

③ Spiral Pointed Tap Series for through 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

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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/Metal Surgical Instruments

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③-27

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Z-PRO

HVPO ZP



Z-PRO

Hybrid Value Spiral Pointed Taps for Zinc Plating

Specification

HSS

OX
Oxide



Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
3~12
(m/min)

Medium carbon steels
中炭素鋼
3~12
(m/min)

High carbon steels
高炭素鋼
3~12
(m/min)

Alloy steels
合金鋼
3~12
(m/min)

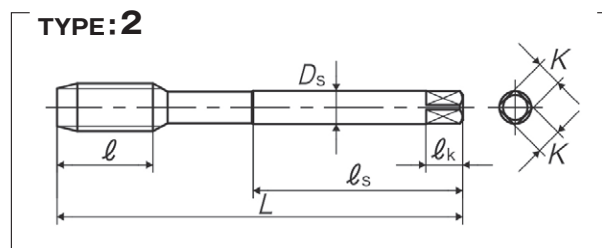
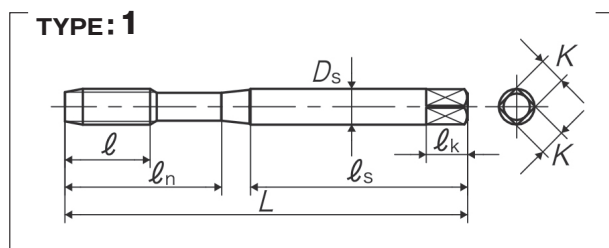
Thermal refined steels
調質鋼
~5
(m/min)
25~35HRC

Stainless steels
ステンレス鋼
~5
(m/min)

Cast steels
鋳鋼
3~12
(m/min)

Product Features

- YAMAWA has designed a flute shape and cutting edge angle to improve the chip ejection properties.
- A heel grind on the rear threads has improved the performance of the tap and eliminated the materials chip residue in the threads that is caused on reversal by the tap's end threads.
- With no chips left in the threads, the tapping operation is less likely to chip the flutes or threads of the tap during the tap's reversal.



Segment : 1E

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
For Metric Threads												
M8 × 1.25	D7+.004	5122201064	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	1
M8 × 1.25	D7+.008	5122301064	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	1
M8 × 1.25	D7+.012	5122401064	5P	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	1
M10 × 1.5	D7+.004	5122201078	5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	1
M10 × 1.5	D7+.008	5122301078	5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	1
M10 × 1.5	D7+.012	5122401078	5P	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	1
M12 × 1.75	D8+.004	5122201088	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	2
M12 × 1.75	D8+.008	5122301088	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	2
M12 × 1.75	D8+.012	5122401088	5P	4.331	1.024	-	2.205	0.367	0.275	0.437	3	2
M14 × 2	D8+.004	5122201100	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	2
M14 × 2	D8+.008	5122301100	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	2
M14 × 2	D8+.012	5122401100	5P	4.331	1.024	-	2.205	0.429	0.322	0.5	3	2
M16 × 2	D8+.004	5122201114	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	2
M16 × 2	D8+.008	5122301114	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	2
M16 × 2	D8+.012	5122401114	5P	4.331	1.024	-	2.205	0.48	0.36	0.562	3	2
M18 × 2.5	D8+.004	5122201128	5P	4.921	1.299	-	2.52	0.542	0.406	0.625	3	2
M18 × 2.5	D8+.008	5122301128	5P	4.921	1.299	-	2.52	0.542	0.406	0.625	3	2

Think threads with
YAMAWA

· This product is different from JIS products in shape and dimensions, please be careful when using.

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M18 × 2.5	D8+.012	5122401128	5P	4.921	1.299	-	2.52	0.542	0.406	0.625	3	2
M20 × 2.5	D8+.004	5122201141	5P	5.512	1.299	-	2.795	0.652	0.489	0.687	3	2
M20 × 2.5	D8+.008	5122301141	5P	5.512	1.299	-	2.795	0.652	0.489	0.687	3	2
M20 × 2.5	D8+.012	5122401141	5P	5.512	1.299	-	2.795	0.652	0.489	0.687	3	2
M22 × 2.5	D8+.004	5122201156	5P	5.512	1.299	-	2.795	0.697	0.523	0.75	3	2
M22 × 2.5	D8+.008	5122301156	5P	5.512	1.299	-	2.795	0.697	0.523	0.75	3	2
M22 × 2.5	D8+.012	5122401156	5P	5.512	1.299	-	2.795	0.697	0.523	0.75	3	2
M24 × 3	D9+.004	5122201167	5P	6.299	1.457	-	3.228	0.76	0.57	0.75	3	2
M24 × 3	D9+.008	5122301167	5P	6.299	1.457	-	3.228	0.76	0.57	0.75	3	2
M24 × 3	D9+.012	5122401167	5P	6.299	1.457	-	3.228	0.76	0.57	0.75	3	2
M27 × 3	D9+.004	5122201186	5P	7.087	1.732	-	3.622	0.896	0.672	0.875	4	2
M27 × 3	D9+.008	5122301186	5P	7.087	1.732	-	3.622	0.896	0.672	0.875	4	2
M27 × 3	D9+.012	5122401186	5P	7.087	1.732	-	3.622	0.896	0.672	0.875	4	2
M30 × 3.5	D10+.004	5122201199	5P	7.087	1.732	-	3.622	1.021	0.766	1	4	2
M30 × 3.5	D10+.008	5122301199	5P	7.087	1.732	-	3.622	1.021	0.766	1	4	2
M30 × 3.5	D10+.012	5122401199	5P	7.087	1.732	-	3.622	1.021	0.766	1	4	2
M33 × 3.5	D10+.004	5122201211	5P	7.087	1.732	-	3.622	1.108	0.831	1.062	4	2
M33 × 3.5	D10+.008	5122301211	5P	7.087	1.732	-	3.622	1.108	0.831	1.062	4	2
M33 × 3.5	D10+.012	5122401211	5P	7.087	1.732	-	3.622	1.108	0.831	1.062	4	2
M36 × 4	D10+.004	5122201225	5P	7.874	2.047	-	4.016	1.233	0.925	1.125	4	2
M36 × 4	D10+.008	5122301225	5P	7.874	2.047	-	4.016	1.233	0.925	1.125	4	2
M36 × 4	D10+.012	5122401225	5P	7.874	2.047	-	4.016	1.233	0.925	1.125	4	2

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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

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