

⑧ Pipe Tap Series

Overall length	Thread length	Position on basic dia.	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓg	ℓs	Ds	K	ℓk

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

⑧-17

Z-PRO

PMSP OX Rc

Z-PRO

Spiral Fluted Taps for Taper Pipe Threads, for High Hardness Materials



Specification

HSS-P

OX
Oxide



Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
~5
(m/min)

Medium carbon steels
中炭素鋼
~5
(m/min)

High carbon steels
高炭素鋼
~5
(m/min)

Alloy steels
合金鋼
~5
(m/min)

Thermal refined steels
調質鋼
~3
(m/min)
25~35HRC

Thermal refined steels
調質鋼
~3
(m/min)
35~45HRC

Tool steels
工具鋼
~5
(m/min)

Cast steels
鑄鋼
~5
(m/min)

Cast irons
鑄鉄
~5
(m/min)

Ductile cast irons
強靱鑄鉄
~5
(m/min)

Aluminum alloy castings
アルミ合金鑄物
~7
(m/min)

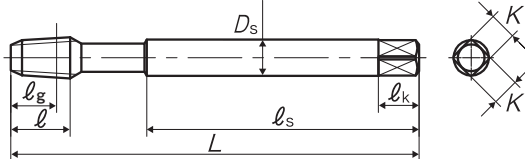
Magnesium alloy die castings
マグネシウム合金鑄物
~7
(m/min)

Zinc alloy castings
亜鉛合金鑄物
~7
(m/min)

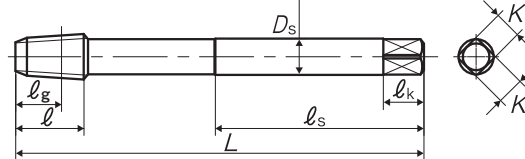
Brass
黄銅
~7
(m/min)

Brass castings
黄銅鑄物
~7
(m/min)

TYPE: 1



TYPE: 2



Segment : 1H

Size	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓg (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For Pipe Threads												
Rc 1/16-28	3117020002	C (2.5P)	7.723	90	14	10.1	46	6	4.9	8	3	1
Rc 1/8-28	3117020004	C (2.5P)	9.728	90	15	10.1	46	7	5.5	8	3	2
Rc 1/4-19	3117020006	C (2.5P)	13.157	100	19	15.0	51	11	9	12	3	2
Rc 3/8-19	3117020008	C (2.5P)	16.662	100	21	15.4	51	12	9	12	3	2
Rc 1/2-14	3117020009	C (2.5P)	20.955	125	26	20.5	64	16	12	15	4	2
Rc 3/4-14	3117020011	C (2.5P)	26.441	140	28	21.8	71	20	16	19	4	2
Rc 1 -11	3117020013	C (2.5P)	33.249	160	33	26.0	82	25	20	23	4	2

Think threads with
YAMAWA

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