

| 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

③-95



## 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



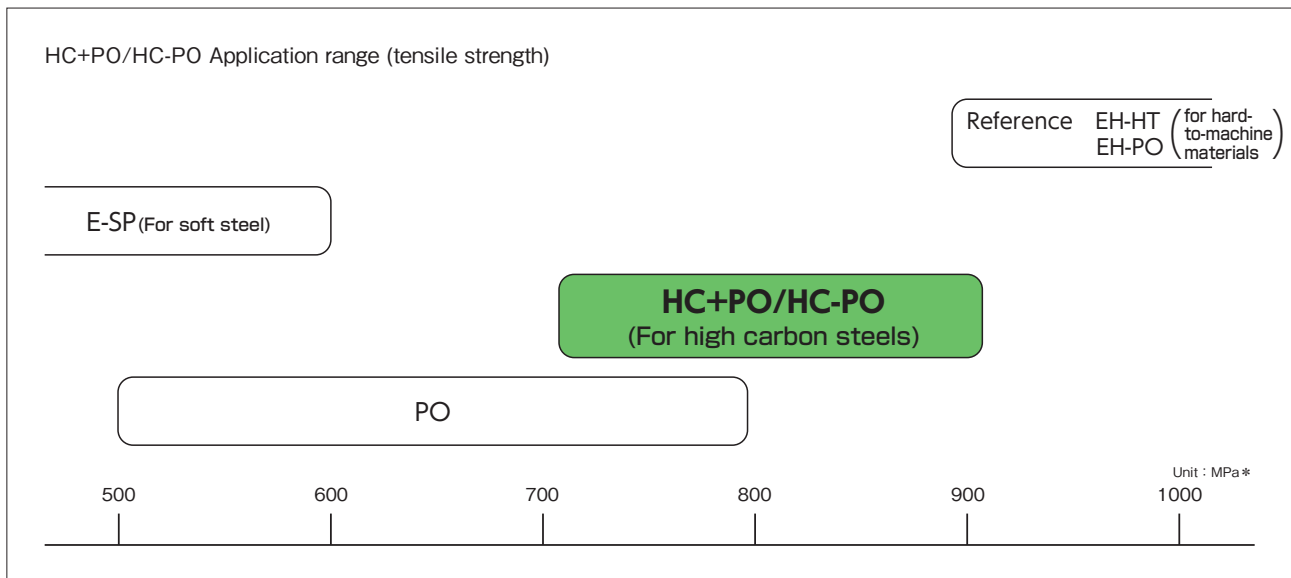
• Product Name and Size.

|       |        |
|-------|--------|
| 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)



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

| Overall length | Thread length | Thread + Neck length | Shank length   | Shank dia.     | Size of square | Length of square |
|----------------|---------------|----------------------|----------------|----------------|----------------|------------------|
| L              | ℓ             | ℓ <sub>n</sub>       | ℓ <sub>s</sub> | D <sub>s</sub> | K              | ℓ <sub>k</sub>   |

3

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

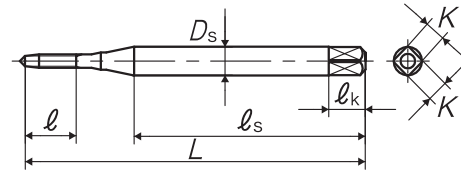
Precision Machinery/  
Metal Surgical Instruments

⑫

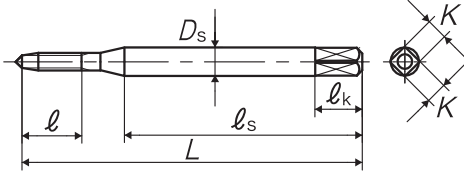
JIS

③-96

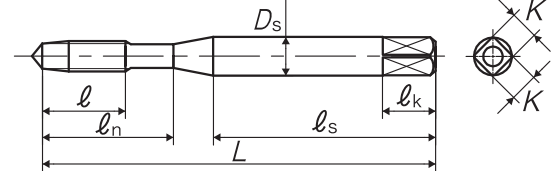
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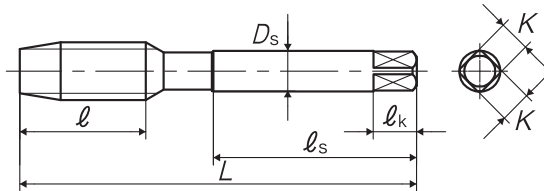
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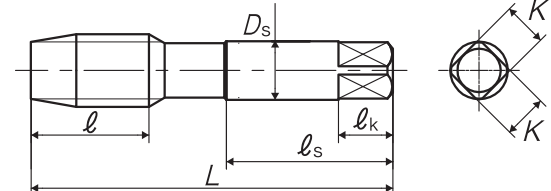
TYPE: 3



TYPE: 4



TYPE: 5



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

Segment : 1E

| Size               | Class | Code     | Chamfer | L<br>(mm) | ℓ<br>(mm) | ℓ <sub>n</sub><br>(mm) | ℓ <sub>s</sub><br>(mm) | D <sub>s</sub><br>(mm) | K<br>(mm) | ℓ <sub>k</sub><br>(mm) | No. of<br>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<br>(mm) | ℓ<br>(mm) | ℓ <sub>n</sub><br>(mm) | ℓ <sub>s</sub><br>(mm) | D <sub>s</sub><br>(mm) | K<br>(mm) | ℓ <sub>k</sub><br>(mm) | No. of<br>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