

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

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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

⑥-7



MHRZ-J

Roll Taps for Medium Hardness Carbon Steels



Specification



Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Thermal refined steels 調質鋼
10~30 (m/min)	10~30 (m/min)	10~30 (m/min)	10~20 (m/min)
			25~35HRC

Product Features

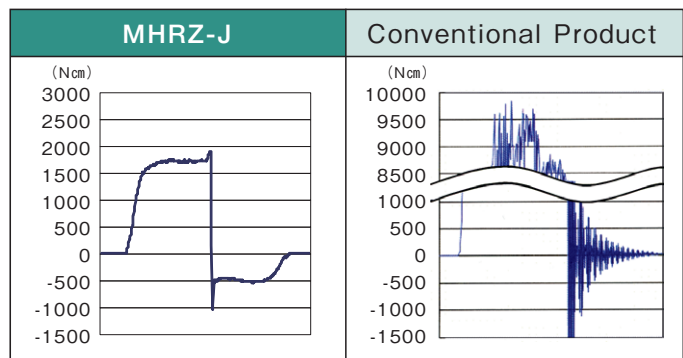
- Torque reduction is achieved from the new design and specifications.
- Tool life is dramatically improved with superb tool materials and coatings offering excellent wear resistance.
- Stable screw thread tapping in thermal refined material up to 35 HRC.
- The MHRZ-J roll taps can be used with water soluble cutting fluid.

Tapping Data

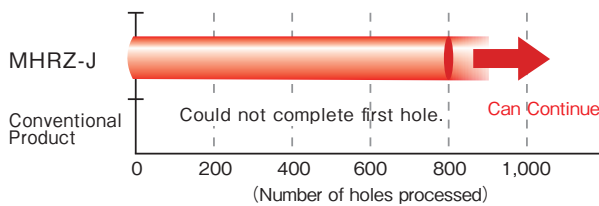
Tapping Conditions [M12×1.5]

Workpiece Material	SCM440/35HRC
Bored Hole Size	φ11.3
Tapping Length	18mm through hole
Tapping Speed	20m/min
Machinery Type	MC (perfect synchronous feed)
Tapping Fluid	Water soluble cutting fluid

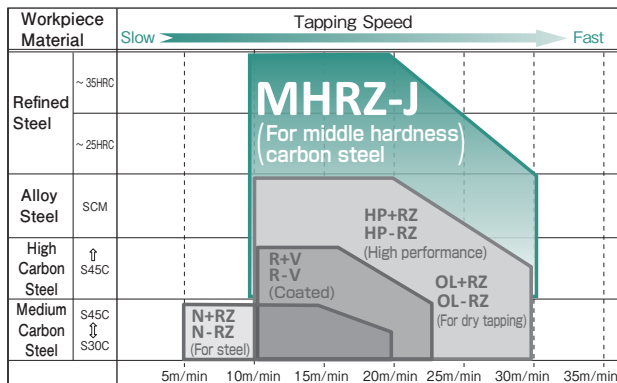
Comparison of tapping torque



Comparison chart for the number of holes processed



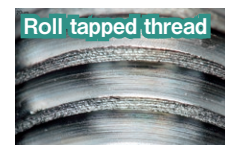
Recommended speed chart



Troubleshooting!



◆ Eliminate problem of tangled chip by using roll taps!



◆ Thread surface finish improvement!

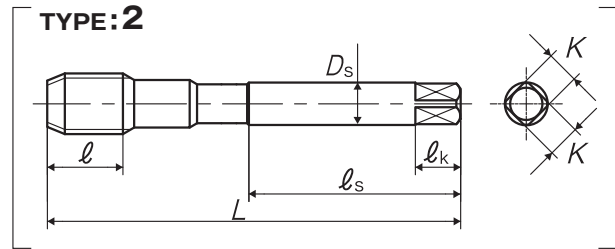
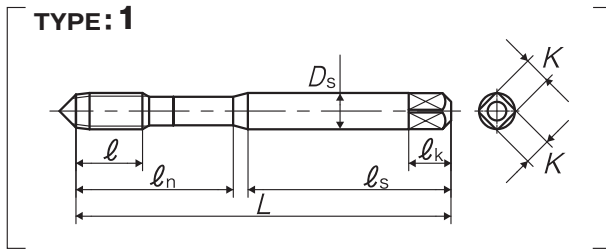
You can also see it from the video site on the right.



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L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

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Recommended class

Segment : 1J

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	Lobe	TYPE	MSRP
For Metric Threads													
M6 × 1	G8	RY6.0M8OCTP	4P	62	11	26	33	6	4.5	7	5	1	¥ 4,510
M6 × 1	G8	RY6.0M8OCTB	2P	62	11	26	33	6	4.5	7	5	1	¥ 4,510
M8 × 1.25	G8	RY8.0N8OCTP	4P	70	12	-	36	6.2	5	8	6	2	¥ 6,120
M8 × 1.25	G8	RY8.0N8OCTB	2P	70	12	-	36	6.2	5	8	6	2	¥ 6,120
M10 × 1.5	G8	RY010O8OCTP	4P	75	13	-	38	7	5.5	8	8	2	¥ 7,400
M10 × 1.5	G8	RY010O8OCTB	2P	75	13	-	38	7	5.5	8	8	2	¥ 7,400
M10 × 1.25	G8	RY010N8OCTP	4P	75	13	-	38	7	5.5	8	8	2	¥ 7,400
M10 × 1.25	G8	RY010N8OCTB	2P	75	13	-	38	7	5.5	8	8	2	¥ 7,400
M12 × 1.75	G8	RY012P8OCTP	4P	82	15	-	42	8.5	6.5	9	8	2	¥ 11,400
M12 × 1.75	G8	RY012P8OCTB	2P	82	15	-	42	8.5	6.5	9	8	2	¥ 11,400
M12 × 1.5	G8	RY012O8OCTP	4P	82	15	-	42	8.5	6.5	9	8	2	¥ 11,400
M12 × 1.5	G8	RY012O8OCTB	2P	82	15	-	42	8.5	6.5	9	8	2	¥ 11,400
M12 × 1.25	G8	RY012N8OCTP	4P	82	15	-	42	8.5	6.5	9	8	2	¥ 11,400
M12 × 1.25	G8	RY012N8OCTB	2P	82	15	-	42	8.5	6.5	9	8	2	¥ 11,400
M14 × 1.5	G9	RY014O9OCTP	4P	88	18	-	45	10.5	8	11	8	2	¥ 15,400
M14 × 1.5	G9	RY014O9OCTB	2P	88	18	-	45	10.5	8	11	8	2	¥ 15,400
M16 × 1.5	G9	RY016O9OCTP	4P	95	18	-	48	12.5	10	13	8	2	¥ 19,300
M16 × 1.5	G9	RY016O9OCTB	2P	95	18	-	48	12.5	10	13	8	2	¥ 19,300
M18 × 1.5	G10	RY018O0OCTP	4P	100	20	-	51	14	11	14	8	2	¥ 26,600
M18 × 1.5	G10	RY018O0OCTB	2P	100	20	-	51	14	11	14	8	2	¥ 26,600
M20 × 1.5	G10	RY020O0OCTP	4P	105	20	-	50	15	12	15	8	2	¥ 31,800
M20 × 1.5	G10	RY020O0OCTB	2P	105	20	-	50	15	12	15	8	2	¥ 31,800

Number of oil grooves: M6 = 5, M8 = 6, M10 and larger = 8

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

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