No. 072  
Class 2, 6H internal thread and a tap P class

**[Question]**

Is it possible to process a 6H internal thread and a second grade internal thread with the same YAMAWA standard grade cutting tap?

**[Answer]**

Yes, of course you can process both threads with the same YAMAWA standard grade tap. The YAMAWA standard grade of cutting tap is ground for processing a 6H internal thread and second class internal thread. Below, I listed one example of the pitch diameter tolerance range of the grade 6H internal screw thread and the second internal screw thread. I have also listed the tap grade and the gauge position relationship, so please take a look at the reference.

**[Description]**

Example: An M10X1.5 internal thread pitch diameter tolerance and a tap P class with the thread gauge position relationship is shown below.

- Tap class (P2/P3/P4/P5)
- M10 x 1.5 standard class of cutting tap (SP/PO/HT)
- Pitch diameter tolerance of a 6H internal thread
- Pitch diameter tolerance of a class 2 internal thread

**[Advice]**

Depending on the processing environment, internal threads machined with the cutting tap can cause problems with the thread cutting oversize, so it is important to perform an inspection with a GO thread plug gauge after tapping.