

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

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

⑦-7

LS-AL-HT STI

Long, Hand Taps for Aluminum Materials (for Helical Coil Wire Screw Thread Inserts)



Specification

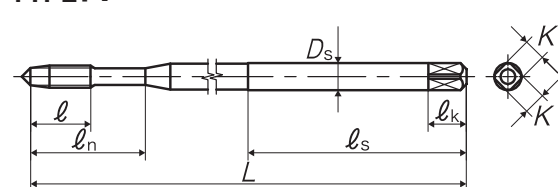


Tapping Speeds depending on Materials

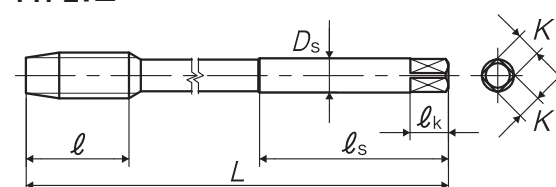
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

- This is used to cut a comparatively soft material, such as aluminum, and create an internal thread for accommodating a helical coil wire screw thread insert, in order to reinforce the internal thread and increase durability.
- Diameter of the internal screw threads into which the insert coil is inserted, is larger than that of the corresponding external screw threads by the thickness of the coil. Therefore, the internal screw thread diameter of the insert coil thread tap is also larger than its nominal diameter.
- The bored hole size needs to be also larger. Make sure to prepare an appropriate bored hole size before tapping.
- The shank diameter is also larger. Make sure to use an appropriate tap holder.
- Oversize taps of lb+30 are also available to allow for shrinkage of internal threads.

TYPE:1



TYPE:2



Segment : 1A

Size	Class	Code	Chamfer	Basic major dia (mm)	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	Ib	TW3.0G1LEB5E	5P	3.650	100	7.5	21	40	5	4	7	3	1	¥ 7,480 ※
M3 × 0.5	Ib	TW3.0G1LEBAE	1.5P	3.650	100	7.5	21	40	5	4	7	3	1	¥ 7,480 ※
M4 × 0.7	Ib	TW4.0I1LEB5E	5P	4.909	100	13	25	40	5.5	4.5	7	4	1	¥ 6,480 ※
M4 × 0.7	Ib	TW4.0I1LEBAE	1.5P	4.909	100	13	25	40	5.5	4.5	7	4	1	¥ 6,480 ※
M5 × 0.8	Ib	TW5.0K1LEB5E	5P	6.039	100	15	30	40	6	4.5	7	4	1	¥ 5,430 ※
M5 × 0.8	Ib	TW5.0K1LEBAE	1.5P	6.039	100	15	30	40	6	4.5	7	4	1	¥ 5,430 ※
M6 × 1	Ib	TW6.0M1LEB5E	5P	7.299	100	19	-	50	6.2	5	8	4	2	¥ 4,370 ※
M6 × 1	Ib	TW6.0M1LEB5G	5P	7.299	150	19	-	50	6.2	5	8	4	2	¥ 7,740 ※
M6 × 1	Ib	TW6.0M1LEBAE	1.5P	7.299	100	19	-	50	6.2	5	8	4	2	¥ 4,370 ※
M6 × 1	Ib	TW6.0M1LEBAG	1.5P	7.299	150	19	-	50	6.2	5	8	4	2	¥ 7,740 ※
M8 × 1.25	Ib	TW8.0N1LEB5E	5P	9.624	100	23	-	50	7	5.5	8	4	2	¥ 5,730 ※
M8 × 1.25	Ib	TW8.0N1LEB5G	5P	9.624	150	23	-	50	7	5.5	8	4	2	¥ 9,750 ※
M8 × 1.25	Ib	TW8.0N1LEBAE	1.5P	9.624	100	23	-	50	7	5.5	8	4	2	¥ 5,730 ※
M8 × 1.25	Ib	TW8.0N1LEBAG	1.5P	9.624	150	23	-	50	7	5.5	8	4	2	¥ 9,750 ※
M10 × 1.5	Ib	TW010O1LEB5G	5P	11.948	150	26	-	50	8.5	6.5	9	4	2	¥ 12,100 ※
M10 × 1.5	Ib	TW010O1LEBAG	1.5P	11.948	150	26	-	50	8.5	6.5	9	4	2	¥ 12,100 ※
M10 × 1.25	Ib	TW010N1LEB5G	5P	11.624	150	26	-	50	8.5	6.5	9	4	2	¥ 12,100 ※
M10 × 1.25	Ib	TW010N1LEBAG	1.5P	11.624	150	26	-	50	8.5	6.5	9	4	2	¥ 12,100 ※
M12 × 1.75	Ib	TW012P1LEB5G	5P	14.273	150	26	-	60	12.5	10	13	4	2	¥ 14,600 ※
M12 × 1.75	Ib	TW012P1LEBAG	1.5P	14.273	150	26	-	60	12.5	10	13	4	2	¥ 14,600 ※
M12 × 1.5	Ib	TW012O1LEB5G	5P	13.948	150	26	-	60	10.5	8	11	4	2	¥ 14,600 ※
M12 × 1.5	Ib	TW012O1LEBAG	1.5P	13.948	150	26	-	60	10.5	8	11	4	2	¥ 14,600 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

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

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M12 × 1.25	1 b	TW012N1LEB5G	5P	13.624	150	26	-	60	10.5	8	11	4	2	¥ 14,600 ※
M12 × 1.25	1 b	TW012N1LEBAG	1.5P	13.624	150	26	-	60	10.5	8	11	4	2	¥ 14,600 ※

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JIS

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
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(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 ⑪Precision Machinery/
Medical Surgical Instruments ⑫

JIS

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YAMAWA