

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

JIS

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

①-133

S-SP

Short Spiral Fluted Taps, Deep Hole Use



Specification

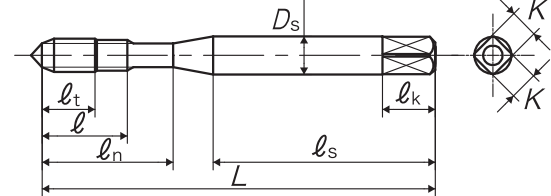


■ Due to short thread portion, friction becomes less and lubrication supply becomes better, and S-SP is the spiral fluted tap quite efficient for tapping deep holes that are 2.5 times deeper than the nominal dia.

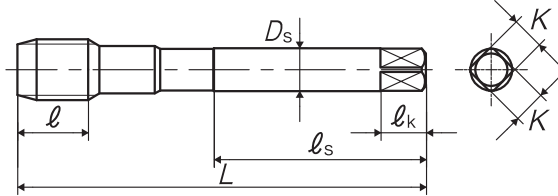
Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Ductile cast irons 強靱鑄鉄
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

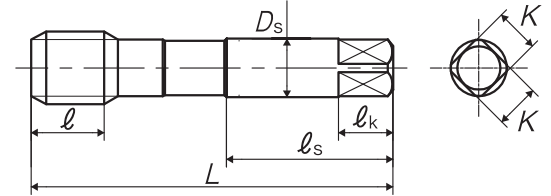
TYPE: 1



TYPE: 2



TYPE: 3



Oversize

Segment : 1C

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	MSRP
For Metric Threads														
M2 × 0.4	P1	SSMP2.0E	2.5P	42	4	7.2	12	27	3	2.5	5	2	1	¥ 3,260
M2 × 0.4	P3	SSMR2.0E	2.5P	42	4	7.2	12	27	3	2.5	5	2	1	¥ 3,260 ※
M2.3 × 0.4	P1	SSMP2.3E	2.5P	42	4	7.2	12	27	3	2.5	5	2	1	¥ 2,970 ※
M2.3 × 0.4	P3	SSMR2.3E	2.5P	42	4	7.2	12	27	3	2.5	5	2	1	¥ 2,970 ※
M2.5 × 0.45	P1	SSMP2.5F	2.5P	46	4	8.1	14	29	3	2.5	5	2	1	¥ 2,490 ※
M2.5 × 0.45	P2	SSMQ2.5F	2.5P	46	4	8.1	14	29	3	2.5	5	2	1	¥ 2,490 ※
M2.5 × 0.45	P3	SSMR2.5F	2.5P	46	4	8.1	14	29	3	2.5	5	2	1	¥ 2,490 ※
M2.6 × 0.45	P1	SSMP2.6F	2.5P	46	4	8.1	14	29	3	2.5	5	2	1	¥ 2,490 ※
M2.6 × 0.45	P3	SSMR2.6F	2.5P	46	4	8.1	14	29	3	2.5	5	2	1	¥ 2,490 ※
M3 × 0.5	P1	SSMP3.0G-3	2.5P	46	5	9	14	26	4	3.2	6	3	1	¥ 1,740
M3 × 0.5	P2	SSMQ3.0G	2.5P	46	5	9	14	26	4	3.2	6	3	1	¥ 1,740 ※
M3 × 0.5	P3	SSMR3.0G	2.5P	46	5	9	14	26	4	3.2	6	3	1	¥ 1,740 ※
M3.5 × 0.6	P1	SSMP3.5H-3	2.5P	52	7	11	16	29	5	4	7	3	1	¥ 1,740 ※
M3.5 × 0.6	P2	SSMQ3.5H	2.5P	52	7	11	16	29	5	4	7	3	1	¥ 1,740 ※
M4 × 0.7	P2	SSMQ4.0I	2.5P	52	7	11	17	29	5	4	7	3	1	¥ 1,740
M4 × 0.7	P3	SSMR4.0I	2.5P	52	7	11	17	29	5	4	7	3	1	¥ 1,740 ※

