

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



PO OX

Spiral Pointed Taps, Oxidized



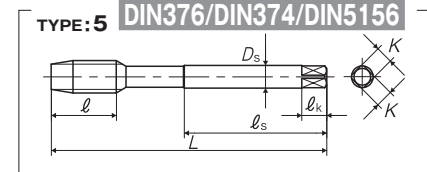
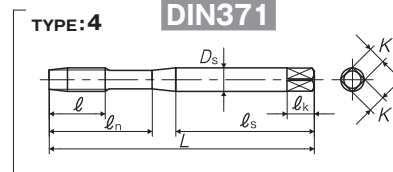
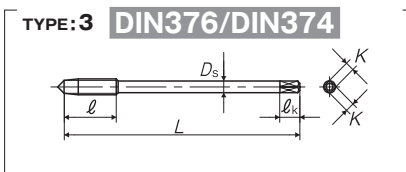
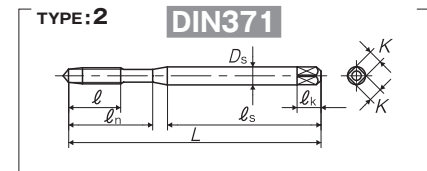
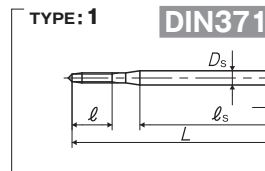
Specification



■ The +PO is a spiral pointed tap for through hole tapping and is suitable for synchronous feed processing in middle to high thread processing of soft steel materials whose chips easily weld to the taps thread such as low carbon steels.

Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)



Segment: 1F (G=1H)

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For Metric Threads												
M2 × 0.4	ISO2	PD2.0EANEX	5P	45	8	-	32	2.8	2.1	5	3	1
M2.2 × 0.45	ISO2	PD2.2FANEX	5P	45	9	-	32	2.8	2.1	5	3	1
M2.3 × 0.4	ISO2	PD2.3EANEX	5P	45	9	-	32	2.8	2.1	5	3	1
M2.5 × 0.45	ISO2	PD2.5FANEX	5P	50	8	15	33	2.8	2.1	5	3	2
M2.6 × 0.45	ISO2	PD2.6FANEX	5P	50	8	15	33	2.8	2.1	5	3	2
M3 × 0.5	ISO2	PD3.0GANEX	5P	56	9	18	34	3.5	2.7	6	3	2
M3 × 0.5	ISO3	PD3.0GMNEX	5P	56	9	18	34	3.5	2.7	6	3	2
M3.5 × 0.6	ISO2	PD3.5HANEX	5P	56	11	20	32	4	3	6	3	2
M4 × 0.7	ISO2	PD4.0IANEX	5P	63	13	21	38	4.5	3.4	6	3	2
M4 × 0.7	ISO2	PG4.0IANEX	5P	63	13	-	-	2.8	2.1	5	3	3
M4 × 0.7	ISO3	PD4.0IMNEX	5P	63	13	21	38	4.5	3.4	6	3	2
M4 × 0.5	ISO2	PM4.0GANEX	5P	63	9	-	-	2.8	2.1	5	3	3
M5 × 0.8	ISO2	PD5.0KANEX	5P	70	14	25	39	6	4.9	8	3	2
M5 × 0.8	ISO2	PG5.0KANEX	5P	70	14	-	-	3.5	2.7	6	3	3
M5 × 0.8	ISO3	PD5.0KMNEX	5P	70	14	25	39	6	4.9	8	3	2
M5 × 0.5	ISO2	PM5.0GANEX	5P	70	11	-	-	3.5	2.7	6	3	3
M6 × 1	ISO2	PD6.0MANEX	5P	80	15	30	45	6	4.9	8	3	2
M6 × 1	ISO2	PG6.0MANEX	5P	80	15	-	-	4.5	3.4	6	3	3
M6 × 1	ISO3	PD6.0MMNEX	5P	80	15	30	45	6	4.9	8	3	2
M6 × 0.75	ISO2	PM6.0JANEX	5P	80	13	-	-	4.5	3.4	6	3	3

