

# 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	$\ell$	$\ell_n$	$\ell_s$	Ds	K	$\ell_k$

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

①-211

# DIN

## HFASP

For Ultra Fast Tapping, Horizontal Use, Low Spiral Fluted Taps for Aluminum



### Specification



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

### Tapping Speeds depending on Materials

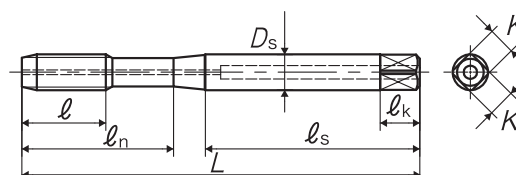
Wrought aluminum  
アルミ圧延材  
**30~100**  
(m/min)

Aluminum alloy castings  
アルミ合金鋳物  
**30~100**  
(m/min)

Magnesium alloy die castings  
マグネシウム合金鋳物  
**30~100**  
(m/min)

Zinc alloy castings  
亜鉛合金鋳物  
**30~100**  
(m/min)

### TYPE: 1



Segment : 1D

Size	Class	Code	Chamfer	L (mm)	$\ell$ (mm)	$\ell_n$ (mm)	$\ell_s$ (mm)	Ds (mm)	K (mm)	$\ell_k$ (mm)	No. of flutes	TYPE
For Metric Threads												
M6 × 1	ISO2X	SY6.0MBLDTHZ	2.5P	80	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	SY8.0NBLDTHZ	2.5P	90	19	35	48	8	6.2	9	3	1
M10 × 1.5	ISO2X	SY010OBLDTHZ	2.5P	100	23	39	53	10	8	11	3	1
M10 × 1.25	ISO2X	SY010NBLDTHZ	2.5P	100	23	39	53	10	8	11	3	1
M12 × 1.75	ISO2X	SY012PBLDTHZ	2.5P	110	26	44	57	12	9	12	3	1
M12 × 1.5	ISO2X	SY012OBLDTHZ	2.5P	110	26	44	57	12	9	12	3	1
M12 × 1.25	ISO2X	SY012NBLDTHZ	2.5P	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.