

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

JIS

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

JIS

①-153



LO-SP Low Spiral Fluted Taps



Specification



Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)

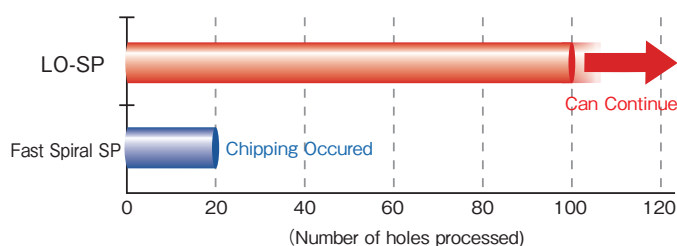
Product Features

- The chips are cut short in length and ejected smoothly due to the effect of a low spiral flute.
- The LO-SP is effective for thread processing and horizontal machining of tempered materials such as high carbon steel and alloy tool steel.

Tapping Data

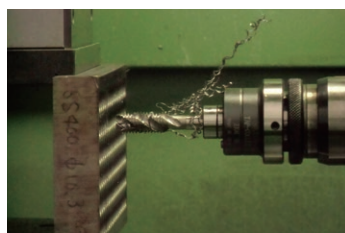
Tapping conditions [M12×1.75]

Work Piece Material	SS400
Bored Hole Size	φ10.3
Tapping Length	25mm (Blind hole)
Tapping Speed	10m/min
Machinery Type	CNC horizontal machining center (synchronous)
Holder	Fixed
Tapping Fluid	Water soluble cutting fluid



〈Chip evacuation capability〉

High spiral tap.



When horizontal tapping, the chips tend to hang down due to gravity. These chips wrap around the taps and the holders.

LO-SP



By cutting chips small, the chip problem is eliminated.

Chips



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

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

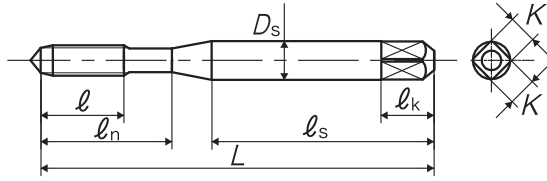
Precision Machinery/
Medical Surgical Instruments

⑫

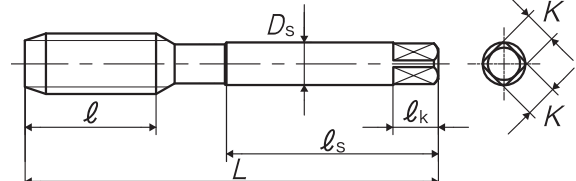
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①-154

TYPE:1



TYPE:2



Segment : 1C

Size	Class	Code	Chamfer	Helix angle	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														
M3 × 0.5	P1	LSHMP3.0G8	2.5P	8°	46	9	14	26	4	3.2	6	3	1	¥ 1,520 ※
M3 × 0.5	P1	LSHMP3.0G15	2.5P	15°	46	9	14	26	4	3.2	6	3	1	¥ 1,520 ※
M3 × 0.5	P1	LSHMP3.0G20	2.5P	20°	46	9	14	26	4	3.2	6	3	1	¥ 1,520 ※
M4 × 0.7	P2	LSHMQ4.0I8	2.5P	8°	52	11	17	29	5	4	7	3	1	¥ 1,520 ※
M4 × 0.7	P2	LSHMQ4.0I15	2.5P	15°	52	11	17	29	5	4	7	3	1	¥ 1,520 ※
M4 × 0.7	P2	LSHMQ4.0I20	2.5P	20°	52	11	17	29	5	4	7	3	1	¥ 1,520 ※
M5 × 0.8	P2	LSHMQ5.0K8	2.5P	8°	60	13	22	33	5.5	4.5	7	3	1	¥ 1,530 ※
M5 × 0.8	P2	LSHMQ5.0K15	2.5P	15°	60	13	22	33	5.5	4.5	7	3	1	¥ 1,530 ※
M5 × 0.8	P2	LSHMQ5.0K20	2.5P	20°	60	13	22	33	5.5	4.5	7	3	1	¥ 1,530 ※
M6 × 1	P2	LSHMQ6.0M8	2.5P	8°	62	15	26	33	6	4.5	7	3	1	¥ 1,680 ※
M6 × 1	P2	LSHMQ6.0M15	2.5P	15°	62	15	26	33	6	4.5	7	3	1	¥ 1,680 ※
M6 × 1	P2	LSHMQ6.0M20	2.5P	20°	62	15	26	33	6	4.5	7	3	1	¥ 1,680 ※
M8 × 1.25	P2	LSHMQ8.0N8	2.5P	8°	70	19	-	36	6.2	5	8	3	2	¥ 2,310 ※
M8 × 1.25	P2	LSHMQ8.0N15	2.5P	15°	70	19	-	36	6.2	5	8	3	2	¥ 2,310 ※
M8 × 1.25	P2	LSHMQ8.0N20	2.5P	20°	70	19	-	36	6.2	5	8	3	2	¥ 2,310 ※
M10 × 1.5	P2	LSHMQ10.0O8	2.5P	8°	75	23	-	38	7	5.5	8	3	2	¥ 2,930 ※
M10 × 1.5	P2	LSHMQ10.0O15	2.5P	15°	75	23	-	38	7	5.5	8	3	2	¥ 2,930 ※
M10 × 1.5	P2	LSHMQ10.0O20	2.5P	20°	75	23	-	38	7	5.5	8	3	2	¥ 2,930 ※
M12 × 1.75	P2	LSHMQ12.0P8	2.5P	8°	82	26	-	42	8.5	6.5	9	3	2	¥ 4,160 ※
M12 × 1.75	P2	LSHMQ12.0P15	2.5P	15°	82	26	-	42	8.5	6.5	9	3	2	¥ 4,160 ※
M12 × 1.75	P2	LSHMQ12.0P20	2.5P	20°	82	26	-	42	8.5	6.5	9	3	2	¥ 4,160 ※

※ = Specified Distribution Items. Made to order products.

Think threads with YAMAWA