

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

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

⑥-3

JIS

Z-PRO MHRZ



Z-PRO
Roll Taps for Medium Hardness Carbon Steels

Specification



Tapping Speeds depending on Materials

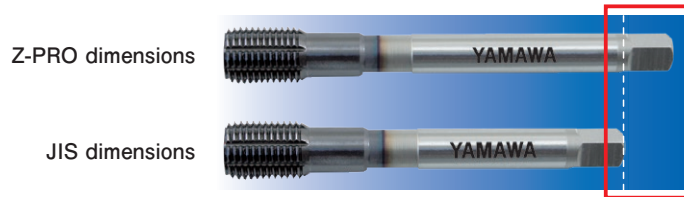
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Thermal refined steels 調質鋼
10~30 (m/min)	10~30 (m/min)	10~30 (m/min)	10~20 (m/min)
25~35HRC			

Product Features

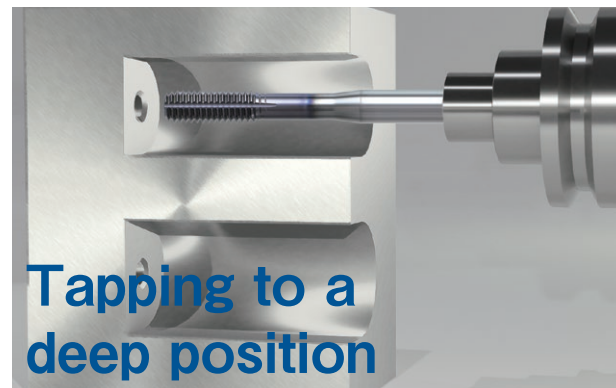
- Torque reduction is achieved from the new design and specifications.
- Tool life is dramatically improved with superb tool materials and coatings offering excellent wear resistance.
- Stable screw thread tapping in thermal refined material up to 35 HRC.
- The MHRZ roll taps can be used with water soluble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

Benefits of Z-PRO dimensions

- A longer overall length enables a better supply of cutting fluid, resulting in excellent finish of internal threads.



- Secures appropriate tool projection length to prevent interference with workpieces



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

- 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 Mills
Simple Inspection Tools

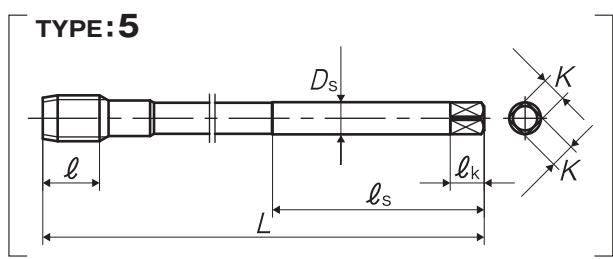
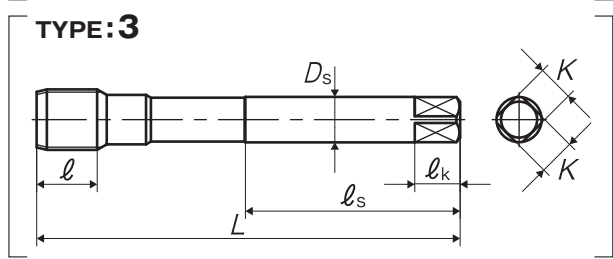
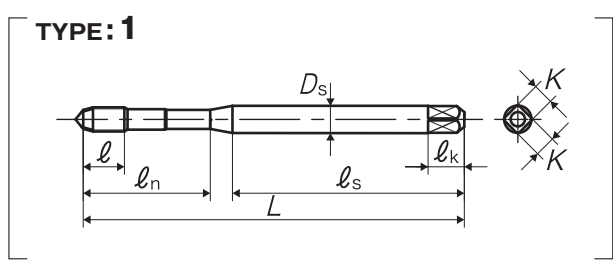
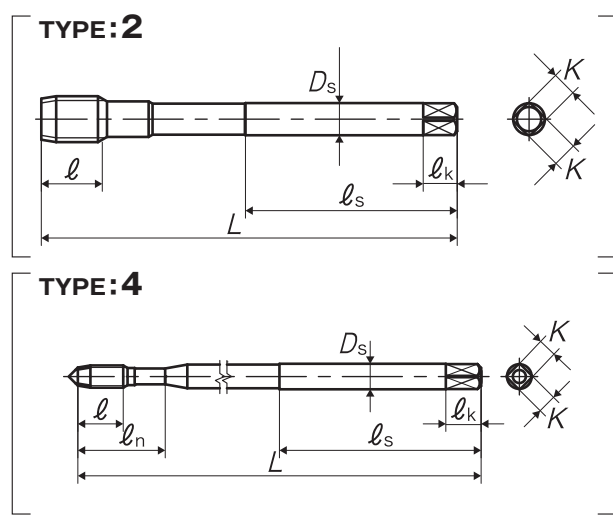
- ⑧ Pipe Taps

- ⑨ Thread Mills
Premium Thread Mills

- ⑩ Dies

- ⑪ Center Drills
Centering Tools

- ⑫ Precision Machinery/
Metal Surgical Instruments



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	1110101055	4P	80	11	30	45	6	4.5	7	5	1	¥ 4,950
M6 × 1	G8	1111101055	2P	80	11	30	45	6	4.5	7	5	1	¥ 4,950
M8 × 1.25	G8	1110101064	4P	90	12	-	46	6.2	5	8	6	2	¥ 6,690
M8 × 1.25	G8	1111101064	2P	90	12	-	46	6.2	5	8	6	2	¥ 6,690
M10 × 1.5	G8	1110101078	4P	100	13	-	51	7	5.5	8	8	2	¥ 8,300
M10 × 1.5	G8	1111101078	2P	100	13	-	51	7	5.5	8	8	2	¥ 8,300
M10 × 1.25	G8	1110101079	4P	100	13	-	51	7	5.5	8	8	2	¥ 8,300
M10 × 1.25	G8	1111101079	2P	100	13	-	51	7	5.5	8	8	2	¥ 8,300
M12 × 1.75	G8	1110101088	4P	110	15	-	56	8.5	6.5	9	8	2	¥ 11,700
M12 × 1.75	G8	1111101088	2P	110	15	-	56	8.5	6.5	9	8	2	¥ 11,700
M12 × 1.5	G8	1110101089	4P	110	15	-	56	8.5	6.5	9	8	2	¥ 11,700
M12 × 1.5	G8	1111101089	2P	110	15	-	56	8.5	6.5	9	8	2	¥ 11,700
M12 × 1.25	G8	1110101090	4P	110	15	-	56	8.5	6.5	9	8	2	¥ 11,700
M12 × 1.25	G8	1111101090	2P	110	15	-	56	8.5	6.5	9	8	2	¥ 11,700
M14 × 1.5	G9	1110101102	4P	110	18	-	56	10.5	8	11	8	2	¥ 15,900
M14 × 1.5	G9	1111101102	2P	110	18	-	56	10.5	8	11	8	2	¥ 15,900
M16 × 1.5	G9	1110101116	4P	110	18	-	56	12.5	10	13	8	2	¥ 19,700
M16 × 1.5	G9	1111101116	2P	110	18	-	56	12.5	10	13	8	2	¥ 19,700
M18 × 1.5	G10	1110101130	4P	125	20	-	64	14	11	14	8	2	¥ 27,000
M18 × 1.5	G10	1111101130	2P	125	20	-	64	14	11	14	8	2	¥ 27,000
M20 × 1.5	G10	1110101144	4P	140	20	-	71	15	12	15	8	3	¥ 35,800
M20 × 1.5	G10	1111101144	2P	140	20	-	71	15	12	15	8	3	¥ 35,800
For Long Metric Threads													
M6 × 1	G8	2110101055	4P	100	11	30	45	6	4.5	7	5	4	¥ 6,560
M6 × 1	G8	2310101055	4P	150	11	30	45	6	4.5	7	5	4	¥ 9,210
M6 × 1	G8	2111101055	2P	100	11	30	45	6	4.5	7	5	4	¥ 6,560
M6 × 1	G8	2311101055	2P	150	11	30	45	6	4.5	7	5	4	¥ 9,210

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

MHRZ Z-PRO Roll Taps for Medium Hardness Carbon Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE	MSRP
M8 × 1.25	G8	2110101064	4P	150	12	-	46	6.2	5	8	6	5	¥ 11,400
M8 × 1.25	G8	2111101064	2P	150	12	-	46	6.2	5	8	6	5	¥ 11,400
M10 × 1.5	G8	2110101078	4P	150	13	-	51	7	5.5	8	8	5	¥ 13,400
M10 × 1.5	G8	2111101078	2P	150	13	-	51	7	5.5	8	8	5	¥ 13,400
M10 × 1.25	G8	2110101079	4P	150	13	-	51	7	5.5	8	8	5	¥ 13,400
M10 × 1.25	G8	2111101079	2P	150	13	-	51	7	5.5	8	8	5	¥ 13,400
M12 × 1.75	G8	2110101088	4P	150	15	-	56	8.5	6.5	9	8	5	¥ 15,900
M12 × 1.75	G8	2111101088	2P	150	15	-	56	8.5	6.5	9	8	5	¥ 15,900
M12 × 1.5	G8	2110101089	4P	150	15	-	56	8.5	6.5	9	8	5	¥ 15,900
M12 × 1.5	G8	2111101089	2P	150	15	-	56	8.5	6.5	9	8	5	¥ 15,900
M12 × 1.25	G8	2110101090	4P	150	15	-	56	8.5	6.5	9	8	5	¥ 15,900
M12 × 1.25	G8	2111101090	2P	150	15	-	56	8.5	6.5	9	8	5	¥ 15,900
M14 × 1.5	G9	2110101102	4P	150	18	-	56	10.5	8	11	8	5	¥ 21,200
M14 × 1.5	G9	2111101102	2P	150	18	-	56	10.5	8	11	8	5	¥ 21,200
M16 × 1.5	G9	2110101116	4P	150	18	-	56	12.5	10	13	8	5	¥ 23,300
M16 × 1.5	G9	2111101116	2P	150	18	-	56	12.5	10	13	8	5	¥ 23,300

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.

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