

② Spiral Fluted Tap Series for through hole

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

DIN

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

DIN

②-37

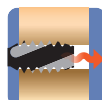
DIN

HDISL



Spiral Fluted Taps for Steels, for Dry Tapping and for Ultra High Speed Tapping, Through Hole Use (with LH Spiral Flutes)

Specification



■ Tapping under ultra high speed and under mist and dry, is possible with HDISL. Having radial coolant through hole, HDISL is suitable for carbon steels and alloy steels. For through hole use (with LH spiral flutes) for both vertical and horizontal use.

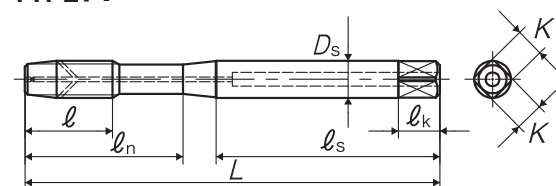
Tapping Speeds depending on Materials

Medium carbon steels
中炭素鋼
20~50
(m/min)

High carbon steels
高炭素鋼
20~50
(m/min)

Alloy steels
合金鋼
20~50
(m/min)

TYPE: 1



Segment : 1T

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads												
M6 × 1	ISO2X	LY6.0MBEDTLZ	5.5P	80	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	LY8.0NBEDTLZ	5.5P	90	19	35	48	8	6.2	9	3	1
M10 × 1.5	ISO2X	LY010OBEDTLZ	5.5P	100	23	39	53	10	8	11	3	1
M10 × 1.25	ISO2X	LY010NBEDTLZ	5.5P	100	23	39	53	10	8	11	3	1
M12 × 1.75	ISO2X	LY012PBEDTLZ	5.5P	110	26	44	57	12	9	12	3	1
M12 × 1.5	ISO2X	LY012OBEDTLZ	5.5P	110	26	44	57	12	9	12	3	1
M12 × 1.25	ISO2X	LY012NBEDTLZ	5.5P	110	26	44	57	12	9	12	3	1

Think threads with
YAMAWA

· This product is different from JIS products in shape and dimensions, please be careful when using.