- 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

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

PO OX Spiral Pointed Taps, Oxidized

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M6 × 0.5	ISO2	PM6.0GANEX	5P	80	13	-	-	4.5	3.4	6	3	3
M7 × 1	ISO2	PD7.0MANEX	5P	80	15	30	45	7	5.5	8	3	4
M7 × 0.75	ISO2	PM7.0JANEX	5P	80	13	-	41	5.5	4.3	7	3	5
M7 × 0.5	ISO2	PM7.0GANEX	5P	80	13	-	41	5.5	4.3	7	3	5
M8 × 1.25	ISO2	PD8.0ANEX	5P	90	19	35	47	8	6.2	9	3	4
M8 × 1.25	ISO2	PG8.0ANEX	5P	90	19	-	46	6	4.9	8	3	5
M8 × 1.25	ISO3	PD8.0NMNEX	5P	90	19	35	47	8	6.2	9	3	4
M8 × 1	ISO2	PM8.0MANEX	5P	90	19	-	46	6	4.9	8	3	5
M8 × 0.75	ISO2	PM8.0JANEX	5P	80	19	-	41	6	4.9	8	3	5
M8 × 0.5	ISO2	PM8.0GANEX	5P	80	19	-	41	6	4.9	8	3	5
M9 × 1.25	ISO2	PD9.0ANEX	5P	90	19	35	48	9	7	10	3	4
M9 × 1.25	ISO2	PG9.0ANEX	5P	90	19	-	46	7	5.5	8	3	5
M9 × 1	ISO2	PM9.0MANEX	5P	90	19	-	46	7	5.5	8	3	5
M10 × 1.5	ISO2	PD0100ANEX	5P	100	23	39	52.5	10	8	11	3	4
M10 × 1.5	ISO2	PG0100ANEX	5P	100	23	-	51	7	5.5	8	3	5
M10 × 1.5	ISO3	PD0100MNEX	5P	100	23	39	52.5	10	8	11	3	4
M10 × 1.25	ISO2	PM010ANEX	5P	100	23	-	51	7	5.5	8	3	5
M10 × 1	ISO2	PM010MANEX	5P	90	19	-	46	7	5.5	8	3	5
M10 × 0.75	ISO2	PM010JANEX	5P	90	19	-	46	7	5.5	8	3	5
M11 × 1.5	ISO2	PG0110ANEX	5P	100	23	-	51	8	6.2	9	3	5
M12 × 1.75	ISO2	PG012PANEX	5P	110	26	-	56	9	7	10	3	5
M12 × 1.75	ISO3	PG012PMNEX	5P	110	26	-	56	9	7	10	3	5
M12 × 1.5	ISO2	PM0120ANEX	5P	100	21	-	51	9	7	10	3	5
