

⑥ Roll Tap Series

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

⑥-37

N

D

N+RS N-RS

Roll Taps for Non-Ferrous Materials

Specification



Tapping Speeds 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)

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

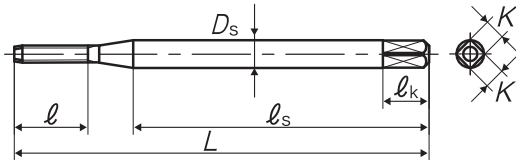


■ N+RS/N-RS is the forming tap suitable for non-ferrous materials such as aluminum castings, aluminum die castings and brass.

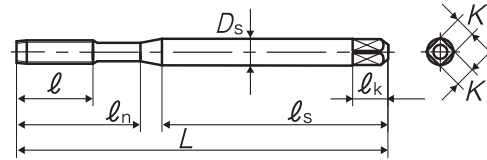
• Product symbol is distinguished depend on the size.

N+RS	~ M6
N-RS	M8 ~

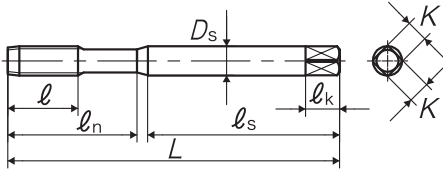
TYPE: 1



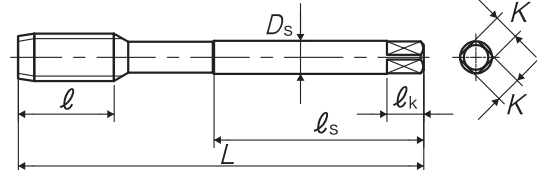
TYPE: 2



TYPE: 3



TYPE: 4



N+RS Roll Taps for Non-Ferrous Materials

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												
M2 × 0.4	ISO2X	RE2.0EBKENB	2P	45	8	-	32	2.8	2.1	5	4	1
M2.3 × 0.4	ISO2X	RE2.3EBKENB	2P	45	9	-	32	2.8	2.1	5	4	1
M2.5 × 0.45	ISO2X	RE2.5FBKENB	2P	50	8	15	33	2.8	2.1	5	4	2
M3 × 0.5	ISO2X	RE3.0GBKENB	2P	56	9	18	34	3.5	2.7	6	4	2
M4 × 0.7	ISO2X	RE4.0IBKENB	2P	63	13	21	38	4.5	3.4	6	4	2
M5 × 0.8	ISO2X	RE5.0KBKENB	2P	70	14	25	39	6	4.9	8	4	2
M6 × 1	ISO2X	RE6.0MBKENB	2P	80	15	30	45	6	4.9	8	4	2

N-RS Roll Taps for Non-Ferrous Materials

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												
M8 × 1.25	ISO2X	RD8.0NBKENB	2P	90	19	35	47	8	6.2	9	6	3
M10 × 1.5	ISO2X	RD10.0OBKENB	2P	100	23	39	52.5	10	8	11	6	3
M12 × 1.75	ISO2X	RG12.0PBKENB	2P	110	26	-	56	9	7	10	6	4

Number of oil grooves: M2.5 and smaller = non, M3 and larger = 1

Think threads with
YAMAWA

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