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

HDASP

For Dry Tapping, Blind Hole Use. Spiral Fluted Taps for Aluminum

Specification

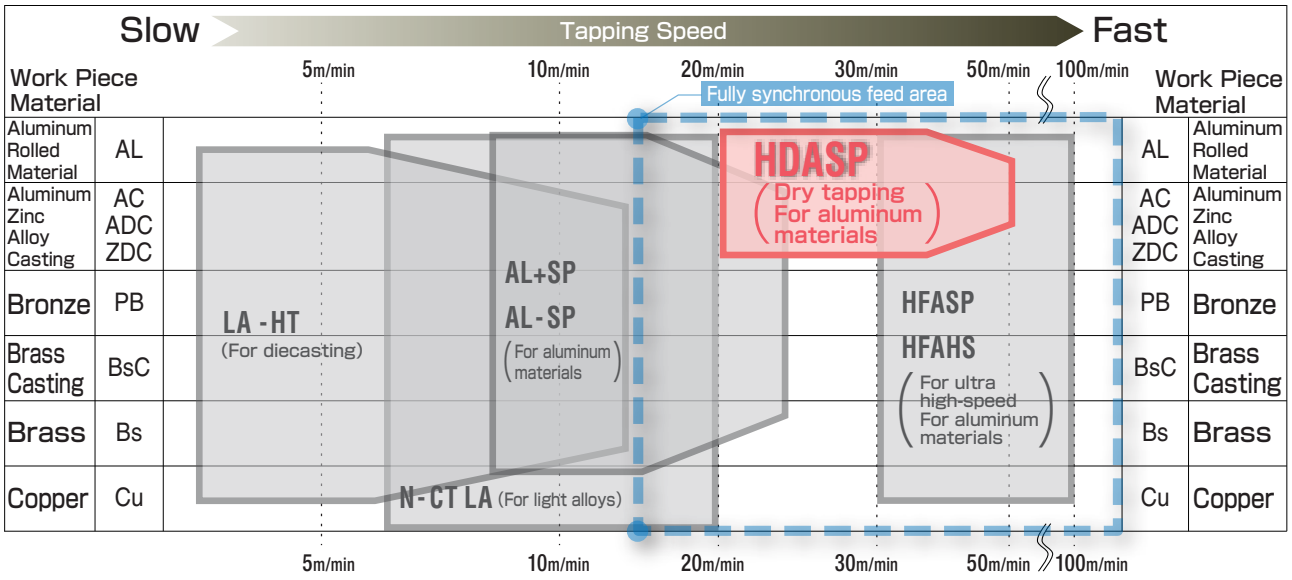
Tapping Speeds depending on Materials

Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物	Magnesium alloy die castings マグネシウム合金鋳物	Zinc alloy castings 亜鉛合金鋳物
20~50 (m/min)	20~50 (m/min)	20~50 (m/min)	20~50 (m/min)

Product Features

- Designed with a through center hole for coolant lubrication, mist lubrication or air blast applications in blind holes.
- The low helix flutes, making it the optimum tap for blind hole tapping on horizontal and vertical machines in materials such as aluminum castings, magnesium alloys and zinc alloys.

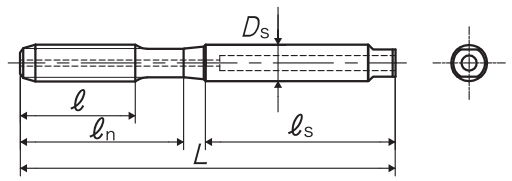
Speed chart



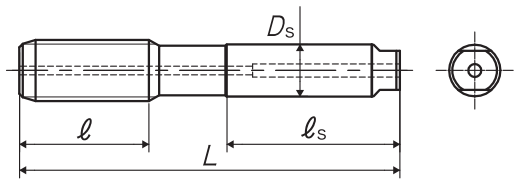
Tapping range by material being cut.

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



TYPE: 2



Segment : 1D

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													
M6 × 1	P4	HDASPS6.0M	2.5P	62	19	27	32	6	-	-	3	1	¥ 5,040
M8 × 1.25	P4	HDASPS8.0N	2.5P	70	22	-	36	8	-	-	3	2	¥ 7,410
M10 × 1.5	P4	HDASPS010O	2.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M10 × 1.25	P4	HDASPS010N	2.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M12 × 1.75	P4	HDASPS012P	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.5	P4	HDASPS012O	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.25	P4	HDASPS012N	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M14 × 1.5	P4	HDASPS014O	2.5P	88	30	-	40	12	-	-	3	2	¥ 18,300
M16 × 1.5	P4	HDASPS016O	2.5P	95	32	-	43	16	-	-	3	2	¥ 24,100
M18 × 1.5	P4	HDASPS018O	2.5P	100	37	-	45	16	-	-	3	2	¥ 34,200
M20 × 1.5	P5	HDASPT020O	2.5P	105	37	-	45	16	-	-	3	2	¥ 44,600

Note:
- There is no shank square. Use a holder with high holding force like a milling chuck.
- The back end of the HDASP shank has a tongue drive design. If the tool holder only grips on the back end of the HDASP shank tongue drive, the coolant may leak.