

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

DIN

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

DIN

⑥-11



Z-PRO MHRZ



Z-PRO Roll Taps for Medium Hardness Carbon Steels

Specification

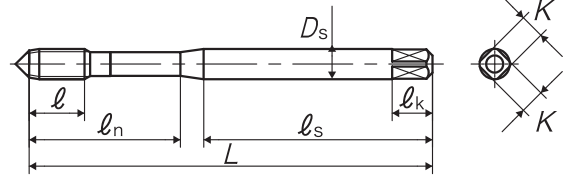


■ Suitable tapping in thermal refined steels (~35HRC).

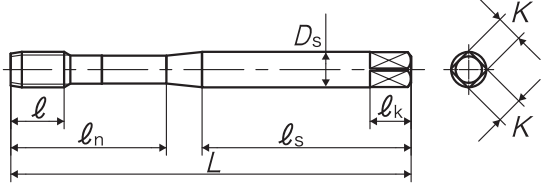
Recommended Tapping Speed depending on Materials

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

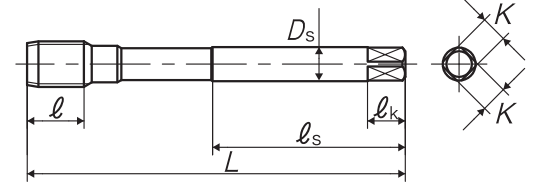
TYPE: 1



TYPE: 2



TYPE: 3



Segment: 1J

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	Lobe	TYPE
For Metric Threads												
M6 × 1	ISO2X	RD6.0MBOCTP	4P	80	11	30	45	6	4.9	8	5	1
M6 × 1	ISO2X	RD6.0MBOCTB	2P	80	11	30	45	6	4.9	8	5	1
M8 × 1.25	ISO2X	RD8.0NBOCTP	4P	90	12	35	47	8	6.2	9	6	2
M8 × 1.25	ISO2X	RD8.0NBOCTB	2P	90	12	35	47	8	6.2	9	6	2
M10 × 1.5	ISO2X	RD0100BOCTP	4P	100	13	39	52.5	10	8	11	8	2
M10 × 1.5	ISO2X	RD0100BOCTB	2P	100	13	39	52.5	10	8	11	8	2
M10 × 1.25	ISO2X	RM010NBOCTP	4P	100	13	-	51	7	5.5	8	8	3
M10 × 1.25	ISO2X	RM010NBOCTB	2P	100	13	-	51	7	5.5	8	8	3
M12 × 1.75	ISO2X	RG012PBOCTP	4P	110	15	-	56	9	7	10	8	3
M12 × 1.75	ISO2X	RG012PBOCTB	2P	110	15	-	56	9	7	10	8	3
M12 × 1.5	ISO2X	RM0120BOCTP	4P	100	15	-	51	9	7	10	8	3
M12 × 1.5	ISO2X	RM0120BOCTB	2P	100	15	-	51	9	7	10	8	3
M12 × 1.25	ISO2X	RM012NBOCTP	4P	100	15	-	51	9	7	10	8	3
M12 × 1.25	ISO2X	RM012NBOCTB	2P	100	15	-	51	9	7	10	8	3
M14 × 1.5	ISO2X	RM0140BOCTP	4P	100	14	-	51	11	9	12	8	3
M14 × 1.5	ISO2X	RM0140BOCTB	2P	100	14	-	51	11	9	12	8	3
M16 × 1.5	ISO2X	RM0160BOCTP	4P	100	18	-	51	12	9	12	8	3



※ 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 (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE
M16 × 1.5	IS02X	RM0160B0CTB	2P	100	18	-	51	12	9	12	8	3
M18 × 1.5	IS02X	RM0180B0CTP	4P	110	20	-	56	14	11	14	8	3
M18 × 1.5	IS02X	RM0180B0CTB	2P	110	20	-	56	14	11	14	8	3
M20 × 1.5	IS02X	RM0200B0CTP	4P	125	20	-	64	16	12	15	8	3
M20 × 1.5	IS02X	RM0200B0CTB	2P	125	20	-	64	16	12	15	8	3

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.

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

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