

4 Hand 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	Ds	K	ℓ_k

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

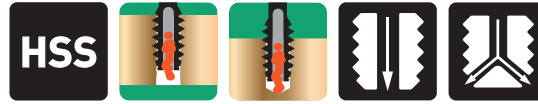
JIS

MC-HT

Hand Taps with Internal Coolant Hole



Specification

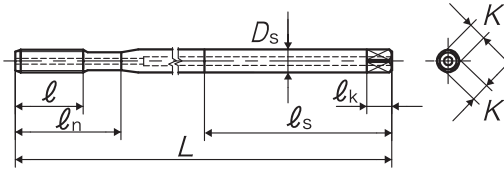


■ Through internal coolant hole, satisfactory amount of oil is supplied to the exact cutting area. MC-HT hand tap ensures a long tool life and internal threads with good surface finish.

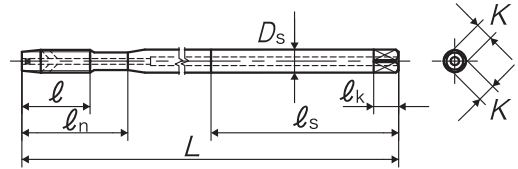
Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

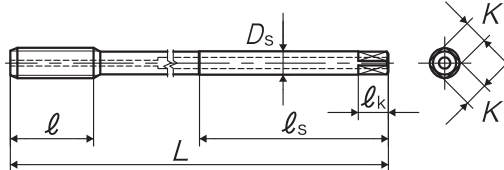
TYPE: 1



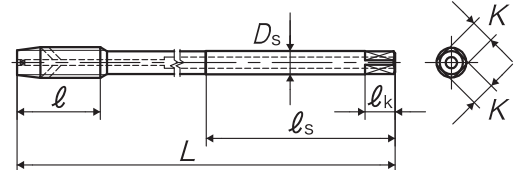
TYPE: 2



TYPE: 3



TYPE: 4



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M6 × 1	P2	ML106.0M5-Q	5P	100	19	30	40	6	4.5	7	4	2	¥ 3,000 ※▲
M6 × 1	P2	ML156.0M5-Q	5P	150	19	30	40	6	4.5	7	4	2	¥ 5,120 ※▲
M6 × 1	P2	ML106.0M1-Q	1.5P	100	19	30	40	6	4.5	7	4	1	¥ 3,000 ※▲
M6 × 1	P2	ML156.0M1-Q	1.5P	150	19	30	40	6	4.5	7	4	1	¥ 5,120 ※▲
M8 × 1.25	P2	ML108.0N5-Q	5P	100	22	-	50	6.2	5	8	4	4	¥ 3,880 ※▲
M8 × 1.25	P2	ML158.0N5-Q	5P	150	22	-	50	6.2	5	8	4	4	¥ 6,400 ※▲
M8 × 1.25	P2	ML108.0N1-Q	1.5P	100	22	-	50	6.2	5	8	4	3	¥ 3,880 ※▲
M8 × 1.25	P2	ML158.0N1-Q	1.5P	150	22	-	50	6.2	5	8	4	3	¥ 6,400 ※▲
M10 × 1.5	P2	ML10010O5-Q	5P	100	24	-	50	7	5.5	8	4	4	¥ 4,720 ※▲
M10 × 1.5	P2	ML15010O5-Q	5P	150	24	-	50	7	5.5	8	4	4	¥ 7,470 ※▲
M10 × 1.5	P2	ML10010O1-Q	1.5P	100	24	-	50	7	5.5	8	4	3	¥ 4,720 ※▲
M10 × 1.5	P2	ML15010O1-Q	1.5P	150	24	-	50	7	5.5	8	4	3	¥ 7,470 ※▲
M10 × 1.25	P2	ML10010N5-Q	5P	100	20	-	50	7	5.5	8	4	4	¥ 4,720 ※▲
M10 × 1.25	P2	ML15010N5-Q	5P	150	20	-	50	7	5.5	8	4	4	¥ 7,470 ※▲
M10 × 1.25	P2	ML10010N1-Q	1.5P	100	20	-	50	7	5.5	8	4	3	¥ 4,720 ※▲
M10 × 1.25	P2	ML15010N1-Q	1.5P	150	20	-	50	7	5.5	8	4	3	¥ 7,470 ※▲
M12 × 1.75	P2	ML10012P5-Q	5P	100	29	-	50	8.5	6.5	9	4	4	¥ 5,790 ※▲
M12 × 1.75	P2	ML15012P5-Q	5P	150	29	-	50	8.5	6.5	9	4	4	¥ 9,340 ※▲
M12 × 1.75	P2	ML20012P5-Q	5P	200	29	-	50	8.5	6.5	9	4	4	¥ 12,600 ※▲

Remarks: Products marked with ▲ in the MSRP column are available while supplies last.



