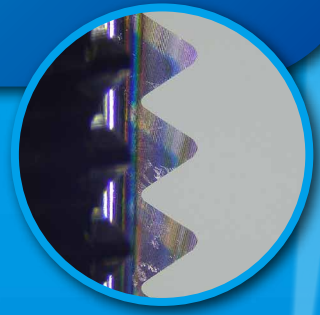


# High Performance Solid Carbide Taps



## TKS Series

P	M	K	N	S	H
○		●	●		



- Spiral Fluted Taps.
- High rigidity prevents tool breakage.
- For cast iron, brass casting, aluminum casting and steel.

## TKT Series

P	M	K	N	S	H
		●	●		



- Straight Fluted Taps.
- Strong cutting edges.
- For cast iron, brass casting, and aluminum casting.

## THT Series

P	M	K	N	S	H
					●



- Straight Fluted Taps.
- Strong cutting edges.
- For hardened steel (HRC 40 ~ 55).

## TNF Series

P	M	K	N	S	H
			●		



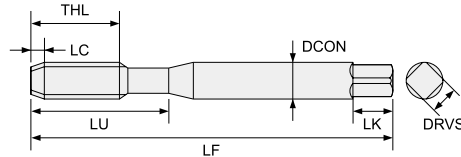
- Forming Taps.
- Do not produce chips.
- For aluminum alloy and copper.

## TKS - Spiral Fluted Taps

P	M	K	N	S	H
○	□	●	●	□	□

### Specification

- Thread type : ISO M
- For cast iron, brass casting, aluminum casting and steel.
- Recommend for through hole.
- New ANAX Smooth Coating
- Vc = 5~15 m/min



### JIS

Unit:mm

Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKSNM306010031A	M6×1.00		19	29	70	6	7	4.5	3	OH3	5.0
TKSNM308012531A	M8×1.25		22	-	75	6.2	8	5	3		6.75
TKSNM310012531A	M10×1.25	2~3P	24	-	75	7	8	5.5	3		8.5
TKSNM310012631A	M10×1.50		24	-	75	7	8	5.5	3	OH4	8.5
TKSNM312012531A	M12×1.25		29	-	95	8.5	9	6.5	3		10.25
TKSNM312017531A	M12×1.75		29	-	95	8.5	9	6.5	3		10.25

### DIN 371

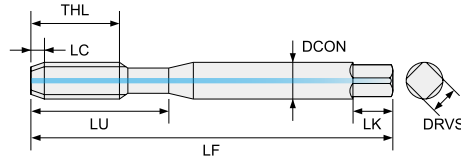
Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKSNM305008033A	M5×0.80		16	24	70	6	8	4.9	3		4.2
TKSNM306010033A	M6×1.00	Form C (2~3P)	19	29	70	6	8	4.9	3	6HX	5.0
TKSNM308012533A	M8×1.25		22	32	75	8	9	6.2	3		6.75
TKSNM310015033A	M10×1.50		24	40	75	10	11	8	3		8.5

## TKS - Spiral Fluted Taps with Internal Coolant

P	M	K	N	S	H
○	□	●	●	□	□

### Specification

- Thread type : ISO M
- For cast iron, brass casting, aluminum casting and steel.
- Recommend for blind hole.
- New ANAX Smooth Coating
- Vc = 10~50 m/min



### JIS

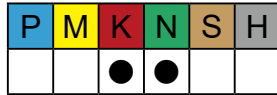
Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKSCM306010031A	M6×1.00		19	29	70	6	7	4.5	3	OH3	5.0
TKSCM308012531A	M8×1.25		22	-	75	6.2	8	5	3		6.75
TKSCM310012531A	M10×1.25	2~3P	24	-	75	7	8	5.5	3		8.5
TKSCM310012631A	M10×1.50		24	-	75	7	8	5.5	3	OH4	8.5
TKSCM312012531A	M12×1.25		29	-	95	8.5	9	6.5	3		10.25
TKSCM312017531A	M12×1.75		29	-	95	8.5	9	6.5	3		10.25

Unit:mm

### DIN 371

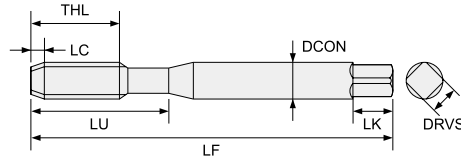
Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKSCM305008033A	M5×0.80		16	24	70	6	8	4.9	3		4.2
TKSCM306010033A	M6×1.00	Form C (2~3P)	19	29	70	6	8	4.9	3	6HX	5.0
TKSCM308012533A	M8×1.25		22	32	75	8	9	6.2	3		6.75
TKSCM310015033A	M10×1.50		24	40	75	10	11	8	3		8.5

## TKT - Straight Fluted Taps



### Specification

- Thread type : ISO M
- For cast iron, brass casting and aluminum casting.
- Recommend for through hole.
- New ANAX Smooth Coating
- Vc = 5~15 m/min



JIS

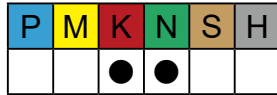
Unit:mm

Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKTNM403005031A	M3×0.50		11	19	65	4	6	3.2	4		2.5
TKTNM404007031A	M4×0.70		13	21	65	5	7	4	4		3.3
TKTNM405008031A	M5×0.80		16	24	70	5.5	7	4.5	4		4.2
TKTNM506010031A	M6×1.00		19	29	70	6	7	4.5	5		5.0
TKTNM508010031A	M8×1.00		22	-	75	6.2	8	5	5	OH3	7.0
TKTNM508012531A	M8×1.25	3P	22	-	75	6.2	8	5	5		6.75
TKTNM510010031A	M10×1.00		24	-	75	7	8	5.5	5		9.0
TKTNM510015031A	M10×1.50		24	-	75	7	8	5.5	5		8.5
TKTNM512015031A	M12×1.50		29	-	95	8.5	9	6.5	5		10.5
TKTNM512017531A	M12×1.75		29	-	95	8.5	9	6.5	5		10.25
TKTNM616020031A	M16×2.00		32	-	95	12.5	13	10	6	OH4	14

DIN 371

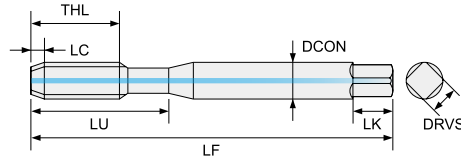
Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKTNM303005053A	M3×0.50		11	19	65	3.5	6	2.7	3		2.5
TKTNM404007053A	M4×0.70		13	21	65	4.5	6	3.4	4		3.3
TKTNM405008053A	M5×0.80		16	24	70	6	8	4.9	4		4.2
TKTNM406010053A	M6×1.00		19	29	70	6	8	4.9	4		5.0
TKTNM508010053A	M8×1.00		22	32	75	8	9	6.2	5		7.0
TKTNM508012553A	M8×1.25	Form D (3.5~5P)	22	32	75	8	9	6.2	5	6H	6.75
TKTNM510010053A	M10×1.00		24	40	75	10	11	8	5		9.0
TKTNM510015053A	M10×1.50		24	40	75	10	11	8	5		8.5
TKTNM512015053A	M12×1.50		29	48	85	12	12	9	5		10.5
TKTNM512017553A	M12×1.75		29	48	85	12	12	9	5		10.25
TKTNM516020053A	M16×2.00		32	64	95	16	15	12	5		14

## TKT - Straight Fluted Taps with Internal Coolant



### Specification

- Thread type : ISO M
- For cast iron, brass casting and aluminum casting.
- Recommend for blind hole.
- New ANAX Smooth Coating
- Vc = 10~50 m/min



JIS

Unit:mm

Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKTCM403005031A	M3×0.50		11	19	65	4	6	3.2	4		2.5
TKTCM404007031A	M4×0.70		13	21	65	5	7	4	4		3.3
TKTCM405008031A	M5×0.80		16	24	70	5.5	7	4.5	4		4.2
TKTCM506010031A	M6×1.00		19	29	70	6	7	4.5	5		5.0
TKTCM508010031A	M8×1.00		22	-	75	6.2	8	5	5	OH3	7.0
TKTCM508012531A	M8×1.25	3P	22	-	75	6.2	8	5	5		6.75
TKTCM510010031A	M10×1.00		24	-	75	7	8	5.5	5		9.0
TKTCM510015031A	M10×1.50		24	-	75	7	8	5.5	5		8.5
TKTCM512015031A	M12×1.50		29	-	95	8.5	9	6.5	5		10.5
TKTCM512017531A	M12×1.75		29	-	95	8.5	9	6.5	5		10.25
TKTCM616020031A	M16×2.00		32	-	95	12.5	13	10	6	OH4	14

