

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

①-139

E-SP

Spiral Fluted Taps for Soft Structural Steels



Specification

HSS

OX
Oxide



Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
5~10
(m/min)

Medium carbon steels
中炭素鋼
5~10
(m/min)

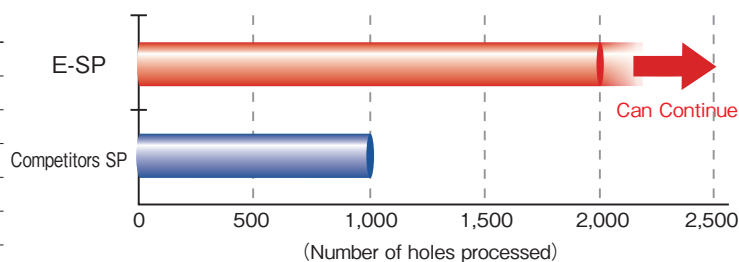
Product Features

- The E-SP is suitable for tapping relatively soft work piece materials such as mild steel (SS41, S25C, etc.).
- It produces a good internal thread with an excellent surface finish.

Tapping Data

Thread Size [M6×1]

Workpiece Material	SS400
Hole Shape	Blind hole
Bored Hole Size	φ5.0
Tapping Length	7mm
Tapping Speed	8m/min
Machinery Type	Drilling machine
Cutting Fluid	Non-water soluble cutting oil

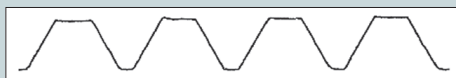


E-SP

Internal thread



Internal thread shape

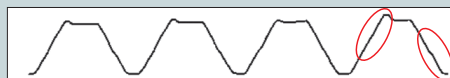


Competitors Spiral Fluted tap

Internal thread



Internal thread shape



Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_n	ℓ_s	Ds	K	ℓ_k

1

JIS

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

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

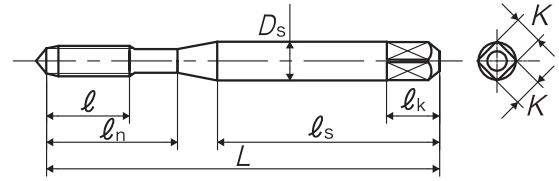
Precision Machinery/
Medical Surgical Instruments

⑫

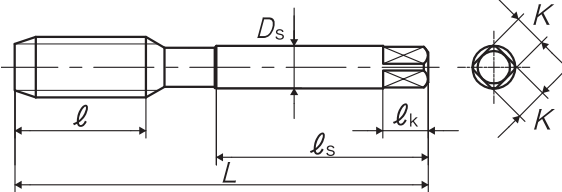
JIS

①-140

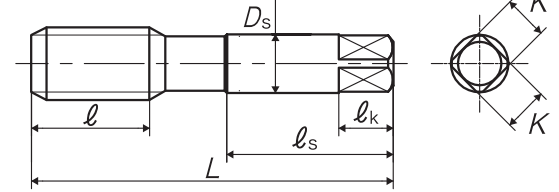
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1C

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M3 × 0.5	P1	ESHMP3.0G	2.5P	46	9	14	26	4	3.2	6	2	1	¥ 1,670 *
M3 × 0.5	P1	ESHMP3.0G-3	2.5P	46	9	14	26	4	3.2	6	3	1	¥ 1,670
M3.5 × 0.6	P1	ESHMP3.5H	2.5P	52	11	16	29	5	4	7	3	1	¥ 1,670 *
M4 × 0.7	P2	ESHMQ4.0I	2.5P	52	11	17	29	5	4	7	3	1	¥ 1,670
M5 × 0.8	P2	ESHMQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 1,680
M6 × 1	P2	ESHMQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,850
M8 × 1.25	P2	ESHMQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 2,550
M10 × 1.5	P2	ESHMQ10.0	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,230
M10 × 1.25	P2	ESHMQ10.1N	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,230 *
M12 × 1.75	P2	ESHMQ12.1P	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,580
M12 × 1.5	P2	ESHMQ12.0	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,580 *
M12 × 1.25	P2	ESHMQ12.1N	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,580 *
M14 × 2	P2	ESHMQ14.1Q	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 6,240 *
M14 × 1.5	P2	ESHMQ14.0	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 6,240 *
M16 × 2	P2	ESHMQ16.1Q	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 8,340
M16 × 1.5	P2	ESHMQ16.0	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 8,340 *
M18 × 2.5	P3	ESHMR18.1R	2.5P	100	33	-	51	14	11	14	4	2	¥ 11,200 *
M18 × 1.5	P2	ESHMQ18.0	2.5P	100	33	-	51	14	11	14	4	2	¥ 11,200 *
M20 × 2.5	P3	ESHMR20.1R	2.5P	105	33	-	50	15	12	15	4	3	¥ 15,300
M20 × 1.5	P3	ESHMR20.0	2.5P	105	33	-	50	15	12	15	4	3	¥ 15,300 *
M22 × 2.5	P3	ESHMR22.1R	2.5P	115	33	-	55	17	13	16	4	3	¥ 19,500 *
M22 × 1.5	P3	ESHMR22.0	2.5P	115	33	-	55	17	13	16	4	3	¥ 19,500 *
M24 × 3	P3	ESHMR24.1S	2.5P	120	39	-	55	19	15	18	4	3	¥ 24,300 *
M24 × 1.5	P3	ESHMR24.0	2.5P	120	39	-	55	19	15	18	4	3	¥ 24,300 *

* = Specified Distribution Items. Made to order products.

 Think threads with
YAMAWA