Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

HC+SP
HC-SP

Spiral Fluted Taps for High Carbon Steels

Specification

・Product Name and Size.

HC+SP	～M6
HC−SP	M8～, all W

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)

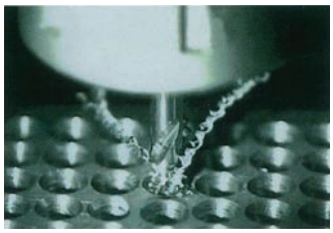
Product Features

●The HC+SP/HC-SP is a spiral flute tap for high carbon steel such as S55C and is suitable for tapping of medium and high hardness materials up to 30 HRC.

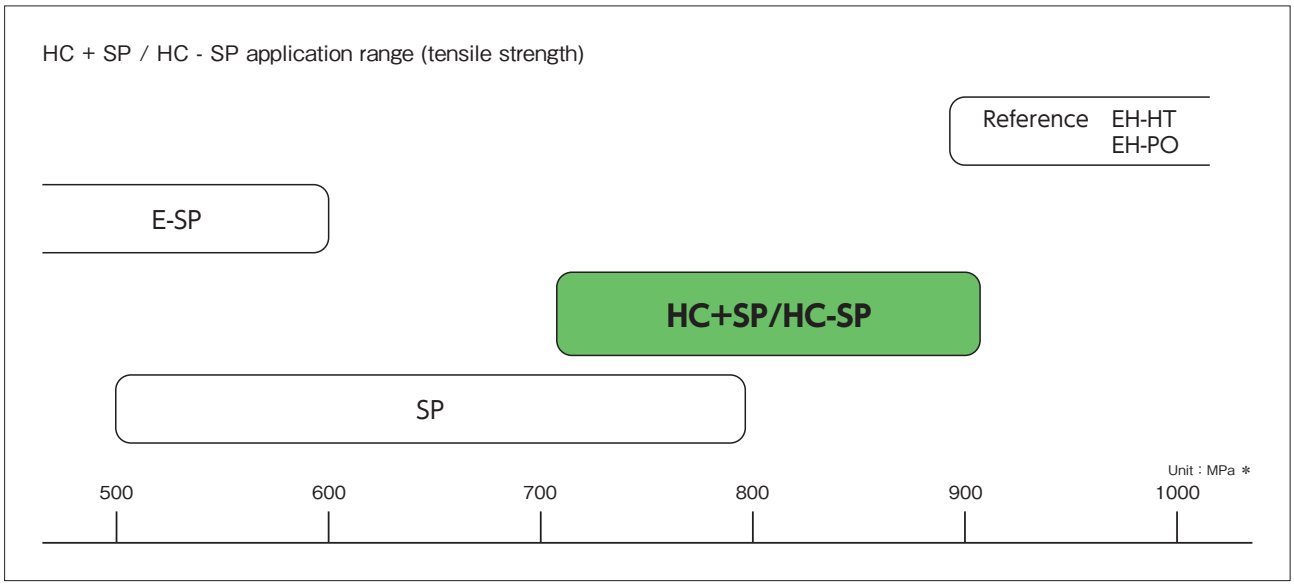
Tapping conditions

The HC+SP/HC-SP is best suited for tapping of high carbon steel, alloy tool steel and refined steel.

Workpiece Material	Cutting Speed (m/min)
S45C～ High Carbon Steel	10～20
SKC、SKD Alloy Tool Steel	5～10
Thermal Refining Steel 25～35HRC	5～10



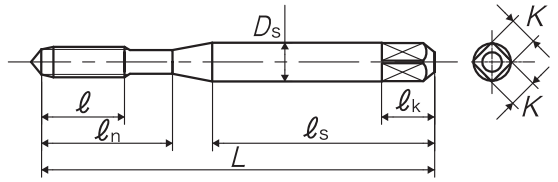
Product chart (tensile strength)



＊1MPa=1N/mm²≒1Kgf/mm²÷9.8

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

TYPE : 1



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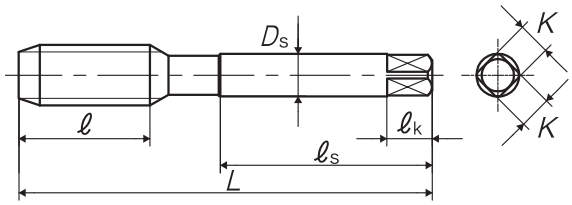

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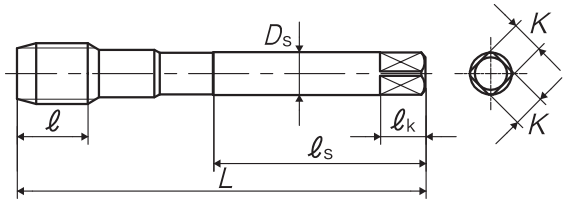

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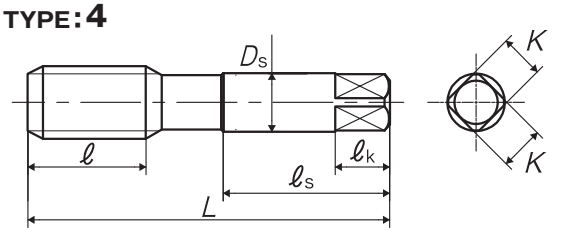