Think threads with
YAMAWA

※ = 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

1

JIS

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

JIS

①-134

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
M5 × 0.8	P2	SSMQ5.0K	2.5P	60	9	13	22	33	5.5	4.5	7	3	1	¥ 1,770
M5 × 0.8	P3	SSMR5.0K	2.5P	60	9	13	22	33	5.5	4.5	7	3	1	¥ 1,770 ※
M6 × 1	P2	SSMQ6.0M	2.5P	62	11	15	26	33	6	4.5	7	3	1	¥ 1,940
M6 × 1	P3	SSMR6.0M	2.5P	62	11	15	26	33	6	4.5	7	3	1	¥ 1,940 ※
M8 × 1.25	P2	SSMQ8.0N	2.5P	70	-	12	-	36	6.2	5	8	3	2	¥ 2,660
M8 × 1.25	P3	SSMR8.0N	2.5P	70	-	12	-	36	6.2	5	8	3	2	¥ 2,660 ※
M8 × 1	P2	SSMQ8.0M	2.5P	70	-	12	-	36	6.2	5	8	3	2	¥ 3,020 ※
M10 × 1.5	P2	SSMQ010O	2.5P	75	-	13	-	38	7	5.5	8	3	2	¥ 3,380
M10 × 1.5	P3	SSMR010O	2.5P	75	-	13	-	38	7	5.5	8	3	2	¥ 3,380 ※
M10 × 1.25	P2	SSMQ010N	2.5P	75	-	13	-	38	7	5.5	8	3	2	¥ 3,380
M10 × 1.25	P3	SSMR010N	2.5P	75	-	13	-	38	7	5.5	8	3	2	¥ 3,380 ※
M10 × 1	P2	SSMQ010M	2.5P	75	-	13	-	38	7	5.5	8	3	2	¥ 4,010 ※
M12 × 1.75	P2	SSMQ012P	2.5P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 4,780
M12 × 1.75	P3	SSMR012P	2.5P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 4,780 ※
M12 × 1.5	P2	SSMQ012O	2.5P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 4,780 ※
M12 × 1.5	P3	SSMR012O	2.5P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 4,780 ※
M12 × 1.25	P2	SSMQ012N	2.5P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 4,780
M12 × 1.25	P3	SSMR012N	2.5P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 4,780 ※
M12 × 1	P2	SSMQ012M	2.5P	82	-	15	-	42	8.5	6.5	9	3	2	¥ 5,630 ※
M14 × 2	P2	SSMQ014Q	2.5P	88	-	18	-	45	10.5	8	11	3	2	¥ 6,520
M14 × 2	P4	SSMS014Q	2.5P	88	-	18	-	45	10.5	8	11	3	2	¥ 6,520 ※
M14 × 1.5	P2	SSMQ014O	2.5P	88	-	14	-	45	10.5	8	11	3	2	¥ 6,520
M14 × 1.5	P4	SSMS014O	2.5P	88	-	14	-	45	10.5	8	11	3	2	¥ 6,520 ※
M14 × 1	P2	SSMQ014M	2.5P	88	-	14	-	45	10.5	8	11	3	2	¥ 7,580 ※
M16 × 2	P2	SSMQ016Q	2.5P	95	-	18	-	48	12.5	10	13	3	2	¥ 8,720
M16 × 2	P3	SSMR016Q	2.5P	95	-	18	-	48	12.5	10	13	3	2	¥ 8,720 ※
M16 × 2	P4	SSMS016Q	2.5P	95	-	18	-	48	12.5	10	13	3	2	¥ 8,720 ※
M16 × 1.5	P2	SSMQ016O	2.5P	95	-	14	-	48	12.5	10	13	3	2	¥ 8,720
M16 × 1.5	P4	SSMS016O	2.5P	95	-	14	-	48	12.5	10	13	3	2	¥ 8,720 ※
M16 × 1	P2	SSMQ016M	2.5P	95	-	14	-	48	12.5	10	13	3	2	¥ 10,400 ※
M18 × 2.5	P3	SSMR018R	2.5P	100	-	20	-	51	14	11	14	4	2	¥ 11,700
M18 × 2.5	P4	SSMS018R	2.5P	100	-	20	-	51	14	11	14	4	2	¥ 11,700 ※
M18 × 2	P3	SSMR018Q	2.5P	100	-	18	-	51	14	11	14	4	2	¥ 11,700 ※
M18 × 1.5	P2	SSMQ018O	2.5P	100	-	14	-	51	14	11	14	4	2	¥ 11,700 ※
M18 × 1.5	P4	SSMS018O	2.5P	100	-	14	-	51	14	11	14	4	2	¥ 11,700 ※
M18 × 1	P2	SSMQ018M	2.5P	100	-	14	-	51	14	11	14	4	2	¥ 15,200 ※
M20 × 2.5	P3	SSMR020R	2.5P	105	-	20	-	50	15	12	15	4	3	¥ 16,000
M20 × 2.5	P4	SSMS020R	2.5P	105	-	20	-	50	15	12	15	4	3	¥ 16,000 ※
M20 × 2	P3	SSMR020Q	2.5P	105	-	18	-	50	15	12	15	4	3	¥ 16,000 ※
M20 × 1.5	P3	SSMR020O	2.5P	105	-	14	-	50	15	12	15	4	3	¥ 16,000 ※
M20 × 1.5	P4	SSMS020O	2.5P	105	-	14	-	50	15	12	15	4	3	¥ 16,000 ※
M20 × 1	P2	SSMQ020M	2.5P	105	-	14	-	50	15	12	15	4	3	¥ 20,200 ※
M22 × 2.5	P3	SSMR022R	2.5P	115	-	20	-	55	17	13	16	4	3	¥ 20,400
M22 × 2	P3	SSMR022Q	2.5P	115	-	18	-	55	17	13	16	4	3	¥ 20,400 ※
M22 × 1.5	P3	SSMR022O	2.5P	115	-	14	-	55	17	13	16	4	3	¥ 20,400 ※
M22 × 1.5	P4	SSMS022O	2.5P	115	-	14	-	55	17	13	16	4	3	¥ 20,400 ※
M24 × 3	P3	SSMR024S	2.5P	120	-	25	-	55	19	15	18	4	3	¥ 25,400
M24 × 3	P4	SSMS024S	2.5P	120	-	25	-	55	19	15	18	4	3	¥ 25,400 ※
M24 × 2	P3	SSMR024Q	2.5P	120	-	18	-	55	19	15	18	4	3	¥ 25,400 ※
M24 × 1.5	P3	SSMR024O	2.5P	120	-	18	-	55	19	15	18	4	3	¥ 25,400 ※

