

YAMAWA GENERAL CATALOG

[JIS • ANSI • DIN]

2023-2024



Thanks & To the Future with You

ANSI Aluminum Threading

Z-PRO



ANSI Only - PioneerNA.com

**Think threads with
YAMAWA**

SINCE 1923

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quicker!

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as soon as
possible.



Aluminum Taps in this Flyer

Spiral Fluted

Z-Pro—VUSP	Page AL5
Z-Pro—VUSP 1.5P	Page AL7
Z-Pro—VUSP CH	Page AL9
AL-SP	Page AL10

Spiral Pointed

Z-Pro—VUPO	Page AL12
AL-PO	Page AL14

Roll Form

N-RS	Page AL16
OL-RZ	Page AL20
HP-RZ	Page AL21

STI—Helical Coil

HT STI	Page AL24
SP STI	Page AL26
PO STI	Page AL28

Explanation of icons

HSS High speed steel		For blind hole with through coolant hole		Spiral pointed tap through hole use
HSS-Co High speed steel (Cobalt HSS)		For through hole with radial coolant hole		Hand tap through hole use
HSS-P Powder HSS	LH Left hand	For left hand thread		Hand tap blind hole use
HF Ultra micro grain cemented carbide	Synchro nized	For synchronized feeding		Spiral fluted tap through hole use
Alloy steel Alloy steel	5	Number of threads on chamfer		Spiral fluted tap blind hole use
OX Oxide	LH	Center drills left hand cut		Low spiral fluted tap blind hole use
NI Nitride		Cutting length		Low spiral fluted tap blind hole use specially for horizontal tapping
NX Nitride+Oxide				Specification Tapping Speeds
Coating Coated				

1 Spiral Fluted Tap Series for blind hole

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

- ANSI
- 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

ANSI

Z-PRO
VUSP

Z-PRO
Coated Spiral Fluted Taps



Specification

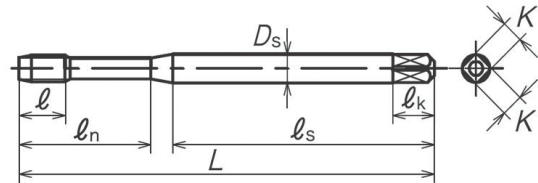


- Durability is improved by premium powder HSS and special coating.
- Chip ejection efficiency is improved and cutting resistance is reduced by the unique cutting edge shape, achieving a good internal thread and long tool life.

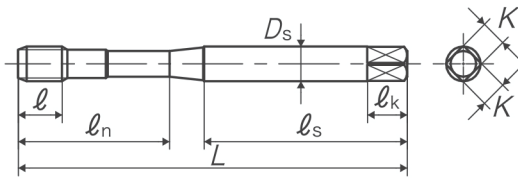
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 10~20 (m/min)	Medium carbon steels 中炭素鋼 10~30 (m/min)	High carbon steels 高炭素鋼 10~30 (m/min)	Alloy steels 合金鋼 10~20 (m/min)	Stainless steels ステンレス鋼 3~10 (m/min)	Tool steels 工具鋼 5~10 (m/min)	Ductile cast irons 独弱鑄鉄 10~30 (m/min)
Wrought aluminum アルミ圧延材 10~30 (m/min)	Aluminum alloy castings アルミ合金鑄物 10~35 (m/min)					

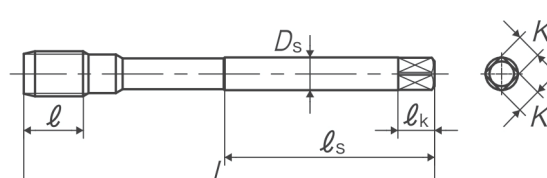
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ _n (inch)	ℓ _s (inch)	D _s (inch)	K (inch)	ℓ _k (inch)	No. of flutes	TYPE
For Metric Threads												
M3 × 0.5	D4	5101101035	2.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	3	1
M3 × 0.35	D4	5101101036	2.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	3	1
M4 × 0.7	D5	5101101042	2.5P	2.48	0.276	0.815	1.535	0.168	0.131	0.25	3	1
M4 × 0.5	D4	5101101043	2.5P	2.48	0.197	0.815	1.535	0.168	0.131	0.25	3	1
M5 × 0.8	D5	5101101049	2.5P	2.756	0.354	0.984	1.654	0.194	0.152	0.25	3	1
M5 × 0.5	D4	5101101051	2.5P	2.756	0.236	0.984	1.654	0.194	0.152	0.25	3	1
M6 × 1	D6	5101101055	2.5P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	3	1
M6 × 0.75	D6	5101101056	2.5P	3.15	0.315	1.181	1.713	0.255	0.191	0.312	3	1
M6 × 0.5	D4	5101101057	2.5P	3.15	0.315	1.181	1.713	0.255	0.191	0.312	3	1
M8 × 1.25	D7	5101101064	2.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	2
M8 × 1	D6	5101101065	2.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	2
M10 × 1.5	D8	5101101078	2.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M10 × 1.25	D6	5101101079	2.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M10 × 1	D6	5101101080	2.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M12 × 1.75	D8	5101101088	2.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3
M12 × 1.5	D7	5101101089	2.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3

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AL 5 of 32
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Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

1

ANSI

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

ANSI

①-10

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M12 × 1.25	D7	5101101090	2.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3
M14 × 2	D9	5101101100	2.5P	4.331	0.709	-	2.205	0.429	0.322	0.5	3	3
M14 × 1.5	D8	5101101102	2.5P	4.331	0.551	-	2.205	0.429	0.322	0.5	3	3
M16 × 2	D9	5101101114	2.5P	4.331	0.709	-	2.205	0.48	0.36	0.562	3	3
M16 × 1.5	D8	5101101116	2.5P	4.331	0.551	-	2.205	0.48	0.36	0.562	3	3
M18 × 2.5	D9	5101101128	2.5P	4.921	0.787	-	2.52	0.542	0.406	0.625	4	3
M18 × 1.5	D8	5101101130	2.5P	4.921	0.551	-	2.52	0.542	0.406	0.625	3	3
M20 × 2.5	D9	5101101141	2.5P	5.512	0.787	-	2.795	0.652	0.489	0.687	4	3
M20 × 1.5	D8	5101101144	2.5P	5.512	0.551	-	2.795	0.652	0.489	0.687	3	3
M22 × 2.5	D9	5101101156	2.5P	5.512	0.787	-	2.795	0.697	0.523	0.75	4	3
M22 × 1.5	D8	5101101158	2.5P	5.512	0.551	-	2.795	0.697	0.523	0.75	3	3
M24 × 3	D10	5101101167	2.5P	6.299	0.984	-	3.228	0.76	0.57	0.75	4	3
M24 × 1.5	D8	5101101170	2.5P	6.299	0.709	-	3.228	0.76	0.57	0.75	3	3
For Unified Threads												
No.5-40UNC	GH2	5101103021	2.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	2	1
No.5-44UNF	GH2	5101103022	2.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	2	1
No.6-32UNC	GH2	5101103023	2.5P	2.205	0.276	0.748	1.339	0.141	0.11	0.187	2	1
No.6-40UNF	GH2	5101103024	2.5P	2.205	0.276	0.748	1.339	0.141	0.11	0.187	2	1
No.8-32UNC	GH3	5101103029	2.5P	2.48	0.276	0.827	1.535	0.168	0.131	0.25	2	1
No.8-36UNF	GH3	5101103030	2.5P	2.48	0.276	0.827	1.535	0.168	0.131	0.25	2	1
No.10-24UNC	GH3	5101103039	2.5P	2.756	0.354	0.945	1.654	0.194	0.152	0.25	2	1
No.10-32UNF	GH3	5101103041	2.5P	2.756	0.354	0.945	1.654	0.194	0.152	0.25	2	1
No.12-24UNC	GH3	5101103047	2.5P	3.15	0.354	0.984	1.953	0.22	0.165	0.281	2	1
No.12-28UNF	GH3	5101103048	2.5P	3.15	0.354	0.984	1.953	0.22	0.165	0.281	2	1
1/4-20UNC	GH3	5101103058	2.5P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	2	1
1/4-20UNC	GH5	5101303058	2.5P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	2	1
1/4-28UNF	GH3	5101103062	2.5P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	2	1
1/4-28UNF	GH5	5101303062	2.5P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	2	1
5/16-18UNC	GH5	5101103071	2.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	2
3/8-16UNC	GH5	5101103082	2.5P	3.937	0.512	1.535	2.028	0.381	0.286	0.437	3	2
7/16-14UNC	GH5	5101103098	2.5P	3.937	0.512	-	2.008	0.323	0.242	0.406	3	3
1/2-13UNC	GH5	5101103111	2.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3
9/16-12UNC	GH5	5101103126	2.5P	4.331	0.709	-	2.205	0.429	0.322	0.5	3	3
5/8-11UNC	GH5	5101103138	2.5P	4.331	0.709	-	2.205	0.48	0.36	0.562	3	3

