

3

| Overall length | Chamfer + full thread | Thread length | Thread + Neck length | Shank length | Shank dia. | Size of square | Length of square |
|----------------|-----------------------|---------------|----------------------|--------------|------------|----------------|------------------|
| L              | <i>lt</i>             | <i>l</i>      | <i>ln</i>            | <i>ls</i>    | Ds         | K              | <i>lk</i>        |

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

JIS



## Short Spiral Pointed Taps for Deep Hole Use

OX  
Oxide

■ S-PO is the spiral pointed tap having short thread portion which reduces friction and makes smooth coolant supply, and is suitable for such deep holes which are deeper than 2.5 times of the nominal dia.

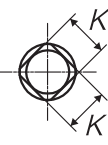
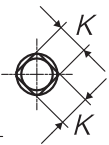
Low carbon steels  
低炭素鋼  
5~10  
(m/min)

Medium carbon steels  
中炭素鋼  
5~10  
(m/min)

High carbon steels  
高炭素鋼  
5~10  
(m/min)

Alloy steels  
合金鋼  
5~10  
(m/min)

Technical drawing of a tapered shaft. The shaft has a total length  $L$ . The diameter at the left end is  $D_s$ . The shaft is divided into several sections with lengths  $l_t$ ,  $l$ ,  $l_n$ ,  $l_s$ , and  $l_k$ . The section with length  $l_k$  is a threaded section.



Oversize

Segment : 1E

| Size               | Class | Code     | Chamfer | L<br>(mm) | ℓt<br>(mm) | ℓ<br>(mm) | ℓn<br>(mm) | ℓs<br>(mm) | Ds<br>(mm) | K<br>(mm) | ℓk<br>(mm) | No. of<br>flutes | TYPE | MSRP                 |
|--------------------|-------|----------|---------|-----------|------------|-----------|------------|------------|------------|-----------|------------|------------------|------|----------------------|
| For Metric Threads |       |          |         |           |            |           |            |            |            |           |            |                  |      |                      |
| M2 × 0.4           | P2    | PSMQ2.0E | 5P      | 42        | 4          | 7.2       | 12         | 27         | 3          | 2.5       | 5          | 2                | 1    | ¥ 3,260              |
| M2 × 0.4           | P3    | PSMR2.0E | 5P      | 42        | 4          | 7.2       | 12         | 27         | 3          | 2.5       | 5          | 2                | 1    | ¥ 3,260 <sup>※</sup> |
| M2.3 × 0.4         | P2    | PSMQ2.3E | 5P      | 42        | 4          | 7.2       | 12         | 27         | 3          | 2.5       | 5          | 2                | 1    | ¥ 2,970 <sup>※</sup> |
| M2.5 × 0.45        | P2    | PSMQ2.5F | 5P      | 46        | 4          | 8.1       | 14         | 29         | 3          | 2.5       | 5          | 2                | 1    | ¥ 2,490 <sup>※</sup> |
| M2.6 × 0.45        | P2    | PSMQ2.6F | 5P      | 46        | 4          | 8.1       | 14         | 29         | 3          | 2.5       | 5          | 2                | 1    | ¥ 2,490 <sup>※</sup> |
| M2.6 × 0.45        | P3    | PSMR2.6F | 5P      | 46        | 4          | 8.1       | 14         | 29         | 3          | 2.5       | 5          | 2                | 1    | ¥ 2,490 <sup>※</sup> |
| M3 × 0.5           | P2    | PSMQ3.0G | 5P      | 46        | 5          | 9         | 14         | 26         | 4          | 3.2       | 6          | 3                | 1    | ¥ 1,740              |
| M3 × 0.5           | P3    | PSMR3.0G | 5P      | 46        | 5          | 9         | 14         | 26         | 4          | 3.2       | 6          | 3                | 1    | ¥ 1,740 <sup>※</sup> |
| 3M0.6              | P2    | PSMQ3.0H | 5P      | 46        | 5          | 9         | 14         | 26         | 4          | 3.2       | 6          | 3                | 1    | ¥ 1,740 <sup>※</sup> |
| M3.5 × 0.6         | P2    | PSMQ3.5H | 5P      | 52        | 7          | 11        | 16         | 29         | 5          | 4         | 7          | 3                | 1    | ¥ 1,740 <sup>※</sup> |
| M4 × 0.7           | P2    | PSMQ4.0I | 5P      | 52        | 7          | 11        | 17         | 29         | 5          | 4         | 7          | 3                | 1    | ¥ 1,740              |
| M4 × 0.7           | P3    | PSMR4.0I | 5P      | 52        | 7          | 11        | 17         | 29         | 5          | 4         | 7          | 3                | 1    | ¥ 1,740 <sup>※</sup> |
| M4 × 0.7           | P4    | PSMS4.0I | 5P      | 52        | 7          | 11        | 17         | 29         | 5          | 4         | 7          | 3                | 1    | ¥ 1,740 <sup>※</sup> |
| 4M0.75             | P2    | PSMQ4.0J | 5P      | 52        | 7          | 11        | 17         | 29         | 5          | 4         | 7          | 3                | 1    | ¥ 1,740 <sup>※</sup> |
| M5 × 0.8           | P2    | PSMQ5.0K | 5P      | 60        | 9          | 13        | 22         | 33         | 5.5        | 4.5       | 7          | 3                | 1    | ¥ 1,770              |
| M5 × 0.8           | P3    | PSMR5.0K | 5P      | 60        | 9          | 13        | 22         | 33         | 5.5        | 4.5       | 7          | 3                | 1    | ¥ 1,770 <sup>※</sup> |
| M5 × 0.8           | P4    | PSMS5.0K | 5P      | 60        | 9          | 13        | 22         | 33         | 5.5        | 4.5       | 7          | 3                | 1    | ¥ 1,770 <sup>※</sup> |

※ = Specified Distribution Items. Made to order products.

| 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 | MSRP       |
|------------|-------|----------|---------|--------|---------|--------|---------|---------|---------|--------|---------|---------------|------|------------|
| 5M0.9      | P2    | PSMQ5.0L | 5P      | 60     | 9       | 13     | 22      | 33      | 5.5     | 4.5    | 7       | 3             | 1    | ¥ 1,770 ※  |
| M6 × 1     | P2    | PSMQ6.0M | 5P      | 62     | 11      | 15     | 26      | 33      | 6       | 4.5    | 7       | 3             | 1    | ¥ 1,940    |
| M6 × 1     | P3    | PSMR6.0M | 5P      | 62     | 11      | 15     | 26      | 33      | 6       | 4.5    | 7       | 3             | 1    | ¥ 1,940 ※  |
| M6 × 1     | P4    | PSMS6.0M | 5P      | 62     | 11      | 15     | 26      | 33      | 6       | 4.5    | 7       | 3             | 1    | ¥ 1,940 ※  |
| M8 × 1.25  | P3    | PSMR8.0N | 5P      | 70     | -       | 12     | -       | 36      | 6.2     | 5      | 8       | 3             | 2    | ¥ 2,660    |
| M8 × 1.25  | P4    | PSMS8.0N | 5P      | 70     | -       | 12     | -       | 36      | 6.2     | 5      | 8       | 3             | 2    | ¥ 2,660 ※  |
| M8 × 1     | P3    | PSMR8.0M | 5P      | 70     | -       | 12     | -       | 36      | 6.2     | 5      | 8       | 3             | 2    | ¥ 3,020 ※  |
| M10 × 1.5  | P3    | PSMR010O | 5P      | 75     | -       | 13     | -       | 38      | 7       | 5.5    | 8       | 3             | 2    | ¥ 3,380    |
| M10 × 1.5  | P4    | PSMS010O | 5P      | 75     | -       | 13     | -       | 38      | 7       | 5.5    | 8       | 3             | 2    | ¥ 3,380 ※  |
| M10 × 1.25 | P3    | PSMR010N | 5P      | 75     | -       | 13     | -       | 38      | 7       | 5.5    | 8       | 3             | 2    | ¥ 3,380 ※  |
| M10 × 1.25 | P4    | PSMS010N | 5P      | 75     | -       | 13     | -       | 38      | 7       | 5.5    | 8       | 3             | 2    | ¥ 3,380 ※  |
| M10 × 1    | P3    | PSMR010M | 5P      | 75     | -       | 13     | -       | 38      | 7       | 5.5    | 8       | 3             | 2    | ¥ 4,010    |
| M12 × 1.75 | P4    | PSMS012P | 5P      | 82     | -       | 15     | -       | 42      | 8.5     | 6.5    | 9       | 3             | 2    | ¥ 4,780    |
| M12 × 1.75 | P5    | PSMT012P | 5P      | 82     | -       | 15     | -       | 42      | 8.5     | 6.5    | 9       | 3             | 2    | ¥ 4,780 ※  |
| M12 × 1.5  | P3    | PSMR012O | 5P      | 82     | -       | 15     | -       | 42      | 8.5     | 6.5    | 9       | 3             | 2    | ¥ 4,780 ※  |