※ = Specified Distribution Items. Made to order products.

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 (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M12 × 1.75	P2	ML10012P1-Q	1.5P	100	29	-	50	8.5	6.5	9	4	3	¥ 5,790 ^{※▲}
M12 × 1.75	P2	ML15012P1-Q	1.5P	150	29	-	50	8.5	6.5	9	4	3	¥ 9,340 ^{※▲}
M12 × 1.75	P2	ML20012P1-Q	1.5P	200	29	-	50	8.5	6.5	9	4	3	¥ 12,600 ^{※▲}
M12 × 1.5	P2	ML10012O5-Q	5P	100	29	-	50	8.5	6.5	9	4	4	¥ 5,790 ^{※▲}
M12 × 1.5	P2	ML15012O5-Q	5P	150	29	-	50	8.5	6.5	9	4	4	¥ 9,340 ^{※▲}
M12 × 1.5	P2	ML20012O5-Q	5P	200	29	-	50	8.5	6.5	9	4	4	¥ 12,600 ^{※▲}
M12 × 1.5	P2	ML10012O1-Q	1.5P	100	29	-	50	8.5	6.5	9	4	3	¥ 5,790 ^{※▲}
M12 × 1.5	P2	ML15012O1-Q	1.5P	150	29	-	50	8.5	6.5	9	4	3	¥ 9,340 ^{※▲}
M12 × 1.5	P2	ML20012O1-Q	1.5P	200	29	-	50	8.5	6.5	9	4	3	¥ 12,600 ^{※▲}
M12 × 1.25	P2	ML10012N5-Q	5P	100	24	-	50	8.5	6.5	9	4	4	¥ 5,790 ^{※▲}
M12 × 1.25	P2	ML15012N5-Q	5P	150	24	-	50	8.5	6.5	9	4	4	¥ 9,340 ^{※▲}
M12 × 1.25	P2	ML20012N5-Q	5P	200	24	-	50	8.5	6.5	9	4	4	¥ 12,600 ^{※▲}
M12 × 1.25	P2	ML10012N1-Q	1.5P	100	24	-	50	8.5	6.5	9	4	3	¥ 5,790 ^{※▲}
M12 × 1.25	P2	ML15012N1-Q	1.5P	150	24	-	50	8.5	6.5	9	4	3	¥ 9,340 ^{※▲}
M12 × 1.25	P2	ML20012N1-Q	1.5P	200	24	-	50	8.5	6.5	9	4	3	¥ 12,600 ^{※▲}
M14 × 2	P2	ML15014Q5-Q	5P	150	30	-	60	10.5	8	11	4	4	¥ 11,900 ^{※▲}
M14 × 2	P2	ML20014Q5-Q	5P	200	30	-	60	10.5	8	11	4	4	¥ 15,300 ^{※▲}
M14 × 2	P2	ML15014Q1-Q	1.5P	150	30	-	60	10.5	8	11	4	3	¥ 11,900 ^{※▲}
M14 × 2	P2	ML20014Q1-Q	1.5P	200	30	-	60	10.5	8	11	4	3	¥ 15,300 ^{※▲}
M14 × 1.5	P2	ML15014O5-Q	5P	150	30	-	60	10.5	8	11	4	4	¥ 11,900 ^{※▲}
M14 × 1.5	P2	ML20014O5-Q	5P	200	30	-	60	10.5	8	11	4	4	¥ 15,300 ^{※▲}
M14 × 1.5	P2	ML15014O1-Q	1.5P	150	30	-	60	10.5	8	11	4	3	¥ 11,900 ^{※▲}
M14 × 1.5	P2	ML20014O1-Q	1.5P	200	30	-	60	10.5	8	11	4	3	¥ 15,300 ^{※▲}
M16 × 2	P2	ML15016Q5-Q	5P	150	32	-	60	12.5	10	13	4	4	¥ 12,900 ^{※▲}
