

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/
Medical Surgical Instruments

DIN

①-189

DIN

PM-SP

Spiral Fluted Taps for Hard-to-Machine Materials



Specification

HSS-P



■ 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.

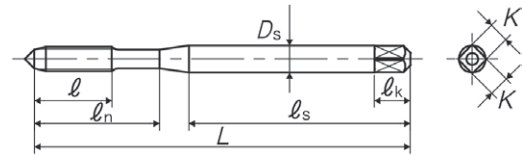
Tapping Speeds depending on Materials

High carbon steels
高炭素鋼
5~10
(m/min)

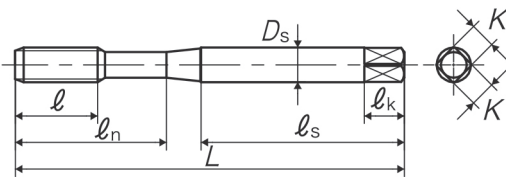
Thermal refined steels
調質鋼
~5
(m/min)
25~35HRC

Thermal refined steels
調質鋼
~5
(m/min)
35~45HRC

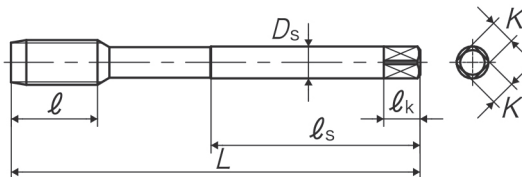
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1D

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	ISO2X	SD3.0GBDPB	2.75P	56	-	9	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2X	SD4.0IBDPB	2.75P	63	-	13	21	38	4.5	3.4	6	3	1
M5 × 0.8	ISO2X	SD5.0KBDPB	2.75P	70	-	14	25	39	6	4.9	8	3	1
M6 × 1	ISO2X	SD6.0MBDPB	2.75P	80	-	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	SD8.0NBDPB	2.75P	90	-	19	35	47	8	6.2	9	3	2
M8 × 1	ISO2X	SM8.0MBDPB	2.75P	90	-	19	-	46	6	4.9	8	3	3
M10 × 1.5	ISO2X	SD10.0BDPB	2.75P	100	-	23	39	52.5	10	8	11	3	2
M10 × 1.25	ISO2X	SM10.0NBDPB	2.75P	100	-	23	-	51	7	5.5	8	3	3
M10 × 1	ISO2X	SM10.0MBDPB	2.75P	90	-	19	-	46	7	5.5	8	3	3
M12 × 1.75	ISO2X	SG012PBDPB	2.75P	110	-	26	-	56	9	7	10	3	3
M12 × 1.5	ISO2X	SM12.0BDPB	2.75P	100	-	21	-	51	9	7	10	3	3
M12 × 1.25	ISO2X	SM12.0NBDPB	2.75P	100	-	21	-	51	9	7	10	3	3
M14 × 2	ISO2X	SG014QBDPB	2.75P	110	-	26	-	56	11	9	12	3	3
M14 × 1.5	ISO2X	SM14.0BDPB	2.75P	100	-	21	-	51	11	9	12	3	3
M16 × 2	ISO2X	SG016QBDPB	2.75P	110	-	26	-	56	12	9	12	3	3
M16 × 1.5	ISO2X	SM16.0BDPB	2.75P	100	-	21	-	51	12	9	12	3	3
M18 × 2.5	ISO2X	SG018RBDPB	2.75P	125	-	33	-	64	14	11	14	4	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
M18 × 1.5	ISO2X	SM018OBDBP	2.75P	110	-	24	-	56	14	11	14	4	3
M20 × 2.5	ISO2X	SG020RBDBP	2.75P	140	-	33	-	71	16	12	15	4	3
M20 × 1.5	ISO2X	SM020OBDBP	2.75P	125	-	24	-	64	16	12	15	4	3
M22 × 2.5	ISO2X	SG022RBDBP	2.75P	140	-	33	-	71	18	14.5	17	4	3
M22 × 1.5	ISO2X	SM022OBDBP	2.75P	125	-	24	-	64	18	14.5	17	4	3
M24 × 3	ISO2X	SG024SBDBP	2.75P	160	-	37	-	82	18	14.5	17	4	3
M24 × 2	ISO2X	SM024QBDBP	2.75P	140	-	27	-	71	18	14.5	17	4	3
M24 × 1.5	ISO2X	SM024OBDBP	2.75P	140	-	27	-	71	18	14.5	17	4	3
M27 × 3	ISO2X	SG027SBDBP	2.75P	160	-	37	-	82	20	16	19	4	3
M27 × 2	ISO2X	SM027QBDBP	2.75P	140	-	27	-	71	20	16	19	4	3
M27 × 1.5	ISO2X	SM027OBDBP	2.75P	140	-	27	-	71	20	16	19	4	3
M30 × 3.5	ISO2X	SG030TBDBP	2.75P	180	-	44	-	92	22	18	21	4	3
M30 × 2	ISO2X	SM030QBDBP	2.75P	150	-	27	-	77	22	18	21	4	3
M30 × 1.5	ISO2X	SM030OBDBP	2.75P	150	-	27	-	77	22	18	21	4	3
For Unified Threads													
5/16-18UNC	2BX	SDU05OYDPB	2.75P	90	-	19	35	47	8	6.2	9	3	2
5/16-24UNF	2BX	SMU05MYDPB	2.75P	90	-	19	-	46	6	4.9	8	3	3
3/8-16UNC	2BX	SDU06PYDPB	2.75P	100	-	23	39	54.5	9	7	10	3	2
3/8-24UNF	2BX	SMU06MYDPB	2.75P	100	-	23	-	51	7	5.5	8	3	3
7/16-14UNC	2BX	SGU07QYDPB	2.75P	100	-	23	-	51	8	6.2	9	3	3
7/16-20UNF	2BX	SMU07NYDPB	2.75P	100	-	23	-	51	8	6.2	9	3	3
1/2-13UNC	2BX	SGU08RYDPB	2.75P	110	-	26	-	56	9	7	10	3	3
1/2-20UNF	2BX	SMU08NYDPB	2.75P	100	-	21	-	51	9	7	10	3	3
5/8-11UNC	2BX	SGU10UYDPB	2.75P	110	-	26	-	56	12	9	12	3	3
5/8-18UNF	2BX	SMU10OYDPB	2.75P	100	-	21	-	51	12	9	12	3	3
3/4-10UNC	2BX	SGU12VYDPB	2.75P	125	-	33	-	64	14	11	14	3	3
3/4-16UNF	2BX	SMU12PYDPB	2.75P	110	-	24	-	56	14	11	14	3	3
1 -8UNC	2BX	SGU16XYDPB	2.75P	160	-	37	-	82	18	14.5	17	3	3
1 -12UNF	2BX	SMU16SYDPB	2.75P	140	-	27	-	71	18	14.5	17	3	3

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DIN ①-190