

Outside diameter	Thickness
D	T

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 Tools

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



# N-RSD

New Rolling Dies

## Specification



## Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼	Brass 黄銅
3~6 (m/min)	3~6 (m/min)	3~6 (m/min)	3~6 (m/min)

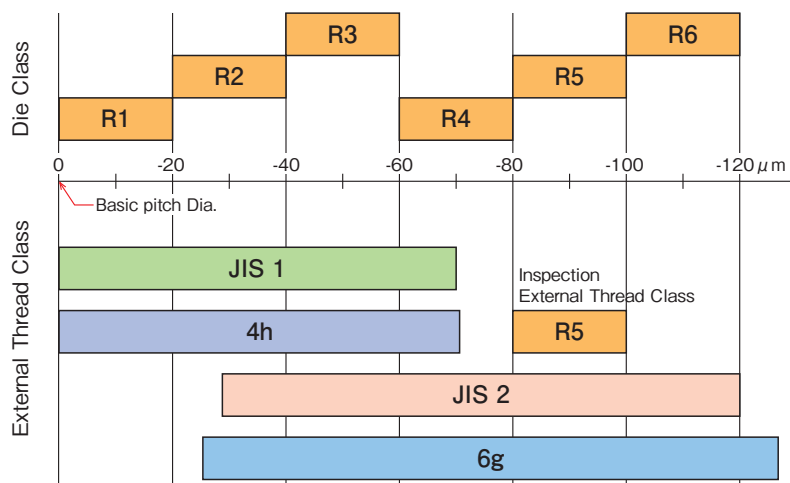


## Product Features

- The new N-RSD rolling dies are capable of producing high precision screw threads through material deformation while producing an excellent surface finish without creating chips.
- The N-RSD has made major improvements in thread rolling efficiency starting with sizes  $P=0.5$  and offers a dramatic improvement in tool life that could not be resolved with conventional rolling dies.
- The lower forming load on the dies chamfer at the starting point is greatly reduced compared to conventional products, achieving longer tool life.
- Ideal for small quantity thread rolling on various kinds of screw threads. Ideal for small diameter and long threads that are difficult to handle with thread rollers.
- YAMAWA recommends using automatic machines and lathes, which allow machining with workpiece rotation, with the N-RSD thread rolling dies.

## Pitch diameter tolerance class comparison chart of die class (R class) and an external thread class.

Comparative example with M6×1



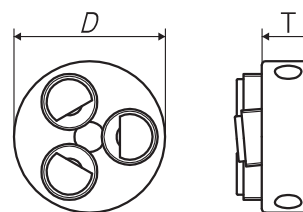
- Die class: Class R is the pitch diameter tolerance zone for inspection of external threads machined with rolling dies.
- External thread surface finish accuracy may differ slightly from inspection external thread specification depending on the type of workpiece and processing conditions.

Outside diameter	Thickness
D	T

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TYPE: 1



Segment : 34

Size	Class	Code	D (mm)	T (mm)	TYPE	MSRP
For Metric Threads						
M3 × 0.5	R4	NRGS3.0G	25	9	1	¥ 27,900 ※
M4 × 0.7	R4	NRGS4.0I	25	9	1	¥ 31,300 ※
M5 × 0.8	R5	NRGT5.0K	25	9	1	¥ 32,900 ※
M6 × 1	R5	NRHT6.0M	30	11	1	¥ 34,600 ※
M6 × 1	R5	NRJT6.0M	38	13	1	¥ 56,000 ※
M8 × 1.25	R6	NRJU8.0N	38	13	1	¥ 56,000 ※

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Thread Mills  
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⑨

Dies

⑩

Center Drills  
Centering Tools

⑪

Precision Machinery/  
Metal Surgical Instruments

⑫

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※ = Specified Distribution Items. Made to order products.

 Think threads with  
**YAMAWA**