

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 |

- 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)



LA-HT

Hand Taps for Die Cast Materials



Specification



Recommended Tapping Speeds depending on Materials

| | | |
|----------------------------|------------------------------------|-------------------------------|
| Wrought aluminum アルミ圧延材 | Aluminum alloy castings アルミ合金鋳物 | Zinc alloy castings 亜鉛合金鋳物 |
| 5~15 (m/min) | 5~15 (m/min) | 5~15 (m/min) |

Product Features

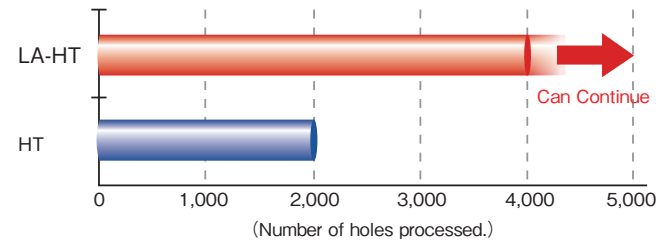
● Aluminum thin alloy like (ADC) , Zinc alloy die casting (ZDC) . It is a slightly oversized tap designed to compensate for the materials tendency to contract after tapping.

Tapping Data

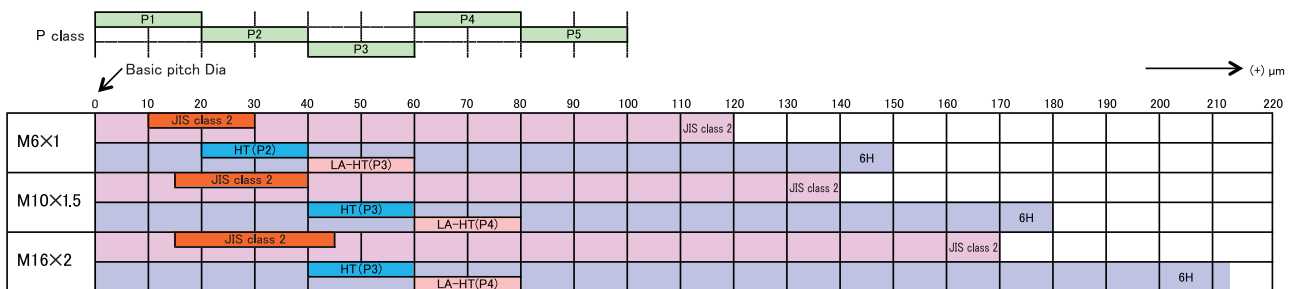
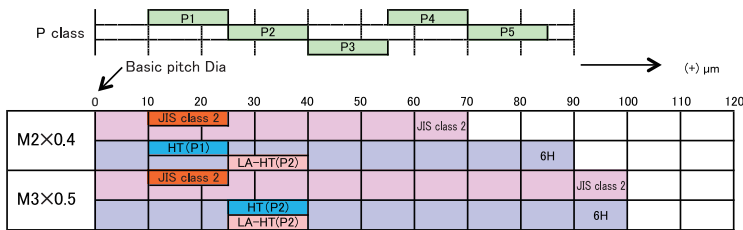
Tapping Conditions [M6×1 1.5P]

| | |
|--------------------|-----------------------------|
| Workpiece Material | ADC12 |
| Bored Hole Size | φ5 |
| Tapping Length | 14.3mm |
| Tapping Speed | 18m/min |
| Machinery Type | M/C |
| Tapping Fluid | Water soluble cutting fluid |

Comparison of number of holes tapped.



Comparison of accuracy between HT and LA-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 |

4

JIS

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple inspection tools ⑦

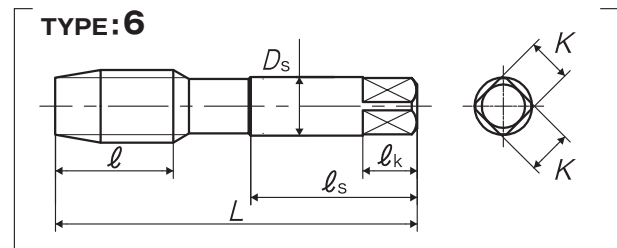
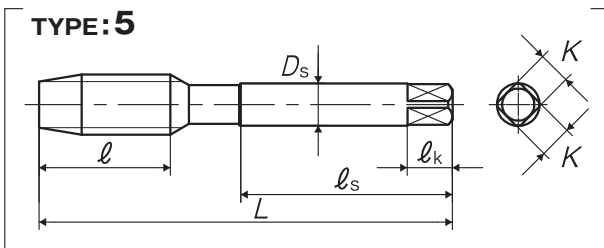
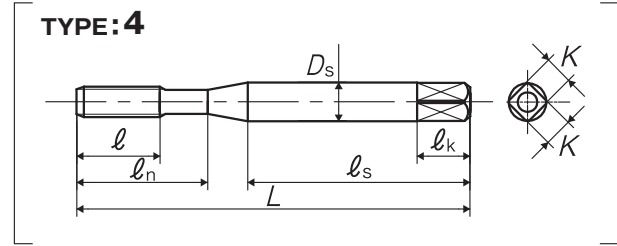
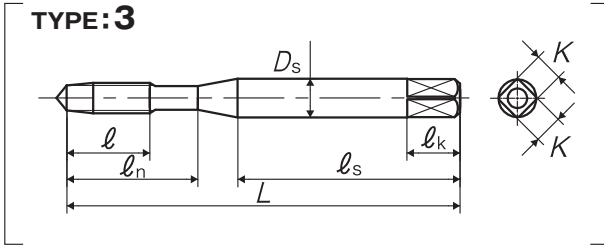
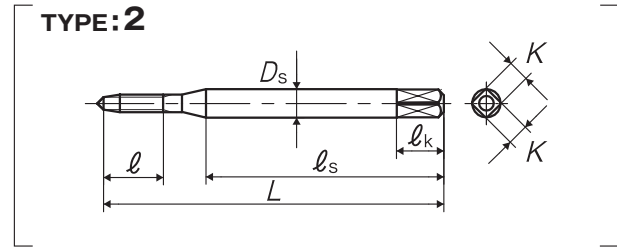
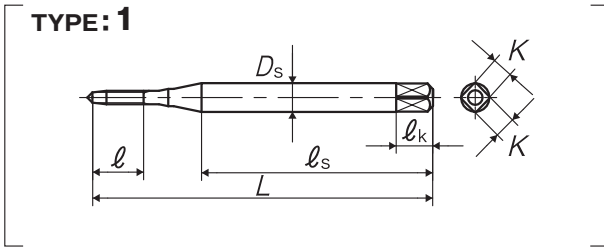
Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

