



# Think threads with YAMAWA YMW-U.S.A. TODAY

NEWSLETTER FROM YAMAWA MFG. CO., LTD. & YMW TAPS USA

Vol.3 Aug 2015

## Greetings from Glynn

by Glynn Simmons  
Yamawa North America  
310-994-6591

## THE YAMAWA ISP, IPO AND IHT STANDARD SERIES TAPS

## In This Issue

NEW I SERIES ISP, IPO AND IHT....1  
MANAGING CHIP CONTROL.....2

### YAMAWA INTRODUCES THE I SERIES TAPS in Blister

<p>Made in Japan For Blind Hole</p> <p><b>Spiral Fluted Taps ISP</b> 3/8-16 UNC Chamfer: 2.5P Tap drill size 0 or .316 (ref.)</p> <p>Detailed explanation about tapping →</p> <p><b>Spiral Fluted Taps ISP</b> Material: HSS</p> <p>3/8-16 UNC Chamfer: 2.5P Shank Diameter: .381 (ANSI Dimension) Tap drill size 0 or .316 (ref.)</p> <p>A suitable surface oxide treatment is applied for soft steel.</p> <p>[REMARKS]</p> <ul style="list-style-type: none"> <li>● THIS TAP IS NOT RECOMMENDED FOR HARD TO MACHINE MATERIALS LIKE HARDENED STEELS OR STAINLESS STEELS.</li> <li>● HSS TAPS MAY SHATTER, DURING USE, APPLY MACHINE COVERS AND WEAR SAFETY GLASSES WHEN USING TAPS FOR CUTTING THREADS.</li> </ul> <p>WHEN SETTING TOOLS AND WORKPIECES, SECURE TIGHTLY TO AVOID VIBRATION AND RUNOUT.</p> <p>DO NOT USE EXCESSIVE FORCE OR LOAD AS IT MAY CAUSE THE TAP BREAK.</p> <p>YAMAWA MFG. CO., LTD. WEBSITE URL <a href="http://www.yamawamfg.com/en/">http://www.yamawamfg.com/en/</a></p>	<p>Made in Japan Through Hole</p> <p><b>Spiral Pointed Taps IPO</b> 3/8-16 UNC Chamfer: 5P Tap drill size 0 or .316 (ref.)</p> <p>Detailed explanation about tapping →</p> <p><b>Spiral Pointed Taps IPO</b> Material: HSS</p> <p>3/8-16 UNC Chamfer: 5P Shank Diameter: .381 (ANSI Dimension) Tap drill size 0 or .316 (ref.)</p> <p>A suitable surface oxide treatment is applied for soft steel.</p> <p>[REMARKS]</p> <ul style="list-style-type: none"> <li>● THIS TAP IS NOT RECOMMENDED FOR HARD TO MACHINE MATERIALS LIKE HARDENED STEELS OR STAINLESS STEELS.</li> <li>● HSS TAPS MAY SHATTER, DURING USE, APPLY MACHINE COVERS AND WEAR SAFETY GLASSES WHEN USING TAPS FOR CUTTING THREADS.</li> </ul> <p>WHEN SETTING TOOLS AND WORKPIECES, SECURE TIGHTLY TO AVOID VIBRATION AND RUNOUT.</p> <p>DO NOT USE EXCESSIVE FORCE OR LOAD AS IT MAY CAUSE THE TAP BREAK.</p> <p>YAMAWA MFG. CO., LTD. WEBSITE URL <a href="http://www.yamawamfg.com/en/">http://www.yamawamfg.com/en/</a></p>	<p>Made in Japan Through Hole</p> <p><b>Straight Fluted Taps IHT</b> 3/8-16 UNC Chamfer: 5P Tap drill size 0 or .316 (ref.)</p> <p>Detailed explanation about tapping →</p> <p><b>Straight Fluted Taps IHT</b> Material: HSS</p> <p>3/8-16 UNC Chamfer: 5P Shank Diameter: .381 (ANSI Dimension) Tap drill size 0 or .316 (ref.)</p> <p>A suitable surface oxide treatment is applied for soft steel.</p> <p>[REMARKS]</p> <ul style="list-style-type: none"> <li>● THIS TAP IS NOT RECOMMENDED FOR HARD TO MACHINE MATERIALS LIKE HARDENED STEELS OR STAINLESS STEELS.</li> <li>● HSS TAPS MAY SHATTER, DURING USE, APPLY MACHINE COVERS AND WEAR SAFETY GLASSES WHEN USING TAPS FOR CUTTING THREADS.</li> </ul> <p>WHEN SETTING TOOLS AND WORKPIECES, SECURE TIGHTLY TO AVOID VIBRATION AND RUNOUT.</p> <p>DO NOT USE EXCESSIVE FORCE OR LOAD AS IT MAY CAUSE THE TAP BREAK.</p> <p>YAMAWA MFG. CO., LTD. WEBSITE URL <a href="http://www.yamawamfg.com/en/">http://www.yamawamfg.com/en/</a></p>	<p>Made in Japan For Blind Hole</p> <p><b>Straight Fluted Taps IHT</b> 3/8-16 UNC Chamfer: 2P Tap drill size 0 or .316 (ref.)</p> <p>Detailed explanation about tapping →</p> <p><b>Straight Fluted Taps IHT</b> Material: HSS</p> <p>3/8-16 UNC Chamfer: 2P Shank Diameter: .381 (ANSI Dimension) Tap drill size 0 or .316 (ref.)</p> <p>A suitable surface oxide treatment is applied for soft steel.</p> <p>[REMARKS]</p> <ul style="list-style-type: none"> <li>● THIS TAP IS NOT RECOMMENDED FOR HARD TO MACHINE MATERIALS LIKE HARDENED STEELS OR STAINLESS STEELS.</li> <li>● HSS TAPS MAY SHATTER, DURING USE, APPLY MACHINE COVERS AND WEAR SAFETY GLASSES WHEN USING TAPS FOR CUTTING THREADS.</li> </ul> <p>WHEN SETTING TOOLS AND WORKPIECES, SECURE TIGHTLY TO AVOID VIBRATION AND RUNOUT.</p> <p>DO NOT USE EXCESSIVE FORCE OR LOAD AS IT MAY CAUSE THE TAP BREAK.</p> <p>YAMAWA MFG. CO., LTD. WEBSITE URL <a href="http://www.yamawamfg.com/en/">http://www.yamawamfg.com/en/</a></p>
---	---	---	---

### THE I SERIES

PRICED AS A BETTER PREFORMING TAP FOR THE DIY MARKET, SMALL BATCH THREADING OR THREAD REPAIR.

CONVENIENTLY WRAPPED IN A SINGLE TAP BLISTER WRAP PACKAGING.

FITS ON A COUNTERTOP PEG BOARD DISPLAYS.

CALL YMW TAPS USA AT 855-969-8721 AND ORDER YOU COUNTER TOP DISPLAY.

ECONOMICALLY PRICED FOR SMALL RUN JOBS OR FOR RETHREADING OF DAMAGED THREADS.

SIZE AND TECHNICAL DETAILS ON BACK COVER TO HELP IN SUCCESSFUL APPLICATIONS.

BEST USED WITH A TAPPING FLUID OR TAPPING COMPOUND.

STEAM OXIDE COATING FOR EVEN DISTRIBUTION OF TAPPING FLUID.

AVAILABLE IN IHT BOTTOMING HAND TAPS, IHT TAPER HAND TAPS, ISP SPIRAL FLUTE TAPS AND IPO SPIRAL POINT TAPS FOR ALL APPLICATIONS.



AVAILABLE IN A CONVENIENT COUNTERTOP DISPLAY FOR WILL CALL AREAS AND CUSTOMER SERVICE COUNTERS.

