

6 Roll Tap Series

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

- ANSI
- 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

ANSI

Z-PRO MHRZ



Z-PRO Roll Taps for Medium Hardness Carbon Steels

Specification

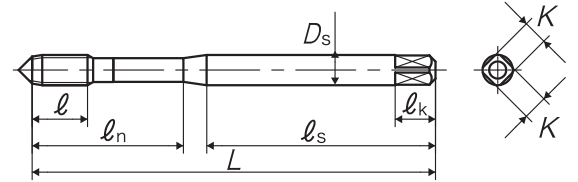


■ Suitable tapping in thermal refined steels (~35HRC).

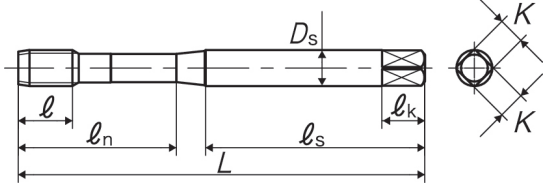
Tapping Speed depending on Materials

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			

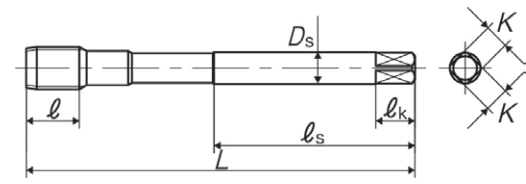
TYPE: 1



TYPE: 2



TYPE: 3



Segment: 1J

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ _n (inch)	ℓ _s (inch)	D _s (inch)	K (inch)	ℓ _k (inch)	Lobe	TYPE
For Unified Threads												
No.10-24UNC	H6	5110103039	4P	2.756	0.354	0.945	1.654	0.194	0.152	0.25	5	1
No.10-24UNC	H6	5111103039	2P	2.756	0.354	0.945	1.654	0.194	0.152	0.25	5	1
No.10-32UNF	H6	5110103041	4P	2.756	0.354	0.945	1.654	0.194	0.152	0.25	5	1
No.10-32UNF	H6	5111103041	2P	2.756	0.354	0.945	1.654	0.194	0.152	0.25	5	1
1/4-20UNC	H7	5110103058	4P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	5	1
1/4-20UNC	H7	5111103058	2P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	5	1
1/4-28UNF	H6	5110103062	4P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	5	1
1/4-28UNF	H6	5111103062	2P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	5	1
5/16-18UNC	H8	5110103071	4P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	6	2
5/16-18UNC	H8	5111103071	2P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	6	2
5/16-24UNF	H7	5110103074	4P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	6	2
5/16-24UNF	H7	5111103074	2P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	6	2
3/8-16UNC	H8	5110103082	4P	3.937	0.512	1.535	2.028	0.381	0.286	0.437	8	2
3/8-16UNC	H8	5111103082	2P	3.937	0.512	1.535	2.028	0.381	0.286	0.437	8	2
3/8-24UNF	H7	5110103085	4P	3.937	0.512	1.535	2.028	0.381	0.286	0.437	8	2
3/8-24UNF	H7	5111103085	2P	3.937	0.512	1.535	2.028	0.381	0.286	0.437	8	2
7/16-14UNC	H9	5110103098	4P	3.937	0.512	-	2.008	0.323	0.242	0.406	8	3

ANSI



This product is different from JIS products in shape and dimensions, please be careful when using.

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	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
7/16-14UNC	H9	5111103098	2P	3.937	0.512	-	2.008	0.323	0.242	0.406	8	3
7/16-20UNF	H8	5110103101	4P	3.937	0.512	-	2.008	0.323	0.242	0.406	8	3
7/16-20UNF	H8	5111103101	2P	3.937	0.512	-	2.008	0.323	0.242	0.406	8	3
1/2-13UNC	H9	5110103111	4P	4.331	0.591	-	2.205	0.367	0.275	0.437	8	3
1/2-13UNC	H9	5111103111	2P	4.331	0.591	-	2.205	0.367	0.275	0.437	8	3
1/2-20UNF	H8	5110103115	4P	4.331	0.591	-	2.205	0.367	0.275	0.437	8	3
1/2-20UNF	H8	5111103115	2P	4.331	0.591	-	2.205	0.367	0.275	0.437	8	3
9/16-12UNC	H10	5110103126	4P	4.331	0.709	-	2.205	0.429	0.322	0.5	8	3
9/16-12UNC	H10	5111103126	2P	4.331	0.709	-	2.205	0.429	0.322	0.5	8	3
9/16-18UNF	H9	5110103129	4P	4.331	0.709	-	2.205	0.429	0.322	0.5	8	3
9/16-18UNF	H9	5111103129	2P	4.331	0.709	-	2.205	0.429	0.322	0.5	8	3

Number of oil grooves : 1/4 and smaller = 5, 5/16 = 6, 3/8 and larger = 8
 For 1/4 and smaller, external centers of 2P chamfer taps are removed.

- 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
- Precision Machinery/
Medical Surgical Instruments ⑫