



10. NUT TAP

Types of Nut Taps

Description	Figure
TiCN Coated ASP Forming Taps-Long Thread	
TiN Coated Forming Taps-Long Thread	
TiN Coated Forming Taps	
TiN Nut Taps	
TCON Nut Taps (For Stainless)	
TiN Spiral Point Taps	
TiN Spiral Flute Taps	
Spiral Point Taps	
Spiral Flute Taps	
SFT Spiral Flute Taps / POT Spiral Point Taps	
S Series Spiral Flute Taps SSP	
Series Spiral Point Taps SGN	



Material of Nut Taps

Chemical composition of the materials specified in JIS

Classification	Symbols	Chemical Composition									
		C	Si	Mn	P	S	Cr	Mo	W	V	Co
W type HSS	SKH2	0.73-0.83	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	-	17.00-19.00	0.80-1.20	-
	SKH3	0.73-0.83	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	-	17.00-19.00	0.80-1.20	4.50-5.50
	SKH4	0.73-0.83	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	-	17.00-19.00	1.00-1.50	9.00-11.00
	SKH10	1.45-1.60	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	-	11.50-13.50	4.20-5.20	4.20-5.20
MO type HSS	SKH51	0.80-0.90	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	4.50-5.50	5.50-6.70	1.60-2.20	-
	SKH52	1.00-1.10	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	4.80-6.20	5.50-6.70	2.30-2.80	-
	SKH55	0.85-0.95	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	4.60-5.30	5.70-6.70	1.70-2.20	4.50-5.50
	SKH56	0.85-0.95	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	4.60-5.30	5.70-6.70	1.70-2.20	7.00-9.00
	SKH58	0.95-1.05	≤0.5	≤0.4	≤0.030	≤0.030	3.50-4.50	8.20-9.20	1.50-2.10	1.70-2.20	-
	SKH59	1.00-1.15	≤0.5	≤0.4	≤0.030	≤0.030	3.50-4.50	9.00-10.00	1.20-1.90	0.90-1.40	7.50-8.50
V type HSS	SKH53	1.10-1.25	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	5.70-6.70	5.70-6.70	2.80-3.30	-
	SKH54	1.25-1.40	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	5.30-6.50	5.30-6.50	3.90-4.50	-
	SKH57	1.20-1.35	≤0.4	≤0.4	≤0.030	≤0.030	3.80-4.50	9.00-11.00	9.00-11.00	3.00-3.70	9.00-11.00

Classification	Symbols	Usage	Cross chart		
			AISI	VDEH	ISO
Symbols	SKH2	Tools for general cutting and other kinds of tools.	T1	S18-0-1	S1(HS18-0-1)
	SKH3	Tools for high speed heavy cutting and other kinds of tools.	T4	S18-1-2-5	S7(HS18-1-1-5)
	SKH4	Tools for cutting hard-to-machine materials and other kinds of tools.	T5	S18-1-2-10	S6(HS18-0-1-10)
	SKH10	Tools for cutting ultra hard-to-machine materials and other kinds of tools	T15	-	S9(HS12-1-5-5)
MO & V type HSS	SKH51	General cutting tools from which toughness is particularly required, and other kinds of tools.	M2	S6-5-2	S4(HS6-5-2)
	SKH52		M3-1	-	-
	SKH53	Tools for cutting high hardness material from which comparatively high toughness is required and other kinds of tools.	M3-2	S6-5-3	S5(HS6-5-3)
	SKH54		M4	-	-
	SKH55		M35	S6-5-2-5	S8(HS6-5-2-5)
	SKH56	High Speed cutting tools from which comparatively high toughness is required and other kinds of tools.	M36	-	-
	SKH57		-	S10-4-3-10	S10(HS10-4-3-10)
	SKH58	General cutting tools from which comparatively high toughness is particularly required, and other kinds of tools.	M7	S2-9-2	S2(HS2-9-2)
	SKH59	High speed heavy cutting tools from which comparatively high toughness is required, and other tools.	M42	S2-10-1-8	S11(HS2-9-1-8)

