

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_n	ℓ_s	Ds	K	ℓ_k

ANSI

OL-RZ



Roll Taps for Dry Tapping, Coated

Specification

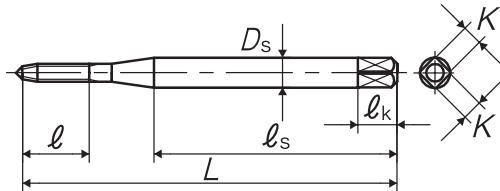


■ OL-RZ is the forming tap enabling dry tapping under following condition : tapping sizes of smaller than M6, thin steel sheets having burring operation, and steel parts with rather short length. Optimum coating suitable to the tapping condition.

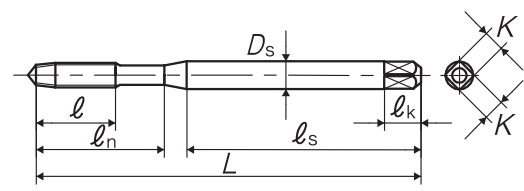
Tapping Speed depending on Materials

Low carbon steels 低碳素鋼	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	Stainless steels ステンレス鋼	Aluminum alloy castings アルミ合金鑄物
15~30 (m/min)	15~30 (m/min)	15~25 (m/min)	15~25 (m/min)	15~25 (m/min)	10~25 (m/min)	15~30 (m/min)
25~35HRC						

TYPE: 1



TYPE: 2



Segment : 1J

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	ℓ_s (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	Lobe	TYPE
For Metric Threads												
M3 × 0.5	D5	386610M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	386611M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M4 × 0.7	D6	386612M	4P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M5 × 0.8	D7	386614M	4P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M6 × 1	D8	386615M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
For Unified Threads												
No.2-56UNC	H3	386600M	4P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.4-40UNC	H5	386601M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	386602M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.5-40UNC	H5	386603M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	386604M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.8-32UNC	H5	386605M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.10-24UNC	H6	386606M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	386607M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
1/4-20UNC	H6	386608M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	386609M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2

Number of oil grooves : non

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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