

4 Hand Tap Series

JIS

① Spiral Fluted Taps
(for blind hole)

② Spiral Fluted Taps
(for through hole)

③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills

Dies

⑩

⑪ Center Drills
Centering Tools

JIS

④-121



RE-HT

Hand Tap for Thread Repair



Specification



Recommended Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
~5 (m/min)	~5 (m/min)	~5 (m/min)	~5 (m/min)

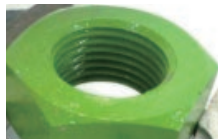
For icon explanation, refer to icon-1

Product features

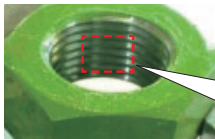
- Main application: repair of screw threads. Removal of burrs, rust, paint or spattering during welding operation.
- Utilizing the best cutting edge shape for manual repairing of large diameter threads.
- By simply exchanging the tap's head portion, it is possible to repair M50 ~ M80 threads using the same arbor and it's very economical.
- By using a long type of arbor, you can repair threads deep in a hole.



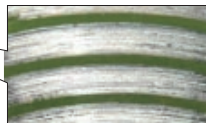
Before repair processing



After repair processing



After repair processing (enlarged picture)



Assembling method

[procedure]

- ① Insert the parallel drive key into the key groove on the arbor.
 - ② Turn the M4 bolt using a 3 mm hex wrench and firmly tighten the parallel drive key in place.
- * 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 the 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 taps head part, secure the arbor firmly to the vise.
- * When ordering for the first time, please order a set of head and arbor.

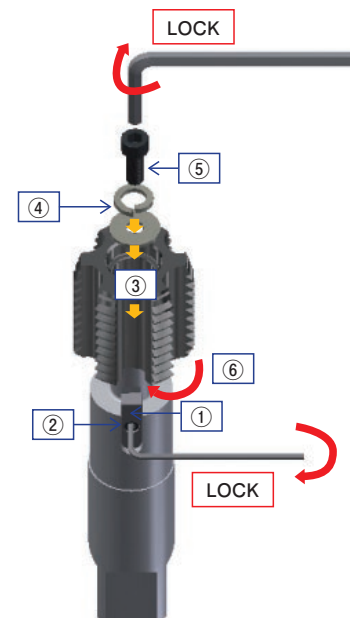
[reference]

Tightening torque of taps head fixing screw

Socket head cap screw	Tightening torque (N · m)
M10	24

Note:

- Because of the tap's head replacement method, normal tapping to produce internal thread can not be performed. Be careful as there is a risk of breakage if an excess torque is imposed on the tap.
- The RE-HT is designed to be used by hand, it can not be used on machines.
- Excessive tightening of hexagon socket head bolts may cause deformation or breakage.



Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

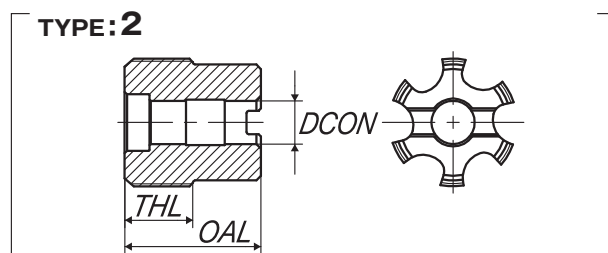
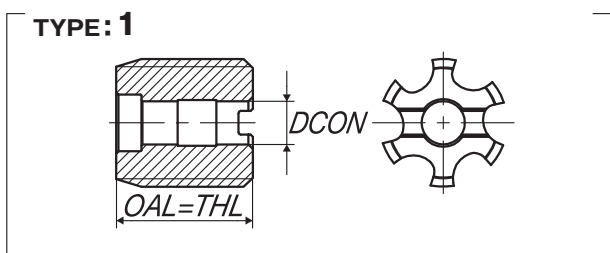
Pipe Taps ⑧

Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

<Head>



Segment : 1A

Size	Class	Code	Chamfer	OAL (L) (mm)	THL (ℓ) (mm)	DCON (d) (mm)	No. of flutes	TYPE	MSRP
For Metric Threads									
M50 × 3	IS02	T5050SANEX2	2P	60	60	22	6	1	¥ 63,900 □
M50 × 2	IS02	T5050QANEX2	2P	60	30	22	6	2	¥ 63,900 □
M50 × 1.5	IS02	T50500ANEX2	2P	60	30	22	6	2	¥ 69,800 □
M52 × 5	IS02	T5052WANEX2	2P	60	60	22	6	1	¥ 69,800 □
M52 × 4	IS02	T5052UANEX2	2P	60	60	22	6	1	¥ 69,800 □
M52 × 3	IS02	T5052SANEX2	2P	60	60	22	6	1	¥ 69,800 □
M52 × 2	IS02	T5052QANEX2	2P	60	30	22	6	2	¥ 69,800 □
M52 × 1.5	IS02	T50520ANEX2	2P	60	30	22	6	2	¥ 69,800 □
M55 × 4	IS02	T5055UANEX2	2P	60	60	22	6	1	¥ 72,300 □
M55 × 3	IS02	T5055SANEX2	2P	60	60	22	6	1	¥ 72,300 □
M55 × 2	IS02	T5055QANEX2	2P	60	30	22	6	2	¥ 72,300 □
M55 × 1.5	IS02	T50550ANEX2	2P	60	30	22	6	2	¥ 72,300 □
M56 × 5.5	IS02	T5056XANEX2	2P	60	60	22	6	1	¥ 81,400 □
M56 × 4	IS02	T5056UANEX2	2P	60	60	22	6	1	¥ 81,400 □
M56 × 3	IS02	T5056SANEX2	2P	60	60	22	6	1	¥ 81,400 □
M56 × 2	IS02	T5056QANEX2	2P	60	30	22	6	2	¥ 81,400 □
M56 × 1.5	IS02	T50560ANEX2	2P	60	30	22	6	2	¥ 81,400 □
M58 × 4	IS02	T5058UANEX2	2P	60	60	22	6	1	¥ 84,800 □
M58 × 3	IS02	T5058SANEX2	2P	60	60	22	6	1	¥ 84,800 □
M58 × 2	IS02	T5058QANEX2	2P	60	30	22	6	2	¥ 84,800 □
M58 × 1.5	IS02	T50580ANEX2	2P	60	30	22	6	2	¥ 84,800 □
M60 × 5.5	IS02	T5060XANEX2	2P	60	60	22	6	1	¥ 98,200 □
M60 × 4	IS02	T5060UANEX2	2P	60	60	22	6	1	¥ 98,200 □
M60 × 3	IS02	T5060SANEX2	2P	60	60	22	6	1	¥ 98,200 □
M60 × 2	IS02	T5060QANEX2	2P	60	30	22	6	2	¥ 98,200 □
M60 × 1.5	IS02	T50600ANEX2	2P	60	30	22	6	2	¥ 98,200 □
M62 × 4	IS02	T5062UANEX2	2P	60	60	22	6	1	¥103,000 □
M62 × 3	IS02	T5062SANEX2	2P	60	60	22	6	1	¥103,000 □
M62 × 2	IS02	T5062QANEX2	2P	60	30	22	6	2	¥103,000 □
M62 × 1.5	IS02	T50620ANEX2	2P	60	30	22	6	2	¥103,000 □
M64 × 6	IS02	T5064YANEX2	2P	60	60	22	6	1	¥120,000 □
M64 × 4	IS02	T5064UANEX2	2P	60	60	22	6	1	¥120,000 □
M64 × 3	IS02	T5064SANEX2	2P	60	60	22	6	1	¥120,000 □
M64 × 2	IS02	T5064QANEX2	2P	60	30	22	6	2	¥120,000 □
M64 × 1.5	IS02	T50640ANEX2	2P	60	30	22	6	2	¥120,000 □
M65 × 4	IS02	T5065UANEX2	2P	60	60	22	6	1	¥125,000 □
M65 × 3	IS02	T5065SANEX2	2P	60	60	22	6	1	¥125,000 □
M65 × 2	IS02	T5065QANEX2	2P	60	30	22	6	2	¥125,000 □
M65 × 1.5	IS02	T50650ANEX2	2P	60	30	22	6	2	¥125,000 □

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RE-HT Hand Tap for Thread Repair

