

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

JIS

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

JIS



OL+RZ OL-RZ

Roll Taps for Dry Tapping, Coated

Specification



• The product symbol is divided by nominal sizes.

OL+RZ	all M
OL-RZ	all U

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

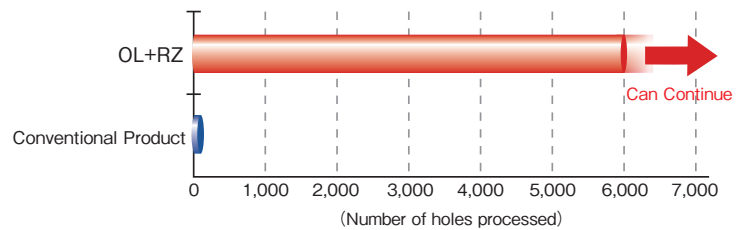
Product Features

- The OL+RZ/OL-RZ roll taps have made it possible tapping without lubrication in the sizes M6 and smaller. These taps are designed for thin steel sheet screw threads or steel with a relatively short screw thread length.
- Increased shank accuracy and an optimum lobe portion design produces a smooth thread forming action and the internal thread accuracy is stabilized even under severe conditions.
- For blind hole tapping, please select the HP+RZ/HP-RZ tap series as an alternative item.

Tapping Data

Processing conditions [M6 × 1 G7P]

Tap Type	OL+RZ, conventional product
Workpiece Material	Rolled steel plate (SPCC)
Bored Hole Size	φ5.55
Tapping Length	4mm through hole
Tapping Speed	15m/min
Machinery Type	Tapping machine
Tapping Fluid	Completely dry



Market Data

Case No.	Size	Class	Processed Workpiece Material	Bored Hole Diameter (mm)	Tapping Depth (mm)	Tapping Speed (m/min)	Machine Type	Tapping Fluid	Market Evaluation
1	M3×0.5	G5	SPCC	φ2.75	6	12	CNC machine	Mist	9,000 holes processed. Good surface finish
2	M6×1	G7	SPCC	φ5.55	4	15	Tapping machine	Mist	15,000 holes processed. Good workability.
3	M1.7×0.35	G5	SS400	φ1.53	1.3	15	Tapping machine	Water soluble	200,000 holes processed. Competitor 100,000 holes.
4	M3×0.5	G5	SUS304	φ2.79	5	15	Special machine	Water soluble	7,000 holes processed. Good workability.
5	M6×1	G7	SS400	φ5.53	12	50	Vertical machining center	Water soluble	5,000 holes processed. Competitors 1,000 holes.

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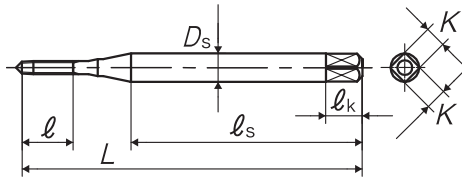
Precision Machinery/
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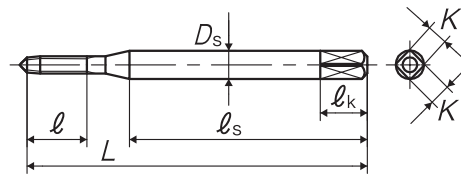
JIS

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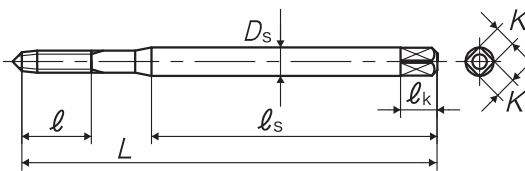
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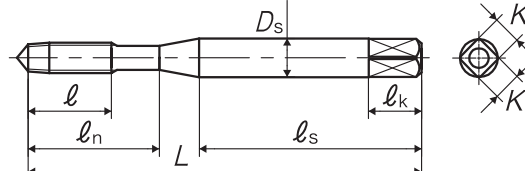
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TYPE:3