EACH TAP IS INDIVIDUALLY WRAPPED IN A SHRINK WRAP BLISTER PACKAGING FOR EASIER HANDLING AND DISPLAY SALES.

THE BACK COVER HAS AN APPLICATION GUIDE AND QR CODE LINKING TO THE VIDEO ON HOW TO USE TO ASSIST IN PROPER USAGE.

THE BEST H.S.S. TAP FOR "DIY" TAPPING, THREAD REPAIRS AND SMALL BATCH OPERATIONS.

YMW TAPS U.S.A.  
855-969-8721  
[www.ymw-tapsusa.com](http://www.ymw-tapsusa.com)  
FOR TECHNICAL ASSISTANCE CALL  
310-994-6591

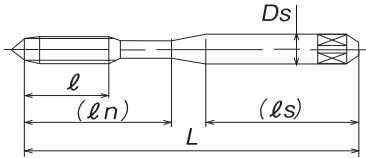
## Features of I series

- Designed specifically for simple tapping jobs like those performed by hand or on a drill press.
- A steam oxide surface treatment is added for tapping materials like SPC and soft steels.
- Recommended for "DIY" projects, small batch quantity jobs and for rethreading damaged threads.

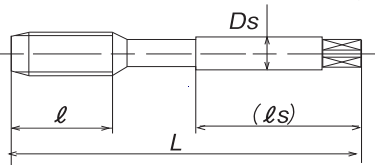
material	C40 HOT ROLL	12L14	low carbon steel	high carbon steel	alloy steel
suitable	◎	◎	◎	○	△

## Table of dimension and sizes

#6-32 TO 1/4"



5/16"-18 TO 3/8"-16



## IHT BOTTOMING HAND TAPS

NC UNC	NUMBER OF FLUTES	OVERALL LENGTH	THREAD LENGTH	CODE
6-32UNC	3	2.000	0.374	IAUN6JXHEX2R
8-32UNC	3	2 1/8"	0.374	IAUN8JXHEX2R
10-24UNC	3	2 3/8"	0.512	IAUNAMXHEX2R
1/4"-20UNC	3	2 1/2"	0.591	IAU04NXHEX2R
5/16"-18UNC	3	2 3/4"	0.669	IAU050XHEX2R
3/8"-16UNC	3	2 15/16"	0.748	IAUN06PHEX2R

BOTTOMING 2 THREAD CHAMFER

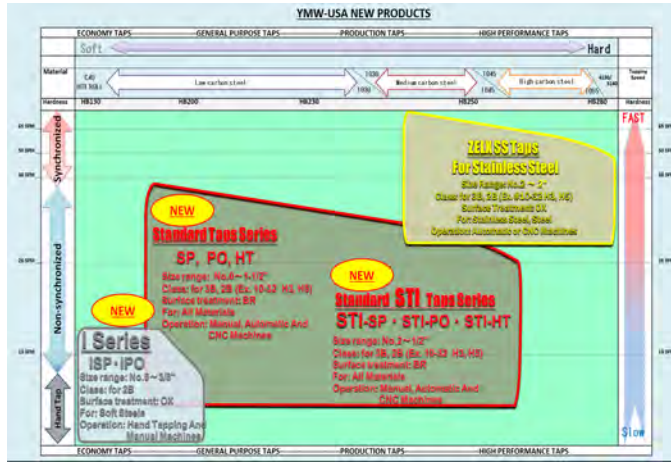
## IHT PLUG HAND TAPS

NC UNC	NUMBER OF FLUTES	OVERALL LENGTH	THREAD LENGTH	CODE
6-32UNC	3	2.000	0.374	IAUN6JXHEX5R
8-32UNC	3	2 1/8"	0.374	IAUN8JXHEX5R
10-24UNC	3	2 3/8"	0.512	IAUNAMXHEX5R
1/4"-20UNC	3	2 1/2"	0.591	IAU04NXHEX5R
5/16"-18UNC	3	2 3/4"	0.669	IAU050XHEX5R
3/8"-16UNC	3	2 15/16"	0.748	IAUN06PHEX5R

PLUG 5 THREAD CHAMFER

## Area of application

Area of tap series application for steels and stainless steels



YMW TAPS U.S.A.  
STOCKING  
WHOLESALE

WEST COAST  
YMW TAPS U.S.A.  
855-969-8721

SOUTHWEST  
C.R. KINSMAN  
800-772-7810

MIDWEST  
DISTRIBUTOR  
TOOL SUPPLY  
937-387-9035

CENTRAL  
SURPLUSS DUNN  
800-621-5117

EAST COAST  
TURPIN  
WHOLESALE  
877-377-7573

## ISP SPIRAL FLUTE TAPS

NC UNC	NUMBER OF FLUTES	OVERALL LENGTH	THREAD LENGTH	CODE
6-32UNC	3	2.000	0.374	UAUN6JXHEXR
8-32UNC	3	2 1/8"	0.374	UAUN8JXHEXR
10-24UNC	3	2 3/8"	0.512	UAUNAMXHEXR
1/4"-20UNC	3	2 1/2"	0.591	UAU04NXHEXR
5/16"-18UNC	3	2 3/4"	0.669	UAU050XHEXR
3/8"-16UNC	3	2 15/16"	0.748	UAUN06PHEXR

2.5 THREAD CHAMFER

## IPO SPIRAL POINT TAPS

NC UNC	NUMBER OF FLUTES	OVERALL LENGTH	THREAD LENGTH	CODE
6-32UNC	3	2.000	0.374	VAUN6JXHEXR
8-32UNC	3	2 1/8"	0.374	VAUN8JXHEXR
10-24UNC	3	2 3/8"	0.512	VAUNAMXHEXR
1/4"-20UNC	3	2 1/2"	0.591	VAU04NXHEXR
5/16"-18UNC	3	2 3/4"	0.669	VAU050XHEXR
3/8"-16UNC	3	2 15/16"	0.748	VAUN06PHEXR

5 THREAD CHAMFER

## Tapping operation

MANUAL TAPPING  
WITH TAP WRENCH

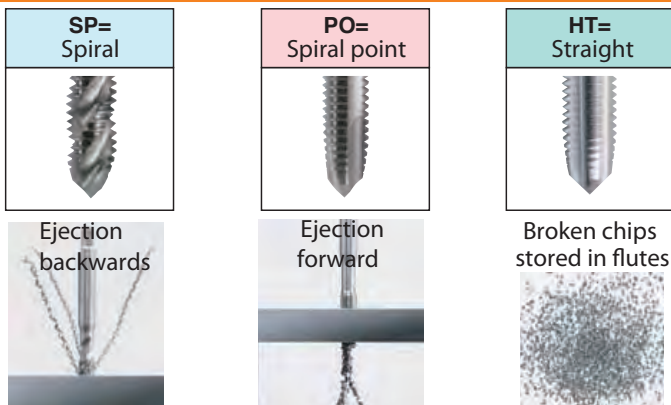


TAPPING ON  
DRILLING MACHINE



## TECHNICAL TAP TIPS

### Flute shape of taps and chip ejection



	Spiral	Spiral point	Straight
Symbol of flute design	SP	PO	HT
Drill hole shape			

USE SPIRAL FLUTE "SP" TAPS ON BLIND OR NON-THROUGH HOLES TO PULL THE CHIPS OUT OF THE HOLE.

USE SPIRAL POINT "PO" TAPS ON THROUGH HOLES TO EJECT THE CHIPS FORWARD OUT OF THE HOLE.

USE PLUG OR BOTTOMING HAND TAPS "HT" ON MATERIALS WHERE THE CHIPS CAN BE BROKEN INTO SMALL PIECES THAT REMAIN IN THE FLUTES.