

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	ℓ _n	ℓ _s	D _s	K	ℓ _k



DIN

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

Dies

10

11 Center Drills
Centering Tools

12 Precision Machinery/
Medical Surgical Instruments

DIN

①-155

DIN

AL+SP AL-SP

Spiral Fluted Taps for Aluminum

Specification



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

Tapping Speeds depending on Materials

Brass
黄銅
10~25
(m/min)

Brass castings
黄銅鑄物
10~25
(m/min)

Bronze
青銅
10~25
(m/min)

Wrought aluminum
アルミ圧延材
10~25
(m/min)

Aluminum alloy castings
アルミ合金鑄物
10~25
(m/min)

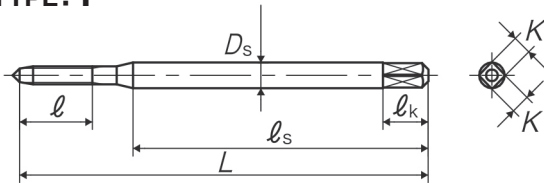
Magnesium alloy die castings
マグネシウム合金鑄物
10~25
(m/min)

Zinc alloy castings
亜鉛合金鑄物
10~25
(m/min)

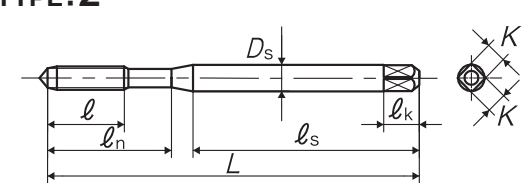
・ Product Name and Size.

AL+SP	~M6
AL-SP	M8~

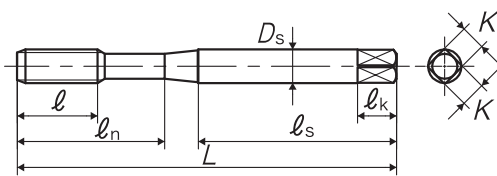
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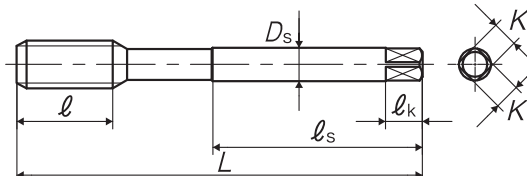
TYPE: 2



TYPE: 3



TYPE: 4



AL+SP Spiral Fluted Taps for Aluminum

Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE
For Metric Threads												
M2 × 0.4	ISO2	SE2.0EALEN	2.5P	45	8	-	32	2.8	2.1	5	2	1
M2.5 × 0.45	ISO2	SE2.5FALEN	2.5P	50	8	15	33	2.8	2.1	5	2	2
M3 × 0.5	ISO2	SE3.0GALEN	2.5P	56	9	18	34	3.5	2.7	6	3	2
M4 × 0.7	ISO2	SE4.0IALEN	2.5P	63	13	21	38	4.5	3.4	6	3	2
M5 × 0.8	ISO2	SE5.0KALEN	2.5P	70	14	25	39	6	4.9	8	3	2
M6 × 1	ISO2	SE6.0MALEN	2.5P	80	15	30	45	6	4.9	8	3	2

AL-SP Spiral Fluted Taps for Aluminum

Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE
For Metric Threads												
M8 × 1.25	ISO2	SD8.0NALEN	2.5P	90	19	35	47	8	6.2	9	3	3
M10 × 1.5	ISO2	SD010OALEN	2.5P	100	23	39	52.5	10	8	11	3	3
M12 × 1.75	ISO2	SG012PALEN	2.5P	110	26	-	56	9	7	10	3	4
M14 × 2	ISO2	SG014QALEN	2.5P	110	26	-	56	11	9	12	3	4
M16 × 2	ISO2	SG016QALEN	2.5P	110	26	-	56	12	9	12	3	4

Think threads with
YAMAWA

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