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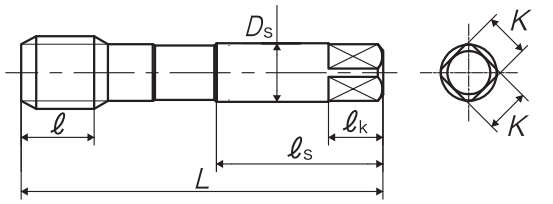

HC+SP Spiral Fluted Taps for High Carbon Steels

Segment : 1C

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M3 × 0.5	P1	SCPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	1	¥ 1,260
M4 × 0.7	P2	SCPQ4.0I	2.5P	52	11	17	29	5	4	7	3	1	¥ 1,260
M5 × 0.8	P2	SCPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 1,270
M6 × 1	P2	SCPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,400

HC-SP Spiral Fluted Taps for High Carbon Steels

Segment : 1C

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M8 × 1.25	P2	SCMQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 1,920
M8 × 1	P2	SCMQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 2,180 ※
M10 × 1.5	P2	SCMQ010O	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 2,440
M10 × 1.25	P2	SCMQ010N	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 2,440 ※
M10 × 1	P2	SCMQ010M	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 2,900 ※
M12 × 1.75	P2	SCMQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 3,460
M12 × 1.5	P2	SCMQ012O	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 3,460 ※
M12 × 1.25	P2	SCMQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 3,460 ※
M12 × 1	P2	SCMQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,070 ※
M14 × 2	P2	SCMQ014Q	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 4,720 ※
M14 × 1.5	P2	SCMQ014O	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 4,720 ※
M14 × 1.25	P2	SCMQ014N	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 5,480 ※
M14 × 1	P2	SCMQ014M	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 5,480 ※
M16 × 2	P2	SCMQ016Q	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 6,310

※ = Specified Distribution Items. Made to order products.

Think threads with YAMAWA

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

HC-SP Spiral Fluted 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 × 1.5	P2	SCMQ016O	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 6,310 ※
M16 × 1	P2	SCMQ016M	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 7,520 ※
M18 × 2.5	P3	SCMR018R	2.5P	100	33	-	51	14	11	14	4	2	¥ 8,430 ※
M18 × 2	P3	SCMR018Q	2.5P	100	33	-	51	14	11	14	4	2	¥ 8,430 ※
M18 × 1.5	P2	SCMQ018O	2.5P	100	33	-	51	14	11	14	4	2	¥ 8,430 ※
M18 × 1	P2	SCMQ018M	2.5P	100	18	-	51	14	11	14	4	3	¥ 10,900 ※
M20 × 2.5	P3	SCMR020R	2.5P	105	33	-	50	15	12	15	4	4	¥ 11,500
M20 × 2	P3	SCMR020Q	2.5P	105	33	-	50	15	12	15	4	4	¥ 11,500 ※
M20 × 1.5	P3	SCMR020O	2.5P	105	33	-	50	15	12	15	4	4	¥ 11,500 ※
M20 × 1	P2	SCMQ020M	2.5P	105	18	-	50	15	12	15	4	5	¥ 14,600 ※
M22 × 2.5	P3	SCMR022R	2.5P	115	33	-	55	17	13	16	4	4	¥ 14,700 ※
M22 × 2	P3	SCMR022Q	2.5P	115	33	-	55	17	13	16	4	4	¥ 14,700 ※
M22 × 1.5	P3	SCMR022O	2.5P	115	33	-	55	17	13	16	4	4	¥ 14,700 ※
M24 × 3	P3	SCMR024S	2.5P	120	39	-	55	19	15	18	4	4	¥ 18,300 ※
M24 × 2	P3	SCMR024Q	2.5P	120	39	-	55	19	15	18	4	4	¥ 18,300 ※
M24 × 1.5	P3	SCMR024O	2.5P	120	39	-	55	19	15	18	4	4	¥ 18,300 ※
M25 × 1.5	P3	SCMR025O	2.5P	125	39	-	58	19	15	18	4	4	¥ 23,700 ※
M26 × 1.5	P3	SCMR026O	2.5P	130	39	-	60	20	15	18	4	4	¥ 25,500 ※
M27 × 3	P3	SCMR027S	2.5P	130	39	-	60	20	15	18	4	4	¥ 25,500 ※
M27 × 1.5	P3	SCMR027O	2.5P	130	39	-	60	20	15	18	4	4	¥ 25,500 ※
M28 × 1.5	P3	SCMR028O	2.5P	135	46	-	62	23	17	20	4	4	¥ 32,500 ※
M30 × 3.5	P4	SCMS030T	2.5P	135	46	-	62	23	17	20	4	4	¥ 32,500 ※
M30 × 1.5	P3	SCMR030O	2.5P	135	46	-	62	23	17	20	4	4	¥ 32,500 ※
For Whitworth Threads													
1/4W20	P2	SCMQW04N	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,600 ※
5/16W18	P2	SCMQW05O	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 2,210 ※
3/8W16	P2	SCMQW06P	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 2,830 ※
1/2W12	P3	SCMRW08S	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 4,230 ※
5/8W11	P3	SCMRW10U	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 6,310 ※
3/4W10	P3	SCMRW12V	2.5P	105	33	-	50	15	12	15	4	4	¥ 11,500 ※
7/8W9	P3	SCMRW14W	2.5P	115	33	-	55	17	13	16	4	4	¥ 16,200 ※
1 W8	P3	SCMRW16X	2.5P	125	39	-	58	19	15	18	4	4	¥ 23,700 ※

※ = Specified Distribution Items. Made to order products.