

1 Spiral Fluted Tap Series for blind 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

- 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



HFAHS



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

Specification

HSS-Co

Coating

Synchro nized

Tapping Speeds depending on Materials

30~100
(m/min)

30~100
(m/min)

30~100
(m/min)

30~100
(m/min)

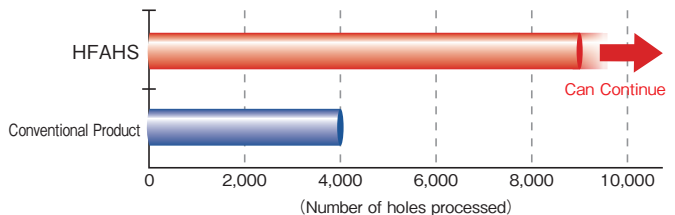
Product Features

- A center coolant through hole tap that can be used at ultra high speed and is compatible with internal lubrication processing.
- The high helix flutes, making it the optimum tap for materials such as aluminum alloy, magnesium alloy and zinc alloy castings.

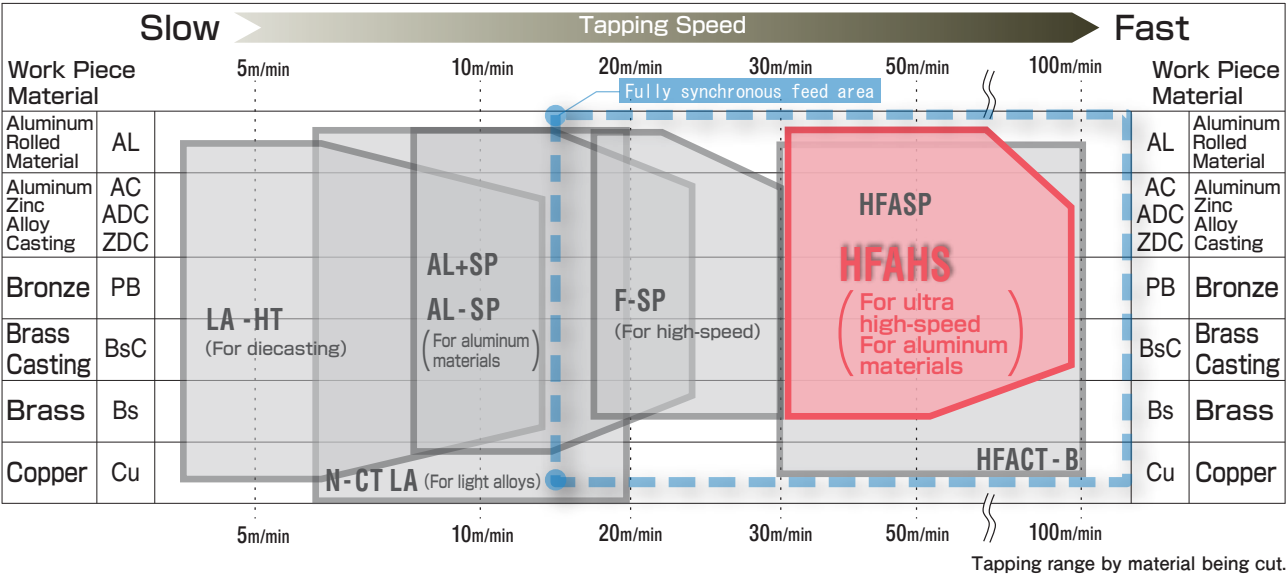
Tapping Data

Tapping Condition [P4 M6×1]

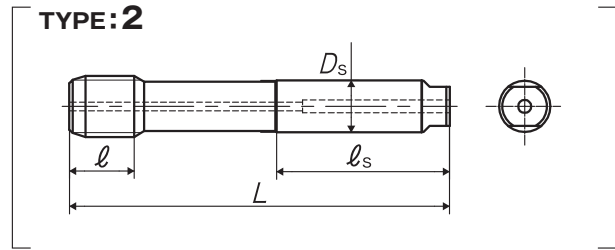
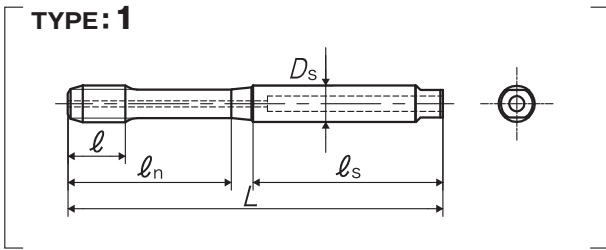
Work Piece Material	ADC12
Bored Hole Shape	Blind hole
Bored Hole Size	φ5.1
Tapping Length	15mm
Tapping Speed	104m/min
Machinery Type	M/C machining center (vertical type)
Cutting Fluid	Water soluble cutting fluid
Nubmer of Holes Processed	9,000



Speed chart



Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k



Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M6 × 1	P4	HFAHSS6.0M	2.5P	62	11	27	32	6	-	-	3	1	¥ 5,040
M8 × 1.25	P4	HFAHSS8.0N	2.5P	70	12	-	36	8	-	-	3	2	¥ 7,410
M10 × 1.5	P4	HFAHSS010O	2.5P	75	13	-	37	10	-	-	3	2	¥ 9,380
M10 × 1.25	P4	HFAHSS010N	2.5P	75	12	-	37	10	-	-	3	2	¥ 9,380
M12 × 1.75	P4	HFAHSS012P	2.5P	82	15	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.5	P4	HFAHSS012O	2.5P	82	14	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.25	P4	HFAHSS012N	2.5P	82	14	-	40	12	-	-	3	2	¥ 13,400
M14 × 1.5	P4	HFAHSS014O	2.5P	88	14	-	40	12	-	-	3	2	¥ 18,300
M16 × 1.5	P4	HFAHSS016O	2.5P	95	14	-	43	16	-	-	3	2	¥ 24,100
M18 × 1.5	P4	HFAHSS018O	2.5P	100	14	-	45	16	-	-	3	2	¥ 34,200
M20 × 1.5	P5	HFAHST020O	2.5P	105	14	-	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 HFAHS shank has a tongue drive design. If the tool holder only grips on the back end of the HFAHS shank tongue drive, the coolant may leak.

1

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