DIN 371

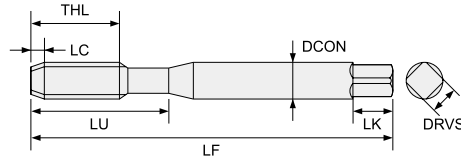
Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
TKTCM303005053A	M3×0.50		11	19	65	3.5	6	2.7	3		2.5
TKTCM404007053A	M4×0.70		13	21	65	4.5	6	3.4	4		3.3
TKTCM405008053A	M5×0.80		16	24	70	6	8	4.9	4		4.2
TKTCM406010053A	M6×1.00		19	29	70	6	8	4.9	4		5.0
TKTCM508010053A	M8×1.00		22	32	75	8	9	6.2	5		7.0
TKTCM508012553A	M8×1.25	Form D (3.5~5P)	22	32	75	8	9	6.2	5	6H	6.75
TKTCM510010053A	M10×1.00		24	40	75	10	11	8	5		9.0
TKTCM510015053A	M10×1.50		24	40	75	10	11	8	5		8.5
TKTCM512015053A	M12×1.50		29	48	85	12	12	9	5		10.5
TKTCM512017553A	M12×1.75		29	48	85	12	12	9	5		10.25
TKTCM516020053A	M16×2.00		32	64	95	16	15	12	5		14

## THT - Straight Fluted Taps



### Specification

- Thread type : ISO M
- For hardened steel (HRC 40 ~ 55)
- Suitable for through or blind hole.
- New ANAX Smooth Coating
- Vc = 2~4 m/min



JIS

Unit:mm

Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
THTNM403005031A	M3×0.50		11	19	65	4	6	3.2	4		2.5
THTNM404007031A	M4×0.70		13	21	65	5	7	4	4		3.3
THTNM405008031A	M5×0.80		16	24	70	5.5	7	4.5	4		4.2
THTNM506010031A	M6×1.00		19	29	70	6	7	4.5	5		5.0
THTNM508010031A	M8×1.00		22	-	75	6.2	8	5	5	OH3	7.0
THTNM508012531A	M8×1.25	3P	22	-	75	6.2	8	5	5		6.75
THTNM510010031A	M10×1.00		24	-	75	7	8	5.5	5		9.0
THTNM510015031A	M10×1.50		24	-	75	7	8	5.5	5		8.5
THTNM512015031A	M12×1.50		29	-	95	8.5	9	6.5	5		10.5
THTNM512017531A	M12×1.75		29	-	95	8.5	9	6.5	5		10.25
THTNM616020031A	M16×2.00		32	-	95	12.5	13	10	6	OH4	14

DIN 371

Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Flutes	TAP Limit	Drill Hole
THTNM303005053A	M3×0.50		11	19	65	3.5	6	2.7	3		2.5
THTNM404007053A	M4×0.70		13	21	65	4.5	6	3.4	4		3.3
THTNM405008053A	M5×0.80		16	24	70	6	8	4.9	4		4.2
THTNM406010053A	M6×1.00		19	29	70	6	8	4.9	4		5.0
THTNM508010053A	M8×1.00		22	32	75	8	9	6.2	5		7.0
THTNM508012553A	M8×1.25	Form D (3.5~5P)	22	32	75	8	9	6.2	5	6H	6.75
THTNM510010053A	M10×1.00		24	40	75	10	11	8	5		9.0
THTNM510015053A	M10×1.50		24	40	75	10	11	8	5		8.5
THTNM512015053A	M12×1.50		29	48	85	12	12	9	5		10.5
THTNM512017553A	M12×1.75		29	48	85	12	12	9	5		10.25
THTNM516020053A	M16×2.00		32	64	95	16	15	12	5		14

## TNF - Forming Taps

P	M	K	N	S	H
			●		

### Specification

- Thread type : ISO M
- Flute : 4
- For aluminum alloy and copper.
- Chamfer Length(LC) 4P for through holes, 2P for blind holes
- Vc = 15~30 m/min
- Suitable for through or blind hole.



Fig. 1

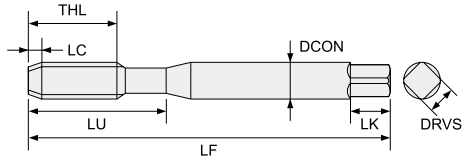
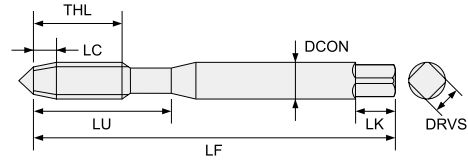


