

Roll Taps for Medium Hardness Carbon Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	Lobe	TYPE
For Metric Threads												
M6 × 1	G8	RY6.0M8OCTP	4P	62	11	26	33	6	4.5	7	5	1
M6 × 1	G8	RY6.0M8OCTB	2P	62	11	26	33	6	4.5	7	5	1
M8 × 1.25	G8	RY8.0N8OCTP	4P	70	12	-	36	6.2	5	8	6	2
M8 × 1.25	G8	RY8.0N8OCTB	2P	70	12	-	36	6.2	5	8	6	2
M10 × 1.5	G8	RY010O8OCTP	4P	75	13	-	38	7	5.5	8	8	2
M10 × 1.5	G8	RY010O8OCTB	2P	75	13	-	38	7	5.5	8	8	2
M10 × 1.25	G8	RY010N8OCTP	4P	75	13	-	38	7	5.5	8	8	2
M10 × 1.25	G8	RY010N8OCTB	2P	75	13	-	38	7	5.5	8	8	2
M12 × 1.75	G8	RY012P8OCTP	4P	82	15	-	42	8.5	6.5	9	8	2
M12 × 1.75	G8	RY012P8OCTB	2P	82	15	-	42	8.5	6.5	9	8	2
M12 × 1.5	G8	RY012O8OCTP	4P	82	15	-	42	8.5	6.5	9	8	2
M12 × 1.5	G8	RY012O8OCTB	2P	82	15	-	42	8.5	6.5	9	8	2
M12 × 1.25	G8	RY012N8OCTP	4P	82	15	-	42	8.5	6.5	9	8	2
M12 × 1.25	G8	RY012N8OCTB	2P	82	15	-	42	8.5	6.5	9	8	2
M14 × 1.5	G9	RY014O9OCTP	4P	88	18	-	45	10.5	8	11	8	2
M14 × 1.5	G9	RY014O9OCTB	2P	88	18	-	45	10.5	8	11	8	2
M16 × 1.5	G9	RY016O9OCTP	4P	95	18	-	48	12.5	10	13	8	2
M16 × 1.5	G9	RY016O9OCTB	2P	95	18	-	48	12.5	10	13	8	2
M18 × 1.5	G10	RY018OOCTP	4P	100	20	-	51	14	11	14	8	2
M18 × 1.5	G10	RY018OOCTB	2P	100	20	-	51	14	11	14	8	2
M20 × 1.5	G10	RY020OOCTP	4P	105	20	-	50	15	12	15	8	2
M20 × 1.5	G10	RY020OOCTB	2P	105	20	-	50	15	12	15	8	2

Number of oil grooves: M6 = 5, M8 = 6, M10 and larger = 8

For M6 and smaller, external centers of 2 thread chamfer taps are removed.