

6 Roll Tap Series

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

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

⑥-47

DIN

OL+RZ

Roll Taps for Dry Tapping, Coated



Specification



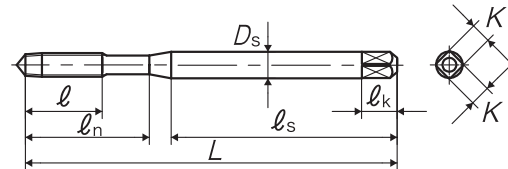
■OL+RZ is the forming taps enabling dry tapping under following condition : tapping sizes of smaller than M6, thin steel sheets having burring operation, and steel parts with rather short length. Optimum coating suitable to the tapping condition.

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	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 アルミ合金鋳物
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



Segment : 1J

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	Lobe	TYPE
For Metric Threads												
M3 × 0.5	ISO2X	RE3.0GBHPTP	4P	56	9	18	34	3.5	2.7	6	4	1
M4 × 0.7	ISO2X	RE4.0IBHPTP	4P	63	13	21	38	4.5	3.4	6	4	1
M5 × 0.8	ISO2X	RE5.0KBHPTP	4P	70	14	25	39	6	4.9	8	4	1
M6 × 1	ISO2X	RE6.0MBHPTP	4P	80	15	30	45	6	4.9	8	4	1

Number of oil grooves : non

Think threads with
YAMAWA

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