

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	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

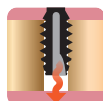
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EH-PO

Spiral Pointed Taps for Hard-to-Machine Materials



Specification



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

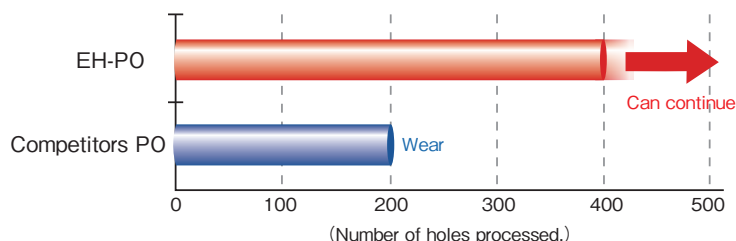
Product Features

- The EH-PO taps are suitable for high hardness materials from 30 to 45 HRC in high carbon steel, alloy steel forging, tempering material and mold materials.
- Tool life is greatly improved using a cutting edge shape suitable for difficult to machine materials. The tap exhibits excellent wear resistance.
- For through hole applications.

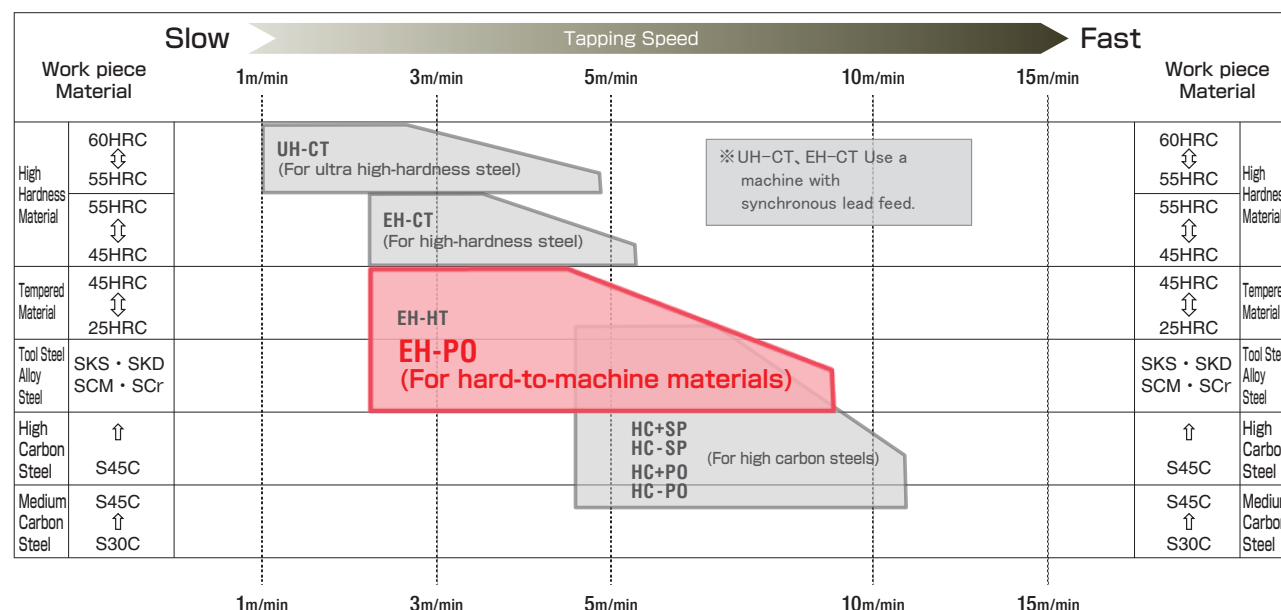
Tapping Data

Processing conditions [M10×1.25 P4]

Workpiece Material	S55C/A hub
Bored Hole Size	φ8.8
Tapping Length	11mm (Through hole)
Tapping Speed	10m/min
Machinery Type	Vertical machining center (asynchronous)
Holder	With tension
Tapping Fluid	Water soluble cutting fluid



Recommendation chart



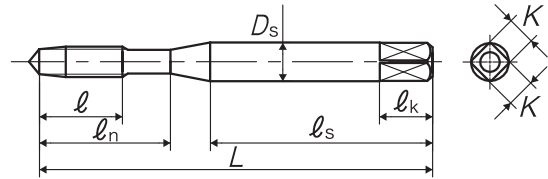
Processing range chart.

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

3

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TYPE: 1

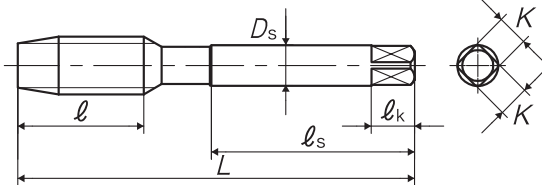
Spiral Fluted Taps
(for blind hole)

①

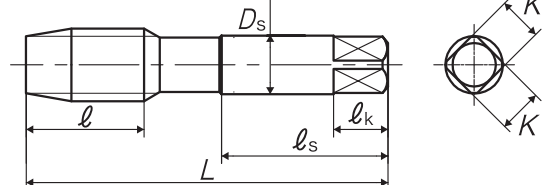
Spiral Fluted Taps
(for through hole)

②

TYPE: 2



TYPE: 3

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Segment : 1F

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	P3	EPHMR3.0G	4.5P	46	9	14	26	4	3.2	6	3	1	¥ 2,020
M4 × 0.7	P3	EPHMR4.0I	4.5P	52	11	17	29	5	4	7	3	1	¥ 2,020
M5 × 0.8	P3	EPHMR5.0K	4.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 2,030
M6 × 1	P3	EPHMR6.0M	4.5P	62	15	26	33	6	4.5	7	3	1	¥ 2,240
M8 × 1.25	P4	EPHMS8.0N	4.5P	70	19	-	36	6.2	5	8	3	2	¥ 3,130
M10 × 1.5	P4	EPHMS010O	4.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,970
M10 × 1.25	P4	EPHMS010N	4.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,970
M12 × 1.75	P4	EPHMS012P	4.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 5,630
M12 × 1.5	P4	EPHMS012O	4.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 5,630 ※
M12 × 1.25	P4	EPHMS012N	4.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 5,630 ※
M14 × 2	P5	EPHMT014Q	4.5P	88	26	-	45	10.5	8	11	3	2	¥ 7,670 ※
M14 × 1.5	P4	EPHMS014O	4.5P	88	26	-	45	10.5	8	11	3	2	¥ 7,670
M16 × 2	P5	EPHMT016Q	4.5P	95	26	-	48	12.5	10	13	3	2	¥ 10,300
M16 × 1.5	P4	EPHMS016O	4.5P	95	26	-	48	12.5	10	13	3	2	¥ 10,300 ※
M18 × 2.5	P5	EPHMT018R	4.5P	100	33	-	51	14	11	14	3	2	¥ 13,900 ※
M18 × 1.5	P4	EPHMS018O	4.5P	100	33	-	51	14	11	14	3	2	¥ 13,900 ※
M20 × 2.5	P5	EPHMT020R	4.5P	105	33	-	50	15	12	15	3	3	¥ 18,700 ※
M20 × 1.5	P4	EPHMS020O	4.5P	105	33	-	50	15	12	15	3	3	¥ 18,700 ※
M22 × 2.5	P5	EPHMT022R	4.5P	115	33	-	55	17	13	16	3	3	¥ 23,900 ※
M22 × 1.5	P4	EPHMS022O	4.5P	115	33	-	55	17	13	16	3	3	¥ 23,900 ※
M24 × 3	P5	EPHMT024S	4.5P	120	39	-	55	19	15	18	3	3	¥ 29,900 ※
M24 × 1.5	P4	EPHMS024O	4.5P	120	39	-	55	19	15	18	3	3	¥ 29,900 ※

Cemented
Carbide Taps

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Thread Mills
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Center Drills
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Precision Machinery/
Metal Surgical Instruments

⑫

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③-94

※ = Specified Distribution Items. Made to order products.

 Think threads with
YAMAWA