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

AL 6 of 32
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Think threads with
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1 Spiral Fluted Tap Series for blind hole

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

- ANSI
- 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

ANSI

Z-PRO

VUSP 1.5P



Z-PRO

Coated Spiral Fluted Taps 1.5P

Specification

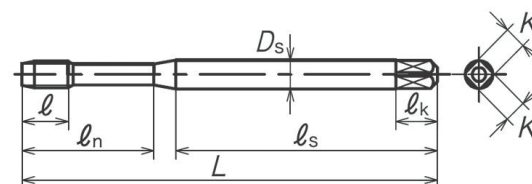


- Lead length of 1.5P makes it ideal for blind hole drilling, in which there is no tolerance for prepared hole depth and effective thread length.
- Durability is improved by premium powder HSS and special coating.
- Chip ejection efficiency is improved and cutting resistance is reduced by the unique cutting edge shape, achieving a good internal thread and long tool life.

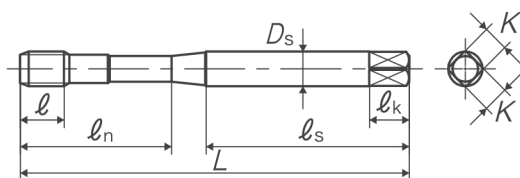
Tapping Speeds depending on Materials

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	Tool steels 工具鋼	Ductile cast irons 強靱鑄鉄
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	3~10 (m/min)	5~10 (m/min)	5~15 (m/min)
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物					
5~20 (m/min)	5~20 (m/min)					

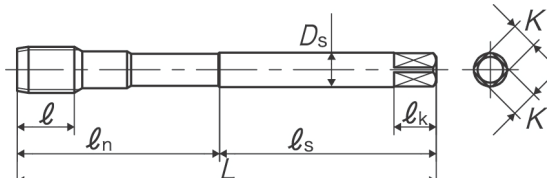
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	ℓ_s (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Metric Threads												
M3 × 0.5	D4	5103101035	1.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	3	1
M3 × 0.35	D4	5103101036	1.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	3	1
M4 × 0.7	D5	5103101042	1.5P	2.48	0.276	0.815	1.535	0.168	0.131	0.25	3	1
M4 × 0.5	D4	5103101043	1.5P	2.48	0.197	0.815	1.535	0.168	0.131	0.25	3	1
M5 × 0.8	D5	5103101049	1.5P	2.756	0.354	0.984	1.654	0.194	0.152	0.25	3	1
M5 × 0.5	D4	5103101051	1.5P	2.756	0.236	0.984	1.654	0.194	0.152	0.25	3	1
M6 × 1	D6	5103101055	1.5P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	3	1
M6 × 0.75	D6	5103101056	1.5P	3.15	0.315	1.181	1.713	0.255	0.191	0.312	3	1
M6 × 0.5	D4	5103101057	1.5P	3.15	0.315	1.181	1.713	0.255	0.191	0.312	3	1
M8 × 1.25	D7	5103101064	1.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	2
M8 × 1	D6	5103101065	1.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	2
M10 × 1.5	D8	5103101078	1.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M10 × 1.25	D6	5103101079	1.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M10 × 1	D6	5103101080	1.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M12 × 1.75	D8	5103101088	1.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3
M12 × 1.5	D7	5103101089	1.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3

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AL 7 of 32
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Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M12 × 1.25	D7	5103101090	1.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3
M14 × 2	D9	5103101100	1.5P	4.331	0.709	-	2.205	0.429	0.322	0.5	3	3
M14 × 1.5	D8	5103101102	1.5P	4.331	0.551	-	2.205	0.429	0.322	0.5	3	3
M16 × 2	D9	5103101114	1.5P	4.331	0.709	-	2.205	0.48	0.36	0.562	3	3
M16 × 1.5	D8	5103101116	1.5P	4.331	0.551	-	2.205	0.48	0.36	0.562	3	3

1

ANSI

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

ANSI

①-18

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

Think threads with
YAMAWA

AL 8 of 32
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1 Spiral Fluted Tap Series for blind hole

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

- ANSI
- 1 Spiral Fluted Taps (for blind hole)
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- 8 Pipe Taps
- 9 Thread Mills Premium Thread Mills
- 10 Dies
- 11 Center Drills Centering Tools
- 12 Precision Machinery/Medical Surgical Instruments

ANSI

Z-PRO

VUSP CH



Z-PRO

Coated Spiral Fluted Taps with Coolant Through Hole

Specification

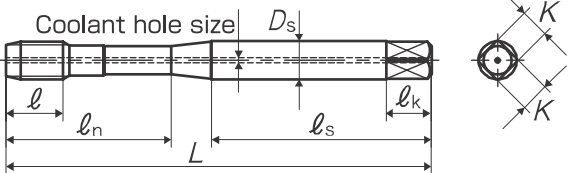


- Durability is improved by premium powder HSS and special coating.
- Chip ejection efficiency is improved and cutting resistance is reduced by the unique cutting edge shape, achieving a good internal thread and long tool life.

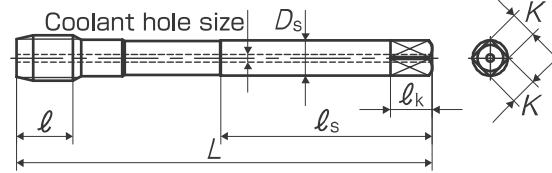
Tapping Speeds depending on Materials

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	Tool steels 工具鋼	Ductile cast irons 強靱鑄鉄
10~20 (m/min)	10~30 (m/min)	10~30 (m/min)	10~20 (m/min)	3~10 (m/min)	5~10 (m/min)	10~20 (m/min)
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物					
10~20 (m/min)	10~20 (m/min)					

TYPE: 1



TYPE: 2



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	Coolant hole size (inch)	TYPE
For Unified Threads													
5/16-18UNC	GH5	5201103071	2.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	0.039	1
3/8-16UNC	GH5	5201103082	2.5P	3.937	0.512	1.535	2.028	0.381	0.286	0.437	3	0.059	1
1/2-13UNC	GH5	5201103111	2.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	0.079	2

Think threads with
YAMAWA

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

AL 9 of 32
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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

1

ANSI

Spiral Fluted Taps
(for blind hole)

1

Spiral Fluted Taps
(for through hole)

2

Spiral Pointed Taps
(for through hole)

3

Hand Taps

4

Cemented
Carbide Taps

5

Roll Taps

6

Special Thread Taps
Simple inspection tools

7

Pipe Taps

8

Thread Mills
Premium Thread Mills

9

Dies

10

Center Drills
Centering Tools

11

Precision Machinery/
Medical Surgical Instruments

12

ANSI

1-142

ANSI

AL-SP

Spiral Fluted Taps for Aluminum



Specification

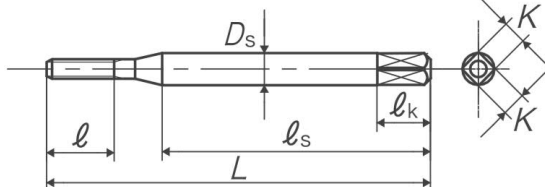


■ In aluminum die casting and aluminum casting tapping, AL-SP solves such problems as chip jamming, chip clogging, and torn threads.