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L	ℓt	ℓ	ℓn	ℓs	Ds	K	ℓk

JIS

S-SP Short Spiral Fluted Taps, Deep Hole Use

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
M24 × 1.5	P4	SSMS024O	2.5P	120	-	18	-	55	19	15	18	4	3	¥ 25,400 ※
M27 × 3	P3	SSMR027S	2.5P	130	-	25	-	60	20	15	18	4	3	¥ 35,300 ※
M27 × 2	P3	SSMR027Q	2.5P	130	-	20	-	60	20	15	18	4	3	¥ 35,300 ※
M27 × 1.5	P3	SSMR027O	2.5P	130	-	20	-	60	20	15	18	4	3	¥ 35,300 ※
M30 × 3.5	P4	SSMS030T	2.5P	135	-	30	-	62	23	17	20	4	3	¥ 44,900 ※
M30 × 3	P3	SSMR030S	2.5P	135	-	28	-	62	23	17	20	4	3	¥ 44,900 ※
M30 × 2	P3	SSMR030Q	2.5P	135	-	20	-	62	23	17	20	4	3	¥ 44,900 ※
M30 × 1.5	P3	SSMR030O	2.5P	135	-	20	-	62	23	17	20	4	3	¥ 44,900 ※
M32 × 2	P3	SSMR032Q	2.5P	145	-	20	-	67	24	19	22	4	3	¥ 52,200 ※
M32 × 1.5	P3	SSMR032O	2.5P	145	-	20	-	67	24	19	22	4	3	¥ 52,200 ※
M33 × 3.5	P4	SSMS033T	2.5P	145	-	30	-	67	25	19	22	4	3	¥ 52,200 ※
M33 × 3	P3	SSMR033S	2.5P	145	-	28	-	67	25	19	22	4	3	¥ 52,200 ※
M33 × 2	P3	SSMR033Q	2.5P	145	-	20	-	67	25	19	22	4	3	¥ 52,200 ※
M33 × 1.5	P3	SSMR033O	2.5P	145	-	20	-	67	25	19	22	4	3	¥ 52,200 ※
M35 × 2	P3	SSMR035Q	2.5P	155	-	20	-	71	28	21	24	4	3	¥ 60,500 ※
M35 × 1.5	P3	SSMR035O	2.5P	155	-	20	-	71	28	21	24	4	3	¥ 60,500 ※
M36 × 4	P4	SSMS036U	2.5P	155	-	40	-	71	28	21	24	4	3	¥ 60,500 ※
M36 × 3	P3	SSMR036S	2.5P	155	-	30	-	71	28	21	24	4	3	¥ 60,500 ※
M36 × 2	P3	SSMR036Q	2.5P	155	-	20	-	71	28	21	24	4	3	¥ 60,500 ※
M36 × 1.5	P3	SSMR036O	2.5P	155	-	20	-	71	28	21	24	4	3	¥ 60,500 ※
M39 × 4	P4	SSMS039U	2.5P	165	-	40	-	76	30	23	26	4	3	¥ 69,400 ※
M42 × 4.5	P4	SSMS042V	2.5P	175	-	40	-	81	32	26	30	4	3	¥ 84,400 ※
M45 × 4.5	P4	SSMS045V	2.5P	180	-	45	-	83	35	26	30	4	3	¥ 97,700 ※
M48 × 5	P4	SSMS048W	2.5P	185	-	45	-	85	38	29	32	4	3	¥ 123,000 ※

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3 Spiral Pointed Taps (for through hole)

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