

① Spiral Fluted Tap Series for blind hole

Overall length	Chamfer + full thread	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ_t	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
①-207

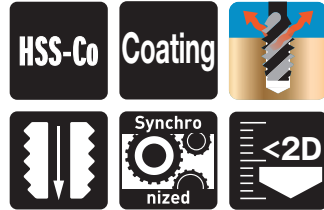
DIN

HFAHS

For Ultra Fast Tapping, Vertical Use, Spiral Fluted Taps for Aluminum



Specification



■ Applicable for ultra high speed tapping. Having center through hole geometry to correspond with inner coolant supply system, HFAHS is suitable for aluminum castings, blind hole use. Vertical tapping use.

Tapping Speeds depending on Materials

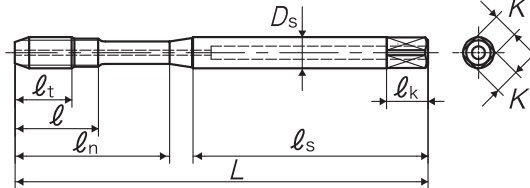
Wrought aluminum
アルミ圧延材
30~100
(m/min)

Aluminum alloy castings
アルミ合金鑄物
30~100
(m/min)

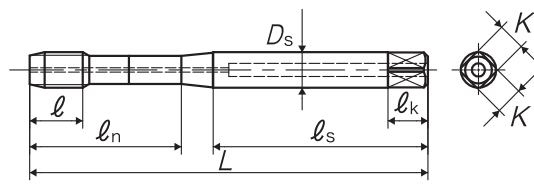
Magnesium alloy die castings
マグネシウム合金鑄物
30~100
(m/min)

Zinc alloy castings
亜鉛合金鑄物
30~100
(m/min)

TYPE: 1



TYPE: 2



Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ_t (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	SY6.0MBLDTZ	2.5P	80	11	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	SY8.0NBLDTZ	2.5P	90	-	12	35	48	8	6.2	9	3	2
M10 × 1.5	ISO2X	SY010OBLDTZ	2.5P	100	-	13	39	53	10	8	11	3	2
M10 × 1.25	ISO2X	SY010NBLDTZ	2.5P	100	-	13	39	53	10	8	11	3	2
M12 × 1.75	ISO2X	SY012PBLDTZ	2.5P	110	-	15	44	57	12	9	12	3	2
M12 × 1.5	ISO2X	SY012OBLDTZ	2.5P	110	-	15	44	57	12	9	12	3	2
M12 × 1.25	ISO2X	SY012NBLDTZ	2.5P	110	-	15	44	57	12	9	12	3	2

Think threads with
YAMAWA

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