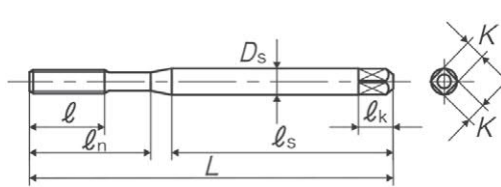
Tapping Speed depending on Materials



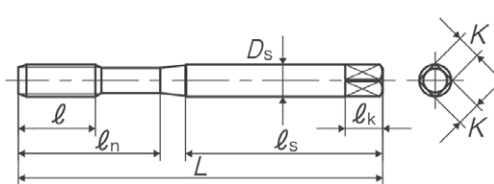
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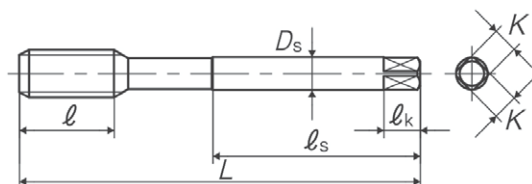
TYPE:2



TYPE:3



TYPE:4



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	ℓ_s (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Metric Threads												
M3 × 0.5	D3	386528M	2.5P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	3	2
M3.5 × 0.6	D4	386529M	2.5P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	3	2
M4 × 0.7	D4	386530M	2.5P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	3	2
M5 × 0.8	D4	386531M	2.5P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	3	2
M6 × 1	D5	386532M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
M7 × 1	D5	386533M	2.5P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	3	3
M8 × 1.25	D5	386535M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
M8 × 1	D5	386534M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
M10 × 1.5	D6	386537M	2.5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	3
M10 × 1.25	D5	386536M	2.5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	3
M12 × 1.75	D6	386540M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
M12 × 1.5	D5	386539M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
M12 × 1.25	D5	386538M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4

• This product is different from AL-10 of 32 in product name, shape and dimensions, please be careful when using.

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Think threads with
YAMAWA

1

Spiral Fluted Tap Series for blind hole

ANSI

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

ANSI

1-143

Overall length
L

Thread length
ℓ

Thread + Neck length
ℓn

Shank length
ℓs

Shank dia.
Ds

Size of square
K

Length of square
ℓk

AL-SP

Spiral Fluted Taps for Aluminum

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
For Unified Threads												
No.2-56UNC	GH2	386500M	2.5P	1.772	0.314	-	1.161	0.141	0.11	0.187	2	1
No.4-40UNC	GH2	386501M	2.5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	2	2
No.5-40UNC	GH2	386502M	2.5P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	3	2
No.6-32UNC	GH3	386503M	2.5P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	3	2
No.8-32UNC	GH3	386504M	2.5P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	3	2
No.10-24UNC	GH3	386505M	2.5P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	3	2
No.10-32UNF	GH3	386506M	2.5P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	3	2
1/4-20UNC	GH3	386507M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
1/4-20UNC	GH5	386508M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
1/4-28UNF	GH3	386509M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
1/4-28UNF	GH4	386511M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
5/16-18UNC	GH3	386512M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
5/16-18UNC	GH5	386513M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
5/16-24UNF	GH3	386514M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
5/16-24UNF	GH4	386515M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
3/8-16UNC	GH3	386516M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
3/8-16UNC	GH5	386517M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
3/8-24UNF	GH3	386518M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
3/8-24UNF	GH4	386519M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
7/16-14UNC	GH3	386520M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
7/16-14UNC	GH5	386521M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
7/16-20UNF	GH3	386522M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
7/16-20UNF	GH5	386523M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
1/2-13UNC	GH3	386524M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
1/2-13UNC	GH5	386525M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
1/2-20UNF	GH3	386526M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
1/2-20UNF	GH5	386527M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4

Think threads with

YAMAWA

AL 11 of 32

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

3 Spiral Pointed Tap Series for through hole

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

ANSI

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

ANSI

3-7

ANSI

Z-PRO
VUPO

Z-PRO Coated Spiral Pointed Taps



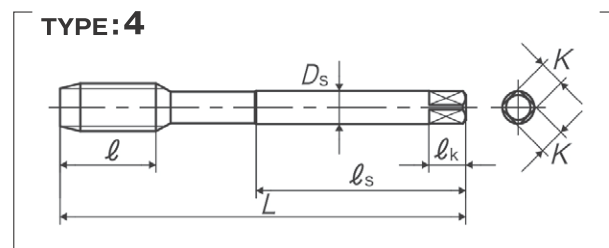
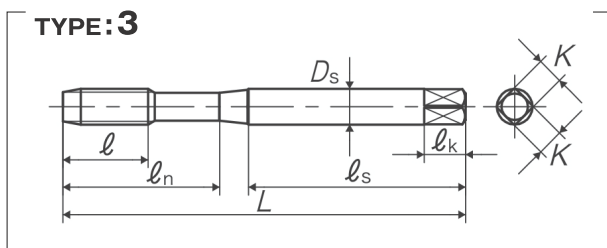
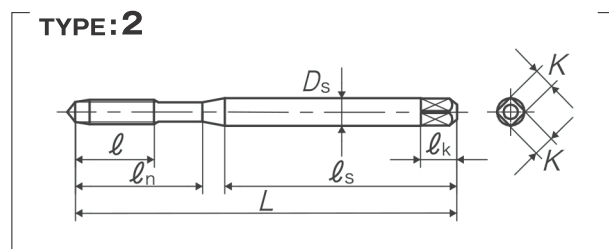
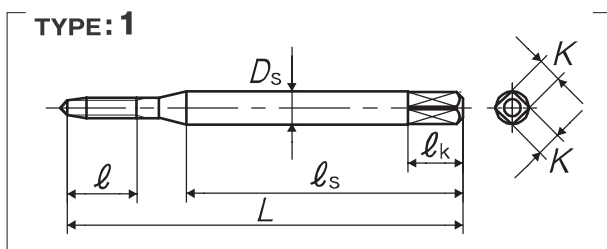
Specification



- Durability is improved by premium powder HSS and special coating.
- Chip ejection efficiency is improved and cutting resistance is reduced by the unique cutting edge shape, achieving a good internal thread and long tool life.

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	Tool steels 工具鋼	Ductile cast irons 強靱鑄鉄
10~30 (m/min)	10~30 (m/min)	10~30 (m/min)	10~30 (m/min)	5~15 (m/min)	5~15 (m/min)	10~35 (m/min)
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鑄物					
10~35 (m/min)	10~35 (m/min)					



Segment : 1F

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ _n (inch)	ℓ _s (inch)	D _s (inch)	K (inch)	ℓ _k (inch)	No. of flutes	TYPE
For Metric Threads												
M2 × 0.4	D4	5102101021	5P	1.772	0.314	-	1.161	0.141	0.11	0.187	2	1
M2.2 × 0.45	D4	5102101024	5P	1.772	0.314	-	1.161	0.141	0.11	0.187	2	1
M2.3 × 0.4	D4	5102101026	5P	1.772	0.314	-	1.161	0.141	0.11	0.187	2	1
M2.5 × 0.45	D4	5102101029	5P	2.205	0.354	0.693	1.28	0.141	0.11	0.187	2	2
M2.6 × 0.45	D4	5102101032	5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	2	2
M3 × 0.5	D4	5102101035	5P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	3	2
M3 × 0.35	D4	5102101036	5P	2.205	0.256	0.736	1.339	0.141	0.11	0.187	3	2
M4 × 0.7	D5	5102101042	5P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	3	2
M4 × 0.5	D4	5102101043	5P	2.48	0.354	0.815	1.535	0.168	0.131	0.25	3	2
M5 × 0.8	D5	5102101049	5P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	3	2
M5 × 0.5	D4	5102101051	5P	2.756	0.354	0.984	1.654	0.194	0.152	0.25	3	2
M6 × 1	D6	5102101055	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
M6 × 0.75	D6	5102101056	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2