| M12 × 1.5  | P5    | PSMT012O | 5P      | 82     | -       | 15     | -       | 42      | 8.5     | 6.5    | 9       | 3             | 2    | ¥ 4,780 ※  |
| M12 × 1.25 | P4    | PSMS012N | 5P      | 82     | -       | 15     | -       | 42      | 8.5     | 6.5    | 9       | 3             | 2    | ¥ 4,780    |
| M12 × 1.25 | P5    | PSMT012N | 5P      | 82     | -       | 15     | -       | 42      | 8.5     | 6.5    | 9       | 3             | 2    | ¥ 4,780 ※  |
| M12 × 1    | P3    | PSMR012M | 5P      | 82     | -       | 15     | -       | 42      | 8.5     | 6.5    | 9       | 3             | 2    | ¥ 5,630 ※  |
| M14 × 2    | P4    | PSMS014Q | 5P      | 88     | -       | 18     | -       | 45      | 10.5    | 8      | 11      | 3             | 2    | ¥ 6,520    |
| M14 × 2    | P5    | PSMT014Q | 5P      | 88     | -       | 18     | -       | 45      | 10.5    | 8      | 11      | 3             | 2    | ¥ 6,520 ※  |
| M14 × 1.5  | P3    | PSMR014O | 5P      | 88     | -       | 14     | -       | 45      | 10.5    | 8      | 11      | 3             | 2    | ¥ 6,520    |
| M14 × 1.5  | P5    | PSMT014O | 5P      | 88     | -       | 14     | -       | 45      | 10.5    | 8      | 11      | 3             | 2    | ¥ 6,520 ※  |
| M16 × 2    | P4    | PSMS016Q | 5P      | 95     | -       | 18     | -       | 48      | 12.5    | 10     | 13      | 3             | 2    | ¥ 8,720    |
| M16 × 2    | P5    | PSMT016Q | 5P      | 95     | -       | 18     | -       | 48      | 12.5    | 10     | 13      | 3             | 2    | ¥ 8,720 ※  |
| M16 × 1.5  | P3    | PSMR016O | 5P      | 95     | -       | 14     | -       | 48      | 12.5    | 10     | 13      | 3             | 2    | ¥ 8,720 ※  |
| M16 × 1.5  | P5    | PSMT016O | 5P      | 95     | -       | 14     | -       | 48      | 12.5    | 10     | 13      | 3             | 2    | ¥ 8,720 ※  |
| M18 × 2.5  | P4    | PSMS018R | 5P      | 100    | -       | 20     | -       | 51      | 14      | 11     | 14      | 3             | 2    | ¥ 11,700 ※ |
| M18 × 2.5  | P5    | PSMT018R | 5P      | 100    | -       | 20     | -       | 51      | 14      | 11     | 14      | 3             | 2    | ¥ 11,700 ※ |
| M18 × 1.5  | P4    | PSMS018O | 5P      | 100    | -       | 14     | -       | 51      | 14      | 11     | 14      | 3             | 2    | ¥ 11,700 ※ |
| M18 × 1.5  | P5    | PSMT018O | 5P      | 100    | -       | 14     | -       | 51      | 14      | 11     | 14      | 3             | 2    | ¥ 11,700 ※ |
| M20 × 2.5  | P4    | PSMS020R | 5P      | 105    | -       | 20     | -       | 50      | 15      | 12     | 15      | 3             | 3    | ¥ 16,000   |
