

# 6 Roll Tap Series

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ <sub>n</sub>	ℓ <sub>s</sub>	D <sub>s</sub>	K	ℓ <sub>k</sub>

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

⑧ Pipe Taps

⑨ Thread Mills Premium Thread Mills

⑩ Simple Inspection Tools Related Products

⑪ Dies

⑫ Center Drills Centering Tools

⑬ Precision Machinery/Medical Surgical Instruments

DIN

⑥-5



## Z-PRO EHRZ

### Z-PRO Extra Hard Roll Taps



#### Specification



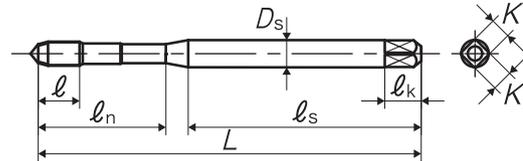
- A semi-long shape allows for more efficient external lubrication and achieves excellent machining results.
- The combination of a unique thread relief and a coating that maximizes the benefits of surface treatments results in reduced torque and improved welding-resistance.

#### Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Thermal refined steels 調質鋼	Stainless steels ステンレス鋼
10~30 (m/min)	10~30 (m/min)	10~30 (m/min)	10~20 (m/min)	5~15 (m/min)
25~40HRC				

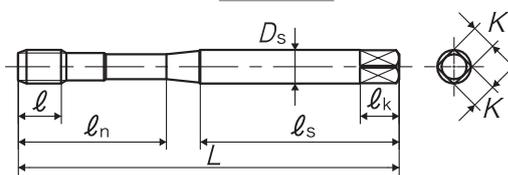
\*For sizes M14 and larger, please use a tapping speed 30% lower than pictured above.

#### TYPE: 1

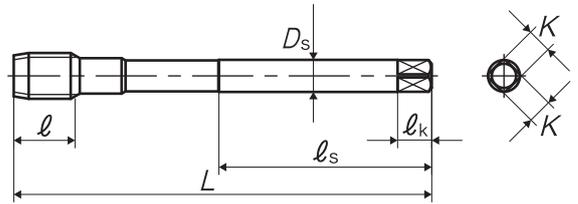


#### TYPE: 2

DIN371



#### TYPE: 3



Segment : 1J

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ <sub>n</sub> (mm)	ℓ <sub>s</sub> (mm)	D <sub>s</sub> (mm)	K (mm)	ℓ <sub>k</sub> (mm)	Lobe	TYPE
For Metric Threads												
M3 × 0.5	ISO2X	3120101035	D (4P)	56	5	18	34	3.5	2.7	6	5	1
M3 × 0.5	ISO2X	3121101035	C (2P)	56	5	18	34	3.5	2.7	6	5	1
M4 × 0.7	ISO2X	3120101042	D (4P)	63	7	21	38	4.5	3.4	6	5	1
M4 × 0.7	ISO2X	3121101042	C (2P)	63	7	21	38	4.5	3.4	6	5	1
M5 × 0.8	ISO2X	3120101049	D (4P)	70	9	25	39	6	4.9	8	5	1
M5 × 0.8	ISO2X	3121101049	C (2P)	70	9	25	39	6	4.9	8	5	1
M6 × 1	ISO2X	3120101055	D (4P)	80	11	30	45	6	4.9	8	5	1
M6 × 1	ISO2X	3121101055	C (2P)	80	11	30	45	6	4.9	8	5	1
M8 × 1.25	ISO2X	3120101064	D (4P)	90	12	35	47	8	6.2	9	6	2
M8 × 1.25	ISO2X	3121101064	C (2P)	90	12	35	47	8	6.2	9	6	2
M8 × 1	ISO2X	3120101065	D (4P)	90	12	-	46	6	4.9	8	6	3
M8 × 1	ISO2X	3121101065	C (2P)	90	12	-	46	6	4.9	8	6	3
M10 × 1.5	ISO2X	3120101078	D (4P)	100	13	39	52	10	8	11	8	2
M10 × 1.5	ISO2X	3121101078	C (2P)	100	13	39	52	10	8	11	8	2
M10 × 1.25	ISO2X	3120101079	D (4P)	100	13	-	51	7	5.5	8	8	3
M10 × 1.25	ISO2X	3121101079	C (2P)	100	13	-	51	7	5.5	8	8	3



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

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE
M10 × 1	ISO2X	3120101080	D (4P)	90	13	-	46	7	5.5	8	8	3
M10 × 1	ISO2X	3121101080	C (2P)	90	13	-	46	7	5.5	8	8	3
M12 × 1.75	ISO2X	3120101088	D (4P)	110	15	-	56	9	7	10	8	3
M12 × 1.75	ISO2X	3121101088	C (2P)	110	15	-	56	9	7	10	8	3
M12 × 1.5	ISO2X	3120101089	D (4P)	100	15	-	51	9	7	10	8	3
M12 × 1.5	ISO2X	3121101089	C (2P)	100	15	-	51	9	7	10	8	3
M12 × 1.25	ISO2X	3120101090	D (4P)	100	15	-	51	9	7	10	8	3
M12 × 1.25	ISO2X	3121101090	C (2P)	100	15	-	51	9	7	10	8	3
M12 × 1	ISO2X	3120101091	D (4P)	100	15	-	51	9	7	10	8	3
M12 × 1	ISO2X	3121101091	C (2P)	100	15	-	51	9	7	10	8	3
M14 × 2	ISO2X	3120101100	D (4P)	110	18	-	56	11	9	12	8	3
M14 × 2	ISO2X	3121101100	C (2P)	110	18	-	56	11	9	12	8	3
M14 × 1.5	ISO2X	3120101102	D (4P)	100	18	-	51	11	9	12	8	3
M14 × 1.5	ISO2X	3121101102	C (2P)	100	18	-	51	11	9	12	8	3
M14 × 1.25	ISO2X	3120101103	D (4P)	100	18	-	51	11	9	12	8	3
M14 × 1.25	ISO2X	3121101103	C (2P)	100	18	-	51	11	9	12	8	3
M16 × 2	ISO2X	3120101114	D (4P)	110	18	-	56	12	9	12	8	3
M16 × 2	ISO2X	3121101114	C (2P)	110	18	-	56	12	9	12	8	3
M16 × 1.5	ISO2X	3120101116	D (4P)	100	18	-	51	12	9	12	8	3
M16 × 1.5	ISO2X	3121101116	C (2P)	100	18	-	51	12	9	12	8	3

Number of oil grooves: M3~M6 = 5, M8 = 6, M10 and larger = 8

For M6 and smaller, external centers of 2 thread chamfer taps are removed.

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 ⑦

Pipe Taps ⑧

Thread Mills  
Premium Thread Mills ⑨

Simple Inspection Tools  
Related Products ⑩

Dies ⑪

Center Drills  
Centering Tools ⑫

Precision Machinery/  
Medical Surgical Instruments ⑬

DIN

⑥-6