

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 Tools
- 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



N-RS

Roll Taps for Non-Ferrous Materials



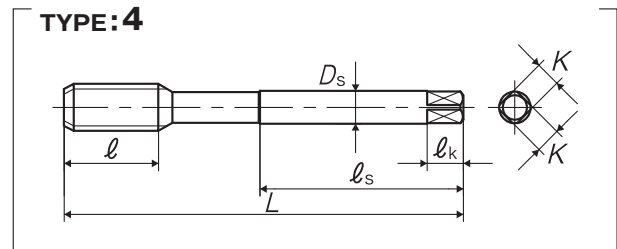
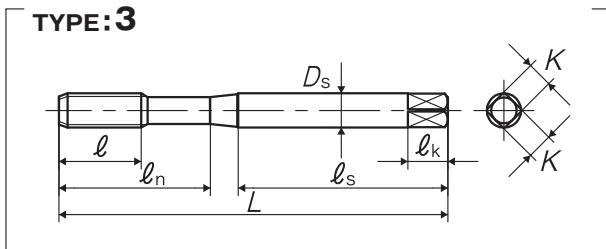
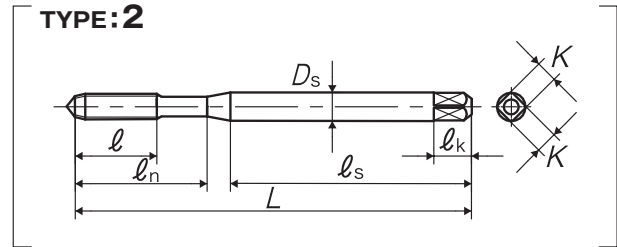
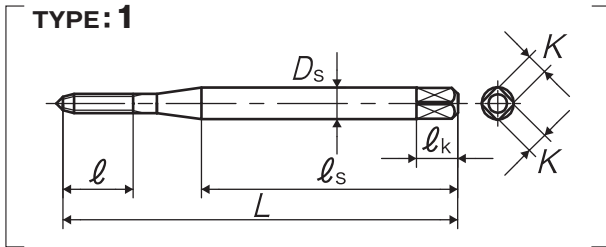
Specification



■ N-RS is the forming tap suitable for non-ferrous materials such as aluminum castings, aluminum die castings and brass.

Tapping Speed 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
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)



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 Metric Threads												
M3 × 0.5	D5	388513M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3 × 0.5	D5	388512M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	388515M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	388514M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M4 × 0.7	D6	388517M	4P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M4 × 0.7	D6	388516M	2P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M5 × 0.8	D7	388519M	4P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M5 × 0.8	D7	388518M	2P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M6 × 1	D8	388521M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M6 × 1	D8	388520M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M7 × 1	D9	388523M	4P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M7 × 1	D9	388522M	2P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M8 × 1.25	D9	388527M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1.25	D9	388526M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	388525M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	388524M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M10 × 1.5	D10	388531M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3

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

- 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/Metal Surgical Instruments

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
M10 × 1.5	D10	388530M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3
M10 × 1.25	D9	388529M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3
M10 × 1.25	D9	388528M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3
M12 × 1.75	D11	388535M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
M12 × 1.75	D11	388534M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
M12 × 1.25	D9	388533M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
M12 × 1.25	D9	388532M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
For Unified Threads												
No.0-80UNF	H2	388410M	2P	1.772	0.236	-	1.161	0.141	0.11	0.187	3	1
No.1-64UNC	H2	388411M	2P	1.772	0.276	-	1.161	0.141	0.11	0.187	3	1
No.1-72UNF	H2	388412M	2P	1.772	0.276	-	1.161	0.141	0.11	0.187	3	1
No.2-56UNC	H2	388413M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-56UNC	H3	388414M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-64UNF	H2	388415M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-64UNF	H3	388416M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.3-48UNC	H2	388417M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-48UNC	H3	388418M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-56UNF	H2	388419M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-56UNF	H3	388420M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H3	388423M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H3	388421M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H5	388424M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H5	388422M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H3	388427M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H3	388425M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	388428M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	388426M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.5-40UNC	H3	388431M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H3	388429M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H5	388432M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H5	388430M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H3	388435M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H3	388433M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H5	388436M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H5	388434M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	388440M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	388437M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	388441M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	388438M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H3	388444M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H3	388442M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H5	388445M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H5	388443M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.8-32UNC	H3	388448M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H3	388446M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	388449M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	388447M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H3	388452M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H3	388450M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H5	388453M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2

· 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

- 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

N-RS Roll Taps for Non-Ferrous Materials

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
No.8-36UNF	H5	388451M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.10-24UNC	H4	388456M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H4	388454M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	388457M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	388455M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	388460M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	388458M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	388461M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	388459M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.12-24UNC	H4	388464M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H4	388462M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H6	388465M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H6	388463M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H4	388468M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H4	388466M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H6	388469M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H6	388467M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
1/4-20UNC	H4	388472M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H4	388470M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	388473M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	388471M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	388476M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	388474M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	388477M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	388475M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
5/16-18UNC	H5	388480M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H5	388478M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	388481M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	388479M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	388484M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	388482M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H7	388485M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H7	388483M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
3/8-16UNC	H5	388488M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H5	388486M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	388489M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	388487M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	388492M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	388490M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	388493M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	388491M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
7/16-14UNC	H5	388496M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-14UNC	H5	388494M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-14UNC	H7	388497M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-14UNC	H7	388495M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H5	388502M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H5	388498M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H7	388503M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H7	388499M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
1/2-13UNC	H5	388506M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4

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

N-RS Roll Taps for Non-Ferrous Materials

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
1/2-13UNC	H5	388504M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-13UNC	H7	388507M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-13UNC	H7	388505M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H5	388510M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H5	388508M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H7	388511M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H7	388509M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4

Number of oil grooves : Metric thread : =1
 Unified thread : No.4 and smaller=non, No.5 and larger=1
 For M6, 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/
Metal Surgical Instruments ⑫