

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	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

②-29



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
低碳素鋼
15~25
(m/min)

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

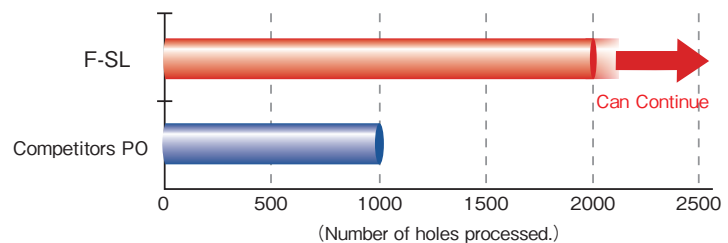
Product Features

- High speed machining is possible with a machine equipped with a fully synchronous feed mechanism.
- At low speed, the shape and discharge of the chip deteriorate, causing problems.

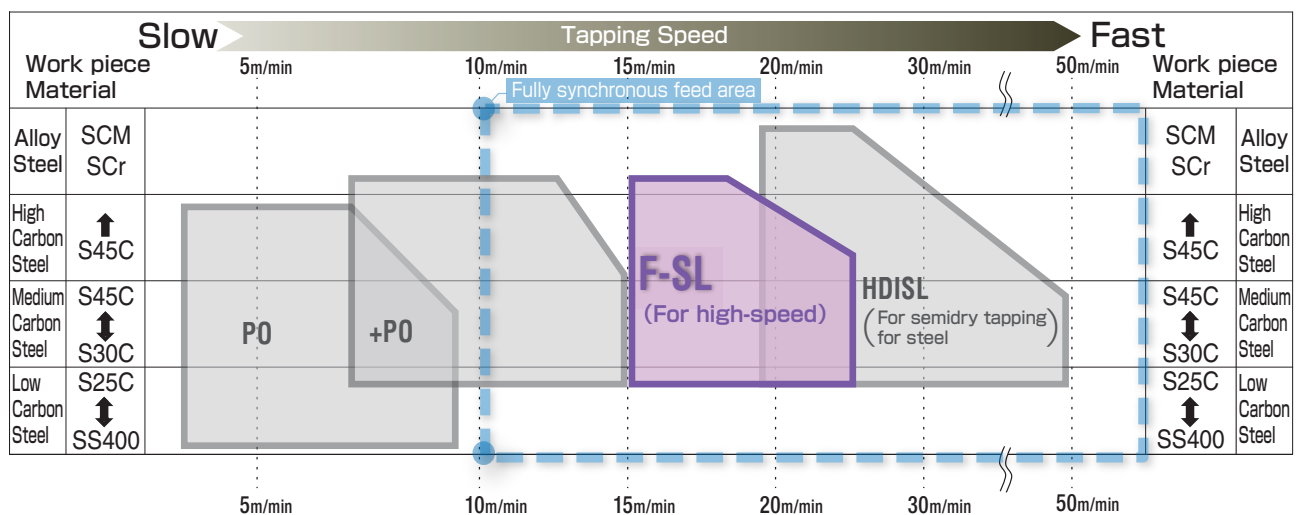
Tapping Data

Tapping conditions [M8 × 1.25]

Workpiece Material	S50C
Hardness	Raw material
Bored Hole Shape	Through hole
Tapping Length	1.5D ~
Machinery Type	M/C
Tapping Direction	Vertical
Type of Feed	Synchronous
Tapping Speed	30m/min
Cutting Fluid	Water soluble cutting fluid
Bored Hole Process	Drill
Tapped Holes	2,000 holes



Recommended speed table



The above diagram is for the different materials shown.

