

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	D _s	K	ℓ _k

DIN

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

DIN

①-49

Z-PRO MHSP

Z-PRO

Spiral Fluted Taps for Carbon Steels of Medium hardness



Specification



- Most suitable for forgings from S48C to S55C and thermal refined materials (25 to 35 HRC)
- Long life is achieved by the adoption of HSS material and special coating for wear resistance.

Tapping Speeds depending on Materials

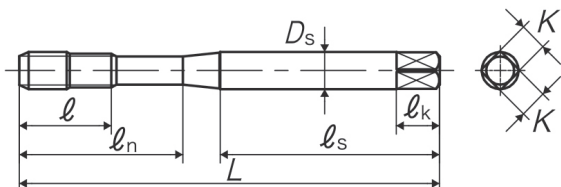
High carbon steels
高炭素鋼
5~20
(m/min)

Alloy steels
合金鋼
5~20
(m/min)

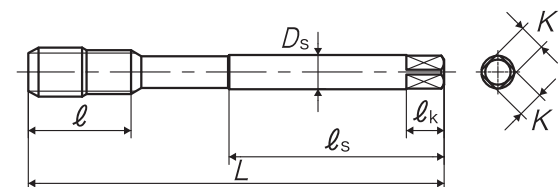
Thermal refined steels
調質鋼
5~15
(m/min)

25~35HRC

TYPE: 1



TYPE: 2



Segment : 1D

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
For Metric Threads												
M8 × 1.25	ISO2X	SD8.0NBOCLJ	2.5P	90	19	35	47	8	6.2	9	3	1
M10 × 1.5	ISO2X	SD010OBOCLJ	2.5P	100	23	39	52.5	10	8	11	3	1
M10 × 1.25	ISO2X	SM010NBOCLJ	2.5P	100	23	-	51	7	5.5	8	3	2
M10 × 1	ISO2X	SM010MBOCLJ	2.5P	90	19	-	46	7	5.5	8	3	2
M12 × 1.75	ISO2X	SG012PBOCLJ	2.5P	110	26	-	56	9	7	10	4	2
M12 × 1.5	ISO2X	SM012OBOCLJ	2.5P	100	21	-	51	9	7	10	4	2
M12 × 1.25	ISO2X	SM012NBOCLJ	2.5P	100	21	-	51	9	7	10	4	2
M14 × 2	ISO2X	SG014QBOCLJ	2.5P	110	26	-	56	11	9	12	4	2
M14 × 1.5	ISO2X	SM014OBOCLJ	2.5P	100	21	-	51	11	9	12	4	2
M16 × 2	ISO2X	SG016QBOCLJ	2.5P	110	26	-	56	12	9	12	4	2
M16 × 1.5	ISO2X	SM016OBOCLJ	2.5P	100	21	-	51	12	9	12	4	2

Think threads with
YAMAWA

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