

R-D

Roll Taps for General Purpose



Specification



■ R-D is the forming tap suitable for steel materials.

Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
10~20
(m/min)

Medium carbon steels
中炭素鋼
10~20
(m/min)

High carbon steels
高炭素鋼
10~20
(m/min)

Alloy steels
合金鋼
10~20
(m/min)

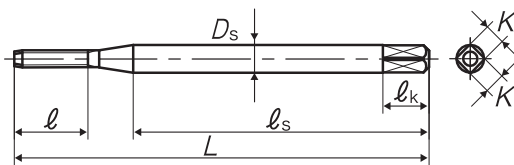
Stainless steels
ステンレス鋼
10~20
(m/min)

Aluminum alloy castings
アルミ合金鋳物
10~20
(m/min)

Zinc alloy castings
亜鉛合金鋳物
10~20
(m/min)

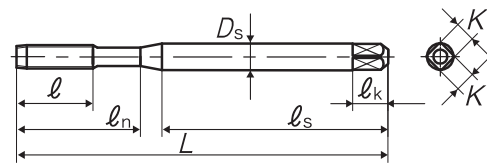
TYPE: 1

DIN371



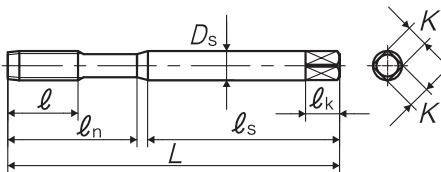
TYPE: 2

DIN371



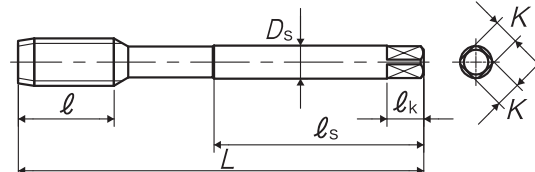
TYPE: 3

DIN371



TYPE: 4

DIN376/DIN5156



Segment : 1J (G=1H)

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	Lobe	TYPE
For Metric Threads												
M2 × 0.4	ISO2X	RD2.0EBNEBB	2P	45	8	-	32	2.8	2.1	5	4	1
M2.5 × 0.45	ISO2X	RD2.5FBNEBB	2P	50	8	15	33	2.8	2.1	5	4	2
M3 × 0.5	ISO2X	RD3.0GBNEBB	2P	56	9	18	34	3.5	2.7	6	4	2
M3.5 × 0.6	ISO2X	RD3.5HBNEBB	2P	56	11	20	32	4	3	6	4	2
M4 × 0.7	ISO2X	RD4.0IBNEBB	2P	63	13	21	38	4.5	3.4	6	4	2
M5 × 0.8	ISO2X	RD5.0KBNEBB	2P	70	14	25	39	6	4.9	8	4	2
M6 × 1	ISO2X	RD6.0MBNEBB	2P	80	15	30	45	6	4.9	8	4	2
M8 × 1.25	ISO2X	RD8.0NBNEBB	2P	90	19	35	47	8	6.2	9	6	3
M10 × 1.5	ISO2X	RD10.0OBNEBB	2P	100	23	39	52.5	10	8	11	8	3
M12 × 1.75	ISO2X	RG012PBNEBB	2P	110	26	-	56	9	7	10	8	4
M14 × 2	ISO2X	RG014QBNEBB	2P	110	26	-	56	11	9	12	8	4
M16 × 2	ISO2X	RG016QBNEBB	2P	110	26	-	56	12	9	12	8	4
For G Threads												
G 1/8-28	-	RVG0026NEBB	2P	90	19	-	46	7	5.5	8	8	4
G 1/4-19	-	RVG0047NEBB	2P	100	21	-	51	11	9	12	8	4
G 3/8-19	-	RVG0067NEBB	2P	100	21	-	51	12	9	12	8	4

Number of oil grooves: M2.5 and smaller = non,
M3~M6 = 4, M8 = 3, M10 and larger = 4
For M6 and smaller, external centers of 2P chamfer taps are removed.