M16 × 2	P2	ML20016Q5-Q	5P	200	32	-	60	12.5	10	13	4	4	¥ 15,900 ^{※▲}
M16 × 2	P2	ML15016Q1-Q	1.5P	150	32	-	60	12.5	10	13	4	3	¥ 12,900 ^{※▲}
M16 × 2	P2	ML20016Q1-Q	1.5P	200	32	-	60	12.5	10	13	4	3	¥ 15,900 ^{※▲}
M16 × 1.5	P2	ML15016O5-Q	5P	150	32	-	60	12.5	10	13	4	4	¥ 12,900 ^{※▲}
M16 × 1.5	P2	ML20016O5-Q	5P	200	32	-	60	12.5	10	13	4	4	¥ 15,900 ^{※▲}
M16 × 1.5	P2	ML15016O1-Q	1.5P	150	32	-	60	12.5	10	13	4	3	¥ 12,900 ^{※▲}
M16 × 1.5	P2	ML20016O1-Q	1.5P	200	32	-	60	12.5	10	13	4	3	¥ 15,900 ^{※▲}
M18 × 2.5	P3	ML15018R5-R	5P	150	37	-	70	14	11	14	4	4	¥ 14,800 ^{※▲}
M18 × 2.5	P3	ML20018R5-R	5P	200	37	-	70	14	11	14	4	4	¥ 19,400 ^{※▲}
M18 × 2.5	P3	ML15018R1-R	1.5P	150	37	-	70	14	11	14	4	3	¥ 14,800 ^{※▲}
M18 × 2.5	P3	ML20018R1-R	1.5P	200	37	-	70	14	11	14	4	3	¥ 19,400 ^{※▲}
M18 × 1.5	P2	ML15018O5-Q	5P	150	29	-	70	14	11	14	4	4	¥ 14,800 ^{※▲}
M18 × 1.5	P2	ML20018O5-Q	5P	200	29	-	70	14	11	14	4	4	¥ 19,400 ^{※▲}
M18 × 1.5	P2	ML15018O1-Q	1.5P	150	29	-	70	14	11	14	4	3	¥ 14,800 ^{※▲}
M18 × 1.5	P2	ML20018O1-Q	1.5P	200	29	-	70	14	11	14	4	3	¥ 19,400 ^{※▲}
M20 × 2.5	P3	ML15020R5-R	5P	150	37	-	70	15	12	15	4	4	¥ 19,000 ^{※▲}
M20 × 2.5	P3	ML20020R5-R	5P	200	37	-	70	15	12	15	4	4	¥ 24,900 ^{※▲}
M20 × 2.5	P3	ML15020R1-R	1.5P	150	37	-	70	15	12	15	4	3	¥ 19,000 ^{※▲}
M20 × 2.5	P3	ML20020R1-R	1.5P	200	37	-	70	15	12	15	4	3	¥ 24,900 ^{※▲}
M20 × 1.5	P3	ML15020O5-R	5P	150	29	-	70	15	12	15	4	4	¥ 19,000 ^{※▲}
M20 × 1.5	P3	ML20020O5-R	5P	200	29	-	70	15	12	15	4	4	¥ 24,900 ^{※▲}
M20 × 1.5	P3	ML15020O1-R	1.5P	150	29	-	70	15	12	15	4	3	¥ 19,000 ^{※▲}
M20 × 1.5	P3	ML20020O1-R	1.5P	200	29	-	70	15	12	15	4	3	¥ 24,900 ^{※▲}
M22 × 2.5	P3	ML15022R5-R	5P	150	38	-	70	17	13	16	4	4	¥ 21,300 ^{※▲}
M22 × 2.5	P3	ML20022R5-R	5P	200	38	-	70	17	13	16	4	4	¥ 27,700 ^{※▲}
M22 × 2.5	P3	ML15022R1-R	1.5P	150	38	-	70	17	13	16	4	3	¥ 21,300 ^{※▲}

