

1 Spiral Fluted Tap Series for blind hole

Overall length	Chamfer+ full thread	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ_t	ℓ	ℓ_n	ℓ_s	Ds	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/ Metal Surgical Instruments

DIN

①-185

DIN

PH-SP

Spiral Fluted Taps for Hard-to-Machine Materials



Specification



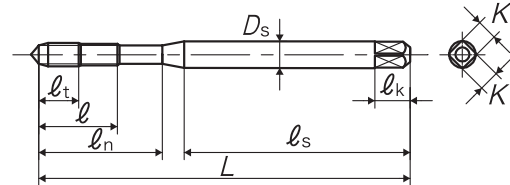
■ Suitable for hard steels of 25-35HRC, such as forgings and thermal refined steels of high carbon steels and alloy steels, and die steels.

Tapping Speeds depending on Materials

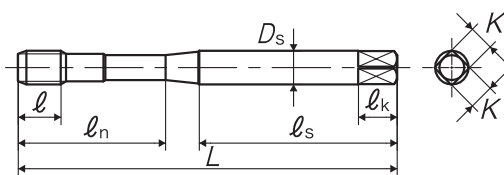
High carbon steels 高炭素鋼	Alloy steels 合金鋼	Thermal refined steels 調質鋼
2~7 (m/min)	2~7 (m/min)	~5 (m/min)

25~35HRC

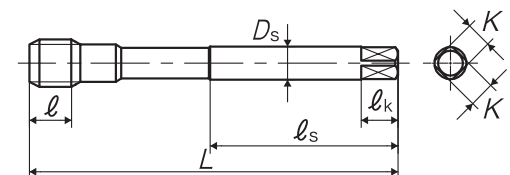
TYPE: 1



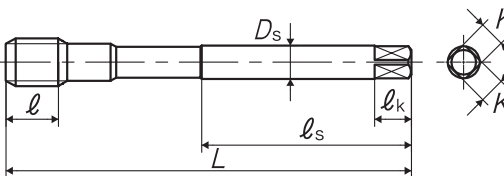
TYPE: 2



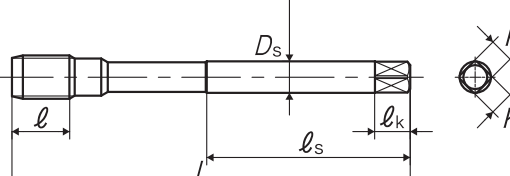
TYPE: 3



TYPE: 4



TYPE: 5



Segment : 1D (G=1H)

Size	Class	Code	Chamfer	L (mm)	ℓ_t (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads													
M3 × 0.5	ISO2	SD3.0GAEEEX	3P	56	5	9	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2	SD4.0IAEEEX	3P	63	7	13	21	38	4.5	3.4	6	3	1
M5 × 0.8	ISO2	SD5.0KAEEEX	3P	70	9	14	25	39	6	4.9	8	3	1
M6 × 1	ISO2	SD6.0MAEEEX	3P	80	11	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2	SD8.0NAEEEX	3P	90	-	12	35	47	8	6.2	9	3	2
M8 × 1	ISO2	SM8.0MAEEEX	3P	90	-	12	-	46	6	4.9	8	3	3
M10 × 1.5	ISO2	SD010OAEEX	3P	100	-	13	39	52.5	10	8	11	3	2
M10 × 1.25	ISO2	SM010NAEEX	3P	100	-	13	-	51	7	5.5	8	3	3
M10 × 1	ISO2	SM010MAEEX	3P	90	-	13	-	46	7	5.5	8	3	3

Think threads with
YAMAWA

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

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

Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M12 × 1.75	ISO2	SG012PAEEX	3P	110	-	15	-	56	9	7	10	4	4
M12 × 1.5	ISO2	SM012OAEEX	3P	100	-	15	-	51	9	7	10	4	3
M12 × 1.25	ISO2	SM012NAEEX	3P	100	-	15	-	51	9	7	10	4	3
M14 × 2	ISO2	SG014QAEEX	3P	110	-	18	-	56	11	9	12	4	4
M14 × 1.5	ISO2	SM014OAEEX	3P	100	-	14	-	51	11	9	12	4	3
M16 × 2	ISO2	SG016QAEEX	3P	110	-	18	-	56	12	9	12	4	4
M16 × 1.5	ISO2	SM016OAEEX	3P	100	-	14	-	51	12	9	12	4	3
M18 × 2.5	ISO2	SG018RAEEX	3P	125	-	20	-	64	14	11	14	4	4
M18 × 1.5	ISO2	SM018OAEEX	3P	110	-	14	-	56	14	11	14	4	3
M20 × 2.5	ISO2	SG020RAEEX	3P	140	-	20	-	71	16	12	15	4	4
M20 × 1.5	ISO2	SM020OAEEX	3P	125	-	14	-	64	16	12	15	4	3
M22 × 2.5	ISO2	SG022RAEEX	3P	140	-	20	-	71	18	14.5	17	5	4
M22 × 1.5	ISO2	SM022OAEEX	3P	125	-	14	-	64	18	14.5	17	5	3
M24 × 3	ISO2	SG024SAEEX	3P	160	-	25	-	82	18	14.5	17	5	4
M24 × 2	ISO2	SM024QAEEX	3P	140	-	18	-	71	18	14.5	17	5	3
M24 × 1.5	ISO2	SM024OAEEX	3P	140	-	18	-	71	18	14.5	17	5	3
M27 × 3	ISO2	SG027SAEEX	3P	160	-	25	-	82	20	16	19	5	4
M27 × 2	ISO2	SM027QAEEX	3P	140	-	20	-	71	20	16	19	5	3
M30 × 3.5	ISO2	SG030TAEEX	3P	180	-	30	-	92	22	18	21	5	4
M30 × 2	ISO2	SM030QAEEX	3P	150	-	20	-	77	22	18	21	5	3
M30 × 1.5	ISO2	SM030OAEEX	3P	150	-	20	-	77	22	18	21	5	3
For G Threads													
G 1/8-28	-	SVG0020EEX	3P	90	-	12	-	46	7	5.5	8	3	5
G 1/4-19	-	SVG0040EEX	3P	100	-	14	-	51	11	9	12	4	5
G 3/8-19	-	SVG0060EEX	3P	100	-	14	-	51	12	9	12	4	5
G 1/2-14	-	SVG0080EEX	3P	125	-	18	-	64	16	12	15	5	5

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DIN

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

DIN

①-186