

HP+RZ HP-RZ

High Performance Roll Taps, Coated

Specification



■ HP+RZ/HP-RZ is the forming tap suitable for steels (up to 35HRC) and light alloys, and applicable to the high speed tapping. Optimum coating suitable to the tapping condition.

Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
15~30
(m/min)

Medium carbon steels
中炭素鋼
15~30
(m/min)

High carbon steels
高炭素鋼
15~25
(m/min)

Alloy steels
合金鋼
15~25
(m/min)

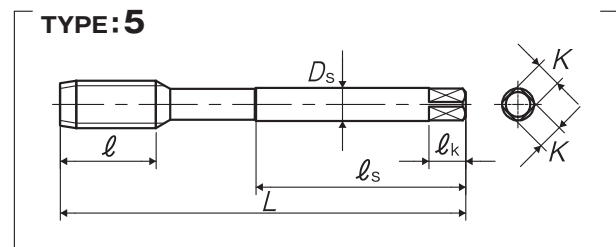
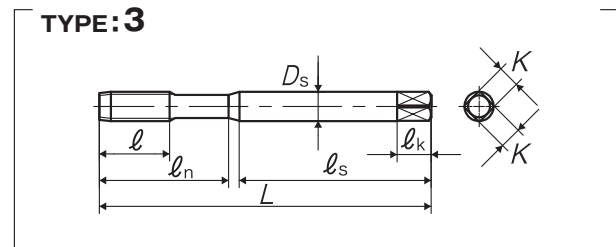
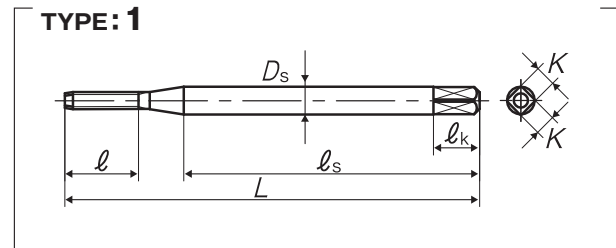
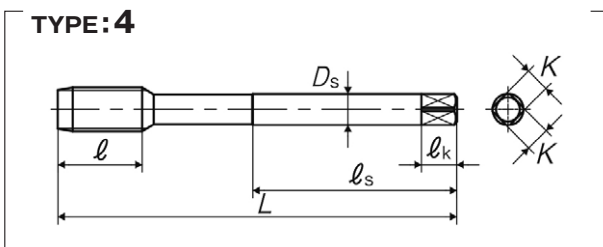
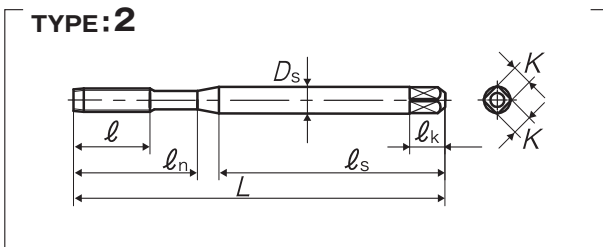
Thermal refined steels
調質鋼
15~25
(m/min)
25~35HRC

Stainless steels
ステンレス鋼
10~25
(m/min)

Aluminum alloy castings
アルミ合金鋳物
15~30
(m/min)

• Product symbol is distinguished depend on the size.

HP+RZ	~ M6
HP-RZ	M8 ~



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Segment : 1J

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	Lobe	TYPE
For Metric Threads												
M2 × 0.4	ISO2X	RE2.0EBFPTB	2P	45	8	-	32	2.8	2.1	5	4	1
M2 × 0.4	ISO3X	RE2.0ENFPTB	2P	45	8	-	32	2.8	2.1	5	4	1
M2.5 × 0.45	ISO2X	RE2.5FBFPTB	2P	50	8	15	33	2.8	2.1	5	4	2
M2.5 × 0.45	ISO3X	RE2.5FNPTB	2P	50	8	15	33	2.8	2.1	5	4	2

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

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

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Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE
M3 × 0.5	ISO2X	RE3.0GBFPTB	2P	56	9	18	34	3.5	2.7	6	4	2
M3 × 0.5	ISO3X	RE3.0GNFPTB	2P	56	9	18	34	3.5	2.7	6	4	2
M4 × 0.7	ISO2X	RE4.0IBFPTB	2P	63	13	21	38	4.5	3.4	6	4	2
M4 × 0.7	ISO3X	RE4.0INFPTB	2P	63	13	21	38	4.5	3.4	6	4	2
M5 × 0.8	ISO2X	RE5.0KBFPPTB	2P	70	14	25	39	6	4.9	8	4	2
M5 × 0.8	ISO3X	RE5.0KNFPTB	2P	70	14	25	39	6	4.9	8	4	2
M6 × 1	ISO2X	RE6.0MBFPTB	2P	80	15	30	45	6	4.9	8	4	2
M6 × 1	ISO3X	RE6.0MNFPTB	2P	80	15	30	45	6	4.9	8	4	2

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Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE
For Metric Threads												
M8 × 1.25	ISO2X	RD8.0NBFPPTB	2P	90	19	35	47	8	6.2	9	6	3
M8 × 1.25	ISO3X	RD8.0NNFPTB	2P	90	19	35	47	8	6.2	9	6	3
M10 × 1.5	ISO2X	RD010OBFPTB	2P	100	23	39	52.5	10	8	11	8	3
M10 × 1.5	ISO3X	RD010ONFPTB	2P	100	23	39	52.5	10	8	11	8	3
M10 × 1.25	ISO2X	RM010NBFPPTB	2P	100	23	-	51	7	5.5	8	8	4
M12 × 1.75	ISO2X	RG012PBFPTB	2P	110	26	-	56	9	7	10	8	5
M12 × 1.75	ISO3X	RG012PNFPTB	2P	110	26	-	56	9	7	10	8	5
M12 × 1.5	ISO2X	RM012OBFPTB	2P	100	21	-	51	9	7	10	8	4
M12 × 1.25	ISO2X	RM012NBFPPTB	2P	100	21	-	51	9	7	10	8	4
M14 × 2	ISO2X	RG014QBFPTB	2P	110	26	-	56	11	9	12	8	5
M14 × 1.5	ISO2X	RM014OBFPTB	2P	100	21	-	51	11	9	12	8	4
M16 × 2	ISO2X	RG016QBFPTB	2P	110	26	-	56	12	9	12	8	5
M16 × 1.5	ISO2X	RM016OBFPTB	2P	100	21	-	51	12	9	12	8	4

Number of oil grooves : M2.6 and smaller = 0, M3 to M6 = 2, M8 = 3, M10 and larger = 4