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

AL-SP

Spiral Fluted Taps for Aluminum

Specification

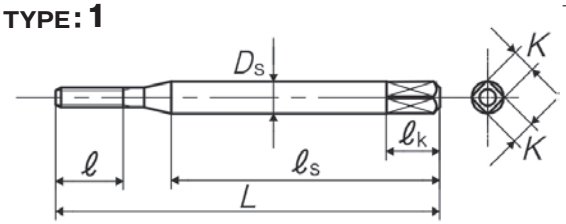
HSS | NI Nitride | <2D

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

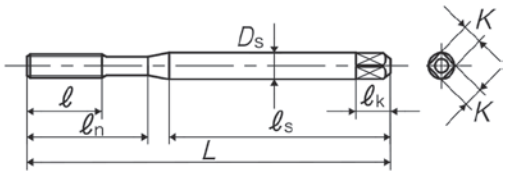
Tapping Speed depending on Materials

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)

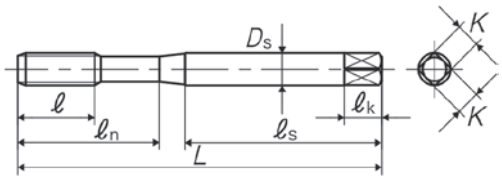
TYPE : 1



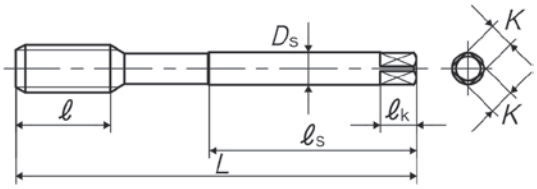
TYPE : 2



TYPE : 3



TYPE : 4



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (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

Think threads with YAMAWA

・This product is different from JIS products in shape and dimensions, please be careful when using.

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	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

・This product is different from JIS products in shape and dimensions, please be careful when using.

Think threads with YAMAWA