

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



HFISP

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



Specification



Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	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)

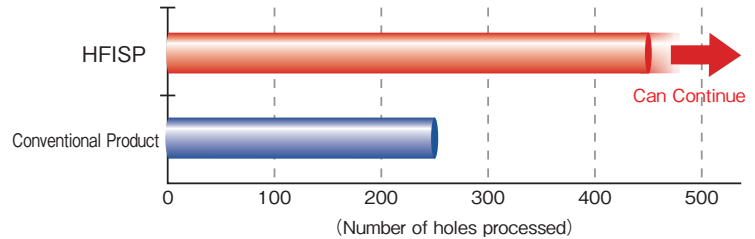
Product Features

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

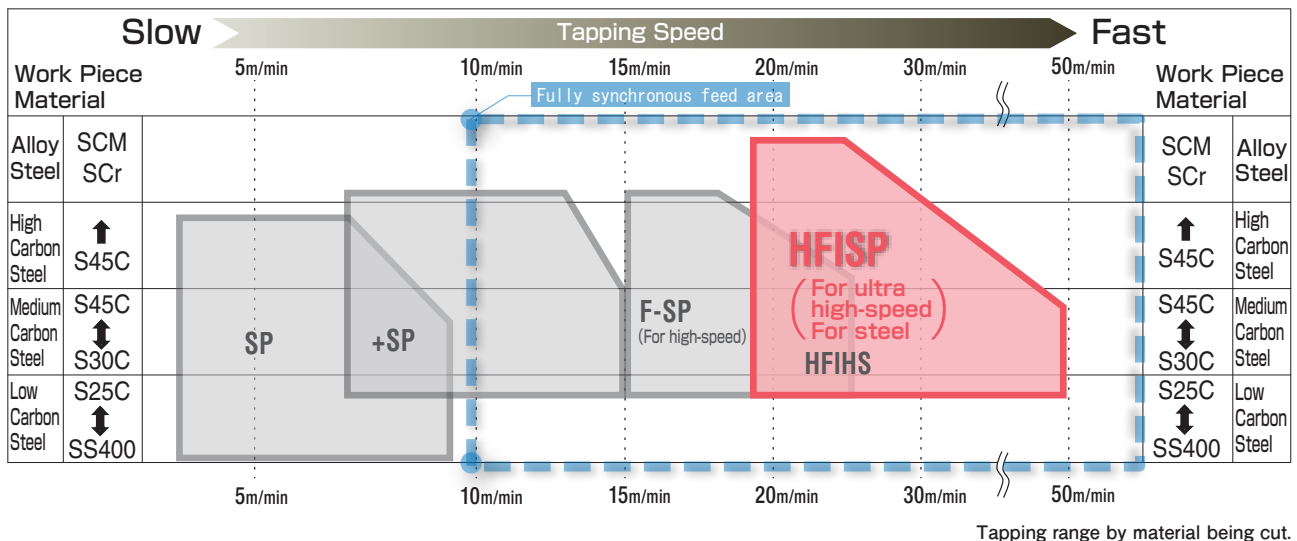
Tapping Data

Tapping Conditions [P4 M10×1.25]

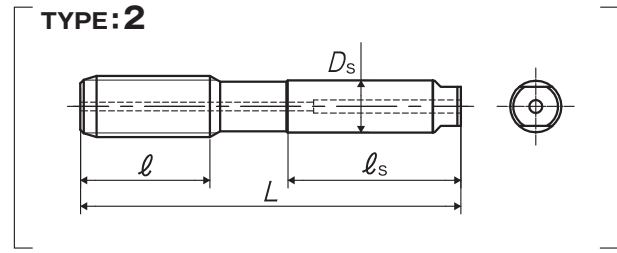
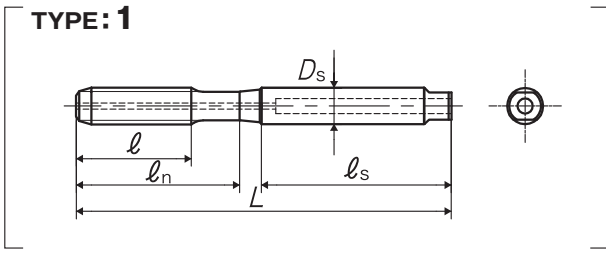
Work Piece Material	S45C
Bored Hole Shape	Blind hole
Bored Hole Size	φ8.8
Tapping Length	18mm
Tapping Speed	126m/min
Machinery Type	M/C machining center (vertical type)
Cutting Fluid	Water soluble cutting fluid
Number of Holes Processed	450



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	HFISPS6.0M	2.5P	62	19	27	32	6	-	-	3	1	¥ 5,040
M8 × 1.25	P4	HFISPS8.0N	2.5P	70	22	-	36	8	-	-	3	2	¥ 7,410
M10 × 1.5	P4	HFISPS010O	2.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M10 × 1.25	P4	HFISPS010N	2.5P	75	24	-	37	10	-	-	3	2	¥ 9,380
M12 × 1.75	P4	HFISPS012P	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.5	P4	HFISPS012O	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M12 × 1.25	P4	HFISPS012N	2.5P	82	29	-	40	12	-	-	3	2	¥ 13,400
M14 × 1.5	P4	HFISPS014O	2.5P	88	30	-	40	12	-	-	3	2	¥ 18,300
M16 × 1.5	P4	HFISPS016O	2.5P	95	32	-	43	16	-	-	3	2	¥ 24,100
M18 × 1.5	P4	HFISPS018O	2.5P	100	37	-	45	16	-	-	4	2	¥ 34,200
M20 × 1.5	P5	HFISPT020O	2.5P	105	37	-	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 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

JIS

①-208