

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

JIS

①-104

S

LS-SP V

Long Shank Spiral Fluted Taps, Coated



Specification



■ Long shank coated spiral fluted taps for tapping threads in deep holes that cannot be reached with a standard overall length.

Tapping Speeds depending on Materials

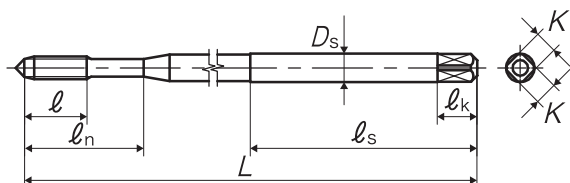
Low carbon steels
低炭素鋼
10~20
(m/min)

Medium carbon steels
中炭素鋼
10~20
(m/min)

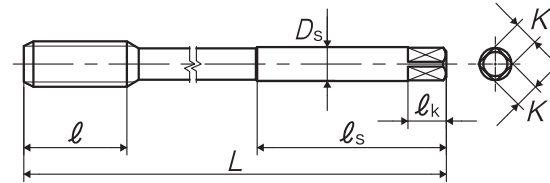
High carbon steels
高炭素鋼
10~20
(m/min)

Alloy steels
合金鋼
10~20
(m/min)

TYPE: 1



TYPE: 2



Segment : 1C

Size	Class	Code	Chamfer	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	VSPFP3.0GL10	2.5P	100	9	18	40	4	3.2	6	3	1	¥ 6,720
M4 × 0.7	P2	VSPFQ4.0IL10	2.5P	100	11	21	40	5	4	7	3	1	¥ 6,300
M5 × 0.8	P2	VSPFQ5.0KL10	2.5P	100	13	25	40	5.5	4.5	7	3	1	¥ 5,900
M6 × 1	P2	VSPFQ6.0ML10	2.5P	100	15	30	40	6	4.5	7	3	1	¥ 5,360
M6 × 1	P2	VSPFQ6.0ML15	2.5P	150	15	30	40	6	4.5	7	3	1	¥ 7,470 *
M8 × 1.25	P2	VSPQ8.0NL10	2.5P	100	19	-	50	6.2	5	8	3	2	¥ 6,570
M8 × 1.25	P2	VSPQ8.0NL15	2.5P	150	19	-	50	6.2	5	8	3	2	¥ 9,080
M10 × 1.5	P2	VSPQ010OL15	2.5P	150	23	-	50	7	5.5	8	3	2	¥ 10,600
M10 × 1.25	P2	VSPQ010NL15	2.5P	150	23	-	50	7	5.5	8	3	2	¥ 10,600 *
M12 × 1.75	P2	VSPQ012PL15	2.5P	150	26	-	50	8.5	6.5	9	3	2	¥ 13,400
M12 × 1.5	P2	VSPQ012OL15	2.5P	150	26	-	50	8.5	6.5	9	3	2	¥ 13,400 *
M12 × 1.25	P2	VSPQ012NL15	2.5P	150	26	-	50	8.5	6.5	9	3	2	¥ 13,400 *

* = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA