

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

3

DIN

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/
Metal Surgical Instruments ⑫

DIN

③-118

DIN

PM-PO

Spiral Pointed Taps for Hard-to-Machine Materials



Specification

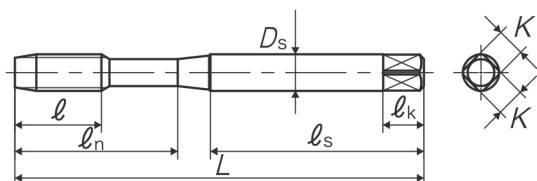


■ Spiral pointed tap suitable for high hardness steels of 25 ~ 45HRC such as forgings and thermal refined steels of high carbon steels and alloy steels, and die steel. Through hole use.

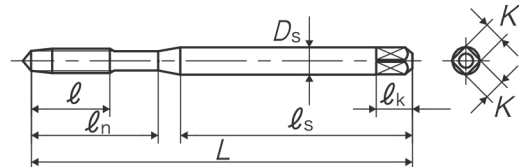
Tapping Speeds depending on Materials

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

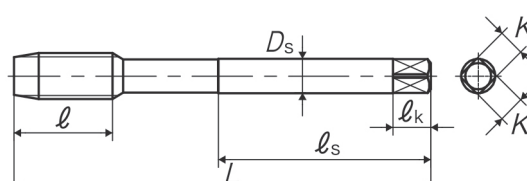
TYPE:2



TYPE:1



TYPE:3



Segment : 1F

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												
M3 × 0.5	ISO2X	PD3.0GBDPB	5.5P	56	9	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2X	PD4.0IBDPB	5.5P	63	13	21	38	4.5	3.4	6	3	1
M5 × 0.8	ISO2X	PD5.0KBDPB	5.5P	70	14	25	39	6	4.9	8	3	1
M6 × 1	ISO2X	PD6.0MBDPB	5.5P	80	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	PD8.0NBDPB	5.5P	90	19	35	47	8	6.2	9	3	2
M10 × 1.5	ISO2X	PD10.0BDPB	5.5P	100	23	39	52.5	10	8	11	3	2
M10 × 1.25	ISO2X	PM10.0NBDPB	5.5P	100	23	-	51	7	5.5	8	3	3
M12 × 1.75	ISO2X	PG12.0PBDPB	5.5P	110	26	-	56	9	7	10	3	3
M12 × 1.5	ISO2X	PM12.0BDPB	5.5P	100	21	-	51	9	7	10	3	3
M12 × 1.25	ISO2X	PM12.0NBDPB	5.5P	100	21	-	51	9	7	10	3	3
M14 × 2	ISO2X	PG14.0QBDPB	5.5P	110	26	-	56	11	9	12	3	3
M14 × 1.5	ISO2X	PM14.0BDPB	5.5P	100	21	-	51	11	9	12	3	3
M16 × 2	ISO2X	PG16.0QBDPB	5.5P	110	26	-	56	12	9	12	3	3
M16 × 1.5	ISO2X	PM16.0BDPB	5.5P	100	21	-	51	12	9	12	3	3
M18 × 2.5	ISO2X	PG18.0RBDPB	5.5P	125	33	-	64	14	11	14	3	3
M18 × 1.5	ISO2X	PM18.0BDPB	5.5P	110	24	-	56	14	11	14	3	3
M20 × 2.5	ISO2X	PG20.0RBDPB	5.5P	140	33	-	71	16	12	15	3	3

③ Spiral Pointed Tap Series for through 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

