

# 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

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

JIS

①-215



## HFASP

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



### Specification

HSS-Co

Coating



### 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)

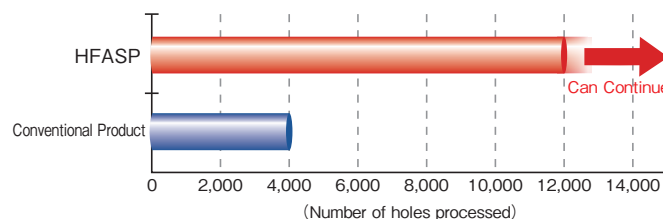
### Product Features

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

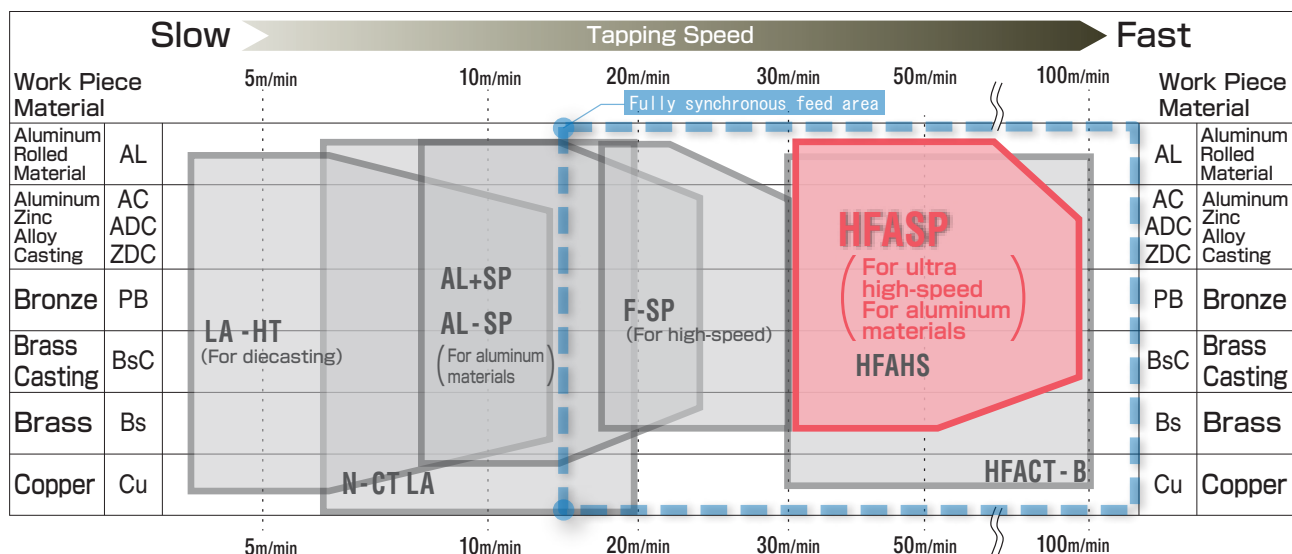
### Tapping Data

#### Tapping Condition [P4 M8×1.25]

Work Piece Material	ADC12-T5
Bored Hole Shape	Blind hole
Bored Hole Size	φ6.8
Tapping Length	28.5mm
Tapping Speed	100m/min
Machinery Type	M/C machining center (vertical type)
Cutting Fluid	Water soluble cutting fluid
Number of Holes Processed	12,000



### Speed chart



Tapping range by material being cut.

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	$\ell_k$

1

JIS

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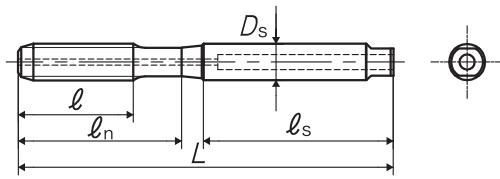
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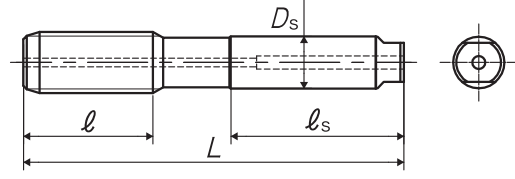
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①-216

TYPE: 1



TYPE: 2



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	MSRP
For Metric Threads													
M6 × 1	P4	HFASPS6.0M	2.5P	62	19	27	32	6	-	-	3	1	¥ 5,040
M8 × 1.25	P4	HFASPS8.0N	2.5P	70	22	-	36	8	-	-	3	2	¥ 7,410
M10 × 1.5	P4	HFASPS010O	2.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M10 × 1.25	P4	HFASPS010N	2.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M12 × 1.75	P4	HFASPS012P	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.5	P4	HFASPS012O	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.25	P4	HFASPS012N	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M14 × 1.5	P4	HFASPS014O	2.5P	88	30	-	40	12	-	-	3	2	¥ 18,300
M16 × 1.5	P4	HFASPS016O	2.5P	95	32	-	43	16	-	-	3	2	¥ 24,100
M18 × 1.5	P4	HFASPS018O	2.5P	100	37	-	45	16	-	-	3	2	¥ 34,200
M20 × 1.5	P5	HFASPT020O	2.5P	105	37	-	45	16	-	-	3	2	¥ 44,600

Remarks:

1. HFACT-P 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.