④-108



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 | | | | | | | | | | | | | |
| M1.4 × 0.3 | P2 | TY1.4CQLEN5 | 5P | 36 | 5.4 | - | 24 | 3 | 2.5 | 5 | 3 | 1 | ¥ 2,880 ^{**} |
| M1.4 × 0.3 | P2 | TY1.4CQLENA | 1.5P | 36 | 5.4 | - | 24 | 3 | 2.5 | 5 | 3 | 1 | ¥ 2,880 ^{**} |
| M1.6 × 0.35 | P2 | TY1.6DQLEN5 | 5P | 36 | 6.3 | - | 24 | 3 | 2.5 | 5 | 3 | 2 | ¥ 2,740 ^{**} |
| M1.6 × 0.35 | P2 | TY1.6DQLENA | 1.5P | 36 | 6.3 | - | 24 | 3 | 2.5 | 5 | 3 | 2 | ¥ 2,740 ^{**} |
| M2 × 0.4 | P2 | TY2.0EQLEN5 | 5P | 42 | 7.2 | 12 | 27 | 3 | 2.5 | 5 | 3 | 3 | ¥ 2,200 |
| M2 × 0.4 | P2 | TY2.0EQLENA | 1.5P | 42 | 7.2 | 12 | 27 | 3 | 2.5 | 5 | 3 | 3 | ¥ 2,200 |
| M2.3 × 0.4 | P2 | TY2.3EQLEN5 | 5P | 42 | 7.2 | 12 | 27 | 3 | 2.5 | 5 | 3 | 3 | ¥ 1,990 ^{**} |
| M2.3 × 0.4 | P2 | TY2.3EQLENA | 1.5P | 42 | 7.2 | 12 | 27 | 3 | 2.5 | 5 | 3 | 3 | ¥ 1,990 ^{**} |
| M2.5 × 0.45 | P2 | TY2.5FQLEN5 | 5P | 46 | 8.1 | 14 | 29 | 3 | 2.5 | 5 | 3 | 3 | ¥ 1,680 |
| M2.5 × 0.45 | P2 | TY2.5FQLENA | 1.5P | 46 | 8.1 | 14 | 29 | 3 | 2.5 | 5 | 3 | 3 | ¥ 1,680 |
| M2.6 × 0.45 | P2 | TY2.6FQLEN5 | 5P | 46 | 8.1 | 14 | 29 | 3 | 2.5 | 5 | 3 | 3 | ¥ 1,680 ^{**} |
| M2.6 × 0.45 | P2 | TY2.6FQLENA | 1.5P | 46 | 8.1 | 14 | 29 | 3 | 2.5 | 5 | 3 | 3 | ¥ 1,680 ^{**} |
| M3 × 0.5 | P2 | TY3.0GQLEN5 | 5P | 46 | 9 | 14 | 26 | 4 | 3.2 | 6 | 3 | 3 | ¥ 1,180 |
| M3 × 0.5 | P2 | TY3.0GQLENA | 1.5P | 46 | 9 | 14 | 26 | 4 | 3.2 | 6 | 3 | 3 | ¥ 1,180 |
| M3.5 × 0.6 | P2 | TY3.5HQLEN5 | 5P | 52 | 11 | 16 | 29 | 5 | 4 | 7 | 3 | 3 | ¥ 1,180 ^{**} |
| M3.5 × 0.6 | P2 | TY3.5HQLENA | 1.5P | 52 | 11 | 16 | 29 | 5 | 4 | 7 | 3 | 3 | ¥ 1,180 ^{**} |
| M4 × 0.7 | P3 | TY4.0IRLEN5 | 5P | 52 | 11 | 17 | 29 | 5 | 4 | 7 | 3 | 3 | ¥ 1,180 |
| M4 × 0.7 | P3 | TY4.0IRLENA | 1.5P | 52 | 11 | 17 | 29 | 5 | 4 | 7 | 3 | 3 | ¥ 1,180 |
| M5 × 0.8 | P3 | TY5.0KRLEN5 | 5P | 60 | 13 | 22 | 33 | 5.5 | 4.5 | 7 | 3 | 3 | ¥ 1,190 |
| M5 × 0.8 | P3 | TY5.0KRLENA | 1.5P | 60 | 13 | 22 | 33 | 5.5 | 4.5 | 7 | 3 | 3 | ¥ 1,190 |
| M6 × 1 | P3 | TY6.0MRLEN5 | 5P | 62 | 15 | 26 | 33 | 6 | 4.5 | 7 | 3 | 3 | ¥ 1,300 |
| M6 × 1 | P3 | TY6.0MRLENA | 1.5P | 62 | 15 | 26 | 33 | 6 | 4.5 | 7 | 3 | 4 | ¥ 1,300 |
| M8 × 1.25 | P3 | TY8.0NRLEN5 | 5P | 70 | 19 | - | 36 | 6.2 | 5 | 8 | 3 | 5 | ¥ 1,820 |
| M8 × 1.25 | P3 | TY8.0NRLENA | 1.5P | 70 | 19 | - | 36 | 6.2 | 5 | 8 | 3 | 5 | ¥ 1,820 |
| M8 × 1 | P3 | TY8.0MRLEN5 | 5P | 70 | 19 | - | 36 | 6.2 | 5 | 8 | 3 | 5 | ¥ 2,070 ^{**} |
| M8 × 1 | P3 | TY8.0MRLENA | 1.5P | 70 | 19 | - | 36 | 6.2 | 5 | 8 | 3 | 5 | ¥ 2,070 ^{**} |

