

N-RZ

Roll Taps for Steels

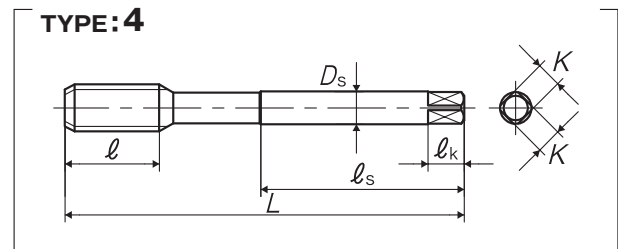
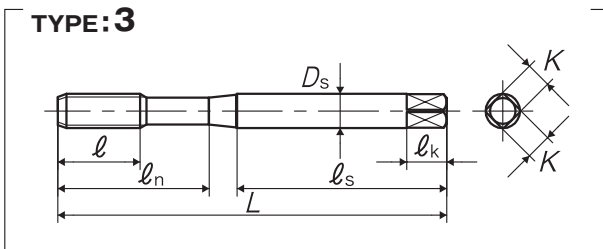
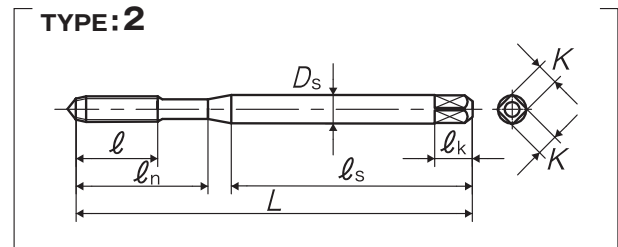
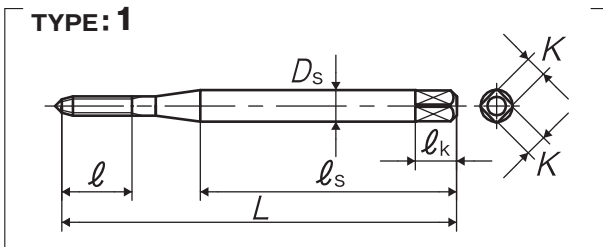
Specification



Tapping Speed depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼
5~15 (m/min)	5~15 (m/min)

■ N-RZ is the forming tap suitable for ferrous materials such as carbon steels, alloy steels, and normal steels.



Segment : 1J

Size	Class	Code	Chamfer	L (inch)	l (inch)	ln (inch)	ls (inch)	Ds (inch)	K (inch)	lk (inch)	Lobe	TYPE
For Metric Threads												
M3 × 0.5	D5	389513M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3 × 0.5	D5	389512M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	389515M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	389514M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M4 × 0.7	D6	389517M	4P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M4 × 0.7	D6	389516M	2P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M5 × 0.8	D7	389519M	4P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M5 × 0.8	D7	389518M	2P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M6 × 1	D8	389521M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M6 × 1	D8	389520M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M7 × 1	D9	389523M	4P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M7 × 1	D9	389522M	2P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M8 × 1.25	D9	389527M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1.25	D9	389526M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	389525M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	389524M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3

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

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N-RZ Roll Taps for Steels

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
M10 × 1.5	D10	389531M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3
M10 × 1.5	D10	389530M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3
M10 × 1.25	D9	389529M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3
M10 × 1.25	D9	389528M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3
M12 × 1.75	D11	389535M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.75	D11	389534M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.25	D9	389533M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.25	D9	389532M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
For Unified Threads												
No.0-80UNF	H2	389410M	2P	1.772	0.236	-	1.161	0.141	0.11	0.187	3	1
No.1-64UNC	H2	389411M	2P	1.772	0.276	-	1.161	0.141	0.11	0.187	3	1
No.1-72UNF	H2	389412M	2P	1.772	0.276	-	1.161	0.141	0.11	0.187	3	1
No.2-56UNC	H2	389413M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-56UNC	H3	389414M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-64UNF	H2	389415M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-64UNF	H3	389416M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.3-48UNC	H2	389417M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-48UNC	H3	389418M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-56UNF	H2	389419M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-56UNF	H3	389420M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H3	389423M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H3	389421M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H5	389424M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H5	389422M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H3	389427M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H3	389425M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	389428M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	389426M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.5-40UNC	H3	389431M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H3	389429M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H5	389432M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H5	389430M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H3	389435M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H3	389433M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H5	389436M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H5	389434M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	389440M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	389437M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	389441M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	389438M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H3	389444M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H3	389442M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H5	389445M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H5	389443M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.8-32UNC	H3	389448M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H3	389446M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	389449M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	389447M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H3	389452M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H3	389450M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2

ANSI

Think threads with
YAMAWA

* 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

6

ANSI

N-RZ Roll Taps for Steels

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
No.8-36UNF	H5	389453M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H5	389451M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.10-24UNC	H4	389456M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H4	389454M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	389457M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	389455M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	389460M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	389458M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	389461M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	389459M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.12-24UNC	H4	389464M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H4	389462M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H6	389465M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H6	389463M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H4	389468M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H4	389466M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H6	389469M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H6	389467M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
1/4-20UNC	H4	389472M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H4	389470M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	389473M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	389471M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	389476M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	389474M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	389477M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	389475M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
5/16-18UNC	H5	389480M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H5	389478M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	389481M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	389479M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	389484M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	389482M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H7	389485M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H7	389483M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
3/8-16UNC	H5	389488M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H5	389486M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	389489M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	389487M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	389492M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	389490M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	389493M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	389491M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
7/16-14UNC	H5	389496M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-14UNC	H5	389494M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-14UNC	H7	389497M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-14UNC	H7	389495M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H5	389502M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H5	389498M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H7	389503M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H7	389499M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4

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

ANSI

⑥-20

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

ANSI

N-RZ Roll Taps for Steels

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
1/2-13UNC	H5	389506M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-13UNC	H5	389504M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-13UNC	H7	389507M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-13UNC	H7	389505M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H5	389510M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H5	389508M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H7	389511M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H7	389509M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4

Number of oil grooves : Metric thread : M3 ~ M7 = 4, M8 = 3, M10 and larger = 4
 Unified thread : No.4 and smaller = non, No.5 ~ 1/4 = 4, 5/16 ~ 3/8 = 3, 7/16 and larger = 4
 For M6, 1/4 and smaller with 2P chamfer, the external center is cut off.

- 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
⑥-21



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