Size	Class	Code	Chamfer	OAL (L) (mm)	THL (ℓ) (mm)	DCON (d) (mm)	No. of flutes	TYPE	MSRP
M68 × 6	IS02	T5068YANEX2	2P	60	60	22	6	1	¥138,000 □
M68 × 4	IS02	T5068UANEX2	2P	60	60	22	6	1	¥138,000 □
M68 × 3	IS02	T5068SANEX2	2P	60	60	22	6	1	¥138,000 □
M68 × 2	IS02	T5068QANEX2	2P	60	30	22	6	2	¥138,000 □
M68 × 1.5	IS02	T50680ANEX2	2P	60	30	22	6	2	¥138,000 □
M70 × 6	IS02	T5070YANEX2	2P	60	60	22	6	1	¥142,000 □
M70 × 4	IS02	T5070UANEX2	2P	60	60	22	6	1	¥142,000 □
M70 × 3	IS02	T5070SANEX2	2P	60	60	22	6	1	¥142,000 □
M70 × 2	IS02	T5070QANEX2	2P	60	30	22	6	2	¥142,000 □
M70 × 1.5	IS02	T50700ANEX2	2P	60	30	22	6	2	¥142,000 □
M72 × 6	IS02	T5072YANEX2	2P	60	60	22	6	1	¥155,000 □
M72 × 4	IS02	T5072UANEX2	2P	60	60	22	6	1	¥155,000 □
M72 × 3	IS02	T5072SANEX2	2P	60	60	22	6	1	¥155,000 □
M72 × 2	IS02	T5072QANEX2	2P	60	30	22	6	2	¥155,000 □
M72 × 1.5	IS02	T50720ANEX2	2P	60	30	22	6	2	¥155,000 □
M75 × 4	IS02	T5075UANEX2	2P	60	60	22	6	1	¥168,000 □
M75 × 3	IS02	T5075SANEX2	2P	60	60	22	6	1	¥168,000 □
M75 × 2	IS02	T5075QANEX2	2P	60	30	22	6	2	¥168,000 □
M75 × 1.5	IS02	T50750ANEX2	2P	60	30	22	6	2	¥168,000 □
M76 × 6	IS02	T5076YANEX2	2P	60	60	22	6	1	¥173,000 □
M76 × 4	IS02	T5076UANEX2	2P	60	60	22	6	1	¥173,000 □
M76 × 3	IS02	T5076SANEX2	2P	60	60	22	6	1	¥173,000 □
M76 × 2	IS02	T5076QANEX2	2P	60	30	22	6	2	¥173,000 □
M76 × 1.5	IS02	T50760ANEX2	2P	60	30	22	6	2	¥173,000 □
M78 × 2	IS02	T5078QANEX2	2P	60	30	22	6	2	¥182,000 □
M80 × 6	IS02	T5080YANEX2	2P	60	60	22	6	1	¥188,000 □
M80 × 4	IS02	T5080UANEX2	2P	60	60	22	6	1	¥188,000 □
M80 × 3	IS02	T5080SANEX2	2P	60	60	22	6	1	¥188,000 □
M80 × 2	IS02	T5080QANEX2	2P	60	30	22	6	2	¥188,000 □
M80 × 1.5	IS02	T50800ANEX2	2P	60	30	22	6	2	¥188,000 □

①

Spiral Fluted Taps
(for blind hole)

②

Spiral Fluted Taps
(for through hole)

③

Spiral Pointed Taps
(for through hole)

④

Hand Taps

⑤

Cemented
Carbide Taps

⑥

Roll Taps

⑦

Special Thread Taps
Simple Inspection Tools

⑧

Pipe Taps

⑨

Thread Mills

⑩

Dies

⑪

Center Drills
Centering Tools

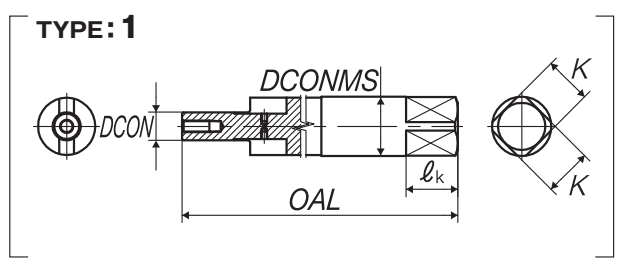
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RE-HT Hand Tap for Thread Repair

