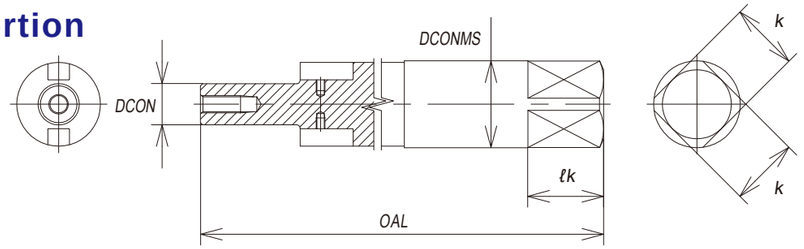
## Dimension and size

### ■ Arbor portion



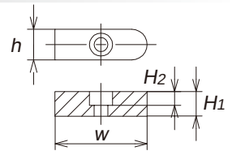

| Code | LF(Overall length after combined with arbor) (mm) | OAL(L) (mm) | DCONMS(Ds) (mm) | DCON(D1) (mm) | k (mm) | ℓk (mm) |
|---|---|---|---|---|---|---|
| REAB22200 | 200 | 183 | 45 | 22 | 35 | 38 |
| REAB22400 | 400 | 383 | | | | |
| REAB22600 | 600 | 583 | | | | |

*Each arbor includes all the following accessaries.

## Accessary

### 1.Parallel key

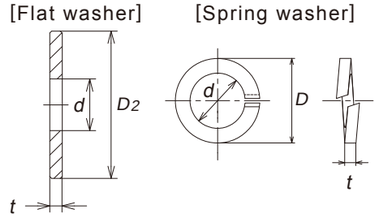
| Code | w (mm) | h (mm) | H1 (mm) | H2 (mm) |
|---|---|---|---|---|
| REPK30 | 30 | 10 | 8 | 4.5 |




### 2.Flat washer and spring washer

| Code | | | | |
|---|---|---|---|---|
| REFS3018.4 | Flat washer | D2 (mm) | d (mm) | t (mm) |
| | | 30 | 10.5 | 3.0 |
| | Spring washer | D (mm) | d (mm) | t (mm) |
| | | 18.4 | 10.2 | 2.5 |

[Flat washer] [Spring washer]

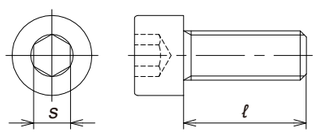



### 3.Bolt with hex hole (fixing screw for cutting edge portion)

| Code | Size | s (mm) | ℓ (mm) |
|---|---|---|---|
| REBL010O | M10 | 8 | 25 |

### (fixing screw for parallel key)

| Code | Size | s (mm) | ℓ (mm) |
|---|---|---|---|
| REBL4.0I | M4 | 3 | 8 |




**Warning**

- ♦Tools may shatter. Wear cover or eye glasses to avoid injury during tapping.
- ♦Tools may shatter. Use tools under the proper tapping condition.
- ♦Never wear gloves during turning operations as the gloves may get caught with the tools.
- ♦Wear safety shoes to avoid injuring yourself by the falling tools.
- ♦On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- ♦Fasten the work pieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- ♦Take a special care to fire trouble. High temperature during machining may cause fire.


YAMAWA Mfg. Co., Ltd.

Head office Nakajima Gold bldg.13-10 Kyobashi 3chome, Chuo-ku, Tokyo 104-0031, JAPAN

Website:http://www.yamawa.com

YAMAWA group for Overseas

YAMAWA International Co., Ltd.


ISO 9001 JQA-QMA14664

ISO 14001 JQA-EM3465



Think threads with YAMAWA

# RE-HT

Exchangeable RE-HT

Most suitable for cleaning larger diameter threads.

▪Taps for thread repair and cleaning▪

# RE-HT

## Features

# RE-HT

HSS OX Oxide

Joint type taps for thread repair and cleaning


•Main usage: For correcting thread flaws, and cleaning out burrs, paint, rust and residual spatters from welding.

•A special geometry and unique cutting edge specification were developed to enable manual repair and cleaning of larger diameter of threads.

•An arbor and exchangeable type cutting edge can hold a variety of larger taps (M50-M80) that enable thread cleaning.

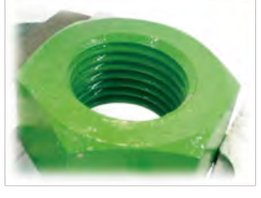
•By using a longer arbor, cleaning deeper threaded holes becomes possible.

•Using a tap arbor with an exchangeable cutting edge portion is much more economical than a solid tap.

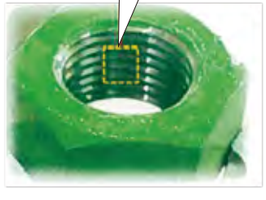
The arbor can facilitate more than one tap size.

After cleaning (enlarged picture)

Before cleaning



After cleaning





## How to combine

### ■ Order of operations

① Insert the parallel drive key into the key groove on the arbor. Turn the M4 bolt using a 3 mm hex wrench and firmly tighten the parallel drive key in place.

