

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

JIS

④-95



FC-HT

Hand Taps for Cast Irons



Specification



Tapping Speeds depending on Materials

Cast irons 鑄鉄	Ductile cast irons 強靱鑄鉄
5~10 (m/min)	5~10 (m/min)

Product Features

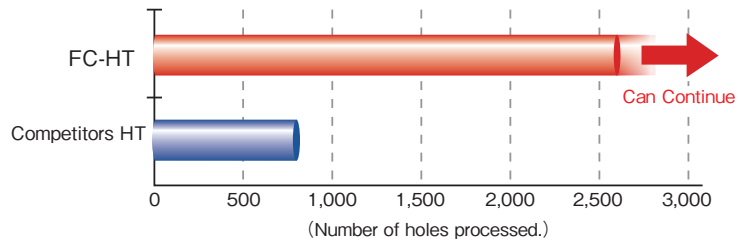
- The FC-HT is suitable for thread processing of hard and brittle materials such as cast iron. It is produced slightly oversized because wear is relatively fast in these materials.

Tapping Data

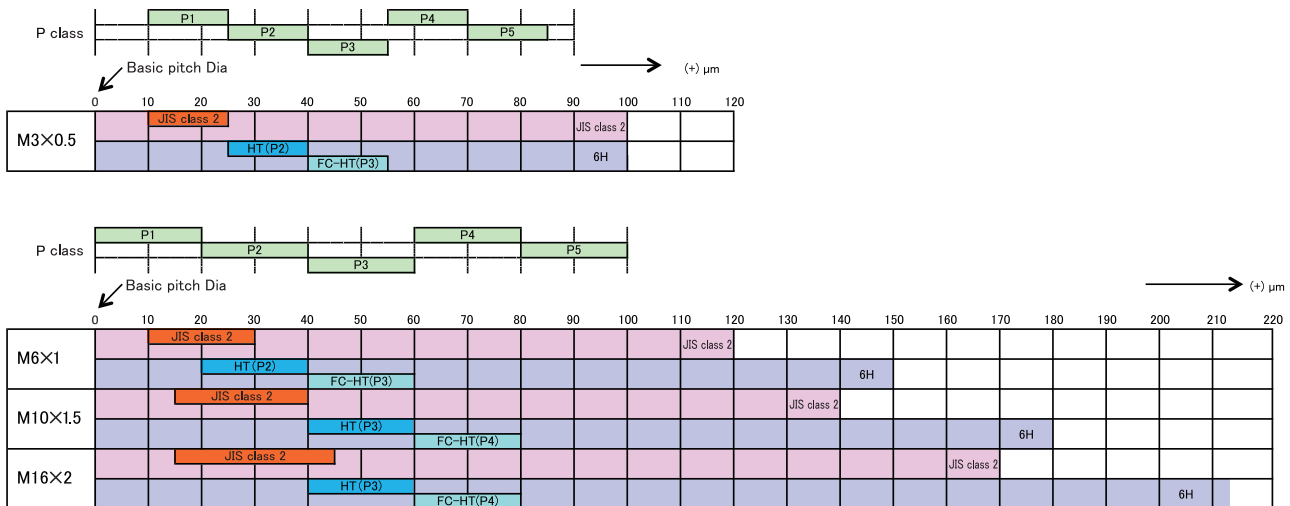
Tapping Conditions [M8×1.25]

Workpiece Material	FC25
Bored Hole Size	φ6.8
Tapping Length	12mm
Tapping Speed	6.5m/min
Machinery Type	Special machine
Tapping Fluid	Water soluble cutting fluid

