

# HT MST

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Hand Taps for  
Microscope  
Objective Lens

Ideal for machining Microscope Objective Threads!!

*26W36 has been added  
for W26 Type!*



# Product Features

Hand Taps for  
Microscope Objective Lens

# HT MST

HSS



Brass  
~10  
(m/min)

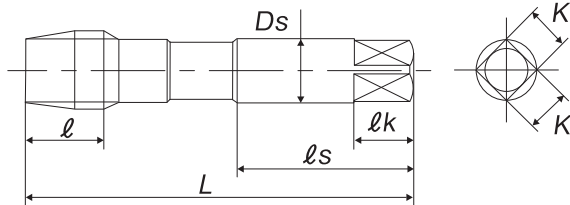
## Features

- Taps for Microscope Objective Lens
- This through-hole tap can be used for tapping internal threads with a machining center or by hand, as well as for re-threading.
- Taps for whitworth threads RMS and W26 type, as specified in JIS B 7141, "Microscopes - Objective Threads".



## Shapes and Dimensions

TYPE:1



### Standard Dimensions of Thread

Unit:mm

Size	Class	Major Diameter	Pitch Diameter	Minor Diameter
		Standard Dimensions	Standard Dimensions	Standard Dimensions
20.32W36	-	20.320	19.868	19.416
26W36	-	26.000	25.548	25.096

### Bored Hole Size

Unit:mm

Size	Minor Diameter of Internal Threads(D1)		Bored Hole Size
	Max.	Min.	
20.32W36	19.550	19.474	19.53
26W36	25.300	25.200	25.28

Segment: 1A

Size	Code	Chamfer	L (mm)	l (mm)	l <sub>s</sub> (mm)	D <sub>s</sub> (mm)	K (mm)	l <sub>k</sub> (mm)	No. of flutes	TYPE	MSRP(JPY)
20.32W36	TYRMS10LEB5	5P	87	16	44	18	14	17	4	1	25,200 □
20.32W36	TYRMS10LEBA	1.5P	87	16	44	18	14	17	4	1	25,200 □
26W36	TYRMS20LEB5	5P	96	17	49	23	17	20	4	1	36,800 □
26W36	TYRMS20LEBA	1.5P	96	17	49	23	17	20	4	1	36,800 □

□=Manufacturer's Stock Items

## Tapping Data

Workpiece Material	Free-Cutting Brass
Tapping Speed	10m/min
Machine Type	Vertical Machining Center
Tapping Fluid	Water-Soluble Cutting Fluid

### Chips (brass)



## About Microscope Objective Threads



Revolver

Microscope  
Objective  
Threads

- The microscope objective threads are used in the revolver part of the microscope, as shown in the photo on the left.
- Typically, "20.32W36" threads, known as "RMS type", are widely used.
- M25 (M25 x 0.75), M27 (M27 x 0.75) and M32 (M32 x 0.75) varieties are also available and can be used with HT. (Specifically distributed products)

Please refer to  
"Bag Full of  
Wisdom when  
you are in trouble"  
for more details.



## 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.

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