Think threads with
YAMAWA

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

AL 12 of 32
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Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

3

ANSI

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Metal Surgical Instruments

⑫

ANSI

③-8

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M6 × 0.5	D4	5102101057	5P	3.15	0.354	1.181	1.713	0.255	0.191	0.312	3	2
M8 × 1.25	D7	5102101064	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
M8 × 1	D6	5102101065	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
M10 × 1.5	D8	5102101078	5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	3
M10 × 1.25	D7	5102101079	5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	3
M10 × 1	D6	5102101080	5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	3
M12 × 1.75	D8	5102101088	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
M12 × 1.5	D8	5102101089	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
M12 × 1.25	D7	5102101090	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
M14 × 2	D9	5102101100	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	4
M14 × 1.5	D8	5102101102	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	4
M16 × 2	D9	5102101114	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	4
M16 × 1.5	D8	5102101116	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	4
M18 × 2.5	D9	5102101128	5P	4.921	1.299	-	2.52	0.542	0.406	0.625	3	4
M18 × 1.5	D8	5102101130	5P	4.921	0.945	-	2.52	0.542	0.406	0.625	3	4
M20 × 2.5	D9	5102101141	5P	5.512	1.299	-	2.795	0.652	0.489	0.687	3	4
M20 × 1.5	D8	5102101144	5P	5.512	0.945	-	2.795	0.652	0.489	0.687	3	4
M22 × 2.5	D9	5102101156	5P	5.512	1.299	-	2.795	0.697	0.523	0.75	3	4
M22 × 1.5	D8	5102101158	5P	5.512	0.945	-	2.795	0.697	0.523	0.75	3	4
M24 × 3	D10	5102101167	5P	6.299	1.457	-	3.228	0.76	0.57	0.75	3	4
M24 × 1.5	D8	5102101170	5P	6.299	1.063	-	3.228	0.76	0.57	0.75	3	4
For Unified Threads												
No.5-40UNC	GH2	5102103021	5P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	2	2
No.5-44UNF	GH2	5102103022	5P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	2	2
No.6-32UNC	GH3	5102103023	5P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	2	2
No.6-40UNF	GH2	5102103024	5P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	2	2
No.8-32UNC	GH3	5102103029	5P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	2	2
No.8-36UNF	GH2	5102103030	5P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	2	2
No.10-24UNC	GH3	5102103039	5P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	2	2
No.10-32UNF	GH3	5102103041	5P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	2	2
No.12-24UNC	GH3	5102103047	5P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	2	2
No.12-28UNF	GH3	5102103048	5P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	2	2
1/4-20UNC	GH5	5102103058	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
1/4-28UNF	GH4	5102103062	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
5/16-18UNC	GH5	5102103071	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
5/16-24UNF	GH4	5102103074	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
3/8-16UNC	GH5	5102103082	5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
3/8-24UNF	GH4	5102103085	5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
7/16-14UNC	GH5	5102103098	5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
7/16-20UNF	GH5	5102103101	5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
1/2-13UNC	GH5	5102103111	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
1/2-20UNF	GH5	5102103115	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
9/16-12UNC	GH5	5102103126	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	4
9/16-18UNF	GH5	5102103129	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	4
5/8-11UNC	GH5	5102103138	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	4
5/8-18UNF	GH5	5102103142	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	4
3/4-10UNC	GH5	5102103161	5P	4.921	1.299	-	2.52	0.59	0.442	0.687	3	4
3/4-16UNF	GH5	5102103164	5P	4.921	1.299	-	2.52	0.59	0.442	0.687	3	4
7/8-9UNC	GH6	5102103181	5P	5.512	1.299	-	2.795	0.697	0.523	0.75	3	4
7/8-14UNF	GH6	5102103184	5P	5.512	1.299	-	2.795	0.697	0.523	0.75	3	4

* This product is different from AL product in shape and dimensions, please be careful when using.

AL 13 of 32
ANSI Only - PioneerNA.com

Think threads with
YAMAWA

3 Spiral Pointed Tap Series for through hole

Overall length	Thread length	Thread + Neck length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_n	Ds	K	ℓ_k



AL-PO

Spiral Pointed Taps for Aluminum

Specification

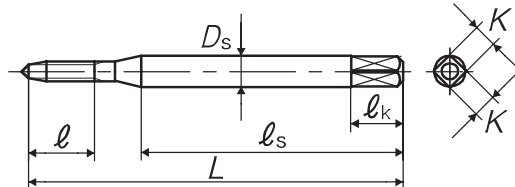


■ In tapping of aluminum die casting and aluminum casting, AL-PO solves chip jamming and chip clogging trouble, and eliminates torn threads.

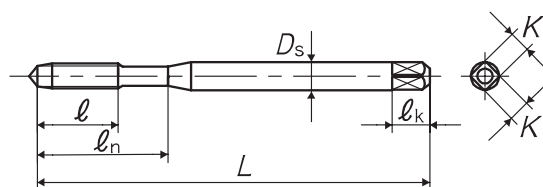
Tapping Speed depending on Materials

Brass 黄銅	Brass castings 黄銅鑄物	Bronze 青銅	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鑄物	Magnesium alloy die castings マグネシウム合金鑄物	Zinc alloy castings 亜鉛合金鑄物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

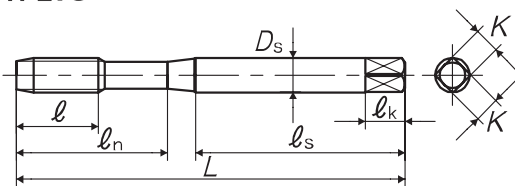
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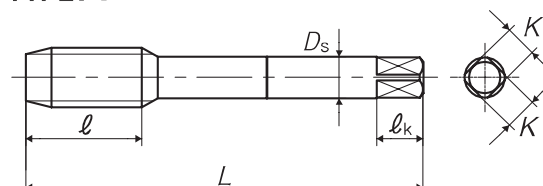
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TYPE:3



TYPE:4



Segment : 1F

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Metric Threads											
M3 × 0.5	D3	386228M	5P	2.205	0.433	0.736	0.141	0.11	0.187	3	2
M3.5 × 0.6	D4	386229M	5P	2.205	0.433	0.748	0.141	0.11	0.187	3	2
M4 × 0.7	D4	386230M	5P	2.48	0.512	0.815	0.168	0.131	0.25	3	2
M5 × 0.8	D4	386231M	5P	2.756	0.551	0.984	0.194	0.152	0.25	3	2
M6 × 1	D5	386232M	5P	3.15	0.591	1.181	0.255	0.191	0.312	3	2
M7 × 1	D5	386233M	5P	3.543	0.748	1.339	0.318	0.238	0.375	3	3
M8 × 1.25	D5	386235M	5P	3.543	0.748	1.378	0.318	0.238	0.375	3	3
M8 × 1	D5	386234M	5P	3.543	0.748	1.378	0.318	0.238	0.375	3	3
M10 × 1.5	D6	386237M	5P	3.937	0.906	1.535	0.381	0.286	0.437	3	3
M10 × 1.25	D5	386236M	5P	3.937	0.906	1.535	0.381	0.286	0.437	3	3
M12 × 1.75	D6	386240M	5P	4.331	1.024	-	0.367	0.275	0.437	3	4
M12 × 1.5	D5	386239M	5P	4.331	1.024	-	0.367	0.275	0.437	3	4
M12 × 1.25	D5	386238M	5P	4.331	1.024	-	0.367	0.275	0.437	3	4
For Unified Threads											
No.2-56UNC	GH2	386200M	5P	1.772	0.314	-	0.141	0.11	0.187	2	1
No.4-40UNC	GH2	386201M	5P	2.205	0.354	0.709	0.141	0.11	0.187	2	2
No.5-40UNC	GH2	386202M	5P	2.205	0.433	0.736	0.141	0.11	0.187	3	2

ANSI



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

ANSI Only - PioneerNA.com

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

3

ANSI

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
No.6-32UNC	GH3	386203M	5P	2.205	0.433	0.748	0.141	0.11	0.187	3	2
No.8-32UNC	GH3	386204M	5P	2.48	0.512	0.827	0.168	0.131	0.25	3	2
No.10-24UNC	GH3	386205M	5P	2.756	0.551	0.945	0.194	0.152	0.25	3	2
No.10-32UNF	GH3	386206M	5P	2.756	0.551	0.945	0.194	0.152	0.25	3	2
1/4-20UNC	GH3	386207M	5P	3.15	0.591	1.181	0.255	0.191	0.312	3	2
1/4-20UNC	GH5	386208M	5P	3.15	0.591	1.181	0.255	0.191	0.312	3	2
1/4-28UNF	GH3	386209M	5P	3.15	0.591	1.181	0.255	0.191	0.312	3	2
1/4-28UNF	GH4	386211M	5P	3.15	0.591	1.181	0.255	0.191	0.312	3	2
5/16-18UNC	GH3	386212M	5P	3.543	0.748	1.378	0.318	0.238	0.375	3	3
5/16-18UNC	GH5	386213M	5P	3.543	0.748	1.378	0.318	0.238	0.375	3	3
5/16-24UNF	GH3	386214M	5P	3.543	0.748	1.378	0.318	0.238	0.375	3	3
5/16-24UNF	GH4	386215M	5P	3.543	0.748	1.378	0.318	0.238	0.375	3	3
3/8-16UNC	GH3	386216M	5P	3.937	0.906	1.535	0.381	0.286	0.437	3	3
3/8-16UNC	GH5	386217M	5P	3.937	0.906	1.535	0.381	0.286	0.437	3	3
3/8-24UNF	GH3	386218M	5P	3.937	0.906	1.535	0.381	0.286	0.437	3	3
3/8-24UNF	GH4	386219M	5P	3.937	0.906	1.535	0.381	0.286	0.437	3	3
7/16-14UNC	GH3	386220M	5P	3.937	0.906	-	0.323	0.242	0.406	3	4
7/16-14UNC	GH5	386221M	5P	3.937	0.906	-	0.323	0.242	0.406	3	4
7/16-20UNF	GH3	386222M	5P	3.937	0.906	-	0.323	0.242	0.406	3	4
7/16-20UNF	GH5	386223M	5P	3.937	0.906	-	0.323	0.242	0.406	3	4
1/2-13UNC	GH3	386224M	5P	4.331	1.024	-	0.367	0.275	0.437	3	4
1/2-13UNC	GH5	386225M	5P	4.331	1.024	-	0.367	0.275	0.437	3	4
1/2-20UNF	GH3	386226M	5P	4.331	1.024	-	0.367	0.275	0.437	3	4
1/2-20UNF	GH5	386227M	5P	4.331	1.024	-	0.367	0.275	0.437	3	4

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

ANSI

③-84

• This product is different from the product in shape and dimensions, please be careful when using.



Think threads with
YAMAWA

6 Roll Tap Series

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

ANSI

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

ANSI

N-RS

Roll Taps for Non-Ferrous Materials



Specification

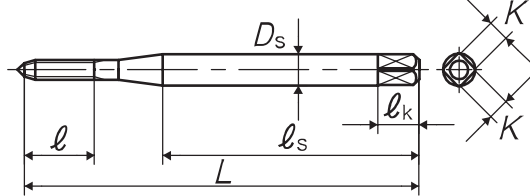


■ N-RS is the forming tap suitable for non-ferrous materials such as aluminum castings, aluminum die castings and brass.

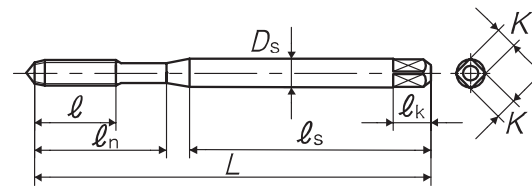
Tapping Speed depending on Materials

Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Zinc alloy castings 亜鉛合金鋳物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

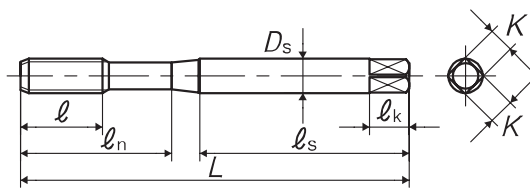
TYPE:1



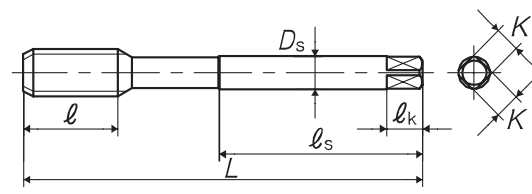
TYPE:2



TYPE:3



TYPE:4



Segment : 1J

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
For Metric Threads												
M3 × 0.5	D5	388513M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3 × 0.5	D5	388512M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	388515M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	388514M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M4 × 0.7	D6	388517M	4P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M4 × 0.7	D6	388516M	2P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M5 × 0.8	D7	388519M	4P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M5 × 0.8	D7	388518M	2P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M6 × 1	D8	388521M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M6 × 1	D8	388520M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M7 × 1	D9	388523M	4P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M7 × 1	D9	388522M	2P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M8 × 1.25	D9	388527M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1.25	D9	388526M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	388525M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	388524M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M10 × 1.5	D10	388531M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3

ANSI

Think threads with
YAMAWA

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

AL 16 of 32
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Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

6

ANSI

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
M10 × 1.5	D10	388530M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3
M10 × 1.25	D9	388529M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3
M10 × 1.25	D9	388528M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	6	3
M12 × 1.75	D11	388535M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
M12 × 1.75	D11	388534M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
M12 × 1.25	D9	388533M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
M12 × 1.25	D9	388532M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
For Unified Threads												
No.0-80UNF	H2	388410M	2P	1.772	0.236	-	1.161	0.141	0.11	0.187	3	1
No.1-64UNC	H2	388411M	2P	1.772	0.276	-	1.161	0.141	0.11	0.187	3	1
No.1-72UNF	H2	388412M	2P	1.772	0.276	-	1.161	0.141	0.11	0.187	3	1
No.2-56UNC	H2	388413M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-56UNC	H3	388414M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-64UNF	H2	388415M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.2-64UNF	H3	388416M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.3-48UNC	H2	388417M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-48UNC	H3	388418M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-56UNF	H2	388419M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-56UNF	H3	388420M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H3	388423M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H3	388421M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H5	388424M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H5	388422M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H3	388427M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H3	388425M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	388428M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	388426M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.5-40UNC	H3	388431M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H3	388429M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H5	388432M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-40UNC	H5	388430M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H3	388435M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H3	388433M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H5	388436M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.5-44UNF	H5	388434M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	388440M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	388437M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	388441M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	388438M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H3	388444M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H3	388442M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H5	388445M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-40UNF	H5	388443M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.8-32UNC	H3	388448M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H3	388446M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	388449M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	388447M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H3	388452M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H3	388450M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-36UNF	H5	388453M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

ANSI

⑥-32

AL 17 of 32
 * This product is different from JIS products in shape and dimensions, please be careful when using.

6 Roll Tap Series

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

ANSI

N-RS Roll Taps for Non-Ferrous Materials

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
No.8-36UNF	H5	388451M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.10-24UNC	H4	388456M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H4	388454M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	388457M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	388455M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	388460M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	388458M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	388461M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	388459M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.12-24UNC	H4	388464M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H4	388462M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H6	388465M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-24UNC	H6	388463M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H4	388468M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H4	388466M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H6	388469M	4P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
No.12-28UNF	H6	388467M	2P	3.15	0.591	0.984	1.953	0.22	0.165	0.281	4	2
1/4-20UNC	H4	388472M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H4	388470M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	388473M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	388471M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	388476M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	388474M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	388477M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	388475M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
5/16-18UNC	H5	388480M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H5	388478M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	388481M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	388479M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	388484M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	388482M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H7	388485M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H7	388483M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
3/8-16UNC	H5	388488M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H5	388486M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	388489M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	388487M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	388492M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	388490M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	388493M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	388491M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
7/16-14UNC	H5	388496M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-14UNC	H5	388494M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-14UNC	H7	388497M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-14UNC	H7	388495M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H5	388502M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H5	388498M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H7	388503M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
7/16-20UNF	H7	388499M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	6	4
1/2-13UNC	H5	388506M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4

ANSI



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

AL18 of 32
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Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

6

ANSI

N-RS Roll Taps for Non-Ferrous Materials

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
1/2-13UNC	H5	388504M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-13UNC	H7	388507M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-13UNC	H7	388505M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H5	388510M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H5	388508M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H7	388511M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4
1/2-20UNF	H7	388509M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	6	4

Number of oil grooves : Metric thread : =1

Unified thread : No.4 and smaller=non, No.5 and larger=1

For M6, 1/4 and smaller, external centers of 2P chamfer taps are removed.

