

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

①-197



HFIHS

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



Specification



Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
20~50
(m/min)

Medium carbon steels
中炭素鋼
20~50
(m/min)

High carbon steels
高炭素鋼
20~30
(m/min)

Alloy steels
合金鋼
20~30
(m/min)

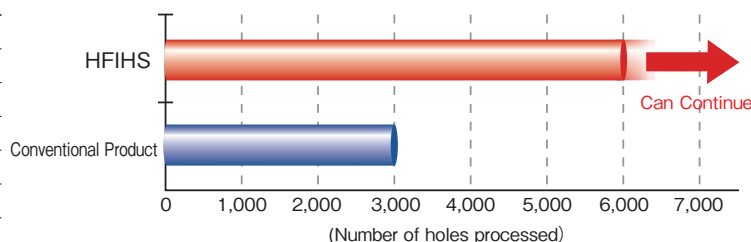
Product Features

- 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 carbon steels and alloy steels.

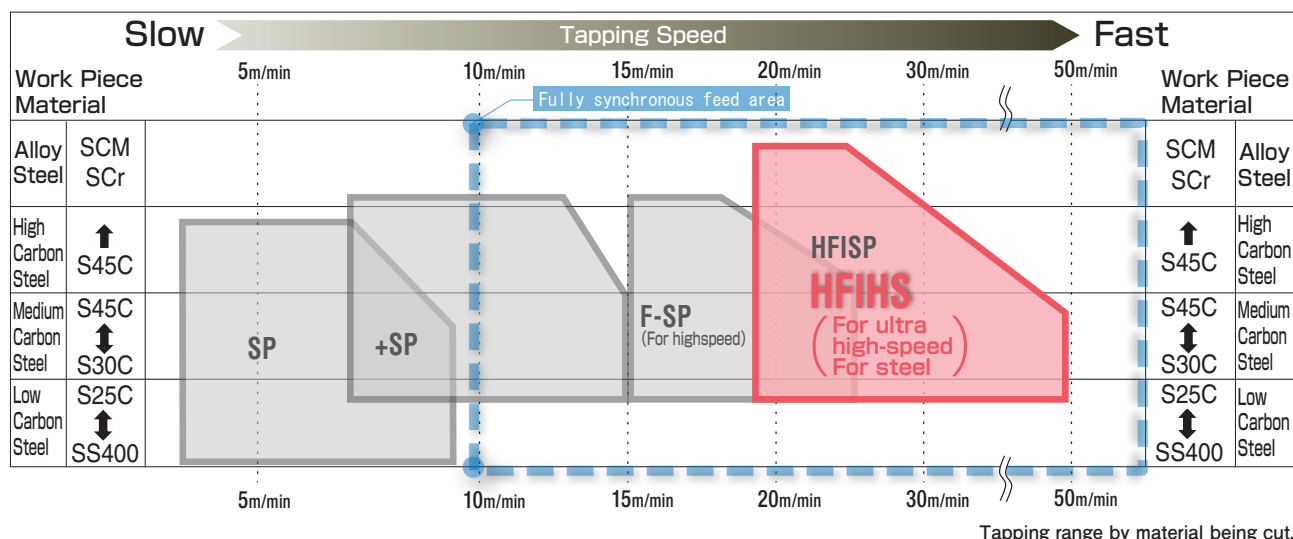
Tapping Data

Tapping conditions [P4 M12 × 1.25]

Work Piece Material	FCD450
Bored Hole Shape	Blind hole
Bored Hole Size	φ10.8
Tapping Length	19mm
Tapping Speed	57m/min
Machinery Type	M/C machining center (vertical type)
Cutting Fluid	Water soluble cutting fluid
Number of Holes Processed	6,000



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	Ds	K	ℓ_k

1

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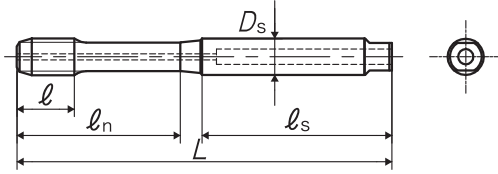
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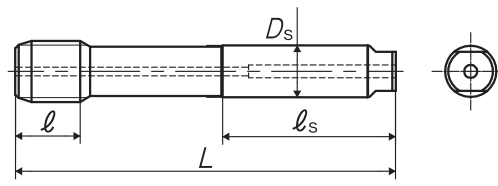
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①-198

TYPE: 1



TYPE: 2



Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M6 × 1	P4	HFIHSS6.0M	2.5P	62	11	27	32	6	-	-	3	1	¥ 5,040
M8 × 1.25	P4	HFIHSS8.0N	2.5P	70	12	-	36	8	-	-	3	2	¥ 7,410
M10 × 1.5	P4	HFIHSS010O	2.5P	75	13	-	37	10	-	-	3	2	¥ 9,380
M10 × 1.25	P4	HFIHSS010N	2.5P	75	12	-	37	10	-	-	3	2	¥ 9,380
M12 × 1.75	P4	HFIHSS012P	2.5P	82	15	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.5	P4	HFIHSS012O	2.5P	82	14	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.25	P4	HFIHSS012N	2.5P	82	14	-	40	12	-	-	3	2	¥ 13,400
M14 × 1.5	P4	HFIHSS014O	2.5P	88	14	-	40	12	-	-	3	2	¥ 18,300
M16 × 1.5	P4	HFIHSS016O	2.5P	95	14	-	43	16	-	-	3	2	¥ 24,100
M18 × 1.5	P4	HFIHSS018O	2.5P	100	14	-	45	16	-	-	4	2	¥ 34,200
M20 × 1.5	P5	HFIHST020O	2.5P	105	14	-	45	16	-	-	4	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 HFIHS shank has a tongue drive design. If the tool holder only grips on the back end of the HFIHS shank tongue drive, the coolant may leak.