

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

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

JIS

①-145



AL+SP AL-SP

Spiral Fluted Taps for Aluminum

Specification



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)
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• Product Name and Size.

AL+SP	~ M6
AL-SP	M8 ~



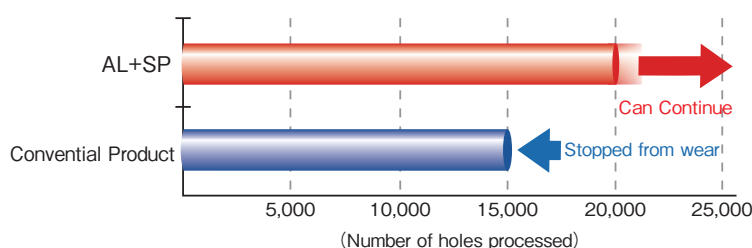
Product Features

- Stable screw tapping in light alloy castings such as aluminum die casting and aluminum casting even at a high speed range.
- Optimum design of the flute makes it possible to produce stable and clean internal threading with fewer burrs on the inner diameter that normally occur in tapping of light alloys.

Tapping Data

Thread Size [M6×1]

Material	AC4C
Bored Hole Size	φ5.0
Tapping Length	9mm (Blind hole)
Tapping Speed	20m/min
Machinery Type	Vertical type machining center
Tapping Fluid	Water soluble cutting fluid (chlorinefree 20 to 1 dilution)



AL+SP

AL+SP Internal Thread

Processing of internal thread surface

No burning to the inner diameter and the finish is good.

Conventional Product

Conventional product internal thread

Processing of internal thread surface

Burning to inner diameter occurs

- AL+SP Compared to conventional products, the internal thread quality is good and the AL+SP had long tool life.

Think threads with
YAMAWA

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L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

1

JIS

Spiral Fluted Taps
(for blind hole)

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Spiral Fluted Taps
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Spiral Pointed Taps
(for through hole)

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Hand Taps

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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

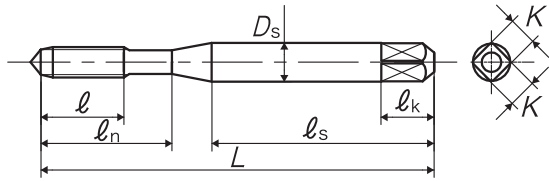
Precision Machinery/
Metal Surgical Instruments

⑫

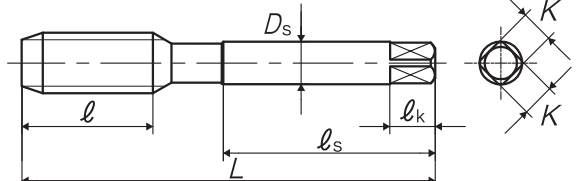
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①-146

TYPE: 1



TYPE: 2



AL+SP Spiral Fluted Taps for Aluminum

Segment : 1C

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	MSRP
For Metric Threads													
M2 × 0.4	P2	ASHPQ2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	1	¥ 3,090
M2.3 × 0.4	P2	ASHPQ2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	1	¥ 2,820 [*]
M2.5 × 0.45	P2	ASHPQ2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	1	¥ 2,360
M2.6 × 0.45	P2	ASHPQ2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	1	¥ 2,360
M3 × 0.5	P2	ASHPQ3.0G	2.5P	46	9	14	26	4	3.2	6	3	1	¥ 1,660
M3.5 × 0.6	P2	ASHPQ3.5H	2.5P	52	11	16	29	5	4	7	3	1	¥ 1,660 [*]
M4 × 0.7	P3	ASHPR4.0I	2.5P	52	11	17	29	5	4	7	3	1	¥ 1,660
M5 × 0.8	P3	ASHPR5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 1,680
M6 × 1	P3	ASHPR6.0M	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,840

AL-SP Spiral Fluted Taps for Aluminum

Segment : 1C

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	MSRP
For Metric Threads													
M8 × 1.25	P3	ASHMR8.0N	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 2,570
M10 × 1.5	P3	ASHMR010O	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,260
M10 × 1.25	P3	ASHMR010N	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,260 [*]
M10 × 1	P3	ASHMR010M	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,880 [*]
M12 × 1.75	P3	ASHMR012P	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,620
M12 × 1.5	P3	ASHMR012O	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,620 [*]
M12 × 1.25	P3	ASHMR012N	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,620 [*]
M12 × 1	P3	ASHMR012M	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 5,450 [*]
M14 × 2	P3	ASHMR014Q	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 6,300 [*]
M14 × 1.5	P3	ASHMR014O	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 6,300 [*]
M16 × 2	P3	ASHMR016Q	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 8,430 [*]
M16 × 1.5	P3	ASHMR016O	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 8,430 [*]

* = Specified Distribution Items. Made to order products.

 Think threads with
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