

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	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

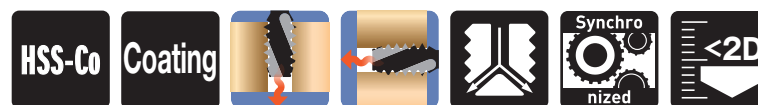
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HDISL



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

Specification



Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼
20~50 (m/min)	20~50 (m/min)	20~50 (m/min)

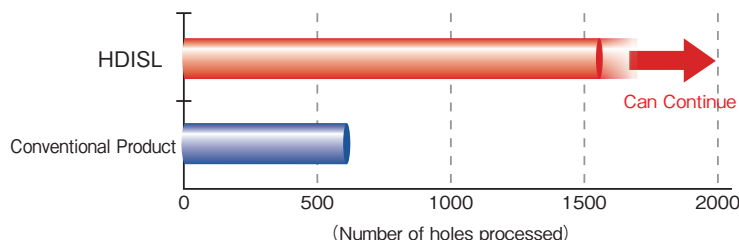
Product Features

- Ultra high-speed machining with mist or dry tapping machining are possible with a side coolant through hole shape.
- The left hand spiral flute shape makes it the perfect tapping for vertical or horizontal machining in carbon steel and alloy steel in through hole applications.

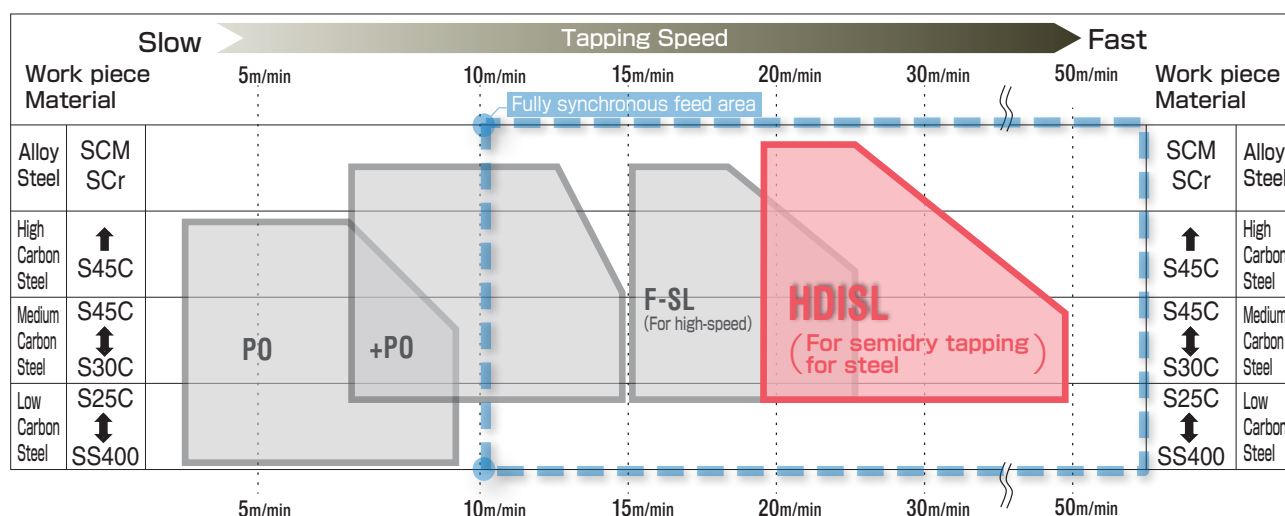
Tapping Data

Tapping Conditions [M12×1.25]

Workpiece Material	S55C tempered steel
Hole Shape	Through holes
Bored Hole Size	φ10.75
Tapping Length	18mm
Tapping Speed	50m/min
Machinery Type	M/C machine (horizontal type)
Cutting Fluid	Water soluble cutting fluid
Number of Holes Processed	1,600 holes



Speed recommendation table

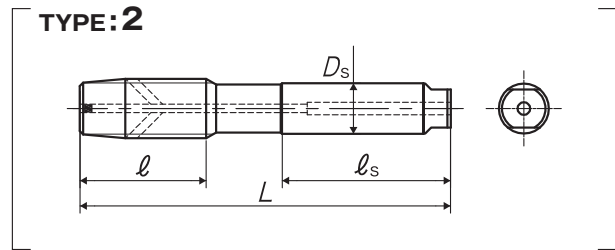
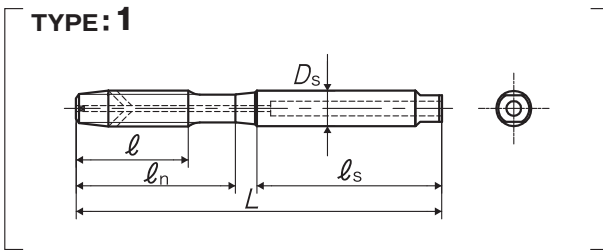


The above diagram is for the different materials shown.

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

2

JIS



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	MSRP
For Metric Threads													
M6 × 1	P4	HDISLS6.0M	5.5P	62	19	27	32	6	-	-	3	1	¥ 5,040
M8 × 1.25	P4	HDISLS8.0N	5.5P	70	22	-	36	8	-	-	3	2	¥ 7,410
M10 × 1.5	P4	HDISLS010O	5.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M10 × 1.25	P4	HDISLS010N	5.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M12 × 1.75	P4	HDISLS012P	5.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.5	P4	HDISLS012O	5.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.25	P4	HDISLS012N	5.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M14 × 1.5	P4	HDISLS014O	5.5P	88	30	-	40	12	-	-	3	2	¥ 18,300
M16 × 1.5	P4	HDISLS016O	5.5P	95	32	-	43	16	-	-	3	2	¥ 24,100
M18 × 1.5	P4	HDISLS018O	5.5P	100	37	-	45	16	-	-	4	2	¥ 34,200
M20 × 1.5	P5	HDISLT020O	5.5P	105	37	-	45	16	-	-	4	2	¥ 44,600

Remarks:

1. HDISL do not have square on its shank, please use holders having strong gripping force, such as milling chucks.
2. Rear end of the shank is to tongue specification. If the portion which contacts the rear end has V saucer, coolant may leak.

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