Fig. 2



Unit:mm

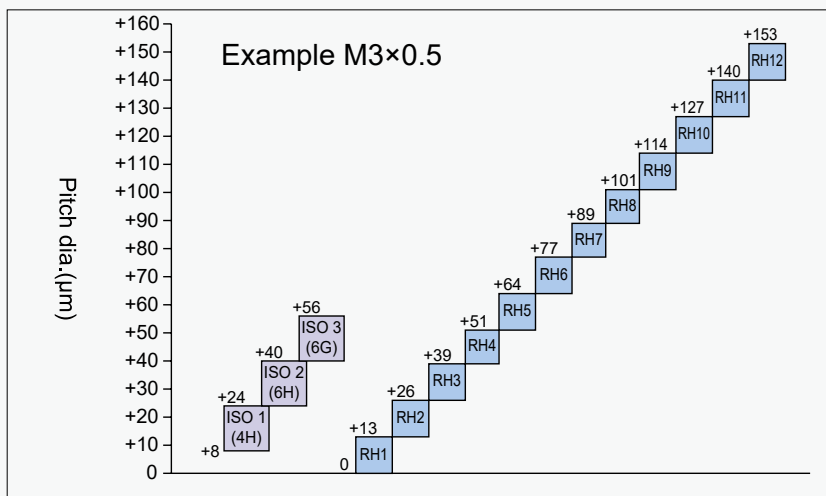
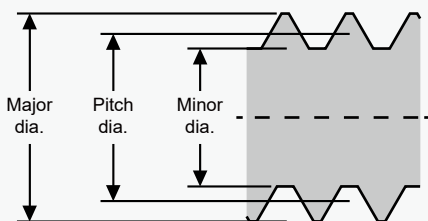
Order No.	Thread	LC	THL	LU	LF	DCON	LK	DRVS	Cutting Edges	Fig	TAP Limit	Drill Hole
TNFM401002541	M1×0.25	4P	6	-	50	3	5	2.5	4	2	RH4	0.92
TNFM401202541	M1.2×0.25	4P	6	-	50	3	5	2.5	4	2	RH4	1.12
TNFM401403041	M1.4×0.30	4P	6	-	50	3	5	2.5	4	2	RH4	1.29
TNFM402004021	M2×0.40	2P	8	-	50	3	5	2.5	4	1	RH4	1.85
TNFM402004041	M2×0.40	4P	8	-	50	3	5	2.5	4	2	RH4	1.85
TNFM403005021	M3×0.50	2P	11	19	50	4	6	3.2	4	1	RH5	2.8
TNFM403005041	M3×0.50	4P	11	19	50	4	6	3.2	4	2	RH5	2.8
TNFM404007021	M4×0.70	2P	13	21	50	5	7	4	4	1	RH6	3.7
TNFM404007041	M4×0.70	4P	13	21	50	5	7	4	4	2	RH6	3.7
TNFM405008021	M5×0.80	2P	16	24	60	6	7	4.5	4	1	RH7	4.65
TNFM405008041	M5×0.80	4P	16	24	60	6	7	4.5	4	2	RH7	4.65
TNFM406010021	M6×1.00	2P	19	29	60	6	7	4.5	4	1	RH7	5.55
TNFM406010041	M6×1.00	4P	19	29	60	6	7	4.5	4	2	RH7	5.55

Tap Limit

RH Limit

Upper limit :  $0.0127 \times n$   
 Lower limit :  $0.0127 \times n - 0.0127$

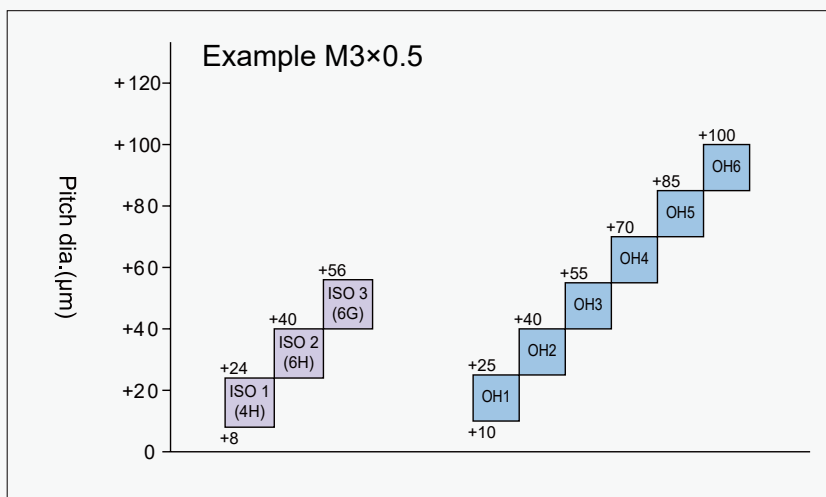
(n=RH number, Unit:mm)



OH Limit

Pitch  $\leq 0.6$   
 Upper limit :  $0.010+0.015 \times n$   
 Lower limit : (upper limit)-0.015

(n=OH number, Unit:mm)



Pitch  $\geq 0.7$   
 Upper limit :  $0.020 \times n$   
 Lower limit : (upper limit)-0.020

(n=OH number, Unit:mm)