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical/Surgical Instruments

⑫

ANSI

⑥-34

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

ANSI

OL-RZ



Roll Taps for Dry Tapping, Coated

Specification

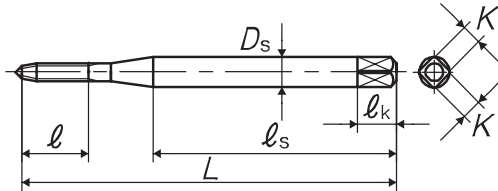


OL-RZ is the forming tap enabling dry tapping under following condition : tapping sizes of smaller than M6, thin steel sheets having burring operation, and steel parts with rather short length. Optimum coating suitable to the tapping condition.

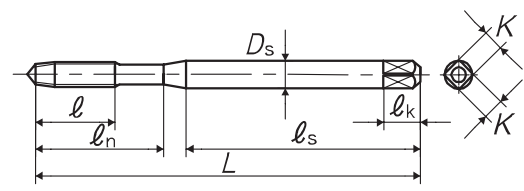
Tapping Speed depending on Materials

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						

TYPE: 1



TYPE: 2



Segment : 1J

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	ℓ_s (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	Lobe	TYPE
For Metric Threads												
M3 × 0.5	D5	386610M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	386611M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M4 × 0.7	D6	386612M	4P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M5 × 0.8	D7	386614M	4P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M6 × 1	D8	386615M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
For Unified Threads												
No.2-56UNC	H3	386600M	4P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.4-40UNC	H5	386601M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	386602M	4P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.5-40UNC	H5	386603M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	386604M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.8-32UNC	H5	386605M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.10-24UNC	H6	386606M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	386607M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
1/4-20UNC	H6	386608M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	386609M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2

Number of oil grooves : non

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

ANSI

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

⑬

ANSI

HP-RZ

High Performance Roll Taps, Coated



Specification

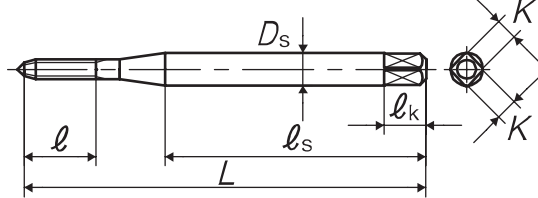


■ HP-RZ is the forming tap suitable for steels (up to 35HRC) and light alloys, and applicable to the high speed tapping. Optimum coating suitable to the tapping condition.

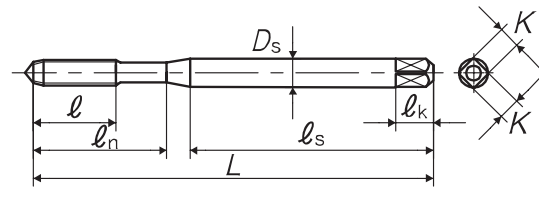
Tapping Speed depending on Materials

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						

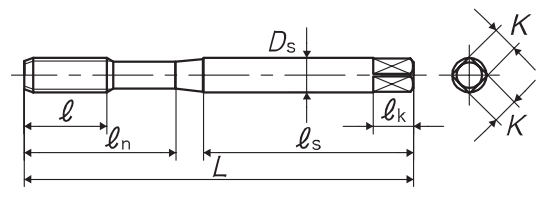
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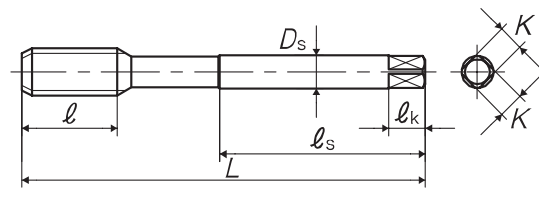
TYPE:2



TYPE:3



TYPE:4



Segment : 1J

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ _n (inch)	ℓ _s (inch)	D _s (inch)	K (inch)	ℓ _k (inch)	Lobe	TYPE
For Metric Threads												
M3 × 0.5	D5	386885M	4P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3 × 0.5	D5	386864M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	386886M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M3.5 × 0.6	D6	386865M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
M4 × 0.7	D6	386887M	4P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M4 × 0.7	D6	386866M	2P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	4	2
M5 × 0.8	D7	386888M	4P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M5 × 0.8	D7	386867M	2P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	4	2
M6 × 1	D8	386889M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M6 × 1	D8	386868M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
M7 × 1	D9	386870M	4P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M7 × 1	D9	386869M	2P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	4	3
M8 × 1.25	D9	386874M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1.25	D9	386873M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	386872M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M8 × 1	D9	386871M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
M10 × 1.5	D10	386878M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3

ANSI

Think threads with
YAMAWA

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

AL 21 of 32
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Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

6

ANSI

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
M10 × 1.5	D10	386877M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3
M10 × 1.25	D9	386876M	4P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3
M10 × 1.25	D9	386875M	2P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	8	3
M12 × 1.75	D11	386884M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.75	D11	386883M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.5	D9	386882M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.5	D9	386881M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.25	D9	386880M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
M12 × 1.25	D9	386879M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
For Unified Threads												
No.0-80UNF	H2	386800M	2P	1.772	0.236	-	1.161	0.141	0.11	0.187	3	1
No.2-56UNC	H3	386801M	2P	1.772	0.314	-	1.161	0.141	0.11	0.187	4	1
No.3-48UNC	H3	386802M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.3-56UNF	H3	386803M	2P	2.205	0.354	0.681	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H3	386804M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-40UNC	H5	386805M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H3	386806M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.4-48UNF	H5	386807M	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	4	2
No.5-40UNC	H5	386799M	2P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	386810M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H3	386808M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	386811M	4P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.6-32UNC	H5	386809M	2P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	4	2
No.8-32UNC	H3	386814M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H3	386812M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	386815M	4P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.8-32UNC	H5	386813M	2P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	4	2
No.10-24UNC	H4	386818M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H4	386816M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	386819M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-24UNC	H6	386817M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	386822M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H4	386820M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	386823M	4P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
No.10-32UNF	H6	386821M	2P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	4	2
1/4-20UNC	H4	386826M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H4	386824M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	386827M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-20UNC	H6	386825M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	386830M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H4	386828M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	386831M	4P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
1/4-28UNF	H6	386829M	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	4	2
5/16-18UNC	H5	386834M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H5	386832M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	386835M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-18UNC	H7	386833M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	386838M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H5	386836M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
5/16-24UNF	H7	386839M	4P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Metal Surgical Instruments

⑫

ANSI

⑥-52

• This product is different from the products in store and dimensions, please be careful when using.

AL 22 of 32
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Think threads with
YAMAWA

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

ANSI

HP-RZ High Performance Roll Taps, Coated

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	Lobe	TYPE
5/16-24UNF	H7	386837M	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	6	3
3/8-16UNC	H5	386842M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H5	386840M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	386843M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-16UNC	H7	386841M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	386846M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H5	386844M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	386847M	4P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
3/8-24UNF	H7	386845M	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	6	3
7/16-14UNC	H5	386850M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-14UNC	H5	386848M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-14UNC	H7	386851M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-14UNC	H7	386849M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H5	386854M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H5	386852M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H7	386855M	4P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
7/16-20UNF	H7	386853M	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	8	4
1/2-13UNC	H5	386858M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-13UNC	H5	386856M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-13UNC	H7	386859M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-13UNC	H7	386857M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H5	386862M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H5	386860M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H7	386863M	4P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4
1/2-20UNF	H7	386861M	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	8	4

Number of oil grooves : Metric thread : M3~M7 = 2, M8 = 3, M10 and larger = 4
 Unified thread : No.4 and smaller = non, No.5~1/4 = 2, 5/16~3/8 = 3, 7/16 and larger = 4
 For M6, 1/4 and smaller, external centers of 2P chamfer taps are removed.