TYPE:4



OL+RZ Roll Taps for Dry Tapping, Coated

Recommended class

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	MSRP
For Metric Threads													
M1 × 0.25	G4	OLRZP41.0BP	4P	36	4.5	-	24	3	2.5	5	4	1	¥ 5,480 *
M1.2 × 0.25	G4	OLRZP41.2BP	4P	36	4.5	-	24	3	2.5	5	4	1	¥ 5,480
M1.4 × 0.3	G4	OLRZP41.4CP	4P	36	5.4	-	24	3	2.5	5	4	1	¥ 4,890
M1.6 × 0.35	G4	OLRZP41.6DP	4P	36	6.3	-	24	3	2.5	5	4	2	¥ 4,720
M1.6 × 0.35	G6	OLRZP61.6DP	4P	36	6.3	-	24	3	2.5	5	4	2	¥ 4,720
M1.7 × 0.35	G4	OLRZP41.7DP	4P	36	6.3	-	24	3	2.5	5	4	2	¥ 4,720
M2 × 0.4	G4	OLRZP42.0EP	4P	42	7.2	-	27	3	2.5	5	4	3	¥ 4,480
M2 × 0.4	G5	OLRZP52.0EP	4P	42	7.2	-	27	3	2.5	5	4	3	¥ 4,480
M2 × 0.4	G6	OLRZP62.0EP	4P	42	7.2	-	27	3	2.5	5	4	3	¥ 4,480 *
M2.3 × 0.4	G4	OLRZP42.3EP	4P	42	7.2	-	27	3	2.5	5	4	3	¥ 4,230
M2.3 × 0.4	G5	OLRZP52.3EP	4P	42	7.2	-	27	3	2.5	5	4	3	¥ 4,230
M2.5 × 0.45	G5	OLRZP52.5FP	4P	46	8.1	14	29	3	2.5	5	4	4	¥ 4,080
M2.5 × 0.45	G6	OLRZP62.5FP	4P	46	8.1	14	29	3	2.5	5	4	4	¥ 4,080
M2.6 × 0.45	G5	OLRZP52.6FP	4P	46	8.1	14	29	3	2.5	5	4	4	¥ 4,080
M2.6 × 0.45	G6	OLRZP62.6FP	4P	46	8.1	14	29	3	2.5	5	4	4	¥ 4,080
M3 × 0.5	G5	OLRZP53.0GP	4P	46	9	14	26	4	3.2	6	4	4	¥ 3,710
M3 × 0.5	G6	OLRZP63.0GP	4P	46	9	14	26	4	3.2	6	4	4	¥ 3,710
M3.5 × 0.6	G5	OLRZP53.5HP	4P	52	11	16	29	5	4	7	4	4	¥ 3,810 *
M3.5 × 0.6	G6	OLRZP63.5HP	4P	52	11	16	29	5	4	7	4	4	¥ 3,810
M4 × 0.7	G6	OLRZP64.0IP	4P	52	11	17	29	5	4	7	4	4	¥ 3,810
M4 × 0.7	G7	OLRZP74.0IP	4P	52	11	17	29	5	4	7	4	4	¥ 3,810
M5 × 0.8	G6	OLRZP65.0KP	4P	60	13	22	33	5.5	4.5	7	4	4	¥ 4,050
M5 × 0.8	G7	OLRZP75.0KP	4P	60	13	22	33	5.5	4.5	7	4	4	¥ 4,050
M6 × 1	G6	OLRZP66.0MP	4P	62	15	26	33	6	4.5	7	4	4	¥ 4,080
M6 × 1	G7	OLRZP76.0MP	4P	62	15	26	33	6	4.5	7	4	4	¥ 4,080

* = Specified Distribution Items. Made to order products.

Think threads with YAMAWA

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L	ℓ	ℓn	ℓs	Ds	K	ℓk

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Segment : 1J

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	Lobe	TYPE	MSRP
For Unified Threads													
No.2-56UNC	G4	OLRZM4UN2EP	4P	42	8.1	-	27	3	2.5	5	4	3	¥ 4,820 ※
No.2-56UNC	G5	OLRZM5UN2EP	4P	42	8.1	-	27	3	2.5	5	4	3	¥ 4,820 ※
No.2-64UNF	G4	OLRZM4UN2DP	4P	42	8.1	-	27	3	2.5	5	4	3	¥ 4,820 ※
No.3-48UNC	G4	OLRZM4UN3FP	4P	46	8.1	14	29	3	2.5	5	4	4	¥ 4,530 ※
No.3-56UNF	G4	OLRZM4UN3EP	4P	46	8.1	14	29	3	2.5	5	4	4	¥ 4,530 ※
No.4-40UNC	G5	OLRZM5UN4HP	4P	46	9	14	25	4	3.2	6	4	4	¥ 4,420
No.4-40UNC	G6	OLRZM6UN4HP	4P	46	9	14	25	4	3.2	6	4	4	¥ 4,420
No.4-48UNF	G5	OLRZM5UN4FP	4P	46	9	14	25	4	3.2	6	4	4	¥ 4,420 ※
No.5-40UNC	G5	OLRZM5UN5HP	4P	52	11	16	28	5	4	7	4	4	¥ 4,040 ※
No.5-44UNF	G5	OLRZM5UN5GP	4P	52	11	16	28	5	4	7	4	4	¥ 4,040 ※
No.6-32UNC	G5	OLRZM5UN6JP	4P	52	11	17	27	5	4	7	4	4	¥ 4,040 ※
No.6-32UNC	G6	OLRZM6UN6JP	4P	52	11	17	27	5	4	7	4	4	¥ 4,040
No.6-40UNF	G5	OLRZM5UN6HP	4P	52	11	17	27	5	4	7	4	4	¥ 4,040 ※
No.8-32UNC	G6	OLRZM6UN8JP	4P	60	13	22	31	5.5	4.5	7	4	4	¥ 4,280 ※
No.8-32UNC	G7	OLRZM7UN8JP	4P	60	13	22	31	5.5	4.5	7	4	4	¥ 4,280 ※
No.8-36UNF	G6	OLRZM6UN8IP	4P	60	13	22	31	5.5	4.5	7	4	4	¥ 4,280 ※
No.10-24UNC	G6	OLRZM6UNAMP	4P	60	13	22	32	5.5	4.5	7	4	4	¥ 4,280 ※
No.10-24UNC	G7	OLRZM7UNAMP	4P	60	13	22	32	5.5	4.5	7	4	4	¥ 4,280 ※
No.10-32UNF	G6	OLRZM6UNAJP	4P	60	13	22	32	5.5	4.5	7	4	4	¥ 4,280 ※
No.10-32UNF	G7	OLRZM7UNAJP	4P	60	13	22	32	5.5	4.5	7	4	4	¥ 4,280 ※
No.12-24UNC	G6	OLRZM6UNCMP	4P	62	15	26	32	6	4.5	7	4	4	¥ 4,590 ※
No.12-28UNF	G6	OLRZM6UNCKP	4P	62	15	26	32	6	4.5	7	4	4	¥ 4,590 ※
1/4-20UNC	G7	OLRZM7U04NP	4P	62	15	26	33	6	4.5	7	4	4	¥ 4,590 ※
1/4-28UNF	G7	OLRZM7U04KP	4P	62	15	26	33	6	4.5	7	4	4	¥ 4,590 ※

Number of oil grooves : non

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