

# ② Spiral Fluted Tap Series for through hole

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	$\ell$	$\ell_n$	$\ell_s$	Ds	K	$\ell_k$

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

②-33

# DIN

## F-SL

Spiral Fluted Taps for High Speed Tapping, Through Hole Use (with LH Spiral Flutes)



### Specification

**HSS**

**Coating**



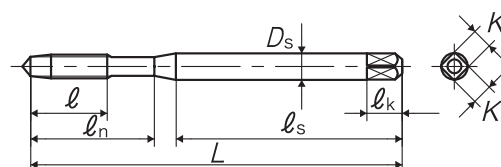
### Tapping Speeds depending on Materials

Low carbon steels  
低炭素鋼  
**15~25**  
(m/min)

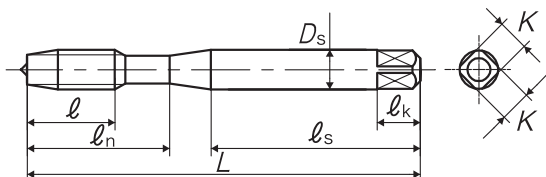
Medium carbon steels  
中炭素鋼  
**15~25**  
(m/min)

■ F-SL, spiral fluted tap, through hole use (with LH spiral flutes) is applicable for such high speed tapping as 15m/min to 25m/min. Under low tapping speed, chip shape and chip ejection may become poor and cause tapping troubles.

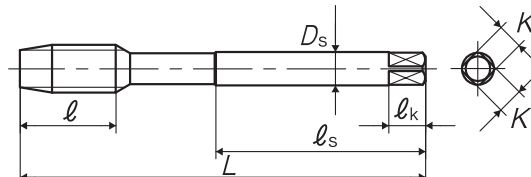
### TYPE:1



### TYPE:2



### TYPE:3



Segment : 1S

Size	Class	Code	Chamfer	L (mm)	$\ell$ (mm)	$\ell_n$ (mm)	$\ell_s$ (mm)	Ds (mm)	K (mm)	$\ell_k$ (mm)	No. of flutes	TYPE
For Metric Threads												
M3 × 0.5	ISO2X	LD3.0GBNEV	5P	56	9	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2X	LD4.0IBNEV	5P	63	13	21	38	4.5	3.4	6	3	1
M5 × 0.8	ISO2X	LD5.0KBNEV	5P	70	14	25	39	6	4.9	8	3	1
M6 × 1	ISO2X	LY6.0MBNEV	5.5P	80	15	30	45	6	4.9	8	3	2
M8 × 1.25	ISO2X	LY8.0NBNEV	5.5P	90	19	35	48	8	6.2	9	3	2
M10 × 1.5	ISO2X	LY010OBNEV	5.5P	100	23	39	53	10	8	11	3	2
M10 × 1.25	ISO2X	LY010NBNEV	5.5P	100	19	39	53	10	8	11	3	2
M12 × 1.75	ISO2X	LY012PBNEV	5.5P	110	26	45	56	12	9	12	3	2
M12 × 1.75	ISO2X	LG012PBNEV	5.5P	110	26	-	56	9	7	10	3	3
M12 × 1.5	ISO2X	LY012OBNEV	5.5P	110	23	45	56	12	9	12	3	2
M12 × 1.5	ISO2X	LM012OBNEV	5.5P	100	21	-	51	9	7	10	3	3
M12 × 1.25	ISO2X	LY012NBNEV	5.5P	110	19	45	56	12	9	12	3	2
M12 × 1.25	ISO2X	LM012NBNEV	5.5P	100	21	-	51	9	7	10	3	3

Think threads with  
**YAMAWA**

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