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Think threads with
YAMAWA

4

JIS

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

JIS

④-142

④ Hand 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

JIS

MC-HT Hand Taps with Internal Coolant Hole

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M22 × 2.5	P3	ML20022R1-R	1.5P	200	38	-	70	17	13	16	4	3	¥ 27,700 ※▲
M22 × 1.5	P3	ML15022O5-R	5P	150	33	-	70	17	13	16	4	4	¥ 21,300 ※▲
M22 × 1.5	P3	ML20022O5-R	5P	200	33	-	70	17	13	16	4	4	¥ 27,700 ※▲
M22 × 1.5	P3	ML15022O1-R	1.5P	150	33	-	70	17	13	16	4	3	¥ 21,300 ※▲
M22 × 1.5	P3	ML20022O1-R	1.5P	200	33	-	70	17	13	16	4	3	¥ 27,700 ※▲
M24 × 3	P3	ML15024S5-R	5P	150	45	-	80	19	15	18	4	4	¥ 24,900 ※▲
M24 × 3	P3	ML20024S5-R	5P	200	45	-	80	19	15	18	4	4	¥ 31,100 ※▲
M24 × 3	P3	ML15024S1-R	1.5P	150	45	-	80	19	15	18	4	3	¥ 24,900 ※▲
M24 × 3	P3	ML20024S1-R	1.5P	200	45	-	80	19	15	18	4	3	¥ 31,100 ※▲
M24 × 1.5	P3	ML15024O5-R	5P	150	35	-	80	19	15	18	4	4	¥ 24,900 ※▲
M24 × 1.5	P3	ML20024O5-R	5P	200	35	-	80	19	15	18	4	4	¥ 31,100 ※▲
M24 × 1.5	P3	ML15024O1-R	1.5P	150	35	-	80	19	15	18	4	3	¥ 24,900 ※▲
M24 × 1.5	P3	ML20024O1-R	1.5P	200	35	-	80	19	15	18	4	3	¥ 31,100 ※▲
M27 × 3	P3	ML20027S5-R	5P	200	45	-	80	20	15	18	4	4	¥ 35,000 ※▲
M27 × 3	P3	ML25027S5-R	5P	250	45	-	80	20	15	18	4	4	¥ 47,100 ※▲
M27 × 3	P3	ML20027S1-R	1.5P	200	45	-	80	20	15	18	4	3	¥ 35,000 ※▲
M27 × 3	P3	ML25027S1-R	1.5P	250	45	-	80	20	15	18	4	3	¥ 47,100 ※▲
M27 × 1.5	P3	ML20027O5-R	5P	200	37	-	80	20	15	18	4	4	¥ 35,000 ※▲
M27 × 1.5	P3	ML25027O5-R	5P	250	37	-	80	20	15	18	4	4	¥ 47,100 ※▲
M27 × 1.5	P3	ML20027O1-R	1.5P	200	37	-	80	20	15	18	4	3	¥ 35,000 ※▲
M27 × 1.5	P3	ML25027O1-R	1.5P	250	37	-	80	20	15	18	4	3	¥ 47,100 ※▲
M30 × 3.5	P4	ML20030T5-S	5P	200	48	-	80	23	17	20	4	4	¥ 45,000 ※▲
M30 × 3.5	P4	ML25030T5-S	5P	250	48	-	80	23	17	20	4	4	¥ 59,600 ※▲
M30 × 3.5	P4	ML20030T1-S	1.5P	200	48	-	80	23	17	20	4	3	¥ 45,000 ※▲
M30 × 3.5	P4	ML25030T1-S	1.5P	250	48	-	80	23	17	20	4	3	¥ 59,600 ※▲
M30 × 1.5	P3	ML20030O5-R	5P	200	37	-	80	23	17	20	4	4	¥ 45,000 ※▲
M30 × 1.5	P3	ML25030O5-R	5P	250	37	-	80	23	17	20	4	4	¥ 59,600 ※▲
M30 × 1.5	P3	ML20030O1-R	1.5P	200	37	-	80	23	17	20	4	3	¥ 45,000 ※▲
M30 × 1.5	P3	ML25030O1-R	1.5P	250	37	-	80	23	17	20	4	3	¥ 59,600 ※▲

Remarks: Products marked with ▲ in the MSRP column are available while supplies last.

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(for blind hole)

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(for through hole)

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Centering Tools

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JIS