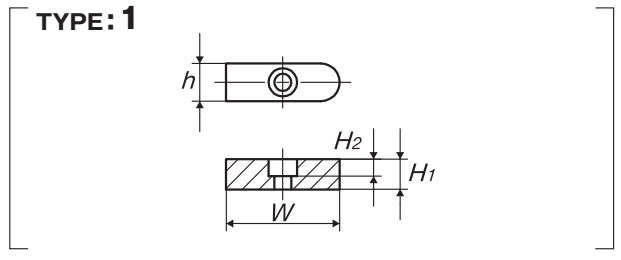
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Size	Code	LF (Overall length after combined with arbor) (mm)	OAL (mm)	DCONMS (mm)	DCON (mm)	K (mm)	lk (mm)	TYPE	MSRP
22 × 45 × 200	REAB22200	200	183	45	22	35	38	1	¥ 60,500 □
22 × 45 × 400	REAB22400	400	383	45	22	35	38	1	¥ 115,000 □
22 × 45 × 600	REAB22600	600	583	45	22	35	38	1	¥ 148,000 □

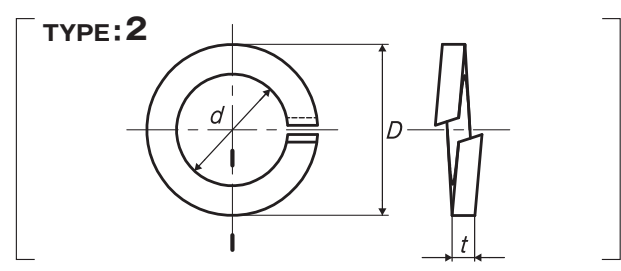
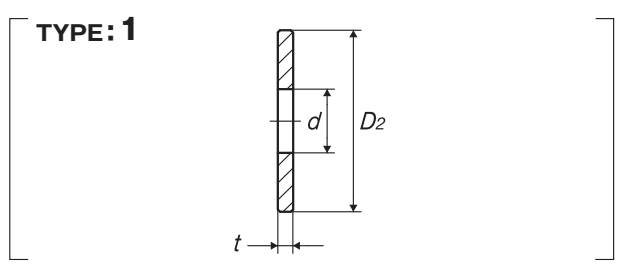
<Arbor Accessories >

1.Parallel Key



Code	w (mm)	h (mm)	H1 (mm)	H2 (mm)	TYPE	MSRP
REPK30	30	10	8	4.5	1	¥ 4,390 □

2.Flat Washer, Spring Washer



Code		D (mm)	D2 (mm)	d (mm)	t (mm)	TYPE	MSRP
REFS3018.4	Flat washer	-	30	10.5	3	1	¥ 480 □
	Spring washer	18.4	-	10.2	2.5	2	

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4 Hand Tap Series

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RE-HT Hand Tap for Thread Repair 3.Hexagon Socket Head Bolt

① Spiral Fluted Taps
(for blind hole)

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③ Spiral Pointed Taps
(for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

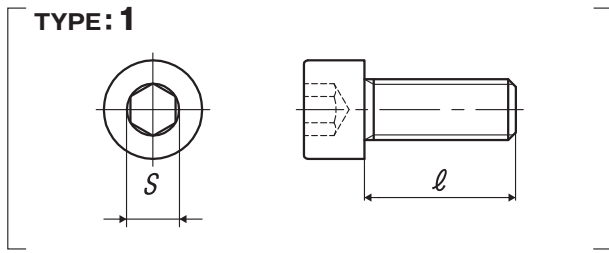
⑦ Special Thread Taps
Simple Inspection Tools

⑧ Pipe Taps

⑨ Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools



Fixing screw for cutting edge portion

Size	Code	S (mm)	ℓ (mm)	TYPE	MSRP
M10	REBL0100	8	25	1	¥ 240 □

Fixing screw for parallel key

Size	Code	S (mm)	ℓ (mm)	TYPE	MSRP
M4	REBL4.0I	3	8	1	¥ 345 □

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