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

AL-SP STI

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

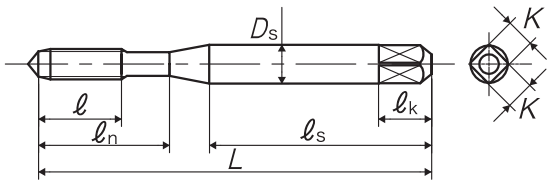
■This is used to cut a comparatively soft material, such as aluminum, and create an internal thread for accommodating a helical coil wire screw thread insert, in order to reinforce the internal thread and increase durability.
■Diameter of the internal screw threads into which the insert coil is inserted, 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.

Specification

Tapping Speed depending on Materials

Brass 黄銅	Brass castings 黄銅鋳物	Bronze 青銅	Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Magnesium alloy die castings マグネシウム合金鋳物	Zinc alloy castings 亜鉛合金鋳物
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



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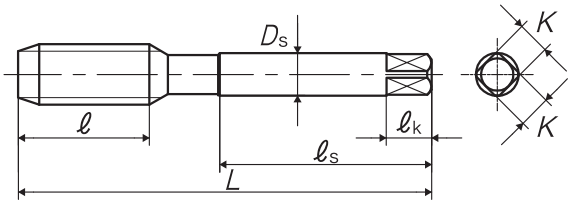

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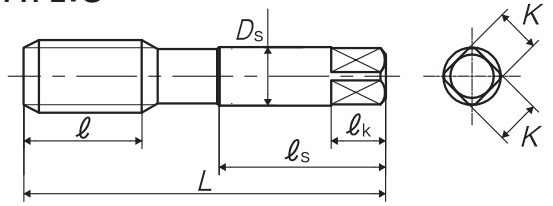

Oversize

Segment : 1C

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
For Metric Threads														
M3 × 0.5	I b	SW3.0G1LEN	2.5P	3.650	52	7.5	17	29	5	4	7	3	1	¥ 2,800
M3 × 0.5	I b+30	SW3.0G3LEN	2.5P	3.650	52	7.5	17	29	5	4	7	3	1	¥ 2,800
M4 × 0.7	I b	SW4.0I1LEN	2.5P	4.909	60	13	22	33	5.5	4.5	7	3	1	¥ 2,660
M4 × 0.7	I b+30	SW4.0I3LEN	2.5P	4.909	60	13	22	33	5.5	4.5	7	3	1	¥ 2,660
M5 × 0.8	I b	SW5.0K1LEN	2.5P	6.039	62	15	26	33	6	4.5	7	3	1	¥ 2,550
M5 × 0.8	I b+30	SW5.0K3LEN	2.5P	6.039	62	15	26	33	6	4.5	7	3	1	¥ 2,550
M6 × 1	I b	SW6.0M1LEN	2.5P	7.299	70	19	-	36	6.2	5	8	3	2	¥ 2,650
M6 × 1	I b+30	SW6.0M3LEN	2.5P	7.299	70	19	-	36	6.2	5	8	3	2	¥ 2,650
M8 × 1.25	I b	SW8.0N1LEN	2.5P	9.624	75	23	-	38	7	5.5	8	3	2	¥ 3,720
M8 × 1.25	I b+30	SW8.0N3LEN	2.5P	9.624	75	23	-	38	7	5.5	8	3	2	¥ 3,720
M10 × 1.5	I b	SW010O1LEN	2.5P	11.948	82	26	-	42	8.5	6.5	9	3	2	¥ 4,990
M10 × 1.5	I b+30	SW010O3LEN	2.5P	11.948	82	26	-	42	8.5	6.5	9	3	2	¥ 4,990
M10 × 1.25	I b	SW010N1LEN	2.5P	11.624	82	26	-	42	8.5	6.5	9	3	2	¥ 4,990 ※
M12 × 1.75	I b	SW012P1LEN	2.5P	14.273	95	26	-	48	12.5	10	13	3	2	¥ 6,860
M12 × 1.5	I b	SW012O1LEN	2.5P	13.948	88	26	-	45	10.5	8	11	3	2	¥ 6,860 ※
M12 × 1.25	I b	SW012N1LEN	2.5P	13.624	88	26	-	45	10.5	8	11	3	2	¥ 6,860 ※

※ = 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

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	Ib	SW014Q1LEN	2.5P	16.598	100	33	-	51	14	11	14	3	2	¥ 9,030 ※
M14 × 1.5	Ib	SW014O1LEN	2.5P	15.948	95	26	-	48	12.5	10	13	3	2	¥ 9,030 ※
M16 × 2	Ib	SW016Q1LEN	2.5P	18.598	105	33	-	50	15	12	15	4	3	¥ 13,200
M16 × 1.5	Ib	SW016O1LEN	2.5P	17.948	100	33	-	51	14	11	14	4	2	¥ 13,200 ※
M18 × 2.5	Ib	SW018R1LEN	2.5P	21.248	115	33	-	55	17	13	16	4	3	¥ 21,600 ※
M18 × 1.5	Ib	SW018O1LEN	2.5P	19.948	105	33	-	50	15	12	15	4	3	¥ 21,600 ※
M20 × 2.5	Ib	SW020R1LEN	2.5P	23.248	120	39	-	55	19	15	18	4	3	¥ 25,700
M20 × 1.5	Ib	SW020O1LEN	2.5P	21.948	115	33	-	55	17	13	16	4	3	¥ 25,700 ※
M22 × 2.5	Ib	SW022R1LEN	2.5P	25.248	125	39	-	58	19	15	18	4	3	¥ 33,700 ※
M24 × 3	Ib	SW024S1LEN	2.5P	27.897	135	46	-	62	23	17	20	4	3	¥ 41,700

※ = Specified Distribution Items. Made to order products.