| M20 × 2.5  | P5    | PSMT020R | 5P      | 105    | -       | 20     | -       | 50      | 15      | 12     | 15      | 3             | 3    | ¥ 16,000 ※ |
| M20 × 1.5  | P4    | PSMS020O | 5P      | 105    | -       | 14     | -       | 50      | 15      | 12     | 15      | 3             | 3    | ¥ 16,000 ※ |
| M20 × 1.5  | P5    | PSMT020O | 5P      | 105    | -       | 14     | -       | 50      | 15      | 12     | 15      | 3             | 3    | ¥ 16,000 ※ |
| M22 × 2.5  | P4    | PSMS022R | 5P      | 115    | -       | 20     | -       | 55      | 17      | 13     | 16      | 3             | 3    | ¥ 20,400 ※ |
| M22 × 1.5  | P4    | PSMS022O | 5P      | 115    | -       | 14     | -       | 55      | 17      | 13     | 16      | 3             | 3    | ¥ 20,400 ※ |
| M24 × 3    | P4    | PSMS024S | 5P      | 120    | -       | 25     | -       | 55      | 19      | 15     | 18      | 3             | 3    | ¥ 25,400 ※ |
| M24 × 1.5  | P4    | PSMS024O | 5P      | 120    | -       | 18     | -       | 55      | 19      | 15     | 18      | 3             | 3    | ¥ 25,400 ※ |
| M27 × 3    | P4    | PSMS027S | 5P      | 130    | -       | 25     | -       | 60      | 20      | 15     | 18      | 4             | 3    | ¥ 35,300 ※ |
| M27 × 1.5  | P4    | PSMS027O | 5P      | 130    | -       | 20     | -       | 60      | 20      | 15     | 18      | 4             | 3    | ¥ 35,300 ※ |
| M30 × 3.5  | P5    | PSMT030T | 5P      | 135    | -       | 30     | -       | 62      | 23      | 17     | 20      | 4             | 3    | ¥ 44,900 ※ |
| M30 × 1.5  | P4    | PSMS030O | 5P      | 135    | -       | 20     | -       | 62      | 23      | 17     | 20      | 4             | 3    | ¥ 44,900 ※ |
| M33 × 3.5  | P5    | PSMT033T | 5P      | 145    | -       | 30     | -       | 67      | 25      | 19     | 22      | 4             | 3    | ¥ 52,200 ※ |
| M36 × 4    | P5    | PSMT036U | 5P      | 155    | -       | 40     | -       | 71      | 28      | 21     | 24      | 4             | 3    | ¥ 60,500 ※ |
| M39 × 4    | P5    | PSMT039U | 5P      | 165    | -       | 40     | -       | 76      | 30      | 23     | 26      | 4             | 3    | ¥ 69,400 ※ |
| M42 × 4.5  | P5    | PSMT042V | 5P      | 175    | -       | 40     | -       | 81      | 32      | 26     | 30      | 4             | 3    | ¥ 84,400 ※ |

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Medical Surgical Instruments

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JIS

③-86

※ = Specified Distribution Items. Made to order products.

 Think threads with  
**YAMAWA**