M12 × 1.25	ISO2	PM012ANEX	5P	100	21	-	51	9	7	10	3	5
M12 × 1	ISO2	PM012MANEX	5P	100	21	-	51	9	7	10	3	5
M14 × 2	ISO2	PG014QANEX	5P	110	26	-	56	11	9	12	3	5
M14 × 2	ISO3	PG014QMNEX	5P	110	26	-	56	11	9	12	3	5
M14 × 1.5	ISO2	PM0140ANEX	5P	100	21	-	51	11	9	12	3	5
M14 × 1.25	ISO2	PM014ANEX	5P	100	21	-	51	11	9	12	3	5
M14 × 1	ISO2	PM014MANEX	5P	100	21	-	51	11	9	12	3	5
M16 × 2	ISO2	PG016QANEX	5P	110	26	-	56	12	9	12	3	5
M16 × 2	ISO3	PG016QMNEX	5P	110	26	-	56	12	9	12	3	5
M16 × 1.5	ISO2	PM0160ANEX	5P	100	21	-	51	12	9	12	3	5
M16 × 1	ISO2	PM016MANEX	5P	100	21	-	51	12	9	12	3	5
M18 × 2.5	ISO2	PG018RANEX	5P	125	33	-	64	14	11	14	3	5
M18 × 2	ISO2	PM018QANEX	5P	125	33	-	64	14	11	14	3	5
M18 × 1.5	ISO2	PM0180ANEX	5P	110	24	-	56	14	11	14	3	5
M18 × 1	ISO2	PM018MANEX	5P	110	24	-	56	14	11	14	3	5
M20 × 2.5	ISO2	PG020RANEX	5P	140	33	-	71	16	12	15	3	5
M20 × 2	ISO2	PM020QANEX	5P	140	33	-	71	16	12	15	3	5
M20 × 1.5	ISO2	PM0200ANEX	5P	125	24	-	64	16	12	15	3	5
M20 × 1	ISO2	PM020MANEX	5P	125	24	-	64	16	12	15	3	5
M22 × 2.5	ISO2	PG022RANEX	5P	140	33	-	71	18	14.5	17	3	5
M22 × 2	ISO2	PM022QANEX	5P	140	33	-	71	18	14.5	17	3	5
M22 × 1.5	ISO2	PM0220ANEX	5P	125	24	-	64	18	14.5	17	3	5
M22 × 1	ISO2	PM022MANEX	5P	125	24	-	64	18	14.5	17	3	5
M24 × 3	ISO2	PG024SANEX	5P	160	37	-	82	18	14.5	17	3	5
M24 × 2	ISO2	PM024QANEX	5P	140	27	-	71	18	14.5	17	3	5
M24 × 1.5	ISO2	PM0240ANEX	5P	140	27	-	71	18	14.5	17	3	5
M24 × 1	ISO2	PM024MANEX	5P	140	27	-	71	18	14.5	17	3	5