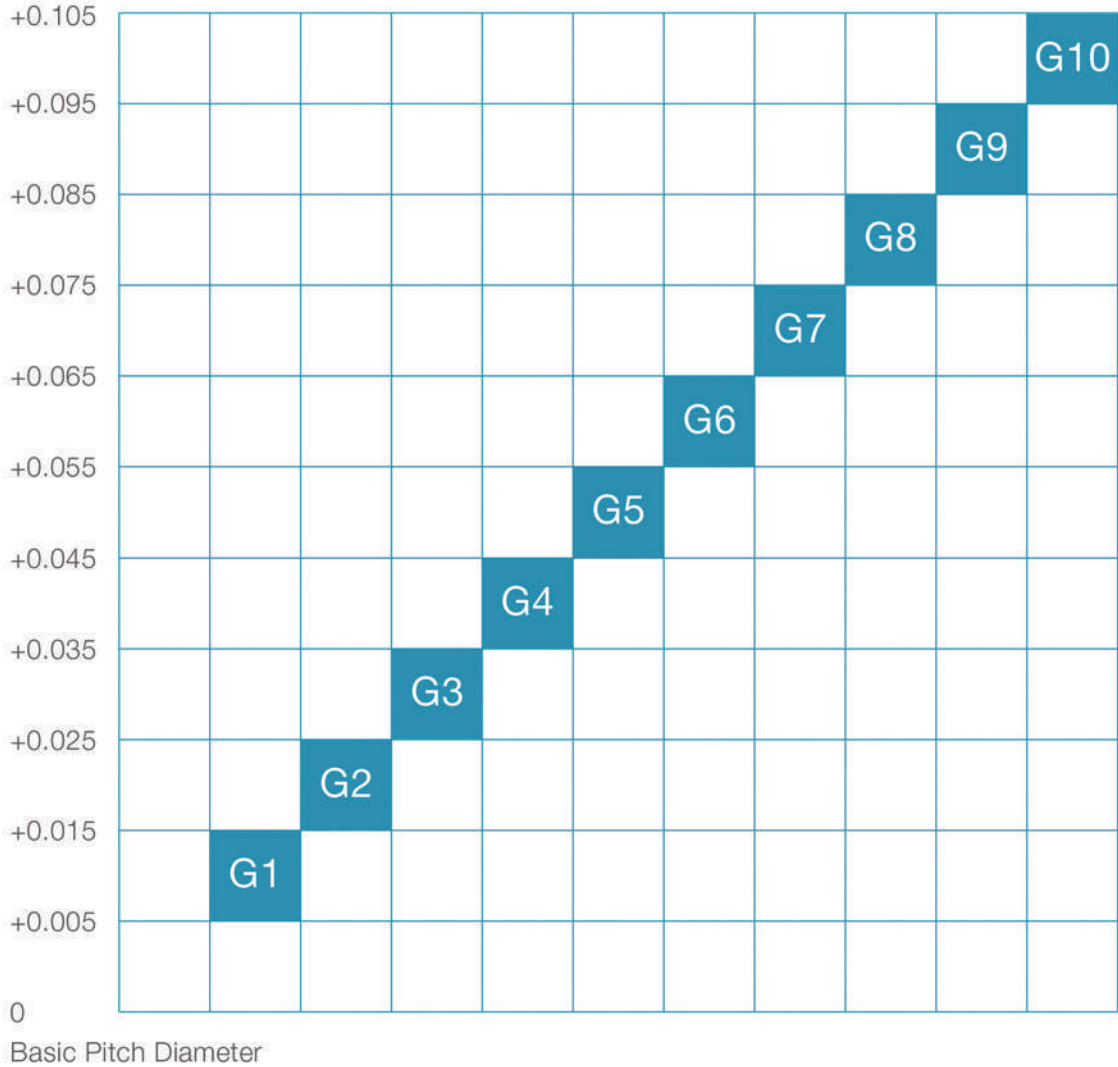
* HSSE: High-speed tool steel that contains more than 4.5% of Cobalt or 2.6% of Vanadium.

* HSS: High-speed tool steel that contains less than 4.5% of Cobalt and 2.6% of Vanadium.



G Grade Limits

H-SNT Pitch Diameter Tolerance Table (G Grade Limits)



1. The pitch diameter tolerance that exceeds over G10 can be derived from the table above.
2. Please specify one of the above listed tolerance grade on ordering.