- 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

ANSI

⑥-53



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

AL 23 of 32

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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

ANSI

HT STI

Hand Taps for Helical Coil Wire Screw Thread Inserts



Specification



Hand tap to cut internal threads for helical coil to enter.

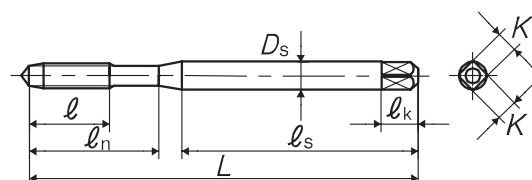
Tapping Speed depending on Materials

Wrought aluminum
アルミ圧延材
5~15
(m/min)

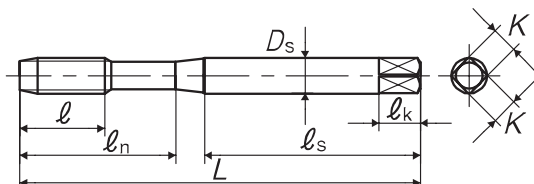
Aluminum alloy castings
アルミ合金鋳物
5~15
(m/min)

Zinc alloy castings
亜鉛合金鋳物
5~15
(m/min)

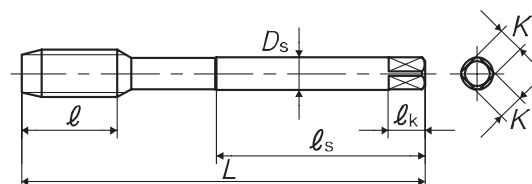
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1A

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	ℓ_s (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Unified Threads												
No.2-56UNC	GH1	TUUN2E1NEB5	5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	3	1
No.2-56UNC	GH1	TUUN2E1NEBA	1.5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	3	1
No.2-56UNC	GH2	TUUN2E2NEB5	5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	3	1
No.2-56UNC	GH2	TUUN2E2NEBA	1.5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	3	1
No.4-40UNC	GH1	TUUN4H1NEB5	5P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	3	1
No.4-40UNC	GH1	TUUN4H1NEBA	1.5P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	3	1
No.4-40UNC	GH2	TUUN4H2NEB5	5P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	3	1
No.4-40UNC	GH2	TUUN4H2NEBA	1.5P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	3	1
No.6-32UNC	GH1	TUUN6J1NEB5	5P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	3	1
No.6-32UNC	GH1	TUUN6J1NEBA	1.5P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	3	1
No.6-32UNC	GH2	TUUN6J2NEB5	5P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	3	1
No.6-32UNC	GH2	TUUN6J2NEBA	1.5P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	3	1
No.8-32UNC	GH1	TUUN8J1NEB5	5P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	3	1
No.8-32UNC	GH1	TUUN8J1NEBA	1.5P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	3	1
No.8-32UNC	GH2	TUUN8J2NEB5	5P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	3	1
No.8-32UNC	GH2	TUUN8J2NEBA	1.5P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	3	1

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple inspection tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

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

ANSI

HT STI Hand Taps for Helical Coil Wire Screw Thread Inserts

	Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
① Spiral Fluted Taps (for blind hole)	No.10-24UNC	GH2	TUUNAM2NEB5	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
	No.10-24UNC	GH2	TUUNAM2NEBA	1.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
	No.10-24UNC	GH3	TUUNAM3NEB5	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
	No.10-24UNC	GH3	TUUNAM3NEBA	1.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
② Spiral Fluted Taps (for through hole)	No.10-32UNF	GH2	TUUNAJ2NEB5	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
	No.10-32UNF	GH2	TUUNAJ2NEBA	1.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
	No.10-32UNF	GH3	TUUNAJ3NEB5	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
	No.10-32UNF	GH3	TUUNAJ3NEBA	1.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
③ Spiral Pointed Taps (for through hole)	1/4-20UNC	GH2	TUU04N2NEB5	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
	1/4-20UNC	GH2	TUU04N2NEBA	1.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
	1/4-20UNC	GH3	TUU04N3NEB5	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
	1/4-20UNC	GH3	TUU04N3NEBA	1.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
④ Hand Taps	1/4-28UNF	GH2	TUU04K2NEB5	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
	1/4-28UNF	GH2	TUU04K2NEBA	1.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
	1/4-28UNF	GH3	TUU04K3NEB5	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
	1/4-28UNF	GH3	TUU04K3NEBA	1.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
⑤ Cemented Carbide Taps	5/16-18UNC	GH2	TUU05O2NEB5	5P	3.937	0.906	1.535	2.067	0.381	0.286	0.437	4	2
	5/16-18UNC	GH2	TUU05O2NEBA	1.5P	3.937	0.906	1.535	2.067	0.381	0.286	0.437	4	2
	5/16-18UNC	GH3	TUU05O3NEB5	5P	3.937	0.906	1.535	2.067	0.381	0.286	0.437	4	2
	5/16-18UNC	GH3	TUU05O3NEBA	1.5P	3.937	0.906	1.535	2.067	0.381	0.286	0.437	4	2
⑥ Roll Taps	5/16-24UNF	GH2	TUU05M2NEB5	5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	4	2
	5/16-24UNF	GH2	TUU05M2NEBA	1.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	4	2
	5/16-24UNF	GH3	TUU05M3NEB5	5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	4	2
	5/16-24UNF	GH3	TUU05M3NEBA	1.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	4	2
⑦ Special Thread Taps Simple Inspection Tools	3/8-16UNC	GH3	TUU06P3NEB5	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	4	3
	3/8-16UNC	GH3	TUU06P3NEBA	1.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	4	3
	3/8-16UNC	GH4	TUU06P4NEB5	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	4	3
	3/8-16UNC	GH4	TUU06P4NEBA	1.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	4	3
⑧ Pipe Taps	3/8-24UNF	GH2	TUU06M2NEB5	5P	3.937	0.906	-	2.008	0.323	0.242	0.406	4	3
	3/8-24UNF	GH2	TUU06M2NEBA	1.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	4	3
	3/8-24UNF	GH3	TUU06M3NEB5	5P	3.937	0.906	-	2.008	0.323	0.242	0.406	4	3
	3/8-24UNF	GH3	TUU06M3NEBA	1.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	4	3
⑨ Thread Mills Premium Thread Mills	7/16-14UNC	GH3	TUU07Q3NEB5	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
	7/16-14UNC	GH3	TUU07Q3NEBA	1.5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
	7/16-14UNC	GH4	TUU07Q4NEB5	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
	7/16-14UNC	GH4	TUU07Q4NEBA	1.5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
⑩ Dies	7/16-20UNF	GH3	TUU07N3NEB5	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
	7/16-20UNF	GH3	TUU07N3NEBA	1.5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
	7/16-20UNF	GH4	TUU07N4NEB5	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
	7/16-20UNF	GH4	TUU07N4NEBA	1.5P	4.331	1.024	-	2.205	0.429	0.322	0.5	4	3
⑪ Center Drills Centering Tools	1/2-13UNC	GH3	TUU08R3NEB5	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3
	1/2-13UNC	GH3	TUU08R3NEBA	1.5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3
	1/2-13UNC	GH4	TUU08R4NEB5	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3
	1/2-13UNC	GH4	TUU08R4NEBA	1.5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3
⑫ Precision Machinery/ Medical Surgical Instruments	1/2-20UNF	GH3	TUU08N3NEB5	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3
	1/2-20UNF	GH3	TUU08N3NEBA	1.5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3
	1/2-20UNF	GH4	TUU08N4NEB5	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3
	1/2-20UNF	GH4	TUU08N4NEBA	1.5P	4.331	1.024	-	2.205	0.48	0.36	0.562	4	3

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

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

ANSI

SP STI



Spiral Fluted Taps for Helical Coil Wire Screw Thread Inserts

Specification

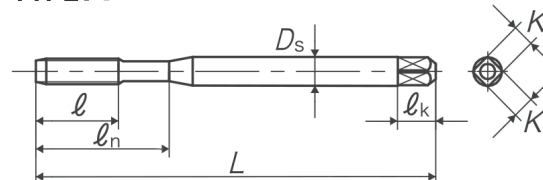


■ Spiral pointed tap to cut internal threads for helical coil to enter.

