8	-	4	3.2	6	3	1	○
M2.5 × 0.45	P3	UHCR2.5F5	5P	44	9.5	-	4	3.2	6	4	1	○
M2.6 × 0.45	P3	UHCR2.6F5	5P	44	9.5	-	4	3.2	6	4	1	○
M3 × 0.5	P3	UHCR3.0G5	5P	46	11	-	5	4	7	4	1	○
M4 × 0.7	P3	UHCR4.0I5	5P	52	13	-	5.5	4.5	7	4	1	○
M5 × 0.8	P3	UHCR5.0K5	5P	60	16	-	6	4.5	7	4	1	○
M6 × 1	P3	UHCR6.0M5	5P	62	19	-	6.2	5	8	5	2	○
M8 × 1.25	P4	UHCS8.0N5	5P	70	22	-	7	5.5	8	5	3	○
M10 × 1.5	P4	UHCS01005	5P	75	24	-	8.5	6.5	9	5	3	○
M10 × 1.25	P4	UHCS010N5	5P	75	24	-	8.5	6.5	9	5	3	△
M12 × 1.75	P4	UHCS012P5	5P	82	30	-	10.5	8	11	5	3	○
M12 × 1.5	P4	UHCS01205	5P	82	30	-	10.5	8	11	5	3	△
M12 × 1.25	P4	UHCS012N5	5P	82	30	-	10.5	8	11	5	3	△
M14 × 2	P4	UHCS014Q5	5P	88	30	-	12.5	10	13	6	3	△
M14 × 1.5	P4	UHCS01405	5P	88	30	-	12.5	10	13	6	3	△
M16 × 2	P4	UHCS016Q5	5P	95	30	-	14	11	14	6	3	△
M16 × 1.5	P4	UHCS01605	5P	95	30	-	14	11	14	6	3	△
M18 × 2.5	P4	UHCS018R5	5P	100	35	-	15	12	15	6	3	△
M18 × 1.5	P4	UHCS01805	5P	100	35	-	15	12	15	6	3	△
M20 × 2.5	P4	UHCS020R5	5P	105	35	-	17	13	16	6	3	△
M20 × 1.5	P4	UHCS02005	5P	105	35	-	17	13	16	6	3	△

HFACT-P



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

Specification



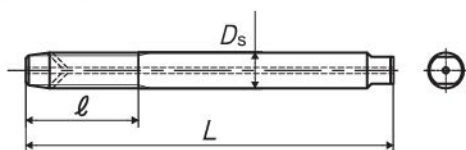
■HFACT-P is the carbide tap applicable under ultra high speed cutting. For such tapping conditions as inner coolant supply, mist coolant and dry under cryogenic condition, HFACT-P has radial type coolant hole and is suitable for through holes of such materials as aluminum castings and aluminum diecastings.

Recommended Tapping Speeds depending on Materials

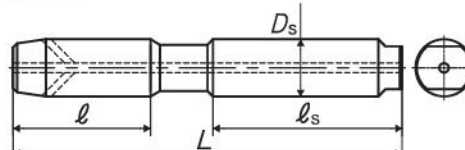
Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
30~100 (m/min)	30~100 (m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



Segment : 1L

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													
M6 × 1	P3	HFACTPR6.0M	4P	62	19	-	-	6	-	-	3	1	○
M8 × 1.25	P3	HFACTPR8.0N	4P	70	22	-	36	8	-	-	3	2	○
M10 × 1.5	P3	HFACTPR0100	4P	75	24	-	37	10	-	-	3	2	○
M10 × 1.25	P3	HFACTPR010N	4P	75	24	-	37	10	-	-	3	2	○
M12 × 1.75	P3	HFACTPR012P	4P	82	29	-	40	12	-	-	3	2	○
M12 × 1.5	P3	HFACTPR0120	4P	82	29	-	40	12	-	-	3	2	○
M12 × 1.25	P3	HFACTPR012N	4P	82	29	-	40	12	-	-	3	2	○

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

HFACT-B



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

Specification

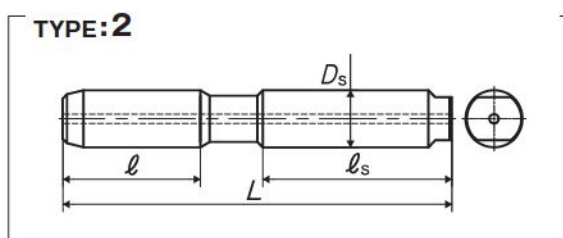
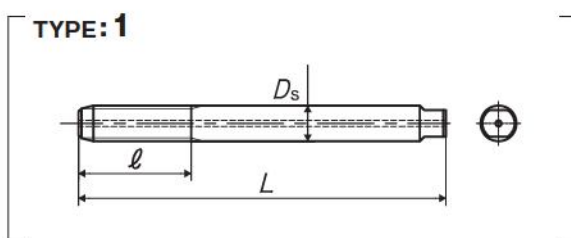


■HFACT-B is the carbide tap applicable under ultra high speed cutting. For such tapping conditions as inner coolant supply, mist coolant and dry under cryogenic condition, HFACT-B has coolant hole (center through type) and is suitable for blind holes of such materials as aluminum castings and aluminum diecastings.

