

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

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
Premium Thread Mills

⑩

Dies

⑪

Center Drills
Centering Tools

⑫

Precision Machinery/
Medical Surgical Instruments



AXE-HT

AXE Hand Taps



Specification

HSS-P

Coating



Tapping Speeds depending on Materials

Cast irons
鑄鉄
5~10
(m/min)

Aluminum alloy castings
アルミ合金鑄物
10~20
(m/min)

Zinc alloy castings
亜鉛合金鑄物
10~20
(m/min)

Product Features

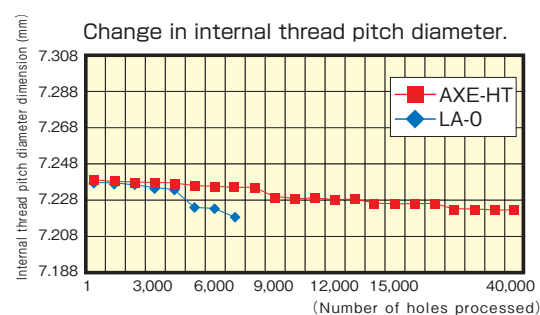
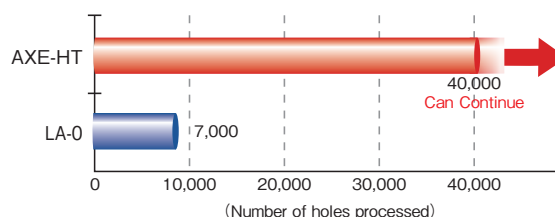
- In the tapping of aluminum alloy castings and their equivalent, the AXE-HT produces an excellent improvement in durability and performance with YAMAWA's unique flute design.
- The unique shape of the special flute design reduces damage to the cutting edge. With the combination of the premium powder HSS (characterized by high abrasion resistance and heat resistance) and the special coating, tool life has increased 5 times compared with the conventional tap designed for aluminum.
- Cutting edge damage diminishes on the flutes. Dimensional change in the internal thread pitch diameter is reduced while surface finishes are improved.
- Suitable from medium to high speed by offering the optimal combination of negative rake angle and eccentric relief.

Tapping Data

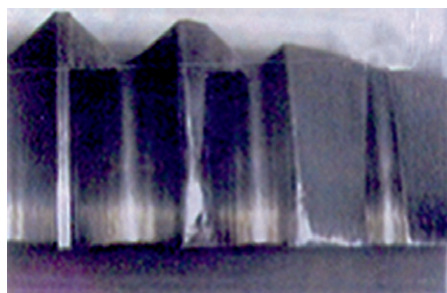
AXE-HT and the LA-O (conventional product)

Processing condition [M8 × 1.25]

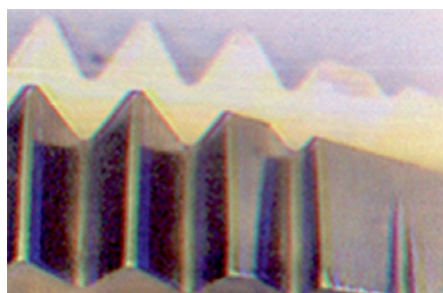
AXE-HT	HSS-P special coating
LA-O	HSS-E NI surface treatment
Workpiece Material	AC4A-T6
Bored Hole Size	φ6.8
Tapping Length	13mm blind hole
Machinery Type	Transfer machine
Feed	Lead screw feed
Tapping Speed	10m/min
Tapping Fluid	Water soluble cutting fluid, 30 to 1 diluted.



Flute of tap after processing 7,000 holes.



LA-O



AXE-HT

Obtainable from
video site shown in right



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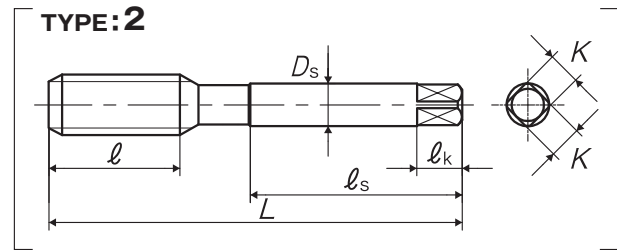
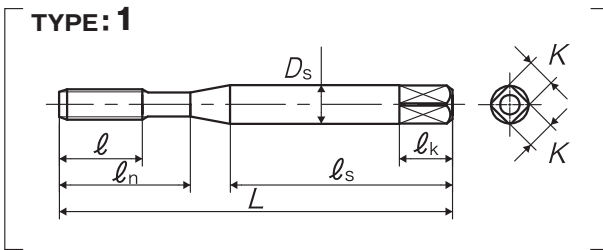
④-115

Think threads with
YAMAWA

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4

JIS



Segment : 1B

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	MSRP
For Metric Threads													
M6 × 1	P3	TAXEMR6.0M1	1.5P	62	15	26	33	6	4.5	7	3	1	¥ 5,280
M8 × 1.25	P3	TAXEMR8.0N1	1.5P	70	19	-	36	6.2	5	8	4	2	¥ 6,890
M10 × 1.5	P3	TAXEMR10O1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 8,180
M10 × 1.25	P3	TAXEMR10N1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 8,180
M10 × 1	P3	TAXEMR10M1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 9,840
M12 × 1.75	P3	TAXEMR12P1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 10,800
M12 × 1.5	P3	TAXEMR12O1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 10,800
M12 × 1.25	P3	TAXEMR12N1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 10,800

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④-116