

5 Cemented Carbide Tap Series

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓ_k

DIN

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

DIN

⑤-25

DIN

EH-CT

Carbide Taps for Hard Materials



Specification



Tapping Speeds depending on Materials

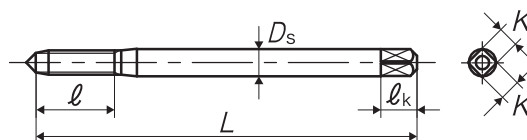


Product Features

- Ideal for hilgh hardness steel blind hole tapping of 45 to 55 HRC materials such as steel for hot dies (SKS 3, SKD 11, etc.).
- The EH-CT utilizes a ultra fine grain cemented carbide that is superior in abrasion resistance and impact resistance.
- Improved run-out accuracy of whole tap and circularity of shank.
- Tapping length is the "major diameter size × 1.5 or less", 5P chamfer for better tool life.
- For the bored hole diameter, the maximum minor diameter of a 6H internal thread diameter maximum value is recommended.

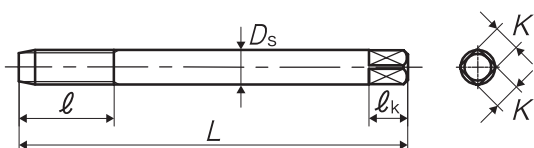
TYPE: 1

YAMAWA



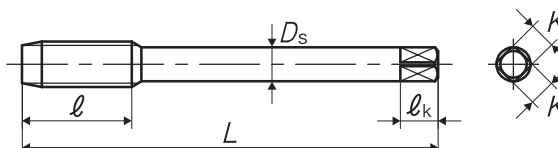
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TYPE: 3

DIN376



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads										
M3 × 0.5	ISO2X	TD3.0GBCWA5	5P	56	11	3.5	2.7	6	4	1
M4 × 0.7	ISO2X	TD4.0IBCWA5	5P	63	13	4.5	3.4	6	4	1
M5 × 0.8	ISO2X	TD5.0KBCWA5	5P	70	16	6	4.9	8	4	1
M6 × 1	ISO2X	TD6.0MBCWA5	5P	80	19	6	4.9	8	5	1
M8 × 1.25	ISO2X	TD8.0NBCWA5	5P	90	22	8	6.2	9	5	2
M10 × 1.5	ISO2X	TD010OBCWA5	5P	100	24	10	8	11	5	2
M12 × 1.75	ISO2X	TG012PBCWA5	5P	110	29	9	7	10	5	3

Think threads with
YAMAWA

· This product is different from JIS products in shape and dimensions, please be careful when using.