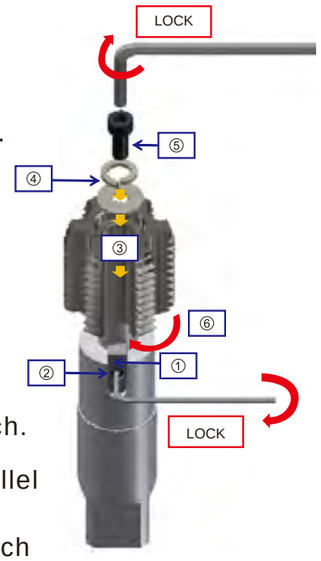
② On the opposite side, follow the operation instructions #1 and #2 and firmly tighten the second parallel drive key.

③ Insert the cutting edge portion of the tap onto the pilot diameter of the arbor. (Align the tenon groove of the cutting edge portion of the tap to the parallel drive key on the arbor).

④ Set the flat washer and the spring washer in the countersink of cutting edge portion.

⑤ Lightly tighten the M10 center bolt with a 8 mm hex wrench.

⑥ Rotate the cutting edge portion of the tap toward the parallel drive key like that of the cutting load during tapping. Firmly tighten the M10 center bolt using a 8 mm hex wrench to attach the cutting edge portion of the tap to the arbor.




* When exchanging the cutting edge portion, firmly clamp the arbor in a vice or other holding device.

* Purchase the hex wrenches from your local tool dealer.

### ■ Reference

Tightening torque of the center bolt for cutting edge portion (N/m)

| Bolt with hex hole | Tightening torque |
|---|---|
| M10 | 24 |

### ■ Remarks during usage

① Due to the drive system, the RE-HT is not recommended for normal machine thread tapping where there is a high load or excessive torque. Only use the RE-HT for repairing threads or for sweeping thread dusts.

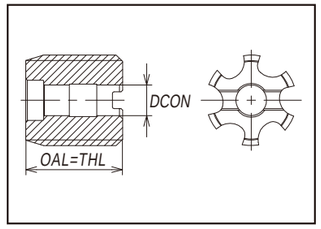
② RE-HT is specifically designed for Hand use. Do not use it with machine operations.

③ Excessive tightening of bolt with hex hole can cause part deformation or part breakage.

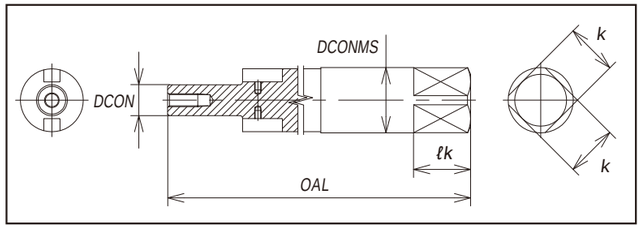
## How to order

### ■ For your first order, be sure to order both a cutting edge tap portion and an arbor portion.

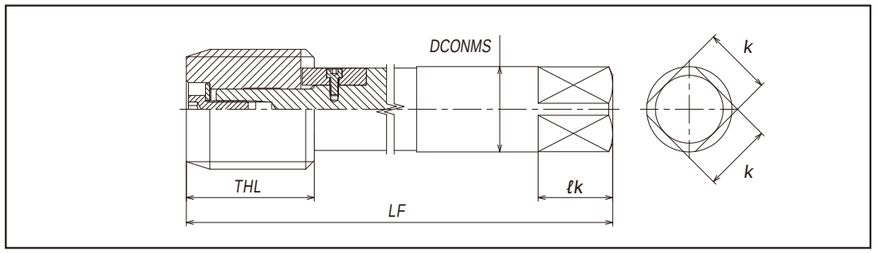
[Cutting Edge Portion]
Refer to P.4 to P.6




[Arbor Portion]
Refer to P.7




[After Setup]




* There are 3 types of Arbors that can make up a RE-HT tap with LF of 200, 400 and 600 mm after combining the arbor with the cutting edge portion.

**[Example of the first order]**

Cutting Edge M50X3 (T5050SANEX2) + Arbor (REAB22200) = RE-HT M50X3 LF-200

### ● From next order

① After the cutting edge is worn out, you can reuse the RE-HT M50X3 LF-200 by purchasing the cutting edge portion M50X3 (T5050SANEX2) only.

② You can also use your Arbor (REAB22200) by combining it with the other sizes of cutting edge portions, like a M80X1.5 (T5080OANEX2). The overall length is still 200 mm which is the same as before.

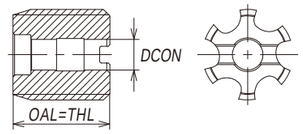
③ You can change the RE-HT M50X3 LF-200 into a long shank type LF-600 by combining your cutting edge M50X3 (T5050SANEX2) with the long type arbor (REAB22600).



