

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	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

⑤-41



## MC-AD-CT

Carbide Taps with Oil Hole



### 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
30~60 (m/min)	30~60 (m/min)	30~60 (m/min)

### Product Features

- The MC-AD-CT is a carbide tap with an coolant through hole, suitable for screw thread tapping of aluminum alloy casting and aluminum die casting in blind holes.
- The flute shape develops less flute damage · The MC-AD-CT is a ultra fine grain cemented carbide tap with superior wear resistance · The superior carbide combined with an optimum coating produces a 5 times longer tool life than conventional aluminum taps.
- The center coolant through hole shape is designed for internal lubrication and mist applications. The lubrication or air lowers the temperature by cooling even in dry tapping. It is effective in removing chips from the pilot hole during tapping and prevents chip welding.

### Tapping Data

#### Tapping conditions [M6×1]

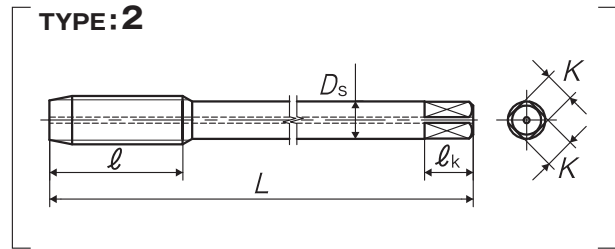
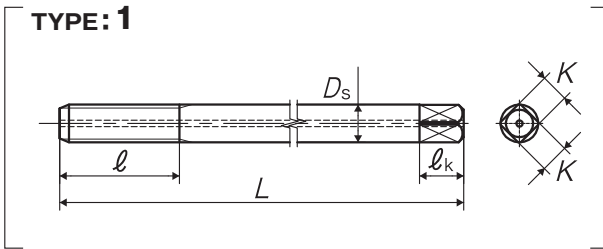
Workpiece Material	ADC12
Bored Hole Shape	Blind Hole
Bored Hole Depth	14mm
Tapping Length	12mm
Tapping Speed	57m/min
Feed	Fully synchronous feed
Machinery Type	Horizontal machining center
Tapping Fluid	Water soluble cutting fluid
Number of Holes Tapped	240,000 holes



Overall length	Thread length	Shank dia.	Size of square	Length of square
L	$\ell$	Ds	K	$\ell_k$

5

JIS



Segment : 1L

Size	Class	Code	Chamfer	L (mm)	$\ell$ (mm)	Ds (mm)	K (mm)	$\ell_k$ (mm)	No. of flutes	TYPE	MSRP
For Metric Threads											
M6 × 1	P3	MCADR6.0M1	1.5P	100	19	6	4.5	7	3	1	¥ 23,000 <sup>□▲</sup>
M8 × 1.25	P3	MCADR8.0N1	1.5P	100	22	6.2	5	8	3	2	¥ 25,400 <sup>□▲</sup>
M10 × 1.5	P4	MCADS010O1	1.5P	100	24	7	5.5	8	3	2	¥ 35,200 <sup>□▲</sup>
M10 × 1.25	P4	MCADS010N1	1.5P	100	22	7	5.5	8	3	2	¥ 35,200 <sup>□▲</sup>
M10 × 1	P4	MCADS010M1	1.5P	100	19	7	5.5	8	3	2	¥ 35,200 <sup>□▲</sup>
M12 × 1.75	P4	MCADS012P1	1.5P	100	30	8.5	6.5	9	3	2	¥ 44,600 <sup>□▲</sup>
M12 × 1.5	P4	MCADS012O1	1.5P	100	24	8.5	6.5	9	3	2	¥ 44,600 <sup>□▲</sup>
M12 × 1.25	P4	MCADS012N1	1.5P	100	22	8.5	6.5	9	3	2	¥ 44,600 <sup>□▲</sup>

Note: Products marked with an ▲ in the stock column are available while supplies last.

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Medical Surgical Instruments

⑫

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□=In stock at manufacturer.

Think threads with  
**YAMAWA**