

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

LS-N-RS

Long Shank Roll Taps for Non-Ferrous Materials



Specification



■ LS-N-RS is the long shank forming tap suitable for non-ferrous materials such as aluminum castings, aluminum diecasting and brass.

Recommended Tapping Speeds depending on Materials

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

Spiral Fluted Taps (for blind hole) ①

Spiral Fluted Taps (for through hole) ②

Spiral Pointed Taps (for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

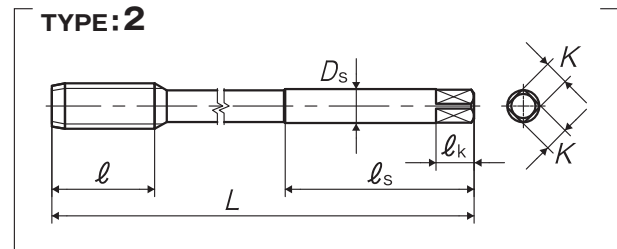
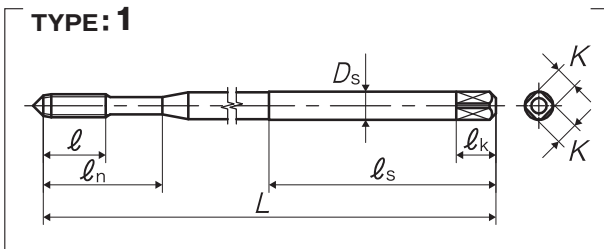
Special Thread Taps Simple inspection tools ⑦

Pipe Taps ⑧

Thread Mills Premium Thread Mills ⑨

Dies ⑩

Center Drills Centering Tools ⑪



Recommended class
Segment : 1J

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE	MSRP
For Metric Threads													
M3 × 0.5	G5	NRSF53.0GP10	4P	100	9	18	40	4	3.2	6	4	1	¥ 3,540
M3 × 0.5	G5	NRSF53.0GB10	2P	100	9	18	40	4	3.2	6	4	1	¥ 3,540
M3 × 0.5	G6	NRSF63.0GP10	4P	100	9	18	40	4	3.2	6	4	1	¥ 3,540
M3 × 0.5	G6	NRSF63.0GB10	2P	100	9	18	40	4	3.2	6	4	1	¥ 3,540
M4 × 0.7	G6	NRSF64.0IP10	4P	100	11	21	40	5	4	7	4	1	¥ 3,230
M4 × 0.7	G6	NRSF64.0IB10	2P	100	11	21	40	5	4	7	4	1	¥ 3,230
M4 × 0.7	G7	NRSF74.0IP10	4P	100	11	21	40	5	4	7	4	1	¥ 3,230
M4 × 0.7	G7	NRSF74.0IB10	2P	100	11	21	40	5	4	7	4	1	¥ 3,230
M5 × 0.8	G6	NRSF65.0KP10	4P	100	13	25	40	5.5	4.5	7	4	1	¥ 2,820*
M5 × 0.8	G6	NRSF65.0KB10	2P	100	13	25	40	5.5	4.5	7	4	1	¥ 2,820*
M5 × 0.8	G7	NRSF75.0KP10	4P	100	13	25	40	5.5	4.5	7	4	1	¥ 2,820*
M5 × 0.8	G7	NRSF75.0KB10	2P	100	13	25	40	5.5	4.5	7	4	1	¥ 2,820*
M6 × 1	G7	NRSF76.0MP10	4P	100	15	30	40	6	4.5	7	4	1	¥ 2,420
M6 × 1	G7	NRSF76.0MP15	4P	150	15	30	40	6	4.5	7	4	1	¥ 4,270
M6 × 1	G7	NRSF76.0MB10	2P	100	15	30	40	6	4.5	7	4	1	¥ 2,420
M6 × 1	G7	NRSF76.0MB15	2P	150	15	30	40	6	4.5	7	4	1	¥ 4,270
M6 × 1	G8	NRSF86.0MP10	4P	100	15	30	40	6	4.5	7	4	1	¥ 2,420*
M6 × 1	G8	NRSF86.0MP15	4P	150	15	30	40	6	4.5	7	4	1	¥ 4,270*
M6 × 1	G8	NRSF86.0MB10	2P	100	15	30	40	6	4.5	7	4	1	¥ 2,420*
M6 × 1	G8	NRSF86.0MB15	2P	150	15	30	40	6	4.5	7	4	1	¥ 4,270*
M8 × 1.25	G7	NRSM78.0NP10	4P	100	19	-	50	6.2	5	8	6	2	¥ 3,110*
M8 × 1.25	G7	NRSM78.0NP15	4P	150	19	-	50	6.2	5	8	6	2	¥ 5,320*
M8 × 1.25	G7	NRSM78.0NB10	2P	100	19	-	50	6.2	5	8	6	2	¥ 3,110*
M8 × 1.25	G7	NRSM78.0NB15	2P	150	19	-	50	6.2	5	8	6	2	¥ 5,320*

* = Specified Distribution Items. Made to order products.

6 Roll 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

LS-N-RS Long Shank Roll Taps for Non-Ferrous Materials

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE	MSRP
M10 × 1.5	G7	NRSM70100P10	4P	100	23	-	50	7	5.5	8	6	2	¥ 3,790 ^{**}
M10 × 1.5	G7	NRSM70100P15	4P	150	23	-	50	7	5.5	8	6	2	¥ 6,190 ^{**}
M10 × 1.5	G7	NRSM70100B10	2P	100	23	-	50	7	5.5	8	6	2	¥ 3,790 ^{**}
M10 × 1.5	G7	NRSM70100B15	2P	150	23	-	50	7	5.5	8	6	2	¥ 6,190 ^{**}
M10 × 1.25	G7	NRSM7010NB10	2P	100	23	-	50	7	5.5	8	6	2	¥ 3,790 ^{**}
M10 × 1.25	G7	NRSM7010NB15	2P	150	23	-	50	7	5.5	8	6	2	¥ 6,190 ^{**}

Number of oil grooves : 1

For M6 and smaller, external centers of 2P chamfer taps are removed.

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