

No. 046

## Removing the center point from a Spiral Fluted Tap

Cutting  
Taps

### 【Question】



I'm using an M6 X 1 Spiral Flute tap to produce a blind hole but the center point of the tap hits the bottom of the hole before reaching the required thread depth. I would like to remove the center point of the tap, but I'm not sure how much I can remove without damaging the tap. Can you tell me how

### 【Answer】

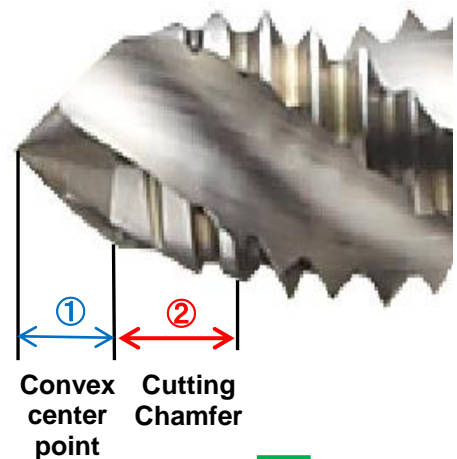
Normally, an M6 or smaller tap has a convex center point. The center point of the tap can be removed by grinding. However, do not grind any portion of the cutting chamfer.



### 【Guide】



If you look closely at the end of the tap, you can see it is divided into two parts. A convex center point ① and the cutting chamfer portion ②. Part ① may be removed by grinding, but be careful not to grind off any portion of the cutting chamfer ② or it will affect the taps performance.



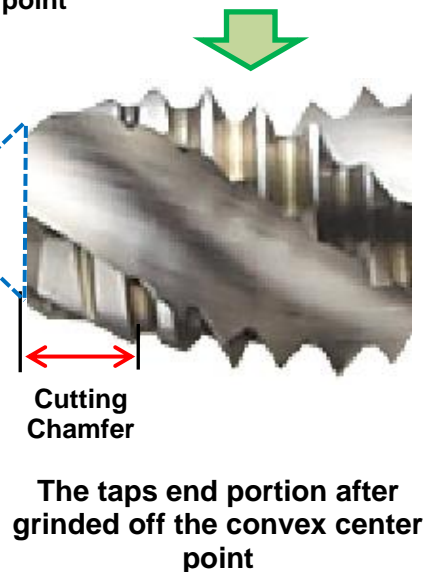
It seems difficult to accurately grind off the center point. Is there a spiral flute tap with a short chamfer and no center point?

The length of the center point that can be removed by grinding to prevent hitting the bottom of the bored hole.

### 【Advice】



Spiral flute taps with a 2.5 thread chamfer are the most suitable for processing blind holes. Yamawa also offers spiral fluted taps with a 1.5 cutting chamfer for blind hole applications here the thread length and the hole depth are within 2 to 3 threads in length. This type of hole will not accommodate a taps center point. The YAMAWA spiral flute taps with a 1.5 cutting chamfer do not have a center point.



Spiral flute tap with a 1.5 thread cutting chamfer.



Spiral Fluted Tap 1.5P (SP 1.5P)  
Dimension range M1.2 × 0.25 ~ M16 × 1.5



Spiral tap for aluminum material 1.5P  
(AL-SP 1.5P)