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

③-53

Think threads with **YAMAWA**

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

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

PO OX Spiral Pointed Taps, Oxidized

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M25 × 1.5	ISO2	PM025OANEX	5P	140	27	-	71	18	14.5	17	3	5
M26 × 1.5	ISO2	PM026OANEX	5P	140	27	-	71	18	14.5	17	4	5
M27 × 3	ISO2	PG027SANEX	5P	160	37	-	82	20	16	19	4	5
M27 × 2	ISO2	PM027QANEX	5P	140	27	-	71	20	16	19	4	5
M27 × 1.5	ISO2	PM027OANEX	5P	140	27	-	71	20	16	19	4	5
M27 × 1	ISO2	PM027MANEX	5P	140	27	-	71	20	16	19	4	5
M28 × 2	ISO2	PM028QANEX	5P	140	27	-	71	20	16	19	4	5
M28 × 1.5	ISO2	PM028OANEX	5P	140	27	-	71	20	16	19	4	5
M28 × 1	ISO2	PM028MANEX	5P	140	27	-	71	20	16	19	4	5
M30 × 3.5	ISO2	PG030TANEX	5P	180	44	-	92	22	18	21	4	5
M30 × 2	ISO2	PM030QANEX	5P	150	27	-	77	22	18	21	4	5
M30 × 1.5	ISO2	PM030OANEX	5P	150	27	-	77	22	18	21	4	5
M30 × 1	ISO2	PM030MANEX	5P	150	27	-	77	22	18	21	4	5
M32 × 2	ISO2	PM032QANEX	5P	150	27	-	77	22	18	21	4	5
M32 × 1.5	ISO2	PM032OANEX	5P	150	27	-	77	22	18	21	4	5
M32 × 1	ISO2	PM032MANEX	5P	150	27	-	77	22	18	21	4	5
M33 × 3.5	ISO2	PG033TANEX	5P	180	46	-	92	25	20	23	4	5
M33 × 2	ISO2	PM033QANEX	5P	160	29	-	82	25	20	23	4	5
M33 × 1.5	ISO2	PM033OANEX	5P	160	29	-	82	25	20	23	4	5
M33 × 1	ISO2	PM033MANEX	5P	160	29	-	82	25	20	23	4	5
M36 × 4	ISO2	PG036UANEX	5P	200	52	-	102	28	22	25	4	5
M36 × 3	ISO2	PM036SANEX	5P	200	52	-	102	28	22	25	4	5
M36 × 2	ISO2	PM036QANEX	5P	170	29	-	87	28	22	25	4	5
M36 × 1.5	ISO2	PM036OANEX	5P	170	29	-	87	28	22	25	4	5
M36 × 1	ISO2	PM036MANEX	5P	170	29	-	87	28	22	25	4	5
M39 × 4	ISO2	PG039UANEX	5P	200	52	-	102	32	24	27	4	5
M39 × 2	ISO2	PM039QANEX	5P	170	29	-	87	32	24	27	4	5
M39 × 1.5	ISO2	PM039OANEX	5P	170	29	-	87	32	24	27	4	5
M39 × 1	ISO2	PM039MANEX	5P	170	29	-	87	32	24	27	4	5
M42 × 4.5	ISO2	PG042VANEX	5P	200	59	-	102	32	24	27	4	5
M42 × 2	ISO2	PM042QANEX	5P	170	29	-	87	32	24	27	4	5
M42 × 1.5	ISO2	PM042OANEX	5P	170	29	-	87	32	24	27	4	5
M42 × 1	ISO2	PM042MANEX	5P	170	29	-	87	32	24	27	4	5
M45 × 4.5	ISO2	PG045VANEX	5P	220	59	-	112	36	29	32	4	5
M45 × 3	ISO2	PM045SANEX	5P	200	49	-	102	36	29	32	4	5
M45 × 2	ISO2	PM045QANEX	5P	180	31	-	92	36	29	32	4	5
M45 × 1.5	ISO2	PM045OANEX	5P	180	31	-	92	36	29	32	4	5
M45 × 1	ISO2	PM045MANEX	5P	180	31	-	92	36	29	32	4	5
M48 × 5	ISO2	PG048WANEX	5P	250	65	-	128	36	29	32	4	5
M48 × 3	ISO2	PM048SANEX	5P	225	49	-	115	36	29	32	4	5
M48 × 2	ISO2	PM048QANEX	5P	190	31	-	97	36	29	32	4	5
M48 × 1.5	ISO2	PM048OANEX	5P	190	31	-	97	36	29	32	4	5
M48 × 1	ISO2	PM048MANEX	5P	190	31	-	97	36	29	32	4	5
For Unified Threads												
No.4-40UNC	2B	PDUN4HXNEX	5P	56	9	18	34	3.5	2.7	6	3	2
No.4-48UNF	2B	PDUN4FXNEX	5P	56	9	18	34	3.5	2.7	6	3	2
No.5-40UNC	2B	PDUN5HXNEX	5P	56	11	18	34	3.5	2.7	6	3	2
No.5-44UNF	2B	PDUN5GXNEX	5P	56	11	18	34	3.5	2.7	6	3	2
No.6-32UNC	2B	PDUN6JXNEX	5P	56	11	19	32	4	3	6	3	2
No.6-40UNF	2B	PDUN6HXNEX	5P	56	11	19	32	4	3	6	3	2

- 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

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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

- ① Spiral Fluted Taps (for blind hole)
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- 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