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

2

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

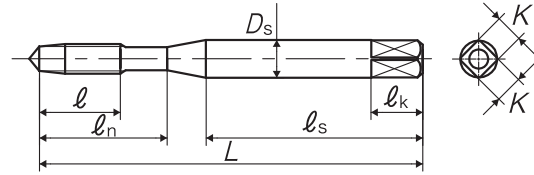
Precision Machinery/
Medical Surgical Instruments

⑫

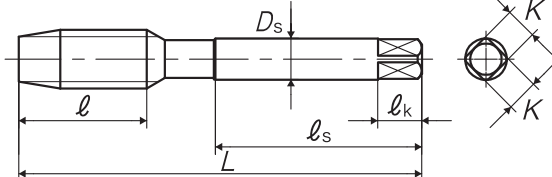
JIS

②-30

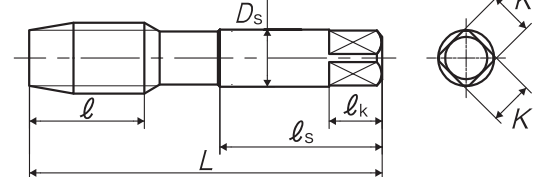
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1S

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													
M3 × 0.5	P2	VFSHM3.0GL	5P	46	9	14	26	4	3.2	6	3	1	¥ 4,240
M4 × 0.7	P2	VFSHM4.0IL	5P	52	11	17	29	5	4	7	3	1	¥ 4,300
M5 × 0.8	P2	VFSHM5.0KL	5P	60	13	22	33	5.5	4.5	7	3	1	¥ 4,610
M6 × 1	P2	VFSHM6.0ML	5P	62	15	26	33	6	4.5	7	3	1	¥ 4,960
M8 × 1.25	P3	VFSHMR8.0NL	5.5P	70	19	-	36	6.2	5	8	3	2	¥ 6,470
M10 × 1.5	P3	VFSHMR10.0L	5.5P	75	23	-	38	7	5.5	8	3	2	¥ 7,550
M10 × 1.25	P3	VFSHMR10.0NL	5.5P	75	23	-	38	7	5.5	8	3	2	¥ 7,550
M12 × 1.75	P4	VFSHMS12.0PL	5.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 9,560
M12 × 1.5	P3	VFSHMR12.0L	5.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 9,560
M12 × 1.25	P4	VFSHMS12.0NL	5.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 9,560
M14 × 2	P4	VFSHMS14.0QL	5.5P	88	26	-	45	10.5	8	11	3	2	¥ 11,800 *
M14 × 1.5	P3	VFSHMR14.0L	5.5P	88	26	-	45	10.5	8	11	3	2	¥ 11,800 *
M16 × 2	P4	VFSHMS16.0QL	5.5P	95	26	-	48	12.5	10	13	3	2	¥ 15,500 *
M16 × 1.5	P3	VFSHMR16.0L	5.5P	95	26	-	48	12.5	10	13	3	2	¥ 15,500 *
M18 × 2.5	P4	VFSHMS18.0RL	5.5P	100	33	-	51	14	11	14	4	2	¥ 20,700 *
M18 × 1.5	P4	VFSHMS18.0L	5.5P	100	33	-	51	14	11	14	4	2	¥ 20,700 *
M20 × 2.5	P4	VFSHMS20.0RL	5.5P	105	33	-	50	15	12	15	4	3	¥ 26,100 *
M20 × 1.5	P4	VFSHMS20.0L	5.5P	105	33	-	50	15	12	15	4	3	¥ 26,100 *
M22 × 2.5	P4	VFSHMS22.0RL	5.5P	115	33	-	55	17	13	16	4	3	¥ 32,900 *
M22 × 1.5	P4	VFSHMS22.0L	5.5P	115	33	-	55	17	13	16	4	3	¥ 32,900 *
M24 × 3	P4	VFSHMS24.0SL	5.5P	120	39	-	55	19	15	18	4	3	¥ 41,400 *
M24 × 1.5	P4	VFSHMS24.0L	5.5P	120	39	-	55	19	15	18	4	3	¥ 41,400 *

* = Specified Distribution Items. Made to order products.

 Think threads with
YAMAWA