

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	ℓt	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

①-189



F-SP

Spiral Fluted Taps for High Speed Tapping



Specification



Tapping Speeds depending on Materials

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

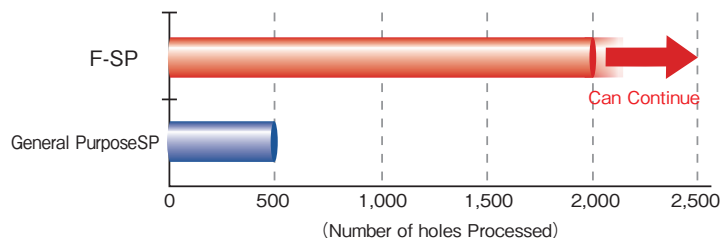
Product Features

- High speed machining is possible with a machine equipped with a fully synchronous feed mechanism.
- The F-SP exhibits excellent chip ejection properties from its unique flute shape and short thread length.
- At low speed, the shape and ejection of the chips can deteriorate, causing problems.

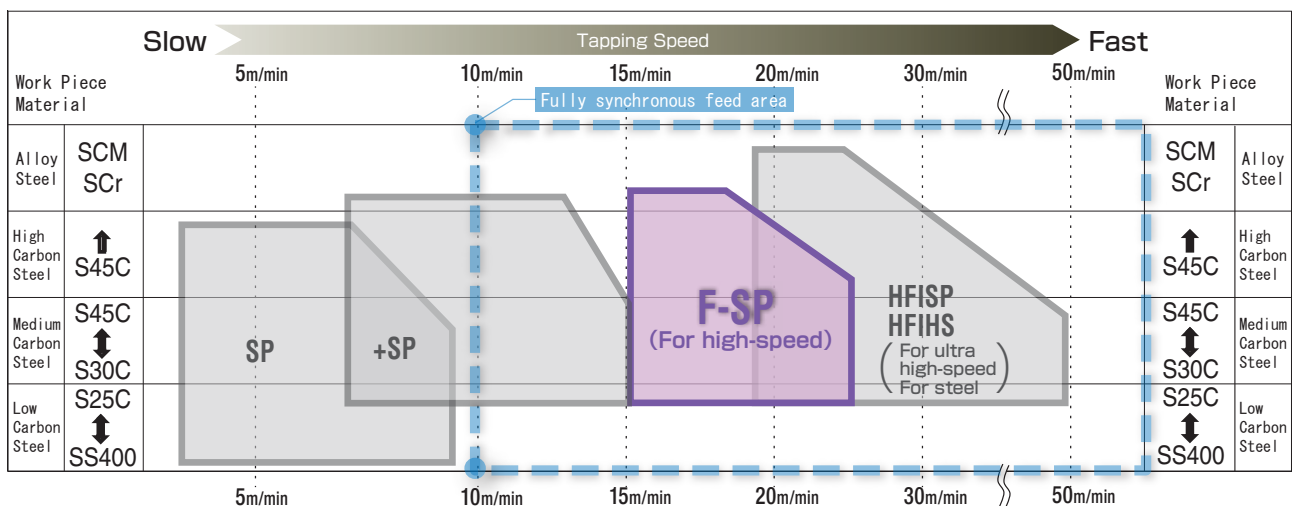
Tapping Data

Tapping Conditions [M6×1]

Work Piece Material	S50C
Bored Hole Shape	Blind hole
Tapping Length	1.5D ~
Machinery Type	M/C
Tapping Direction	Vertical
Feed	Synchronous
Tapping Speed	20m/min
Cutting Fluid	Water soluble cutting fluid
Pilot hole Processing Method	Drill
Number of Holes Processed	2,000



Speed chart



Overall length	Chamfer+ full thread	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ_t	ℓ	ℓ_n	ℓ_s	Ds	K	ℓ_k

1

JIS

Spiral Fluted Taps
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Special Thread Taps
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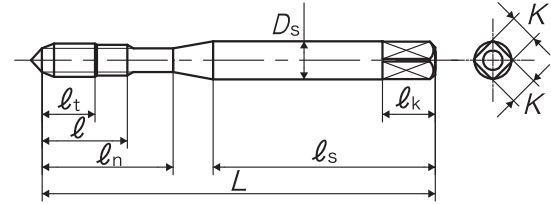
Dies ⑩

Center Drills
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Medical Surgical Instruments ⑫

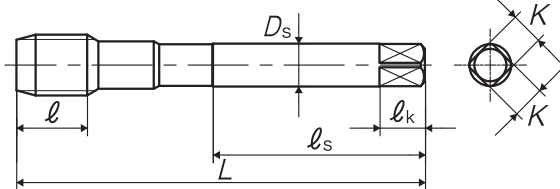
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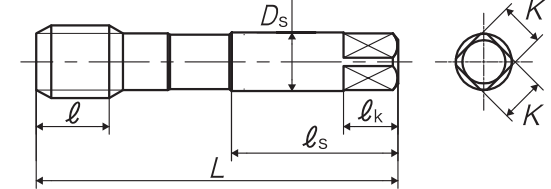
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1C

Size	Class	Code	Chamfer	L (mm)	ℓ_t (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	P2	VFSHMQ3.0G	2.5P	46	5	9	14	26	4	3.2	6	3	1	¥ 4,240
M4 × 0.7	P2	VFSHMQ4.0I	2.5P	52	7	11	17	29	5	4	7	3	1	¥ 4,300
M5 × 0.8	P2	VFSHMQ5.0K	2.5P	60	9	13	22	33	5.5	4.5	7	3	1	¥ 4,610
M6 × 1	P2	VFSHMQ6.0M	2.5P	62	11	15	26	33	6	4.5	7	3	1	¥ 4,960
M8 × 1.25	P3	VFSHMR8.0N	3P	70	-	12	-	36	6.2	5	8	3	2	¥ 6,470
M10 × 1.5	P3	VFSHMR010O	3P	75	-	13	-	38	7	5.5	8	3	2	¥ 7,550
M10 × 1.25	P3	VFSHMR010N	3P	75	-	13	-	38	7	5.5	8	3	2	¥ 7,550
M12 × 1.75	P4	VFSHMS012P	3P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 9,560
M12 × 1.5	P3	VFSHMR012O	3P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 9,560
M12 × 1.25	P4	VFSHMS012N	3P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 9,560
M14 × 2	P4	VFSHMS014Q	3P	88	-	18	-	45	10.5	8	11	3	2	¥ 11,800 ※
M14 × 1.5	P3	VFSHMR014O	3P	88	-	14	-	45	10.5	8	11	3	2	¥ 11,800 ※
M16 × 2	P4	VFSHMS016Q	3P	95	-	18	-	48	12.5	10	13	3	2	¥ 15,500 ※
M16 × 1.5	P3	VFSHMR016O	3P	95	-	14	-	48	12.5	10	13	3	2	¥ 15,500 ※
M18 × 2.5	P4	VFSHMS018R	3P	100	-	20	-	51	14	11	14	4	2	¥ 20,700 ※
M18 × 1.5	P4	VFSHMS018O	3P	100	-	14	-	51	14	11	14	4	2	¥ 20,700 ※
M20 × 2.5	P4	VFSHMS020R	3P	105	-	20	-	50	15	12	15	4	3	¥ 26,100 ※
M20 × 1.5	P4	VFSHMS020O	3P	105	-	14	-	50	15	12	15	4	3	¥ 26,100 ※
M22 × 2.5	P4	VFSHMS022R	3P	115	-	20	-	55	17	13	16	4	3	¥ 32,900 ※
M22 × 1.5	P4	VFSHMS022O	3P	115	-	14	-	55	17	13	16	4	3	¥ 32,900 ※
M24 × 3	P4	VFSHMS024S	3P	120	-	25	-	55	19	15	18	4	3	¥ 41,400 ※
M24 × 1.5	P4	VFSHMS024O	3P	120	-	18	-	55	19	15	18	4	3	¥ 41,400 ※

※ = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA