

# 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	ℓ <sub>n</sub>	ℓ <sub>s</sub>	D <sub>s</sub>	K	ℓ <sub>k</sub>

- ANSI
- 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
- 8 Pipe Taps
- 9 Thread Mills Premium Thread Mills
- 10 Simple Inspection Tools Related Products
- 11 Dies
- 12 Center Drills Centering Tools
- 13 Precision Machinery/Medical Surgical Instruments

# ANSI

## Z-PRO HVSP ZP



### Z-PRO Hybrid Value Spiral Fluted Taps for Zinc Plating

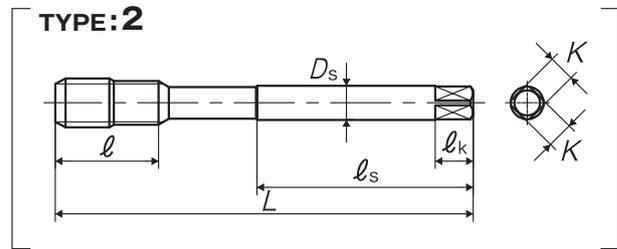
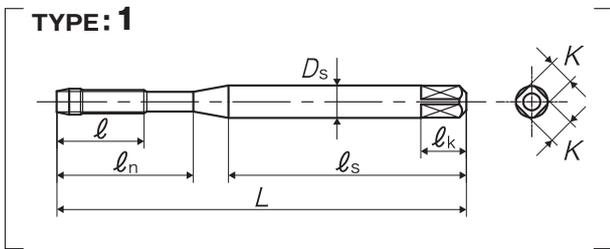
#### Specification



■ The standard line includes tap classes that are optimal for tapping internal screw threads before zinc plating. We developed 3 types of oversized taps in +0.1mm, +0.2mm, +0.3mm, which are in high market demand in certain applications.

#### 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	Thermal refined steels 調質鋼	Stainless steels ステンレス鋼	Cast steels 鋳鋼
3~12 (m/min)	3~12 (m/min)	3~12 (m/min)	3~12 (m/min)	~5 (m/min)	~5 (m/min)	3~12 (m/min)
25~35HRC						



Segment : 1C

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ <sub>n</sub> (inch)	ℓ <sub>s</sub> (inch)	D <sub>s</sub> (inch)	K (inch)	ℓ <sub>k</sub> (inch)	No. of flutes	TYPE
For Metric Threads												
M8 × 1.25	D7+.004	5112201064	C (2.5P)	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	1
M8 × 1.25	D7+.008	5112301064	C (2.5P)	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	1
M8 × 1.25	D7+.012	5112401064	C (2.5P)	3.543	0.748	1.378	1.831	0.318	0.238	0.375	3	1
M10 × 1.5	D8+.004	5112201078	C (2.5P)	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	1
M10 × 1.5	D8+.008	5112301078	C (2.5P)	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	1
M10 × 1.5	D8+.012	5112401078	C (2.5P)	3.937	0.906	1.535	2.126	0.381	0.286	0.437	3	1
M12 × 1.75	D8+.004	5112201088	C (2.5P)	4.331	1.024	-	2.205	0.367	0.275	0.437	3	2
M12 × 1.75	D8+.008	5112301088	C (2.5P)	4.331	1.024	-	2.205	0.367	0.275	0.437	3	2
M12 × 1.75	D8+.012	5112401088	C (2.5P)	4.331	1.024	-	2.205	0.367	0.275	0.437	3	2
M14 × 2	D9+.004	5112201100	C (2.5P)	4.331	1.024	-	2.205	0.429	0.322	0.500	3	2
M14 × 2	D9+.008	5112301100	C (2.5P)	4.331	1.024	-	2.205	0.429	0.322	0.500	3	2
M14 × 2	D9+.012	5112401100	C (2.5P)	4.331	1.024	-	2.205	0.429	0.322	0.500	3	2
M16 × 2	D9+.004	5112201114	C (2.5P)	4.331	1.024	-	2.205	0.480	0.360	0.562	3	2
M16 × 2	D9+.008	5112301114	C (2.5P)	4.331	1.024	-	2.205	0.480	0.360	0.562	3	2
M16 × 2	D9+.012	5112401114	C (2.5P)	4.331	1.024	-	2.205	0.480	0.360	0.562	3	2
M18 × 2.5	D9+.004	5112201128	C (2.5P)	4.921	1.299	-	2.520	0.542	0.406	0.625	4	2
M18 × 2.5	D9+.008	5112301128	C (2.5P)	4.921	1.299	-	2.520	0.542	0.406	0.625	4	2
M18 × 2.5	D9+.012	5112401128	C (2.5P)	4.921	1.299	-	2.520	0.542	0.406	0.625	4	2
M20 × 2.5	D9+.004	5112201141	C (2.5P)	5.512	1.299	-	2.795	0.652	0.489	0.687	4	2
M20 × 2.5	D9+.008	5112301141	C (2.5P)	5.512	1.299	-	2.795	0.652	0.489	0.687	4	2
M20 × 2.5	D9+.012	5112401141	C (2.5P)	5.512	1.299	-	2.795	0.652	0.489	0.687	4	2
M22 × 2.5	D9+.004	5112201156	C (2.5P)	5.512	1.299	-	2.795	0.697	0.523	0.750	4	2
M22 × 2.5	D9+.008	5112301156	C (2.5P)	5.512	1.299	-	2.795	0.697	0.523	0.750	4	2
M22 × 2.5	D9+.012	5112401156	C (2.5P)	5.512	1.299	-	2.795	0.697	0.523	0.750	4	2