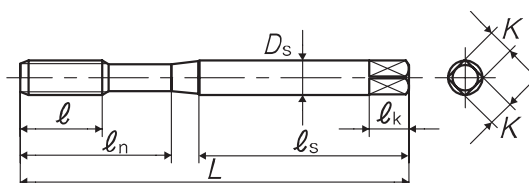
Tapping Speed depending on Materials

Brass 黄銅	Brass castings 黄銅鑄物	Bronze 青銅	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鑄物	Magnesium alloy die castings マグネシウム合金鑄物	Zinc alloy castings 亜鉛合金鑄物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

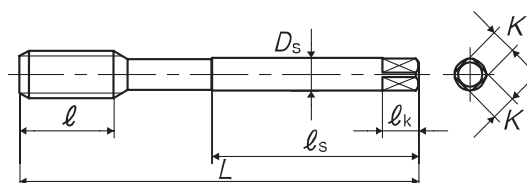
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1C

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	ℓ_s (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Unified Threads												
No.2-56UNC	GH1	SUUN2E1NEB	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	2	1
No.2-56UNC	GH2	SUUN2E2NEB	2P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	2	1
No.4-40UNC	GH1	SUUN4H1NEB	2P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	2	1
No.4-40UNC	GH2	SUUN4H2NEB	2P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	2	1
No.6-32UNC	GH1	SUUN6J1NEB	2P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	3	1
No.6-32UNC	GH2	SUUN6J2NEB	2P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	3	1
No.8-32UNC	GH1	SUUN8J1NEB	2P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	3	1
No.8-32UNC	GH2	SUUN8J2NEB	2P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	3	1
No.10-24UNC	GH2	SUUNAM2NEB	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
No.10-24UNC	GH3	SUUNAM3NEB	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
No.10-32UNF	GH2	SUUNAJ2NEB	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
No.10-32UNF	GH3	SUUNAJ3NEB	2P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	1
1/4-20UNC	GH2	SUU04N2NEB	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
1/4-20UNC	GH3	SUU04N3NEB	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
1/4-28UNF	GH2	SUU04K2NEB	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple inspection tools ⑦

Pipe Taps ⑧

Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

Precision Machinery/
Medical Surgical Instruments ⑫

ANSI

⑦-12

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

ANSI

SP STI Spiral Fluted Taps for Helical Coil Wire Screw Thread Inserts

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
1/4-28UNF	GH3	SUU04K3NEB	2P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	2
5/16-18UNC	GH2	SUU05O2NEB	2P	3.937	0.906	1.535	2.067	0.381	0.286	0.437	3	2
5/16-18UNC	GH3	SUU05O3NEB	2P	3.937	0.906	1.535	2.067	0.381	0.286	0.437	3	2
5/16-24UNF	GH2	SUU05M2NEB	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	2
5/16-24UNF	GH3	SUU05M3NEB	2P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	2
3/8-16UNC	GH2	SUU06P2NEB	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	3
3/8-16UNC	GH3	SUU06P3NEB	2P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	3
3/8-24UNF	GH2	SUU06M2NEB	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	3
3/8-24UNF	GH3	SUU06M3NEB	2P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	3
7/16-14UNC	GH2	SUU07Q2NEB	2P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	3
7/16-14UNC	GH3	SUU07Q3NEB	2P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	3
7/16-20UNF	GH2	SUU07N2NEB	2P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	3
7/16-20UNF	GH3	SUU07N3NEB	2P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	3
1/2-13UNC	GH2	SUU08R2NEB	2P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	3
1/2-13UNC	GH3	SUU08R3NEB	2P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	3
1/2-20UNF	GH2	SUU08N2NEB	2P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	3
1/2-20UNF	GH3	SUU08N3NEB	2P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	3

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

ANSI

⑦-13

Think threads with
YAMAWA

AL 27 of 32

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

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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

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Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

ANSI

⑦-19



PO STI

Spiral Pointed Taps for Helical Coil Wire Screw Thread Inserts



Specification

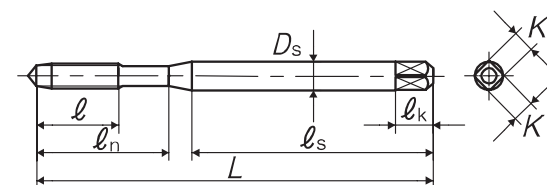


■ Spiral pointed tap to cut internal threads for helical coil to enter.

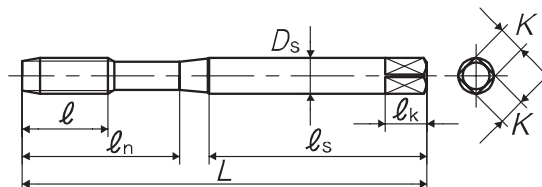
Tapping Speed depending on Materials

Brass 黄銅	Brass castings 黄銅鑄物	Bronze 青銅	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鑄物	Magnesium alloy die castings マグネシウム合金鑄物	Zinc alloy castings 亜鉛合金鑄物
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)

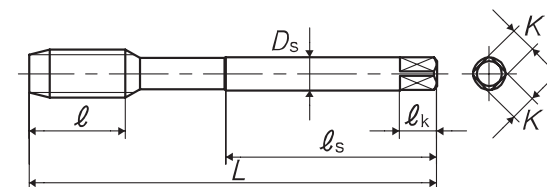
TYPE:1



TYPE:2



TYPE:3



Segment : 1E

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	ℓ_s (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Unified Threads												
No.2-56UNC	GH1	PUUN2E1NEB	5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	2	1
No.2-56UNC	GH2	PUUN2E2NEB	5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	2	1
No.4-40UNC	GH1	PUUN4H1NEB	5P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	2	1
No.4-40UNC	GH2	PUUN4H2NEB	5P	2.48	0.512	0.827	1.496	0.168	0.131	0.25	2	1
No.6-32UNC	GH1	PUUN6J1NEB	5P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	2	1
No.6-32UNC	GH2	PUUN6J2NEB	5P	2.756	0.551	0.945	1.654	0.194	0.131	0.25	2	1
No.8-32UNC	GH1	PUUN8J1NEB	5P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	2	1
No.8-32UNC	GH2	PUUN8J2NEB	5P	3.15	0.591	0.984	1.929	0.22	0.165	0.281	2	1
No.10-24UNC	GH2	PUUNAM2NEB	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	2	1
No.10-24UNC	GH3	PUUNAM3NEB	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	2	1
No.10-32UNF	GH2	PUUNAJ2NEB	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	2	1
No.10-32UNF	GH3	PUUNAJ3NEB	5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	2	1
1/4-20UNC	GH2	PUU04N2NEB	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	2	2
1/4-20UNC	GH3	PUU04N3NEB	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	2	2
1/4-28UNF	GH2	PUU04K2NEB	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	2	2
1/4-28UNF	GH3	PUU04K3NEB	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	2	2

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L	ℓ	ℓn	ℓs	Ds	K	ℓk

7

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Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
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5/16-18UNC	GH3	PUU05O3NEB	5P	3.937	0.906	1.535	2.067	0.381	0.286	0.437	2	2
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Spiral Fluted Taps
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⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

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⑦-20

AL 29 of 32
• This product is different from the product shown in the picture and dimensions, please be careful when using.

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