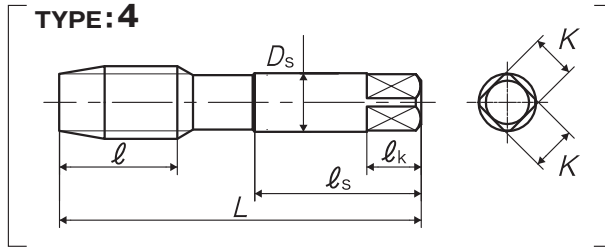
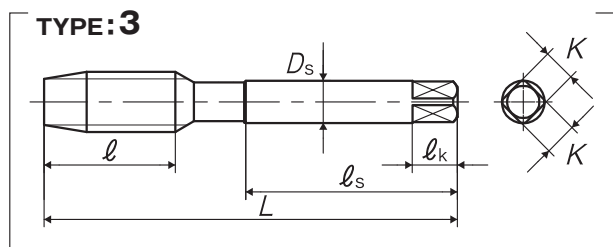
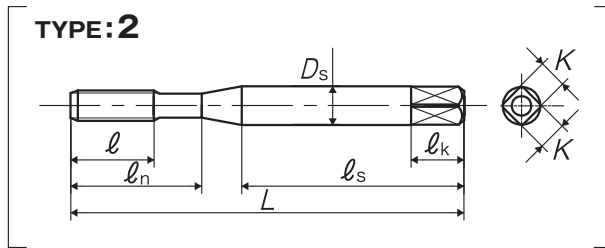
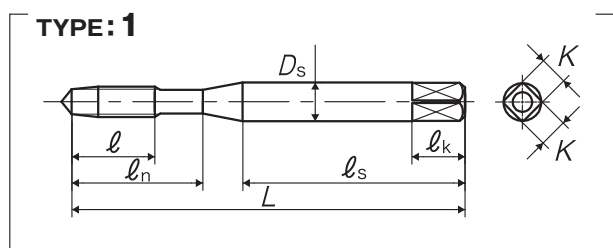
Comparison of number of holes tapped.



Comparison of accuracy between HT and FC-HT



Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M3 × 0.5	P3	TY3.0GRAEN5	5P	46	9	14	26	4	3.2	6	3	1	¥ 1,330
M3 × 0.5	P3	TY3.0GRAENA	1.5P	46	9	14	26	4	3.2	6	3	1	¥ 1,330
M3.5 × 0.6	P3	TY3.5HRAEN5	5P	52	11	16	29	5	4	7	3	1	¥ 1,330*
M3.5 × 0.6	P3	TY3.5HRAENA	1.5P	52	11	16	29	5	4	7	3	1	¥ 1,330*
M4 × 0.7	P3	TY4.0IRAEN5	5P	52	11	17	29	5	4	7	3	1	¥ 1,330
M4 × 0.7	P3	TY4.0IRAENA	1.5P	52	11	17	29	5	4	7	3	1	¥ 1,330
M5 × 0.8	P3	TY5.0KRAEN5	5P	60	13	22	33	5.5	4.5	7	3	1	¥ 1,340
M5 × 0.8	P3	TY5.0KRAENA	1.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 1,340
M6 × 1	P3	TY6.0MRAEN5	5P	62	15	26	33	6	4.5	7	3	1	¥ 1,470
M6 × 1	P3	TY6.0MRAENA	1.5P	62	15	26	33	6	4.5	7	3	2	¥ 1,470
M8 × 1.25	P3	TY8.0NRAEN5	5P	70	19	-	36	6.2	5	8	3	3	¥ 2,120
M8 × 1.25	P3	TY8.0NRAENA	1.5P	70	19	-	36	6.2	5	8	3	3	¥ 2,120
M8 × 1	P3	TY8.0MRAEN5	5P	70	19	-	36	6.2	5	8	3	3	¥ 2,510*
M8 × 1	P3	TY8.0MRAENA	1.5P	70	19	-	36	6.2	5	8	3	3	¥ 2,510*
M10 × 1.5	P4	TY010OSAEN5	5P	75	23	-	38	7	5.5	8	4	3	¥ 2,690
M10 × 1.5	P4	TY010OSAENA	1.5P	75	23	-	38	7	5.5	8	4	3	¥ 2,690
M10 × 1.25	P3	TY010NRAEN5	5P	75	23	-	38	7	5.5	8	4	3	¥ 2,690
M10 × 1.25	P3	TY010NRAENA	1.5P	75	23	-	38	7	5.5	8	4	3	¥ 2,690
M10 × 1	P3	TY010MRAEN5	5P	75	23	-	38	7	5.5	8	4	3	¥ 3,350
M10 × 1	P3	TY010MRAENA	1.5P	75	23	-	38	7	5.5	8	4	3	¥ 3,350
M12 × 1.75	P4	TY012PSAEN5	5P	82	26	-	42	8.5	6.5	9	4	3	¥ 3,820
M12 × 1.75	P4	TY012PSAENA	1.5P	82	26	-	42	8.5	6.5	9	4	3	¥ 3,820
M12 × 1.5	P4	TY012OSAEN5	5P	82	26	-	42	8.5	6.5	9	4	3	¥ 4,000
M12 × 1.5	P4	TY012OSAENA	1.5P	82	26	-	42	8.5	6.5	9	4	3	¥ 4,000
M12 × 1.25	P4	TY012NSAEN5	5P	82	26	-	42	8.5	6.5	9	4	3	¥ 4,000
M12 × 1.25	P4	TY012NSAENA	1.5P	82	26	-	42	8.5	6.5	9	4	3	¥ 4,000
M12 × 1	P3	TY012MRAEN5	5P	82	26	-	42	8.5	6.5	9	4	3	¥ 4,690*
M12 × 1	P3	TY012MRAENA	1.5P	82	26	-	42	8.5	6.5	9	4	3	¥ 4,690*
M14 × 2	P4	TY014QSAEN5	5P	88	26	-	45	10.5	8	11	4	3	¥ 5,440
M14 × 2	P4	TY014QSAENA	1.5P	88	26	-	45	10.5	8	11	4	3	¥ 5,440
M14 × 1.5	P4	TY014OSAEN5	5P	88	26	-	45	10.5	8	11	4	3	¥ 5,440
M14 × 1.5	P4	TY014OSAENA	1.5P	88	26	-	45	10.5	8	11	4	3	¥ 5,440
M16 × 2	P4	TY016QSAEN5	5P	95	26	-	48	12.5	10	13	4	3	¥ 7,280

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L	ℓ	ℓn	ℓs	Ds	K	ℓk

JIS

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Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M16 × 2	P4	TY016QSAENA	1.5P	95	26	-	48	12.5	10	13	4	3	¥ 7,280
M16 × 1.5	P4	TY016OSAEN5	5P	95	26	-	48	12.5	10	13	4	3	¥ 7,280
M16 × 1.5	P4	TY016OSAENA	1.5P	95	26	-	48	12.5	10	13	4	3	¥ 7,280
M18 × 2.5	P5	TY018RTAEN5	5P	100	33	-	51	14	11	14	4	3	¥ 9,700
M18 × 2.5	P5	TY018RTAENA	1.5P	100	33	-	51	14	11	14	4	3	¥ 9,700
M18 × 1.5	P4	TY018OSAEN5	5P	100	33	-	51	14	11	14	4	3	¥ 9,700
M18 × 1.5	P4	TY018OSAENA	1.5P	100	33	-	51	14	11	14	4	3	¥ 9,700
M20 × 2.5	P5	TY020RTAEN5	5P	105	33	-	50	15	12	15	4	4	¥ 13,200
M20 × 2.5	P5	TY020RTAENA	1.5P	105	33	-	50	15	12	15	4	4	¥ 13,200
M20 × 1.5	P4	TY020OSAEN5	5P	105	33	-	50	15	12	15	4	4	¥ 13,200
M20 × 1.5	P4	TY020OSAENA	1.5P	105	33	-	50	15	12	15	4	4	¥ 13,200
M22 × 2.5	P5	TY022RTAEN5	5P	115	33	-	55	17	13	16	4	4	¥ 17,100 [*]
M22 × 2.5	P5	TY022RTAENA	1.5P	115	33	-	55	17	13	16	4	4	¥ 17,100 [*]
M22 × 1.5	P4	TY022OSAEN5	5P	115	33	-	55	17	13	16	4	4	¥ 17,100 [*]
M22 × 1.5	P4	TY022OSAENA	1.5P	115	33	-	55	17	13	16	4	4	¥ 17,100 [*]
M24 × 3	P5	TY024STAEN5	5P	120	39	-	55	19	15	18	4	4	¥ 21,300 [*]
M24 × 3	P5	TY024STAENA	1.5P	120	39	-	55	19	15	18	4	4	¥ 21,300 [*]
M24 × 1.5	P4	TY024OSAEN5	5P	120	39	-	55	19	15	18	4	4	¥ 21,300
M24 × 1.5	P4	TY024OSAENA	1.5P	120	39	-	55	19	15	18	4	4	¥ 21,300

Note: The cast iron hand tap "FC - O" was discontinued in December 2015.

For details of this product please refer to the YAMAWA 2013 - 2014 General Catalog.

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