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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

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Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M24 × 3	D9+.004	5112201167	C (2.5P)	6.299	1.457	-	3.228	0.760	0.570	0.750	4	2
M24 × 3	D9+.008	5112301167	C (2.5P)	6.299	1.457	-	3.228	0.760	0.570	0.750	4	2
M24 × 3	D9+.012	5112401167	C (2.5P)	6.299	1.457	-	3.228	0.760	0.570	0.750	4	2
M27 × 3	D10+.004	5112201186	C (2.5P)	7.087	1.732	-	3.622	0.896	0.672	0.875	4	2
M27 × 3	D10+.008	5112301186	C (2.5P)	7.087	1.732	-	3.622	0.896	0.672	0.875	4	2
M27 × 3	D10+.012	5112401186	C (2.5P)	7.087	1.732	-	3.622	0.896	0.672	0.875	4	2
M30 × 3.5	D10+.004	5112201199	C (2.5P)	7.087	1.732	-	3.622	1.021	0.766	1.000	4	2
M30 × 3.5	D10+.008	5112301199	C (2.5P)	7.087	1.732	-	3.622	1.021	0.766	1.000	4	2
M30 × 3.5	D10+.012	5112401199	C (2.5P)	7.087	1.732	-	3.622	1.021	0.766	1.000	4	2
M33 × 3.5	D10+.004	5112201211	C (2.5P)	7.087	1.732	-	3.622	1.108	0.831	1.062	4	2
M33 × 3.5	D10+.008	5112301211	C (2.5P)	7.087	1.732	-	3.622	1.108	0.831	1.062	4	2
M33 × 3.5	D10+.012	5112401211	C (2.5P)	7.087	1.732	-	3.622	1.108	0.831	1.062	4	2
M36 × 4	D10+.004	5112201225	C (2.5P)	7.874	2.047	-	4.016	1.233	0.925	1.125	4	2
M36 × 4	D10+.008	5112301225	C (2.5P)	7.874	2.047	-	4.016	1.233	0.925	1.125	4	2
M36 × 4	D10+.012	5112401225	C (2.5P)	7.874	2.047	-	4.016	1.233	0.925	1.125	4	2

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 ⑦

Pipe Taps ⑧

Thread Mills  
Premium Thread Mills ⑨

Simple Inspection Tools  
Related Products ⑩

Dies ⑪

Center Drills  
Centering Tools ⑫

Precision Machinery/  
Medical Surgical Instruments ⑬

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