

GG-HT

Hand Taps for Cast Irons

Specification

HSS

NI
Nitride



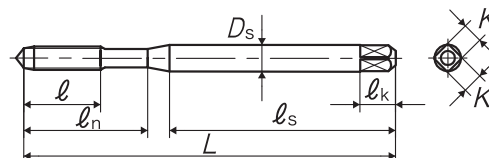
■ Suitable for hard and abrasive materials such as cast irons. Considering comparatively quick wear, GG-HT is properly oversized.

Tapping Speeds depending on Materials

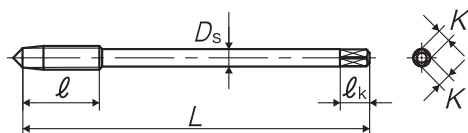
Cast irons
鑄鉄
5~10
(m/min)

Ductile cast irons
強靱鑄鉄
5~10
(m/min)

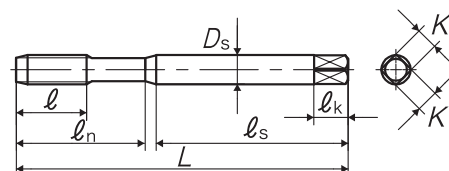
TYPE: 1



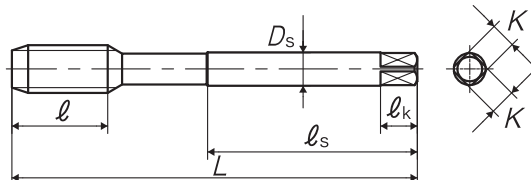
TYPE: 2



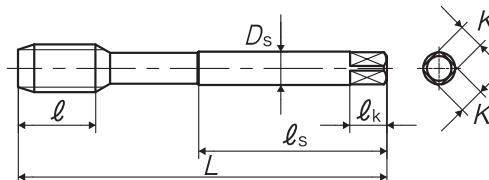
TYPE: 3



TYPE: 4



TYPE: 5



Segment : 1B (G=1H)

Size	Class	Code	Chamfer	L (mm)	l (mm)	ln (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	TYPE
For Metric Threads												
M3 × 0.5	ISO2X	TD3.0GBAENC	2.5P	56	9	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2X	TD4.0IBAENC	2.5P	63	13	21	38	4.5	3.4	6	4	1
M5 × 0.8	ISO2X	TD5.0KBAENC	2.5P	70	14	25	39	6	4.9	8	4	1
M5 × 0.8	ISO2X	TG5.0KBAENC	2.5P	70	14	-	-	3.5	2.7	6	4	2
M6 × 1	ISO2X	TD6.0MBAENC	2.5P	80	15	30	45	6	4.9	8	4	1
M6 × 1	ISO2X	TG6.0MBAENC	2.5P	80	15	-	-	4.5	3.4	6	4	2
M8 × 1.25	ISO2X	TD8.0NBAENC	2.5P	90	19	35	47	8	6.2	9	4	3
M8 × 1.25	ISO2X	TG8.0NBAENC	2.5P	90	19	-	46	6	4.9	8	4	4
M8 × 1	ISO2X	TM8.0MBAENC	2.5P	90	19	-	46	6	4.9	8	4	5
M10 × 1.5	ISO2X	TD10.0BAENC	2.5P	100	23	39	52.5	10	8	11	4	3
M10 × 1.5	ISO2X	TG10.0BAENC	2.5P	100	23	-	51	7	5.5	8	4	4
M10 × 1.25	ISO2X	TM10.0NBAENC	2.5P	100	23	-	51	7	5.5	8	4	5
M10 × 1	ISO2X	TM10.0MBAENC	2.5P	90	19	-	46	7	5.5	8	4	5
M12 × 1.75	ISO2X	TG12.0PBAENC	2.5P	110	26	-	56	9	7	10	4	4
M12 × 1.5	ISO2X	TM12.0BAENC	2.5P	100	21	-	51	9	7	10	4	5
M12 × 1.25	ISO2X	TM12.0NBAENC	2.5P	100	21	-	51	9	7	10	4	5

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

GG-HT Hand Taps for Cast Irons

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M12 × 1	ISO2X	TM012MBAENC	2.5P	100	21	-	51	9	7	10	4	5
M14 × 2	ISO2X	TG014QBAENC	2.5P	110	26	-	56	11	9	12	4	4
M14 × 1.5	ISO2X	TM014OBAENC	2.5P	100	21	-	51	11	9	12	4	5
M16 × 2	ISO2X	TG016QBAENC	2.5P	110	26	-	56	12	9	12	4	4
M16 × 1.5	ISO2X	TM016OBAENC	2.5P	100	21	-	51	12	9	12	4	5
M18 × 2.5	ISO2X	TG018RBAENC	2.5P	125	33	-	64	14	11	14	4	4
M18 × 1.5	ISO2X	TM018OBAENC	2.5P	110	24	-	56	14	11	14	4	5
M20 × 2.5	ISO2X	TG020RBAENC	2.5P	140	33	-	71	16	12	15	4	4
M20 × 1.5	ISO2X	TM020OBAENC	2.5P	125	24	-	64	16	12	15	4	5
M22 × 2.5	ISO2X	TG022RBAENC	2.5P	140	33	-	71	18	14.5	17	4	4
M22 × 1.5	ISO2X	TM022OBAENC	2.5P	125	24	-	64	18	14.5	17	4	5
M24 × 3	ISO2X	TG024SBAENC	2.5P	160	37	-	82	18	14.5	17	4	4
M24 × 1.5	ISO2X	TM024OBAENC	2.5P	140	27	-	71	18	14.5	17	4	5
For G Threads												
G 1/8-28	-	TVG0020AENC	2.5P	90	19	-	46	7	5.5	8	4	5
G 1/4-19	-	TVG0040AENC	2.5P	100	21	-	51	11	9	12	4	5
G 3/8-19	-	TVG0060AENC	2.5P	100	21	-	51	12	9	12	4	5
G 1/2-14	-	TVG0080AENC	2.5P	125	24	-	64	16	12	15	4	5
G 3/4-14	-	TVG0120AENC	2.5P	140	27	-	71	20	16	19	4	5
G 1 -11	-	TVG0160AENC	2.5P	160	29	-	82	25	20	23	4	5

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

④-101

Think threads with
YAMAWA

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