

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	D _s	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

⑥-67

DIN

R-D

Roll Taps for General Purpose, Coated



Specification



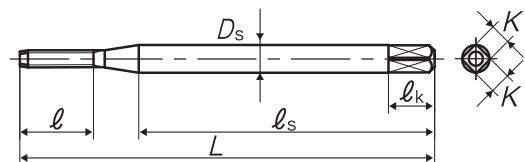
■ R-D is the forming tap suitable for steel materials.

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	Stainless steels ステンレス鋼	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
10~20 (m/min)	10~20 (m/min)	10~20 (m/min)	10~20 (m/min)	10~20 (m/min)	10~20 (m/min)	10~20 (m/min)

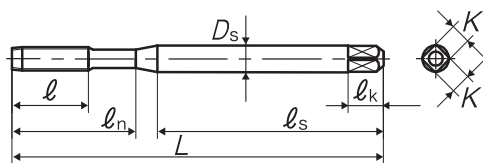
TYPE: 1

DIN371



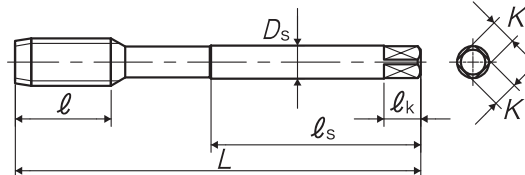
TYPE: 2

DIN371



TYPE: 3

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	93532.0BTI	2P	45	8	-	32	2.8	2.1	5	4	1
M2.5 × 0.45	ISO2X	93532.5BTI	2P	50	8	15	33	2.8	2.1	5	4	2
M3 × 0.5	ISO2X	93533.0BTI	2P	56	9	18	34	3.5	2.7	6	4	2
M3.5 × 0.6	ISO2X	93533.5BTI	2P	56	11	20	32	4	3	6	4	2
M4 × 0.7	ISO2X	93534.0BTI	2P	63	13	21	38	4.5	3.4	6	4	2
M5 × 0.8	ISO2X	93535.0BTI	2P	70	14	25	39	6	4.9	8	4	2
M6 × 1	ISO2X	93536.0BTI	2P	80	15	30	45	6	4.9	8	4	2
M8 × 1.25	ISO2X	93538.0BTI	2P	90	19	35	47	8	6.2	9	6	2
M10 × 1.5	ISO2X	9353010BTI	2P	100	23	39	52.5	10	8	11	8	2
M12 × 1.75	ISO2X	9353012BTI	2P	110	26	-	56	9	7	10	8	3
M14 × 2	ISO2X	9353014BTI	2P	110	26	-	56	11	9	12	8	3
M16 × 2	ISO2X	9353016BTI	2P	110	26	-	56	12	9	12	8	3
For G Threads												
G 1/8-28	-	9953R02TI	2P	90	19	-	46	7	5.5	8	8	3
G 1/4-19	-	9953R04TI	2P	100	21	-	51	11	9	12	8	3
G 3/8-19	-	9953R06TI	2P	100	21	-	51	12	9	12	8	3

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.

Think threads with
YAMAWA

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