

③ Spiral Pointed Tap Series for through 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

⑩

Dies

⑪

Center Drills
Centering Tools

⑫

Precision Machinery/
Medical Surgical Instruments

DIN

③-103

DIN

EH-PO

Spiral Pointed Taps for Hard-to-Machine Materials



Specification

HSS-Co



■ Spiral pointed tap suitable for high hardness steels of 30 ~ 45HRC such as forgings and thermal refined steels of high carbon steels and alloy steels, and die steels. Through hole use.

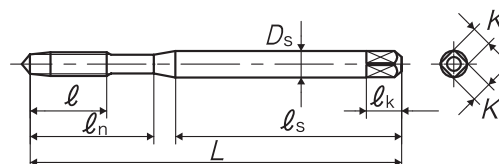
Tapping Speeds depending on Materials

High carbon steels
高炭素鋼
5~10
(m/min)

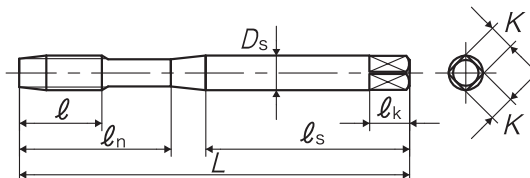
Thermal refined steels
調質鋼
5~10
(m/min)
25~35HRC

Thermal refined steels
調質鋼
~5
(m/min)
35~45HRC

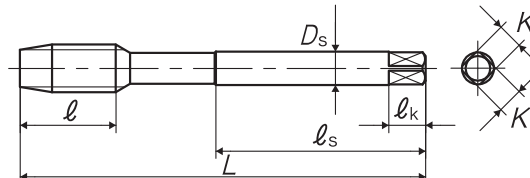
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1F

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												
M3 × 0.5	ISO2X	PD3.0GBDCB	4.5P	56	9	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2X	PD4.0IBDCB	4.5P	63	13	21	38	4.5	3.4	6	3	1
M5 × 0.8	ISO2X	PD5.0KBDCB	4.5P	70	14	25	39	6	4.9	8	3	1
M6 × 1	ISO2X	PD6.0MBDCB	4.5P	80	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	PD8.0NBDCB	4.5P	90	19	35	47	8	6.2	9	3	2
M8 × 1	ISO2X	PM8.0MBDCB	4.5P	90	19	-	46	6	4.9	8	3	3
M10 × 1.5	ISO2X	PD10.0OBDCB	4.5P	100	23	39	52.5	10	8	11	3	2
M10 × 1.25	ISO2X	PM10.0NBDCB	4.5P	100	23	-	51	7	5.5	8	3	3
M10 × 1	ISO2X	PM10.0MBDCB	4.5P	90	19	-	46	7	5.5	8	3	3
M12 × 1.75	ISO2X	PG12.0PBDCB	4.5P	110	26	-	56	9	7	10	3	3
M12 × 1.5	ISO2X	PM12.0OBDCB	4.5P	100	21	-	51	9	7	10	3	3
M12 × 1.25	ISO2X	PM12.0NBDCB	4.5P	100	21	-	51	9	7	10	3	3
M14 × 2	ISO2X	PG14.0QBDCB	4.5P	110	26	-	56	11	9	12	3	3
M14 × 1.5	ISO2X	PM14.0OBDCB	4.5P	100	21	-	51	11	9	12	3	3
M16 × 2	ISO2X	PG16.0QBDCB	4.5P	110	26	-	56	12	9	12	3	3
M16 × 1.5	ISO2X	PM16.0OBDCB	4.5P	100	21	-	51	12	9	12	3	3
M18 × 2.5	ISO2X	PG18.0RBDCB	4.5P	125	33	-	64	14	11	14	3	3
M18 × 1.5	ISO2X	PM18.0OBDCB	4.5P	110	24	-	56	14	11	14	3	3
M20 × 2.5	ISO2X	PG20.0RBDCB	4.5P	140	33	-	71	16	12	15	3	3
M20 × 1.5	ISO2X	PM20.0OBDCB	4.5P	125	24	-	64	16	12	15	3	3
M22 × 2.5	ISO2X	PG22.0RBDCB	4.5P	140	33	-	71	18	14.5	17	3	3
M24 × 3	ISO2X	PG24.0SBDCB	4.5P	160	37	-	82	18	14.5	17	3	3

Think threads with
YAMAWA

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