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

ISP

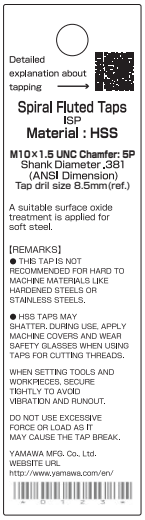
Spiral Fluted Taps for General Purpose

Specification

HSS | OX Oxide | <2D

Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 ~5 (m/min)



Blister Pack

Product Features

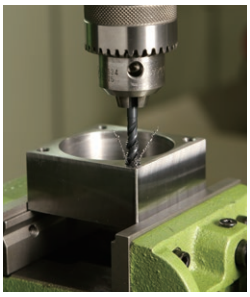
- The IPS is for a blind hole and mainly used for low speed machining on a drilling machine.
- Use the IPS for tapping iron products like SPC and SS400 where there are a small quantities of threads.
- The ISP has an ideal oxidation surface treatment for tapping iron materials.
- The ISP is ideal for small quantity tapping components such as prototype non-production parts.
- The ISP has spiral flutes to discharge the chips back out of the hole.
- Please use the ISP for tapping of blind holes.

Chips from a tapped hole.

How to Use

- First create the workpiece bore diameter with a drill that matches the screw thread size minor diameter, and then start the tapping.
- Please use a cutting speed of 5 m/min or less.
- When tapping, please use a cutting oil.

Hand tapping using a tap handle.



Machining with a drilling machine.

■Thread bored hole diameter table.

Unit: mm

Thread Size	Internal Thread Diameter			Drill Diameter	Percentage of Thread
	Minimum Allowable Bored Hole.	Maximum Allowable Bored Hole.			
		6H (Level 2)	7H (Level 3)		
M3 × 0.5	2.459	2.599	2.639	2.6 (2.5)	74% (92%)
M4 × 0.7	3.242	3.422	3.466	3.4 (3.3)	79% (92%)
M5 × 0.8	4.134	4.344	4.384	4.3 (4.2)	81% (92%)
M6 × 1	4.917	5.153	5.217	5.1 (5.0)	83% (92%)
M8 × 1.25	6.647	6.912	6.982	6.9 (6.8)	91% (89%)
M10 × 1.5	8.376	8.676	8.751	8.6 (8.5)	86% (92%)

Note 1) Recommended bored hole size in this table is for 7H (3rd grade) internal thread, selected from commercially available standard drills.
Note 2) The size of the drill in parentheses is used for cases where the drill cutting oversize is too large or for 6H (2nd grade) internal thread processing.

[Related Products]

Shank Adjuster

- Use the shank adjuster when tapping into deep holes.
- The I series (IHT / ISP / IPO) can be detached from the shank adjuster with one touch.

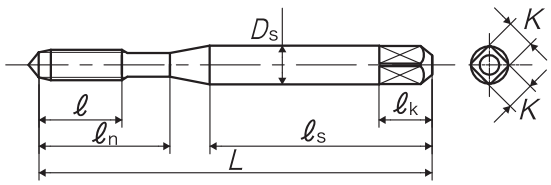
・For details on shank adjusters,refer to ⑦-83.

Think threads with YAMAWA

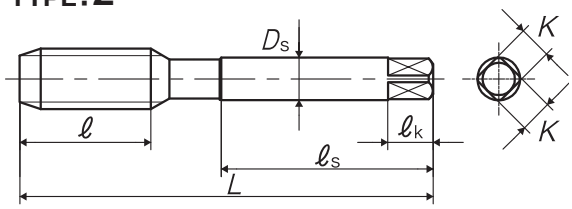
You can also see it from the video site on the right.

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

TYPE: 1



TYPE: 2



Blister Pack

Segment : 1C

Size	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads												
M3 × 0.5	SI73.0GBP	2.5P	46	9	14	26	4	3.2	6	3	1	¥ 910
M4 × 0.7	SI74.0IBP	2.5P	52	11	17	29	5	4	7	3	1	¥ 950
M5 × 0.8	SI75.0KBP	2.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 960
M6 × 1	SI76.0MBP	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,010
M8 × 1.25	SI78.0NBP	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 1,550
M10 × 1.5	SI7010OBP	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 1,940