PO OX Spiral Pointed Taps, Oxidized

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
No.8-32UNC	2B	PDUN8JXNEX	5P	63	13	21	38	4.5	3.4	6	3	2
No.8-36UNF	2B	PDUN8IXNEX	5P	63	13	21	38	4.5	3.4	6	3	2
No.10-24UNC	2B	PDUNAMXNEX	5P	70	14	24	39	6	4.9	8	3	2
No.10-32UNF	2B	PDUNAJXNEX	5P	70	14	24	39	6	4.9	8	3	2
No.12-24UNC	2B	PDUNCMXNEX	5P	80	15	28	45	6	4.9	8	3	2
No.12-28UNF	2B	PDUNCKXNEX	5P	80	15	28	45	6	4.9	8	3	2
1/4-20UNC	2B	PDU04NXNEX	5P	80	15	30	42	7	5.5	8	3	2
1/4-28UNF	2B	PDU04KXNEX	5P	80	15	30	42	7	5.5	8	3	2
5/16-18UNC	2B	PDU05OXNEX	5P	90	19	35	47	8	6.2	9	3	4
5/16-24UNF	2B	PMU05MXNEX	5P	90	19	-	46	6	4.9	8	3	5
3/8-16UNC	2B	PDU06PXNEX	5P	100	23	39	54.5	9	7	10	3	4
3/8-24UNF	2B	PMU06MXNEX	5P	100	23	-	51	7	5.5	8	3	5
7/16-14UNC	2B	PGU07QXNEX	5P	100	23	-	51	8	6.2	9	3	5
7/16-20UNF	2B	PMU07NXNEX	5P	100	23	-	51	8	6.2	9	3	5
1/2-13UNC	2B	PGU08RXNEX	5P	110	26	-	56	9	7	10	3	5
1/2-20UNF	2B	PMU08NXNEX	5P	100	21	-	51	9	7	10	3	5
9/16-12UNC	2B	PGU09SXNEX	5P	110	26	-	56	11	9	12	3	5
9/16-18UNF	2B	PMU09OXNEX	5P	100	21	-	51	11	9	12	3	5
5/8-11UNC	2B	PGU10UXNEX	5P	110	26	-	56	12	9	12	3	5
5/8-18UNF	2B	PMU10OXNEX	5P	100	21	-	51	12	9	12	3	5
3/4-10UNC	2B	PGU12VXNEX	5P	125	33	-	64	14	11	14	3	5
3/4-16UNF	2B	PMU12PXNEX	5P	110	24	-	56	14	11	14	3	5
7/8-9UNC	2B	PGU14WXNEX	5P	140	33	-	71	18	14.5	17	3	5
7/8-14UNF	2B	PMU14QXNEX	5P	125	24	-	64	18	14.5	17	3	5
1 -8UNC	2B	PGU16XXNEX	5P	160	37	-	82	18	14.5	17	3	5
1 -12UNF	2B	PMU16SXNEX	5P	140	27	-	71	18	14.5	17	3	5
1 1/8-7UNC	2B	PGU18YXNEX	5P	180	44	-	92	22	18	21	4	5
1 1/8-12UNF	2B	PMU18SXNEX	5P	150	27	-	77	22	18	21	4	5
1 1/4-7UNC	2B	PGU20YXNEX	5P	180	49	-	92	22	18	21	4	5
1 1/4-12UNF	2B	PMU20SXNEX	5P	150	27	-	77	22	18	21	4	5
1 3/8-6UNC	2B	PGU22ZXNEX	5P	200	55	-	102	28	22	25	4	5
1 3/8-12UNF	2B	PMU22SXNEX	5P	170	29	-	87	28	22	25	4	5
1 1/2-6UNC	2B	PGU24ZXNEX	5P	200	59	-	102	32	24	27	4	5
1 1/2-12UNF	2B	PMU24SXNEX	5P	170	29	-	87	32	24	27	4	5
1 3/4-5UNC	2B	PGU280XNEX	5P	220	65	-	112	36	29	32	4	5
1 3/4-12UN	2B	PMU28SXNEX	5P	180	31	-	92	36	29	32	4	5
For G Threads												
G 1/16-28	-	PVG0010NEX	5P	90	19	-	46	6	4.9	8	3	5
G 1/8-28	-	PVG0020NEX	5P	90	19	-	46	7	5.5	8	3	5
G 1/4-19	-	PVG0040NEX	5P	100	21	-	51	11	9	12	3	5
G 3/8-19	-	PVG0060NEX	5P	100	21	-	51	12	9	12	3	5
G 1/2-14	-	PVG0080NEX	5P	125	24	-	64	16	12	15	3	5
G 5/8-14	-	PVG0100NEX	5P	125	24	-	64	18	14.5	17	3	5
G 3/4-14	-	PVG0120NEX	5P	140	27	-	71	20	16	19	4	5
G 7/8-14	-	PVG0140NEX	5P	150	27	-	77	22	18	21	4	5
G 1 -11	-	PVG0160NEX	5P	160	29	-	82	25	20	23	4	5
G 1 1/8-11	-	PVG0180NEX	5P	170	29	-	87	28	22	25	4	5
G 1 1/4-11	-	PVG0200NEX	5P	170	29	-	87	32	24	27	4	5
G 1 1/2-11	-	PVG0240NEX	5P	190	31	-	97	36	29	32	4	5