

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

①-199

DIN

HFIHS

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



Specification

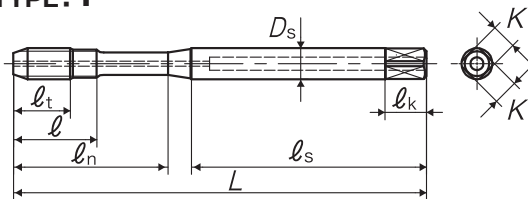


■ Applicable for ultra high speed tapping. Having center through hole geometry to correspond with inner coolant supply system, HFIHS is suitable for carbon steels and alloy steels, blind hole use. Vertical tapping use.

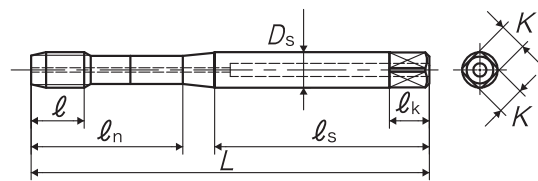
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	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)	20~30 (m/min)	20~30 (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	SY6.0MBEDTZ	2.5P	80	11	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	SY8.0NBEDTZ	2.5P	90	-	12	35	48	8	6.2	9	3	2
M10 × 1.5	ISO2X	SY010OBEDTZ	2.5P	100	-	13	39	53	10	8	11	3	2
M10 × 1.25	ISO2X	SY010NBEDTZ	2.5P	100	-	13	39	53	10	8	11	3	2
M12 × 1.75	ISO2X	SY012PBEDTZ	2.5P	110	-	15	44	57	12	9	12	3	2
M12 × 1.5	ISO2X	SY012OBEDTZ	2.5P	110	-	15	44	57	12	9	12	3	2
M12 × 1.25	ISO2X	SY012NBEDTZ	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.