Think threads with
YAMAWA

** = Specified Distribution Items. Made to order products.

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 |

LA-HT Hand Taps for Die Cast Materials

| Size | Class | Code | Chamfer | L (mm) | ℓ (mm) | ℓn (mm) | ℓs (mm) | Ds (mm) | K (mm) | ℓk (mm) | No. of flutes | TYPE | MSRP |
|------------|-------|-------------|---------|--------|--------|---------|---------|---------|--------|---------|---------------|------|-----------|
| M10 × 1.5 | P4 | TY0100SLEN5 | 5P | 75 | 23 | - | 38 | 7 | 5.5 | 8 | 4 | 5 | ¥ 2,320 |
| M10 × 1.5 | P4 | TY0100SLENA | 1.5P | 75 | 23 | - | 38 | 7 | 5.5 | 8 | 4 | 5 | ¥ 2,320 |
| M10 × 1.25 | P3 | TY010NRLEN5 | 5P | 75 | 23 | - | 38 | 7 | 5.5 | 8 | 4 | 5 | ¥ 2,320 |
| M10 × 1.25 | P3 | TY010NRLENA | 1.5P | 75 | 23 | - | 38 | 7 | 5.5 | 8 | 4 | 5 | ¥ 2,320 |
| M10 × 1 | P3 | TY010MRLEN5 | 5P | 75 | 23 | - | 38 | 7 | 5.5 | 8 | 4 | 5 | ¥ 2,760* |
| M10 × 1 | P3 | TY010MRLENA | 1.5P | 75 | 23 | - | 38 | 7 | 5.5 | 8 | 4 | 5 | ¥ 2,760* |
| M12 × 1.75 | P4 | TY012PSLEN5 | 5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,290 |
| M12 × 1.75 | P4 | TY012PSLENA | 1.5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,290 |
| M12 × 1.5 | P4 | TY0120SLEN5 | 5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,290* |
| M12 × 1.5 | P4 | TY0120SLENA | 1.5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,290* |
| M12 × 1.25 | P4 | TY012NSLEN5 | 5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,290* |
| M12 × 1.25 | P4 | TY012NSLENA | 1.5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,290* |
| M12 × 1 | P3 | TY012MRLEN5 | 5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,870* |
| M12 × 1 | P3 | TY012MRLENA | 1.5P | 82 | 26 | - | 42 | 8.5 | 6.5 | 9 | 4 | 5 | ¥ 3,870* |
| M14 × 2 | P4 | TY014QSLEN5 | 5P | 88 | 26 | - | 45 | 10.5 | 8 | 11 | 4 | 5 | ¥ 4,490* |
| M14 × 2 | P4 | TY014QSLENA | 1.5P | 88 | 26 | - | 45 | 10.5 | 8 | 11 | 4 | 5 | ¥ 4,490* |
| M14 × 1.5 | P4 | TY0140SLEN5 | 5P | 88 | 26 | - | 45 | 10.5 | 8 | 11 | 4 | 5 | ¥ 4,490 |
| M14 × 1.5 | P4 | TY0140SLENA | 1.5P | 88 | 26 | - | 45 | 10.5 | 8 | 11 | 4 | 5 | ¥ 4,490 |
| M16 × 2 | P4 | TY016QSLEN5 | 5P | 95 | 26 | - | 48 | 12.5 | 10 | 13 | 4 | 5 | ¥ 6,000* |
| M16 × 2 | P4 | TY016QSLENA | 1.5P | 95 | 26 | - | 48 | 12.5 | 10 | 13 | 4 | 5 | ¥ 6,000* |
| M16 × 1.5 | P4 | TY0160SLEN5 | 5P | 95 | 26 | - | 48 | 12.5 | 10 | 13 | 4 | 5 | ¥ 6,000* |
| M16 × 1.5 | P4 | TY0160SLENA | 1.5P | 95 | 26 | - | 48 | 12.5 | 10 | 13 | 4 | 5 | ¥ 6,000* |
| M18 × 2.5 | P5 | TY018RTLEN5 | 5P | 100 | 33 | - | 51 | 14 | 11 | 14 | 4 | 5 | ¥ 8,010* |
| M18 × 2.5 | P5 | TY018RTLENA | 1.5P | 100 | 33 | - | 51 | 14 | 11 | 14 | 4 | 5 | ¥ 8,010* |
| M18 × 1.5 | P4 | TY0180SLEN5 | 5P | 100 | 33 | - | 51 | 14 | 11 | 14 | 4 | 5 | ¥ 8,010* |
| M18 × 1.5 | P4 | TY0180SLENA | 1.5P | 100 | 33 | - | 51 | 14 | 11 | 14 | 4 | 5 | ¥ 8,010* |
| M20 × 2.5 | P5 | TY020RTLEN5 | 5P | 105 | 33 | - | 50 | 15 | 12 | 15 | 4 | 6 | ¥ 10,900* |
| M20 × 2.5 | P5 | TY020RTLENA | 1.5P | 105 | 33 | - | 50 | 15 | 12 | 15 | 4 | 6 | ¥ 10,900* |
| M20 × 1.5 | P4 | TY0200SLEN5 | 5P | 105 | 33 | - | 50 | 15 | 12 | 15 | 4 | 6 | ¥ 10,900 |
| M20 × 1.5 | P4 | TY0200SLENA | 1.5P | 105 | 33 | - | 50 | 15 | 12 | 15 | 4 | 6 | ¥ 10,900 |
| M22 × 2.5 | P5 | TY022RTLENA | 1.5P | 115 | 33 | - | 55 | 17 | 13 | 16 | 4 | 6 | ¥ 14,000* |
| M22 × 1.5 | P4 | TY0220SLENA | 1.5P | 115 | 33 | - | 55 | 17 | 13 | 16 | 4 | 6 | ¥ 14,000* |
| M24 × 3 | P5 | TY024STLENA | 1.5P | 120 | 39 | - | 55 | 19 | 15 | 18 | 4 | 6 | ¥ 17,400* |
| M24 × 1.5 | P4 | TY0240SLENA | 1.5P | 120 | 39 | - | 55 | 19 | 15 | 18 | 4 | 6 | ¥ 17,400* |

Note: The die cast materials hand tap "LA-O" was discontinued in December 2015.

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

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