

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

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

④-53

IST

IHT

Hand Taps for General Purpose



Specification



Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼
~5 (m/min)	~5 (m/min)



Blister Pack



Product Features

- IHT is for hand tapping and for re-threading, and is used for both through hole and blind hole.
- Use for threading of the iron (SPC or SS400) products used in our daily life.
- Surface treated. Oxidization, the most suitable surface treatment for iron products.
- Suitable for internal thread cutting in small quantity, such as tapping of test pieces.
- The 5 thread chamfer is recommended for through holes and 2 thread chamfer is recommended for blind holes.



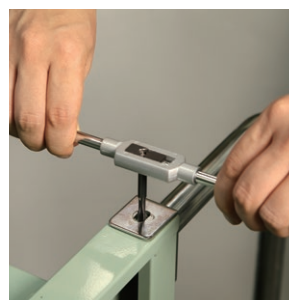
Through hole = 5 thread type



Blind hole = 2 thread type

How to use IHT

- Start tapping after boring holes corresponding to the thread size by using drills (note: For drill sizes, refer to drill sizes shown in the bored hole size table.)
- On hand tapping, operate tapping in an upright position parallel to bored holes by using tap wrenches.
- During tapping, please use tapping oil.



When hand tapping, always use tap wrench



Machine tapping with drilling machine

Table for bored and drilled hole sizes

unit: mm

Size	Minor Diameter of Internal Thread Size			Drill Size	Thread Engagement
	Minimum Tolerance	Maximum Tolerance			
		6H (2nd Class)	7H (3rd Class)		
M3 × 0.5	2.459	2.599	2.639	2.6 (2.5)	74% (92%)
M4 × 0.7	3.242	3.422	3.466	3.4 (3.3)	79% (92%)
M5 × 0.8	4.134	4.344	4.384	4.3 (4.2)	81% (92%)
M6 × 1	4.917	5.153	5.217	5.1 (5.0)	83% (92%)
M8 × 1.25	6.647	6.912	6.982	6.9 (6.8)	91% (89%)
M10 × 1.5	8.376	8.676	8.751	8.6 (8.5)	86% (92%)

note1) Recommended drill sizes shown in this table are for internal threads of 7H class (3rd class), and are selected from the standard drills available in the market.

note2) Drill sizes shown in brackets in this table are for such case as the drilling has oversize cutting tendency or for internal threads of 6H class (2nd class).

[Related products]

Shank adjuster

- For deep hole tapplings, please use shank adjusters.
- There is only a one touch motion required to detach and attach the I series taps (IHT/ISP/IPO) from or to the shank adjuster.

*For details of shank adjuster, refer to ⑦-83



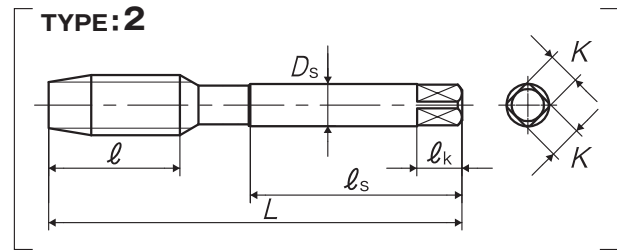
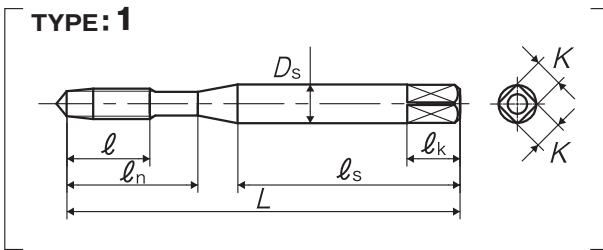
Obtainable from
video site shown in right

Think threads with
YAMAWA

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L	ℓ	ℓ_n	ℓ_s	Ds	K	ℓ_k

4

JIS



Blister Pack

Segment : 1A

Size	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M3 × 0.5	HI73.0G5BP	5P	46	9	14	26	4	3.2	6	3	1	¥ 850
M3 × 0.5	HI73.0G2BP	2P	46	9	14	26	4	3.2	6	3	1	¥ 850
M4 × 0.7	HI74.0I5BP	5P	52	11	17	29	5	4	7	3	1	¥ 790
M4 × 0.7	HI74.0I2BP	2P	52	11	17	29	5	4	7	3	1	¥ 790
M5 × 0.8	HI75.0K5BP	5P	60	13	22	33	5.5	4.5	7	3	1	¥ 850
M5 × 0.8	HI75.0K2BP	2P	60	13	22	33	5.5	4.5	7	3	1	¥ 850
M6 × 1	HI76.0M5BP	5P	62	15	26	33	6	4.5	7	3	1	¥ 930
M6 × 1	HI76.0M2BP	2P	62	15	26	33	6	4.5	7	3	1	¥ 930
M8 × 1.25	HI78.0N5BP	5P	70	19	-	36	6.2	5	8	3	2	¥ 1,420
M8 × 1.25	HI78.0N2BP	2P	70	19	-	36	6.2	5	8	3	2	¥ 1,420
M10 × 1.5	HI7010O5BP	5P	75	23	-	38	7	5.5	8	3	2	¥ 1,800
M10 × 1.5	HI7010O2BP	2P	75	23	-	38	7	5.5	8	3	2	¥ 1,800

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