

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_n	ℓ_s	Ds	K	ℓ_k

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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/ Medical Surgical Instruments

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①-193



LS-PM-SP

Long Shank Spiral Fluted Taps for Hard-to-Machine Materials



Specification

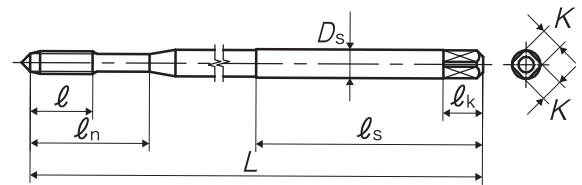


Long shank spiral fluted tap suitable for tapping hard steels with hardness between 25-45HRC such as forgings and thermal refined steels of high carbon steels and alloy steels, and mold steels.

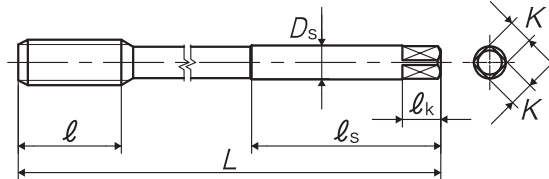
Tapping Speeds depending on Materials

High carbon steels 高炭素鋼	Thermal refined steels 調質鋼	Thermal refined steels 調質鋼
5~10 (m/min)	~5 (m/min)	~5 (m/min)
	25~35HRC	35~45HRC

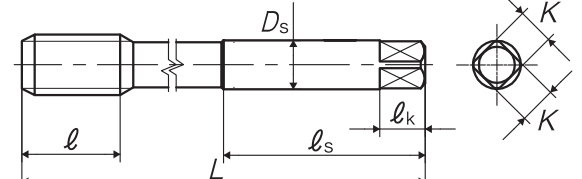
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M3 × 0.5	P3	S43.0GRDPBE	2.75P	100	9	18	40	4	3.2	6	3	1	¥ 5,770 ※
M4 × 0.7	P3	S44.0IRDPBE	2.75P	100	11	21	40	5	4	7	3	1	¥ 5,270 ※
M5 × 0.8	P3	S45.0KRDPE	2.75P	100	13	25	40	5.5	4.5	7	3	1	¥ 4,620 ※
M6 × 1	P3	S46.0MRDPBE	2.75P	100	15	30	40	6	4.5	7	3	1	¥ 3,950 ※
M6 × 1	P3	S46.0MRDPBG	2.75P	150	15	30	40	6	4.5	7	3	1	¥ 6,970 ※
M8 × 1.25	P3	SY8.0NRDPBE	2.75P	100	19	-	50	6.2	5	8	3	2	¥ 5,110 ※
M8 × 1.25	P3	SY8.0NRDPBG	2.75P	150	19	-	50	6.2	5	8	3	2	¥ 8,690 ※
M10 × 1.5	P3	SY010ORDPBG	2.75P	150	23	-	50	7	5.5	8	3	2	¥ 10,200 ※
M10 × 1.25	P3	SY010NRDPBG	2.75P	150	23	-	50	7	5.5	8	3	2	¥ 10,200 ※
M12 × 1.75	P3	SY012PRDPBG	2.75P	150	26	-	50	8.5	6.5	9	3	2	¥ 12,800 ※
M12 × 1.5	P3	SY012ORDPBG	2.75P	150	26	-	50	8.5	6.5	9	3	2	¥ 12,800 ※
M12 × 1.25	P4	SY012NSDPBG	2.75P	150	26	-	50	8.5	6.5	9	3	2	¥ 12,800 ※
M14 × 2	P4	SY014QSDPBG	2.75P	150	26	-	60	10.5	8	11	3	2	¥ 15,900 ※
M14 × 1.5	P3	SY014ORDPBG	2.75P	150	26	-	60	10.5	8	11	3	2	¥ 15,900 ※
M16 × 2	P4	SY016QSDPBG	2.75P	150	26	-	60	12.5	10	13	3	2	¥ 17,300 ※
M16 × 1.5	P3	SY016ORDPBG	2.75P	150	26	-	60	12.5	10	13	3	2	¥ 17,300 ※
M18 × 2.5	P4	SY018RSDPBG	2.75P	150	33	-	70	14	11	14	4	2	¥ 23,600 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

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 (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M18 × 1.5	P4	SY018OSDPBG	2.75P	150	33	-	70	14	11	14	4	2	¥ 23,600 ※
M20 × 2.5	P4	SY020RSDPBG	2.75P	150	33	-	70	15	12	15	4	3	¥ 30,300 ※
M20 × 1.5	P4	SY020OSDPBG	2.75P	150	33	-	70	15	12	15	4	3	¥ 30,300 ※
M22 × 2.5	P4	SY022RSDPBK	2.75P	200	33	-	70	17	13	16	4	3	¥ 41,800 ※
M22 × 1.5	P4	SY022OSDPBK	2.75P	200	33	-	70	17	13	16	4	3	¥ 41,800 ※
M24 × 3	P4	SY024SSDPBK	2.75P	200	39	-	80	19	15	18	4	3	¥ 47,000 ※
M24 × 1.5	P4	SY024OSDPBK	2.75P	200	39	-	80	19	15	18	4	3	¥ 47,000 ※
M27 × 3	P4	SY027SSDPBK	2.75P	200	39	-	80	20	15	18	4	3	¥ 52,700 ※
M27 × 1.5	P4	SY027OSDPBK	2.75P	200	39	-	80	20	15	18	4	3	¥ 52,700 ※
M30 × 3.5	P4	SY030TSDPBK	2.75P	200	46	-	80	23	17	20	4	3	¥ 67,600 ※
M30 × 1.5	P4	SY030OSDPBK	2.75P	200	46	-	80	23	17	20	4	3	¥ 67,600 ※

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Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral 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 ⑪Precision Machinery/
Medical Surgical Instruments ⑫

JIS

①-194

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