Recommended Tapping Speeds depending on Materials

Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
30~100 (m/min)	30~100 (m/min)

For icon explanation, refer to P.24



Segment : 1L

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	HFACTBR6.0M	2.5P	62	19	-	-	6	-	-	3	1	○
M8 × 1.25	P3	HFACTBR8.0N	2.5P	70	22	-	36	8	-	-	3	2	○
M10 × 1.5	P3	HFACTBR0100	2.5P	75	24	-	37	10	-	-	3	2	○
M10 × 1.25	P3	HFACTBR010N	2.5P	75	24	-	37	10	-	-	3	2	○
M12 × 1.75	P3	HFACTBR012P	2.5P	82	29	-	40	12	-	-	3	2	○
M12 × 1.5	P3	HFACTBR0120	2.5P	82	29	-	40	12	-	-	3	2	○
M12 × 1.25	P3	HFACTBR012N	2.5P	82	29	-	40	12	-	-	3	2	○

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Hand Taps
Spiral Pointed Taps
(for through hole)

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

HFICT-P



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

Specification



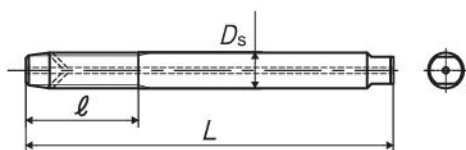
■HFICT-P is the carbide tap applicable under ultra high speed cutting. For such tapping conditions as inner coolant supply, mist coolant and dry under cryogenic condition, HFICT-P has radial type coolant hole, and is suitable for through holes of cast irons and the like.

Recommended Tapping Speeds depending on Materials

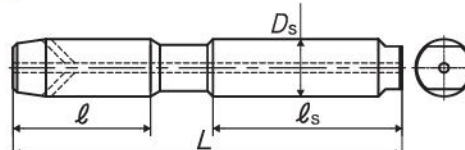
Cast Irons 鑄鉄	Ductile cast Irons 軸鍛鑄鉄
25~50 (m/min)	25~50 (m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



Segment : 1L

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													
M6 × 1	P3	HFICTPR6.0M	4P	62	19	-	-	6	-	-	4	1	○
M8 × 1.25	P3	HFICTPR8.0N	4P	70	22	-	36	8	-	-	4	2	○
M10 × 1.5	P3	HFICTPR0100	4P	75	24	-	37	10	-	-	4	2	○
M10 × 1.25	P3	HFICTPR010N	4P	75	24	-	37	10	-	-	4	2	○
M12 × 1.75	P3	HFICTPR012P	4P	82	29	-	40	12	-	-	4	2	○
M12 × 1.5	P3	HFICTPR0120	4P	82	29	-	40	12	-	-	4	2	○
M12 × 1.25	P3	HFICTPR012N	4P	82	29	-	40	12	-	-	4	2	○

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

HFICT-B

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

Specification

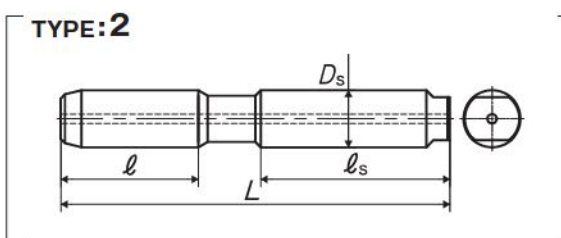
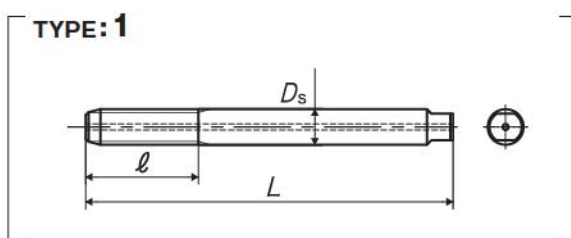


■HFICT-B is the carbide tap applicable under ultra high speed cutting. For such tapping conditions as inner coolant supply, mist coolant and dry under cryogenic condition, HFICT-B has coolant hole(center through type), and is suitable for blind holes of cast irons and the like.

Recommended Tapping Speeds depending on Materials

Cast Irons 鑄鉄	Ductile cast irons 強靱鑄鉄
25~50 (m/min)	25~50 (m/min)

For icon explanation, refer to P.24



Segment : 1L

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	HFICTBR6.0M	2.5P	62	19	-	-	6	-	-	4	1	○
M8 × 1.25	P3	HFICTBR8.0N	2.5P	70	22	-	36	8	-	-	4	2	○
M10 × 1.5	P3	HFICTBR0100	2.5P	75	24	-	37	10	-	-	4	2	○
M10 × 1.25	P3	HFICTBR010N	2.5P	75	24	-	37	10	-	-	4	2	○
M12 × 1.75	P3	HFICTBR012P	2.5P	82	29	-	40	12	-	-	4	2	○
M12 × 1.5	P3	HFICTBR0120	2.5P	82	29	-	40	12	-	-	4	2	○
M12 × 1.25	P3	HFICTBR012N	2.5P	82	29	-	40	12	-	-	4	2	○

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Fluted Taps
(for through hole)

Hand Taps
Spiral Pointed Taps
(for through hole)

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools