

## EH-HT

Hand Taps for Hard-to-Machine Materials



### Specification

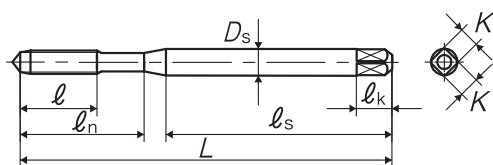


■ EH-HT is the hand tap suitable for hard steels of 35-45HRC, such as forgings and thermal refined steels of high carbon steels and alloy steels, and die steels.

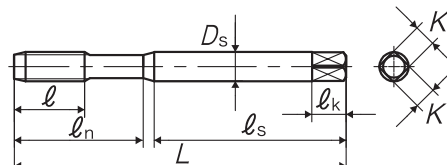
### Tapping Speeds depending on Materials

| Thermal refined steels<br>調質鋼 | Tool steels<br>工具鋼 |
|-------------------------------|--------------------|
| ~5<br>(m/min)                 | ~5<br>(m/min)      |
| 35~45HRC                      |                    |

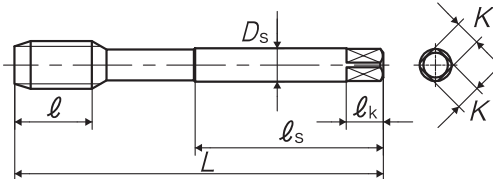
#### TYPE:1



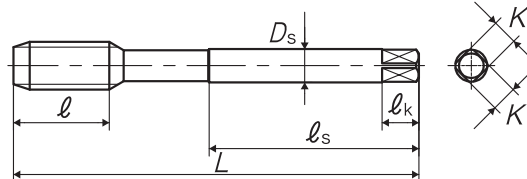
#### TYPE:2



#### TYPE:3



#### TYPE:4



Segment : 1B (G=1H)

| Size               | Class | Code         | Chamfer | L<br>(mm) | l<br>(mm) | ln<br>(mm) | ls<br>(mm) | Ds<br>(mm) | K<br>(mm) | lk<br>(mm) | No. of<br>flutes | TYPE |
|--------------------|-------|--------------|---------|-----------|-----------|------------|------------|------------|-----------|------------|------------------|------|
| For Metric Threads |       |              |         |           |           |            |            |            |           |            |                  |      |
| M2.5 × 0.45        | ISO2X | TD2.5FBDCBC  | 2.5P    | 50        | 8         | 15         | 33         | 2.8        | 2.1       | 5          | 3                | 1    |
| M3 × 0.5           | ISO2X | TD3.0GBDCBC  | 2.5P    | 56        | 9         | 18         | 34         | 3.5        | 2.7       | 6          | 3                | 1    |
| M4 × 0.7           | ISO2X | TD4.0IBDCBC  | 2.5P    | 63        | 13        | 21         | 38         | 4.5        | 3.4       | 6          | 3                | 1    |
| M4.5 × 0.75        | ISO2X | TD4.5JBDCBC  | 2.5P    | 70        | 14        | 24         | 39         | 6          | 4.9       | 8          | 3                | 1    |
| M5 × 0.8           | ISO2X | TD5.0KBDCBC  | 2.5P    | 70        | 14        | 25         | 39         | 6          | 4.9       | 8          | 3                | 1    |
| M6 × 1             | ISO2X | TD6.0MBDCBC  | 2.5P    | 80        | 15        | 30         | 45         | 6          | 4.9       | 8          | 3                | 1    |
| M8 × 1.25          | ISO2X | TD8.0NBDCBC  | 2.5P    | 90        | 19        | 35         | 47         | 8          | 6.2       | 9          | 4                | 2    |
| M8 × 1             | ISO2X | TM8.0MBDCBC  | 2.5P    | 90        | 19        | -          | 46         | 6          | 4.9       | 8          | 4                | 3    |
| M10 × 1.5          | ISO2X | TD10.0OBDCBC | 2.5P    | 100       | 23        | 39         | 52.5       | 10         | 8         | 11         | 4                | 2    |
| M10 × 1.25         | ISO2X | TM10.0NBDCBC | 2.5P    | 100       | 23        | -          | 51         | 7          | 5.5       | 8          | 4                | 3    |
| M10 × 1            | ISO2X | TM10.0MBDCBC | 2.5P    | 90        | 19        | -          | 46         | 7          | 5.5       | 8          | 4                | 3    |
| M12 × 1.75         | ISO2X | TG12.0PBDCBC | 2.5P    | 110       | 26        | -          | 56         | 9          | 7         | 10         | 4                | 4    |
| M12 × 1.5          | ISO2X | TM12.0OBDCBC | 2.5P    | 100       | 21        | -          | 51         | 9          | 7         | 10         | 4                | 3    |
| M12 × 1.25         | ISO2X | TM12.0NBDCBC | 2.5P    | 100       | 21        | -          | 51         | 9          | 7         | 10         | 4                | 3    |
| M14 × 2            | ISO2X | TG14.0QBDCBC | 2.5P    | 110       | 26        | -          | 56         | 11         | 9         | 12         | 4                | 4    |
| M14 × 1.5          | ISO2X | TM14.0OBDCBC | 2.5P    | 100       | 21        | -          | 51         | 11         | 9         | 12         | 4                | 3    |
| M16 × 2            | ISO2X | TG16.0QBDCBC | 2.5P    | 110       | 26        | -          | 56         | 12         | 9         | 12         | 4                | 4    |
| M16 × 1.5          | ISO2X | TM16.0OBDCBC | 2.5P    | 100       | 21        | -          | 51         | 12         | 9         | 12         | 4                | 3    |
| M18 × 2.5          | ISO2X | TG18.0RBDCBC | 2.5P    | 125       | 33        | -          | 64         | 14         | 11        | 14         | 4                | 4    |

# ④ Hand Tap Series

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

DIN

## EH-HT Hand Taps for Hard-to-Machine Materials

| Size             | Class | Code        | Chamfer | L<br>(mm) | ℓ<br>(mm) | ℓn<br>(mm) | ℓs<br>(mm) | Ds<br>(mm) | K<br>(mm) | ℓk<br>(mm) | No. of flutes | TYPE |
|------------------|-------|-------------|---------|-----------|-----------|------------|------------|------------|-----------|------------|---------------|------|
| <b>M18 × 1.5</b> | ISO2X | TM018OBDCBC | 2.5P    | 110       | 24        | -          | 56         | 14         | 11        | 14         | 4             | 3    |
| <b>M20 × 2.5</b> | ISO2X | TG020RBDCBC | 2.5P    | 140       | 33        | -          | 71         | 16         | 12        | 15         | 4             | 4    |
| <b>M20 × 1.5</b> | ISO2X | TM020OBDCBC | 2.5P    | 125       | 24        | -          | 64         | 16         | 12        | 15         | 4             | 3    |
| <b>M22 × 2.5</b> | ISO2X | TG022RBDCBC | 2.5P    | 140       | 33        | -          | 71         | 18         | 14.5      | 17         | 4             | 4    |
| <b>M24 × 3</b>   | ISO2X | TG024SBDCBC | 2.5P    | 160       | 37        | -          | 82         | 18         | 14.5      | 17         | 4             | 4    |
| For G Threads    |       |             |         |           |           |            |            |            |           |            |               |      |
| <b>G 1/8-28</b>  | -     | TVG0020DCBC | 2.5P    | 90        | 19        | -          | 46         | 7          | 5.5       | 8          | 4             | 3    |
| <b>G 1/4-19</b>  | -     | TVG0040DCBC | 2.5P    | 100       | 21        | -          | 51         | 11         | 9         | 12         | 4             | 3    |
| <b>G 3/8-19</b>  | -     | TVG0060DCBC | 2.5P    | 100       | 21        | -          | 51         | 12         | 9         | 12         | 4             | 3    |
| <b>G 1/2-14</b>  | -     | TVG0080DCBC | 2.5P    | 125       | 24        | -          | 64         | 16         | 12        | 15         | 4             | 3    |

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

④-129

Think threads with  
**YAMAWA**

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