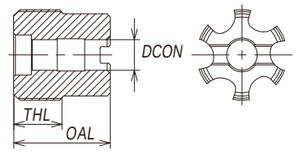
## Dimension and size

### ■ Cutting Edge Portion

[TYPE-1]




[TYPE-2]



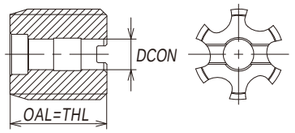

### For Metric Threads

| Size | Code | Class | Chamfer | *OAL(L)* (mm) | *THL(ℓ)* (mm) | *DCON(d)* (mm) | No. of flutes | Type |
|---|---|---|---|---|---|---|---|---|
| M50X3 | T5050SANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M50X2 | T5050QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M50X1.5 | T5050OANEX2 | | | | | | | |
| M52X5 | T5052WANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M52X4 | T5052UANEX2 | | | | | | | |
| M52X3 | T5052SANEX2 | | | | | | | |
| M52X2 | T5052QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M52X1.5 | T5052OANEX2 | | | | | | | |
| M55X4 | T5055UANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M55X3 | T5055SANEX2 | | | | | | | |
| M55X2 | T5055QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M55X1.5 | T5055OANEX2 | | | | | | | |
| M56X5.5 | T5056XANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M56X4 | T5056UANEX2 | | | | | | | |
| M56X3 | T5056SANEX2 | | | | | | | |
| M56X2 | T5056QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M56X1.5 | T5056OANEX2 | | | | | | | |
| M58X4 | T5058UANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M58X3 | T5058SANEX2 | | | | | | | |
| M58X2 | T5058QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M58X1.5 | T5058OANEX2 | | | | | | | |
| M60X5.5 | T5060XANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M60X4 | T5060UANEX2 | | | | | | | |
| M60X3 | T5060SANEX2 | | | | | | | |

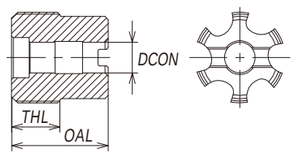
## Dimension and size

### ■ Cutting Edge Portion

[TYPE-1]




[TYPE-2]




### For Metric Threads

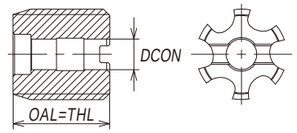
| Size | Code | Class | Chamfer | *OAL(L)* (mm) | *THL(ℓ)* (mm) | *DCON(d)* (mm) | No. of flutes | Type |
|---|---|---|---|---|---|---|---|---|
| M60X2 | T5060QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M60X1.5 | T5060OANEX2 | | | | | | | |
| M62X4 | T5062UANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M62X3 | T5062SANEX2 | | | | | | | |
| M62X2 | T5062QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M62X1.5 | T5062OANEX2 | | | | | | | |
| M64X6 | T5064YANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M64X4 | T5064UANEX2 | | | | | | | |
| M64X3 | T5064SANEX2 | | | | | | | |
| M64X2 | T5064QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M64X1.5 | T5064OANEX2 | | | | | | | |
| M65X4 | T5065UANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M65X3 | T5065SANEX2 | | | | | | | |
| M65X2 | T5065QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M65X1.5 | T5065OANEX2 | | | | | | | |
| M68X6 | T5068YANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M68X4 | T5068UANEX2 | | | | | | | |
| M68X3 | T5068SANEX2 | | | | | | | |
| M68X2 | T5068QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M68X1.5 | T5068OANEX2 | | | | | | | |
| M70X6 | T5070YANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M70X4 | T5070UANEX2 | | | | | | | |
| M70X3 | T5070SANEX2 | | | | | | | |



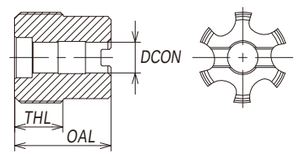
## Dimension and size

### ■ Cutting Edge Portion

[TYPE-1]




[TYPE-2]




### For Metric Threads

| Size | Code | Class | Chamfer | *OAL(L)* (mm) | *THL(ℓ)* (mm) | *DCON(d)* (mm) | No. of flutes | Type |
|---|---|---|---|---|---|---|---|---|
| M70X2 | T5070QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M70X1.5 | T5070OANEX2 | | | | | | | |
| M72X6 | T5072YANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M72X4 | T5072UANEX2 | | | | | | | |
| M72X3 | T5072SANEX2 | | | | | | | |
| M72X2 | T5072QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M72X1.5 | T5072OANEX2 | | | | | | | |
| M75X4 | T5075UANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M75X3 | T5075SANEX2 | | | | | | | |
| M75X2 | T5075QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M75X1.5 | T5075OANEX2 | | | | | | | |
| M76X6 | T5076YANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M76X4 | T5076UANEX2 | | | | | | | |
| M76X3 | T5076SANEX2 | | | | | | | |
| M76X2 | T5076QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M76X1.5 | T5076OANEX2 | | | | | | | |
| M78X2 | T5078QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M80X6 | T5080YANEX2 | ISO2 | 2P | 60 | 60 | 22 | 6 | 1 |
| M80X4 | T5080UANEX2 | | | | | | | |
| M80X3 | T5080SANEX2 | | | | | | | |
| M80X2 | T5080QANEX2 | ISO2 | 2P | 60 | 30 | 22 | 6 | 2 |
| M80X1.5 | T5080OANEX2 | | | | | | | |