

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ <sub>n</sub>	ℓ <sub>s</sub>	D <sub>s</sub>	K	ℓ <sub>k</sub>

# ANSI

## AL-SP

### Spiral Fluted Taps for Aluminum



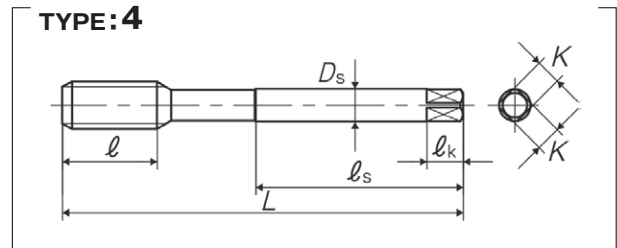
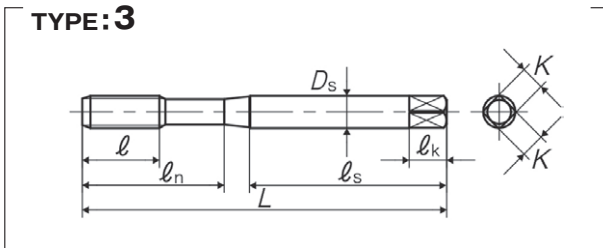
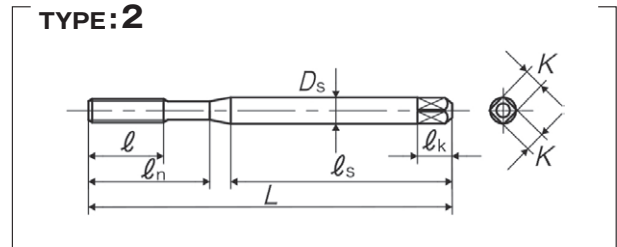
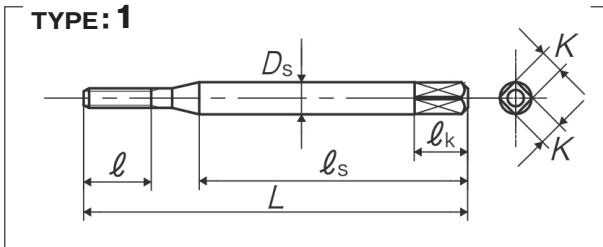
#### Specification



■ In aluminum die casting and aluminum casting tapping, AL-SP solves such problems as chip jamming, chip clogging, and torn 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)



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ <sub>n</sub> (inch)	ℓ <sub>s</sub> (inch)	D <sub>s</sub> (inch)	K (inch)	ℓ <sub>k</sub> (inch)	No. of flutes	TYPE
For Metric Threads												
M3 × 0.5	D3	386528M	2.5P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	3	2
M3.5 × 0.6	D4	386529M	2.5P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	3	2
M4 × 0.7	D4	386530M	2.5P	2.48	0.512	0.815	1.535	0.168	0.131	0.25	3	2
M5 × 0.8	D4	386531M	2.5P	2.756	0.551	0.984	1.654	0.194	0.152	0.25	3	2
M6 × 1	D5	386532M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
M7 × 1	D5	386533M	2.5P	3.543	0.748	1.339	1.831	0.318	0.238	0.375	3	3
M8 × 1.25	D5	386535M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
M8 × 1	D5	386534M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
M10 × 1.5	D6	386537M	2.5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	3
M10 × 1.25	D5	386536M	2.5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	3
M12 × 1.75	D6	386540M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
M12 × 1.5	D5	386539M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
M12 × 1.25	D5	386538M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4

- 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/Metal Surgical Instruments

# 1 Spiral Fluted Tap Series for blind hole

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

- ANSI
- 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

## AL-SP Spiral Fluted Taps for Aluminum

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
For Unified Threads												
No.2-56UNC	GH2	386500M	2.5P	1.772	0.314	-	1.161	0.141	0.11	0.187	2	1
No.4-40UNC	GH2	386501M	2.5P	2.205	0.354	0.709	1.28	0.141	0.11	0.187	2	2
No.5-40UNC	GH2	386502M	2.5P	2.205	0.433	0.736	1.339	0.141	0.11	0.187	3	2
No.6-32UNC	GH3	386503M	2.5P	2.205	0.433	0.748	1.339	0.141	0.11	0.187	3	2
No.8-32UNC	GH3	386504M	2.5P	2.48	0.512	0.827	1.535	0.168	0.131	0.25	3	2
No.10-24UNC	GH3	386505M	2.5P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	3	2
No.10-32UNF	GH3	386506M	2.5P	2.756	0.551	0.945	1.654	0.194	0.152	0.25	3	2
1/4-20UNC	GH3	386507M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
1/4-20UNC	GH5	386508M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
1/4-28UNF	GH3	386509M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
1/4-28UNF	GH4	386511M	2.5P	3.15	0.591	1.181	1.713	0.255	0.191	0.312	3	2
5/16-18UNC	GH3	386512M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
5/16-18UNC	GH5	386513M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
5/16-24UNF	GH3	386514M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
5/16-24UNF	GH4	386515M	2.5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	3
3/8-16UNC	GH3	386516M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
3/8-16UNC	GH5	386517M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
3/8-24UNF	GH3	386518M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
3/8-24UNF	GH4	386519M	2.5P	3.937	0.906	1.535	2.028	0.381	0.286	0.437	3	3
7/16-14UNC	GH3	386520M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
7/16-14UNC	GH5	386521M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
7/16-20UNF	GH3	386522M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
7/16-20UNF	GH5	386523M	2.5P	3.937	0.906	-	2.008	0.323	0.242	0.406	3	4
1/2-13UNC	GH3	386524M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
1/2-13UNC	GH5	386525M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
1/2-20UNF	GH3	386526M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4
1/2-20UNF	GH5	386527M	2.5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	4