

IHT

Hand Taps for General Purpose Specification



Recommended Tapping Speeds depending on Materials

Low carbon steels
~5
(m/min)

For icon explanation, refer to P.50

Product features

- IHT is for hand tapping and for re-threading, and is used for both through hole and blind hole.
- Use for threading of the iron (SPC or SS400) products used in our daily life.
- Surface treated. Oxidation, the most suitable surface treatment for iron products.
- Suitable for internal thread cutting in small quantity, such as tapping of test pieces.
- The 5 thread chamfer is recommended for through holes and 2 thread chamfer is recommended for blind holes.



Through hole = 5 thread type



Blind hole = 2 thread type



How to use IHT

- Start tapping after boring holes corresponding to the thread size by using drills (note: For drill sizes, refer to drill sizes shown in the bored hole size table.)
- On Hand Tapping, operate tapping in an upright position parallel to bored holes by using tap wrenches.
- During tapping, please use tapping oil.



When hand tapping, always use tap wrench



Machine tapping with drilling machine

Table for bored and drilled hole sizes

unit: mm

Size	Minor diameter of internal thread size			Drill size	Thread engagement
	Minimum tolerance	Maximum tolerance			
		6H (2nd class)	7H (3rd class)		
M3 × 0.5	2.459	2.599	2.639	2.6 (2.5)	74% (92%)
M4 × 0.7	3.242	3.422	3.466	3.4 (3.3)	79% (92%)
M5 × 0.8	4.134	4.344	4.384	4.3 (4.2)	81% (92%)
M6 × 1	4.917	5.153	5.217	5.1 (5.0)	83% (92%)
M8 × 1.25	6.647	6.912	6.982	6.9 (6.8)	91% (89%)
M10 × 1.5	8.376	8.676	8.751	8.6 (8.5)	86% (92%)

note1) Recommended drill sizes shown in this table are for internal threads of 7H class (3rd class), and are selected from the standard drills available in the market.

note2) Drill sizes shown in brackets in this table are for such case as the drilling has oversize cutting tendency or for internal threads of 6H class (2nd class).

[Related products]

Shank adjuster

- For deep hole tappings, please use shank adjusters.
- There is only a one touch motion required to detach and attach the I series taps (IHT/ISP/IPO) from or to the shank adjuster.

*For details of shank adjuster, refer to P.545



Obtainable from Video site shown in right

Blister Pack



Detailed explanation about tapping

Straight Fluted Taps
Material: HSS
M10 × 1.5 UNC Chamfer: SP
(ANSI Dimension)
Tap drill size: 8.5mm (ref.)

A suitable surface oxide treatment is applied for soft steel.

[REMARKS]
● THIS TAP IS NOT RECOMMENDED FOR HARD TO MACHINE MATERIALS LIKE HARDENED STEELS OR STAINLESS STEELS.
● HSS TAPS MAY SPATTER DURING USE. APPLY MACHINE COVERS AND WEAR SAFETY GLASSES WHEN USING TAPS FOR CUTTING THREADS.
WHEN SETTING TOOLS AND WORKPIECES, SECURE TIGHTLY TO AVOID VIBRATION AND RINDOUT.
DO NOT USE EXCESSIVE FORCE OR LOAD AS IT MAY CAUSE THE TAP BREAK.
YAMAWA MFG. Co., Ltd.
WEBSITE URL:
<http://www.yamawa.com/en/>



Spiral Fluted Taps (for blind hole)

Spiral Fluted Taps (for through hole)

Spiral Pointed Taps (for through hole)

Hand Taps

Cemented Carbide Taps

Roll Taps

Special Thread Taps Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools