

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

③-87



## HC+PO HC-PO

Spiral Pointed Taps for High Carbon Steels



### Specification



### Tapping Speeds depending on Materials

Medium carbon steels  
中炭素鋼  
**5~10**  
(m/min)

High carbon steels  
高炭素鋼  
**5~10**  
(m/min)

Thermal refined steels  
調質鋼  
**5~10**  
(m/min)

25~35HRC

### • Product Name and Size.

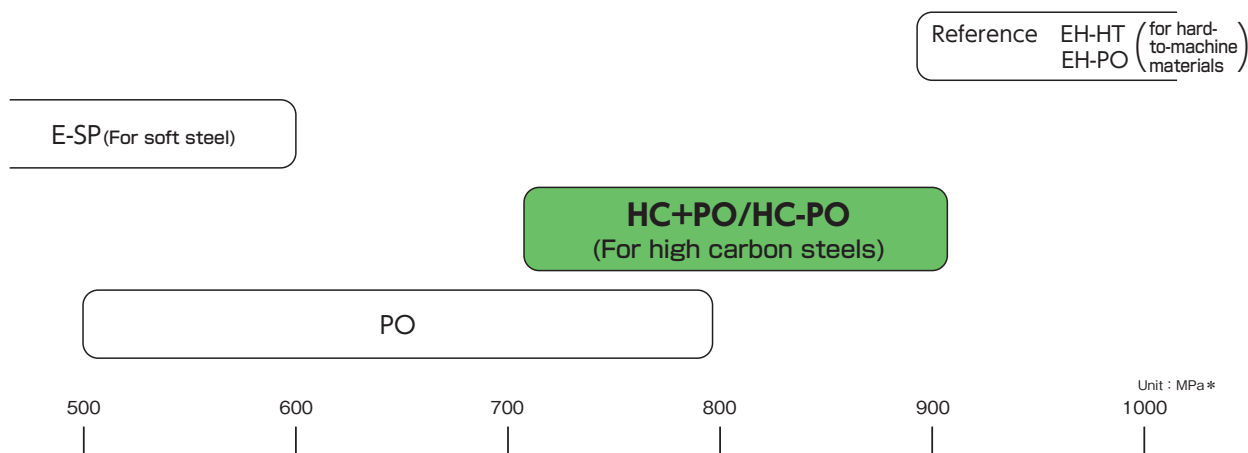
HC+PO	~ M2.6
HC-PO	M3 ~

### Product Features

- The HC+PO/HC-PO is a spiral pointed tap suitable for the tapping medium and high hardness workpiece materials up to 35 HRC in high carbon steel such as S55C.

### Product system chart (tensile strength)

HC+PO/HC-PO Application range (tensile strength)



\* 1MPa=1N/mm<sup>2</sup> ≒ 1Kgf/mm<sup>2</sup> ÷ 9.8

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3

JIS

Spiral Fluted Taps  
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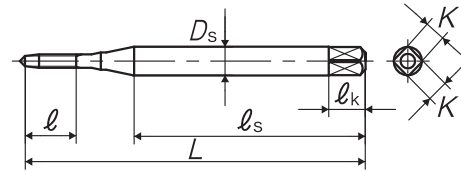
Precision Machinery/  
Metal Surgical Instruments

⑫

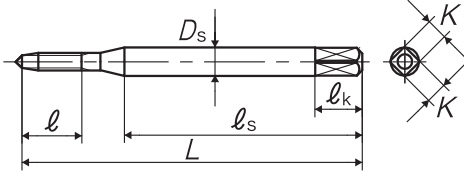
JIS

③-88

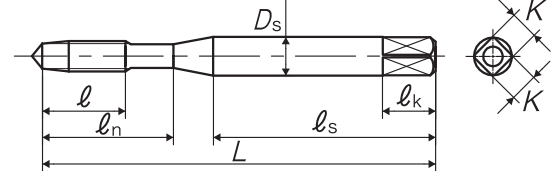
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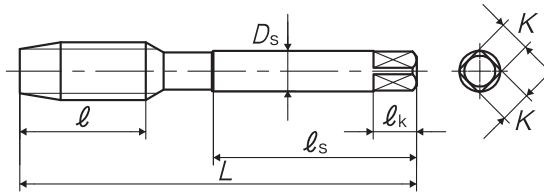
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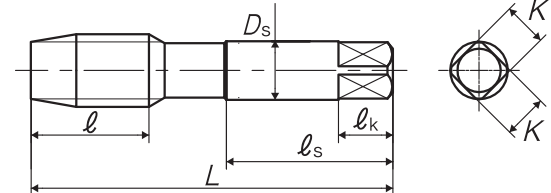
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TYPE: 4



TYPE: 5



## HC+PO Spiral Pointed Taps for High Carbon Steels

Segment : 1E

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ <sub>n</sub> (mm)	ℓ <sub>s</sub> (mm)	D <sub>s</sub> (mm)	K (mm)	ℓ <sub>k</sub> (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M1.4 × 0.3	P1	PCPP1.4C	5P	36	5.4	-	24	3	2.5	5	2	1	¥ 3,700
M1.6 × 0.35	P2	PCPQ1.6D	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,530
M1.7 × 0.35	P2	PCPQ1.7D	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,530
M2 × 0.4	P2	PCPQ2.0E	5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,820
M2.5 × 0.45	P2	PCPQ2.5F	5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,160
M2.6 × 0.45	P2	PCPQ2.6F	5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,160

## HC-PO Spiral Pointed Taps for High Carbon Steels

Segment : 1E

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ <sub>n</sub> (mm)	ℓ <sub>s</sub> (mm)	D <sub>s</sub> (mm)	K (mm)	ℓ <sub>k</sub> (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M3 × 0.5	P2	PCMQ3.0G	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,520
M4 × 0.7	P2	PCMQ4.0I	5P	52	11	17	29	5	4	7	3	3	¥ 1,520
M5 × 0.8	P2	PCMQ5.0K	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,530
M6 × 1	P2	PCMQ6.0M	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,680
M8 × 1.25	P3	PCMR8.0N	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,310
M10 × 1.5	P3	PCMR10.0O	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,930
M10 × 1.25	P3	PCMR10.0N	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,930 *
M12 × 1.75	P4	PCMS12.0P	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,160
M12 × 1.5	P3	PCMR12.0O	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,160 *
M12 × 1.25	P4	PCMS12.0N	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,160 *
M14 × 2	P4	PCMS14.0Q	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,670 *
M14 × 1.5	P3	PCMR14.0O	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,670 *

\* = Specified Distribution Items. Made to order products.

 Think threads with  
**YAMAWA**

# 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

## HC-PO Spiral Pointed Taps for High Carbon Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M16 × 2	P4	PCMS016Q	5P	95	26	-	48	12.5	10	13	3	4	¥ 7,580 ※
M16 × 1.5	P3	PCMR016O	5P	95	26	-	48	12.5	10	13	3	4	¥ 7,580 ※
M18 × 2.5	P4	PCMS018R	5P	100	33	-	51	14	11	14	3	4	¥ 10,200 ※
M18 × 1.5	P4	PCMS018O	5P	100	33	-	51	14	11	14	3	4	¥ 10,200 ※
M20 × 2.5	P4	PCMS020R	5P	105	33	-	50	15	12	15	3	5	¥ 13,800 ※
M20 × 1.5	P4	PCMS020O	5P	105	33	-	50	15	12	15	3	5	¥ 13,800 ※
M22 × 2.5	P4	PCMS022R	5P	115	33	-	55	17	13	16	3	5	¥ 17,700 ※
M24 × 3	P4	PCMS024S	5P	120	39	-	55	19	15	18	3	5	¥ 22,000 ※

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

3-89