

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

HSS-Co

Coating

Synchro
nized

<2D

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)

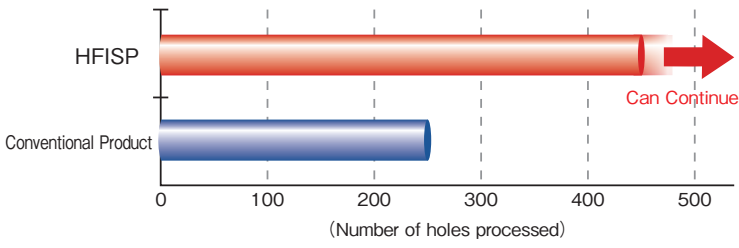
Product Features

- 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.

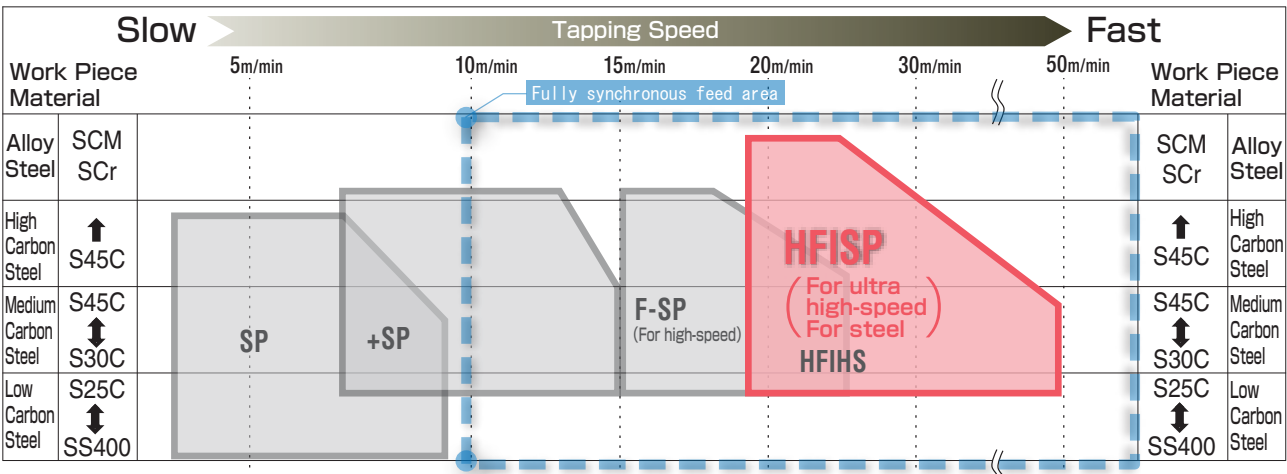
Tapping Data

Tapping Conditions [P4 M10×1.25]

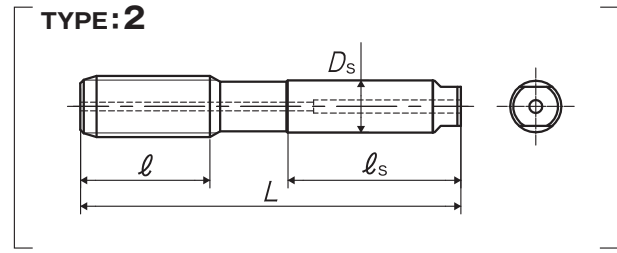
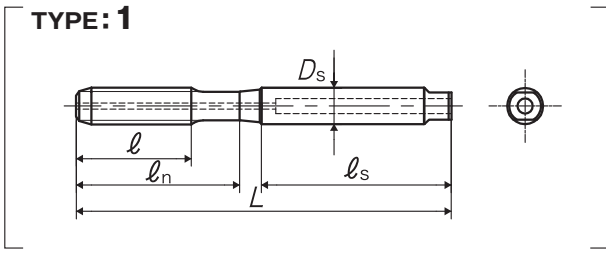
Work Piece Material	S45C
Bored Hole Shape	Blind hole
Bored Hole Size	φ8.8
Tapping Length	18mm
Tapping Speed	126m/min
Machinery Type	M/C machining center (vertical type)
Cutting Fluid	Water soluble cutting fluid
Number of Holes Processed	450



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.

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(for blind hole) ①

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(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

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