

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

JIS

① Spiral Fluted Taps (for blind hole)

② Spiral Fluted Taps (for through hole)

③ Spiral Pointed Taps (for through hole)

④ Hand Taps

⑤ Cemented Carbide Taps

⑥ Roll Taps

⑦ Special Thread Taps Simple inspection tools

⑧ Pipe Taps

⑨ Thread Mills Premium Thread Mills

⑩ Dies

⑪ Center Drills Centering Tools

⑫ Precision Machinery/Medical Surgical Instruments

⑬

JIS

⑦-13



AL-SP STI



Spiral Fluted Taps for Aluminum Materials (for Helical Coil Wire Screw Thread Inserts)

Specification

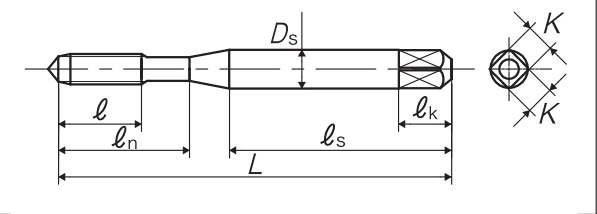


- This is used to cut a comparatively soft material, such as aluminum, and create an internal thread for accommodating a helical coil wire screw thread insert, in order to reinforce the internal thread and increase durability.
- Diameter of the internal screw threads into which the insert coil is inserted, is larger than that of the corresponding external screw threads by the thickness of the coil. Therefore, the internal screw thread diameter of the insert coil thread tap is also larger than its nominal diameter.
- The bored hole size needs to be also larger. Make sure to prepare an appropriate bored hole size before tapping.
- The shank diameter is also larger. Make sure to use an appropriate tap holder.
- Oversize taps of Ib+30 are also available to allow for shrinkage of internal threads.

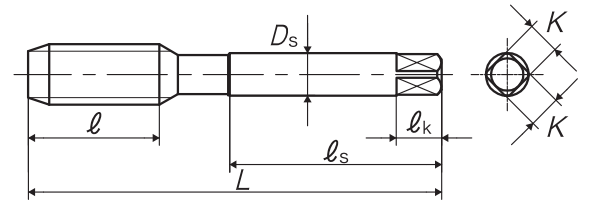
Tapping Speed depending on Materials

Brass 黄銅	Brass castings 黄銅鑄物	Bronze 青銅	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鑄物	Magnesium alloy die castings マグネシウム合金鑄物	Zinc alloy castings 亜鉛合金鑄物
10~25 (m/min)	10~25 (m/min)	10~25 (m/min)	10~25 (m/min)	10~25 (m/min)	10~25 (m/min)	10~25 (m/min)

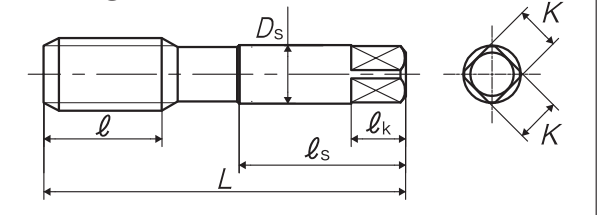
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1C

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE	MSRP	
For Metric Threads															
M3 × 0.5	Ib	SW3.0G1LEN	2.5P	3.650	52	7.5	17	29	5	4	7	3	1	¥ 2,450	
M3 × 0.5	Ib+30	SW3.0G3LEN	2.5P	3.650	52	7.5	17	29	5	4	7	3	1	¥ 2,450	
M4 × 0.7	Ib	SW4.0I1LEN	2.5P	4.909	60	13	22	33	5.5	4.5	7	3	1	¥ 2,330	
M4 × 0.7	Ib+30	SW4.0I3LEN	2.5P	4.909	60	13	22	33	5.5	4.5	7	3	1	¥ 2,330	
M5 × 0.8	Ib	SW5.0K1LEN	2.5P	6.039	62	15	26	33	6	4.5	7	3	1	¥ 2,230	
M5 × 0.8	Ib+30	SW5.0K3LEN	2.5P	6.039	62	15	26	33	6	4.5	7	3	1	¥ 2,230	
M6 × 1	Ib	SW6.0M1LEN	2.5P	7.299	70	19	-	36	6.2	5	8	3	2	¥ 2,280	
M6 × 1	Ib+30	SW6.0M3LEN	2.5P	7.299	70	19	-	36	6.2	5	8	3	2	¥ 2,280	
M8 × 1.25	Ib	SW8.0N1LEN	2.5P	9.624	75	23	-	38	7	5.5	8	3	2	¥ 3,200	
M8 × 1.25	Ib+30	SW8.0N3LEN	2.5P	9.624	75	23	-	38	7	5.5	8	3	2	¥ 3,200	
M10 × 1.5	Ib	SW10.0O1LEN	2.5P	11.948	82	26	-	42	8.5	6.5	9	3	2	¥ 4,300	
M10 × 1.5	Ib+30	SW10.0O3LEN	2.5P	11.948	82	26	-	42	8.5	6.5	9	3	2	¥ 4,300	
M10 × 1.25	Ib	SW10.1N1LEN	2.5P	11.624	82	26	-	42	8.5	6.5	9	3	2	¥ 4,300*	
M12 × 1.75	Ib	SW10.12P1LEN	2.5P	14.273	95	26	-	48	12.5	10	13	3	2	¥ 5,910	
M12 × 1.5	Ib	SW10.12O1LEN	2.5P	13.948	88	26	-	45	10.5	8	11	3	2	¥ 5,910*	
M12 × 1.25	Ib	SW10.12N1LEN	2.5P	13.624	88	26	-	45	10.5	8	11	3	2	¥ 5,910*	



* = Specified Distribution Items. Made to order products.

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

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Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M14 × 2	I b	SW014Q1LEN	2.5P	16.598	100	33	-	51	14	11	14	3	2	¥ 7,780 [*]
M14 × 1.5	I b	SW014O1LEN	2.5P	15.948	95	26	-	48	12.5	10	13	3	2	¥ 7,780 [*]
M16 × 2	I b	SW016Q1LEN	2.5P	18.598	105	33	-	50	15	12	15	4	3	¥ 11,300
M16 × 1.5	I b	SW016O1LEN	2.5P	17.948	100	33	-	51	14	11	14	4	2	¥ 11,300 [*]
M18 × 2.5	I b	SW018R1LEN	2.5P	21.248	115	33	-	55	17	13	16	4	3	¥ 18,600 [*]
M18 × 1.5	I b	SW018O1LEN	2.5P	19.948	105	33	-	50	15	12	15	4	3	¥ 18,600 [*]
M20 × 2.5	I b	SW020R1LEN	2.5P	23.248	120	39	-	55	19	15	18	4	3	¥ 22,100
M20 × 1.5	I b	SW020O1LEN	2.5P	21.948	115	33	-	55	17	13	16	4	3	¥ 22,100 [*]
M22 × 2.5	I b	SW022R1LEN	2.5P	25.248	125	39	-	58	19	15	18	4	3	¥ 28,800 [*]
M24 × 3	I b	SW024S1LEN	2.5P	27.897	135	46	-	62	23	17	20	4	3	¥ 35,600

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple inspection tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical/Surgical Instruments

⑫

JIS

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

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