

# ① Spiral Fluted Tap Series for blind hole

| Overall length | Chamfer+ full thread | Thread length | Thread + Neck length | Shank length | Shank dia. | Size of square | Length of square |
|----------------|----------------------|---------------|----------------------|--------------|------------|----------------|------------------|
| L              | $\ell_t$             | $\ell$        | $\ell_n$             | $\ell_s$     | 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

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## F-SP

Spiral Fluted Taps for High Speed Tapping



### Specification

HSS

Coating



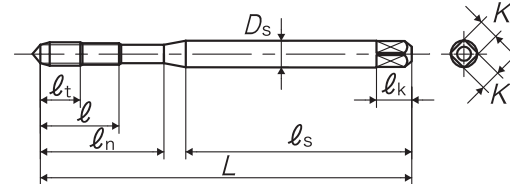
■ Spiral fluted tap applicable for such high speed tapping as 15m/min to 25m/min. Under low tapping speed, poor chip shape and poor chip ejection may occur and cause tapping troubles.

### Tapping Speeds depending on Materials

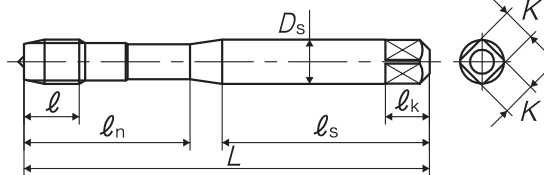
Low carbon steels  
低炭素鋼  
15~25  
(m/min)

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

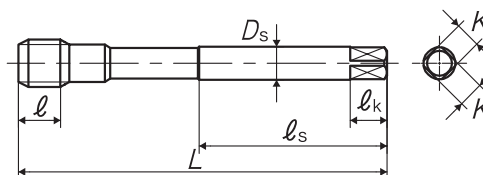
#### TYPE: 1



#### TYPE: 2



#### TYPE: 3



Segment : 1C

| Size               | Class | Code       | Chamfer | L (mm) | $\ell_t$ (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 | SD3.0GBNEV | 2.5P    | 56     | 5             | 9           | 18            | 34            | 3.5     | 2.7    | 6             | 3             | 1    |
| M4 × 0.7           | ISO2X | SD4.0IBNEV | 2.5P    | 63     | 7             | 13          | 21            | 38            | 4.5     | 3.4    | 6             | 3             | 1    |
| M5 × 0.8           | ISO2X | SD5.0KBNEV | 2.5P    | 70     | 9             | 14          | 25            | 39            | 6       | 4.9    | 8             | 3             | 1    |
| M6 × 1             | ISO2X | SY6.0MBNEV | 2.5P    | 80     | 11            | 15          | 30            | 45            | 6       | 4.9    | 8             | 3             | 1    |
| M8 × 1.25          | ISO2X | SY8.0NBNEV | 2.5P    | 90     | -             | 12          | 35            | 48            | 8       | 6.2    | 9             | 3             | 2    |
| M10 × 1.5          | ISO2X | SY010OBNEV | 2.5P    | 100    | -             | 13          | 39            | 53            | 10      | 8      | 11            | 3             | 2    |
| M10 × 1.25         | ISO2X | SY010NBNEV | 2.5P    | 100    | -             | 13          | 39            | 53            | 10      | 8      | 11            | 3             | 2    |
| M12 × 1.75         | ISO2X | SY012PBNEV | 2.5P    | 110    | -             | 15          | 45            | 56            | 12      | 9      | 12            | 3             | 2    |
| M12 × 1.75         | ISO2X | SG012PBNEV | 2.5P    | 110    | -             | 15          | -             | 56            | 9       | 7      | 10            | 3             | 3    |
| M12 × 1.5          | ISO2X | SY012OBNEV | 2.5P    | 110    | -             | 15          | 45            | 56            | 12      | 9      | 12            | 3             | 2    |
| M12 × 1.5          | ISO2X | SM012OBNEV | 2.5P    | 100    | -             | 15          | -             | 51            | 9       | 7      | 10            | 3             | 3    |
| M12 × 1.25         | ISO2X | SY012NBNEV | 2.5P    | 110    | -             | 15          | 45            | 56            | 12      | 9      | 12            | 3             | 2    |
| M12 × 1.25         | ISO2X | SM012NBNEV | 2.5P    | 100    | -             | 15          | -             | 51            | 9       | 7      | 10            | 3             | 3    |

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Think threads with  
**YAMAWA**

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