DIN

PM-PO Spiral Pointed Taps for Hard-to-Machine Materials

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M20 × 1.5	ISO2X	PM020OBDBP	5.5P	125	24	-	64	16	12	15	3	3
M22 × 2.5	ISO2X	PG022RBDPB	5.5P	140	33	-	71	18	14.5	17	3	3
M22 × 1.5	ISO2X	PM022OBDBP	5.5P	125	24	-	64	18	14.5	17	3	3
M24 × 3	ISO2X	PG024SBDPB	5.5P	160	37	-	82	18	14.5	17	3	3
M24 × 1.5	ISO2X	PM024OBDBP	5.5P	140	27	-	71	18	14.5	17	3	3
M27 × 3	ISO2X	PG027SBDPB	5.5P	160	37	-	82	20	16	19	4	3
M27 × 1.5	ISO2X	PM027OBDBP	5.5P	140	27	-	71	20	16	19	4	3
M30 × 3.5	ISO2X	PG030TBDPB	5.5P	180	44	-	92	22	18	21	4	3
M30 × 1.5	ISO2X	PM030OBDBP	5.5P	150	27	-	77	22	18	21	4	3
For Unified Threads												
No.6-32UNC	2B	PDUN6JXDPB	5.5P	56	11	19	32	4	3	6	2	1
No.6-40UNF	2B	PDUN6HXDPB	5.5P	56	11	19	32	4	3	6	2	1
No.8-32UNC	2B	PDUN8JXDPB	5.5P	63	13	21	38	4.5	3.4	6	2	1
No.8-36UNF	2B	PDUN8IXDPB	5.5P	63	13	21	38	4.5	3.4	6	2	1
No.10-24UNC	2B	PDUNAMXDPB	5.5P	70	14	24	39	6	4.9	8	2	1
No.10-32UNF	2B	PDUNAJXDPB	5.5P	70	14	24	39	6	4.9	8	2	1
No.12-24UNC	2B	PDUNCMXDPB	5.5P	80	15	28	45	6	4.9	8	2	1
No.12-28UNF	2B	PDUNCXKDPB	5.5P	80	15	28	45	6	4.9	8	2	1
1/4-20UNC	2BX	PDU04NYDPB	5.5P	80	15	30	42	7	5.5	8	3	1
1/4-28UNF	2BX	PDU04KYDPB	5.5P	80	15	30	42	7	5.5	8	3	1
5/16-18UNC	2BX	PDU05OYDPB	5.5P	90	19	35	47	8	6.2	9	3	2
5/16-24UNF	2BX	PMU05MYDPB	5.5P	90	19	-	46	6	4.9	8	3	3
3/8-16UNC	2BX	PDU06PYDPB	5.5P	100	23	39	54.5	9	7	10	3	2
3/8-24UNF	2BX	PMU06MYDPB	5.5P	100	23	-	51	7	5.5	8	3	3
7/16-14UNC	2BX	PGU07QYDPB	5.5P	100	23	-	51	8	6.2	9	3	3
7/16-20UNF	2BX	PMU07NYDPB	5.5P	100	23	-	51	8	6.2	9	3	3
1/2-13UNC	2BX	PGU08RYDPB	5.5P	110	26	-	56	9	7	10	3	3
1/2-20UNF	2BX	PMU08NYDPB	5.5P	100	21	-	51	9	7	10	3	3
9/16-12UNC	2BX	PGU09SYDPB	5.5P	110	26	-	56	11	9	12	3	3
9/16-18UNF	2BX	PMU09OYDPB	5.5P	100	21	-	51	11	9	12	3	3
5/8-11UNC	2BX	PGU10UYDPB	5.5P	110	26	-	56	12	9	12	3	3
5/8-18UNF	2BX	PMU10OYDPB	5.5P	100	21	-	51	12	9	12	3	3
3/4-10UNC	2BX	PGU12VYDPB	5.5P	125	33	-	64	14	11	14	3	3
3/4-16UNF	2BX	PMU12PYDPB	5.5P	110	24	-	56	14	11	14	3	3
7/8-9UNC	2BX	PGU14WYDPB	5.5P	140	33	-	71	18	14.5	17	3	3
7/8-14UNF	2BX	PMU14QYDPB	5.5P	125	24	-	64	18	14.5	17	3	3
1-8UNC	2BX	PGU16XYDPB	5.5P	160	37	-	82	18	14.5	17	3	3
1-12UNF	2BX	PMU16SYDPB	5.5P	140	27	-	71	18	14.5	17	3	3

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

③-119

Think threads with
YAMAWA

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