

Overall length	Thread length	Shank dia.	Size of square	Length of square
L	ℓ	Ds	K	ℓk

S
I
S

SL Tr

Spiral Flute Tap for Through Hole for Trapezoidal Threads



Specification

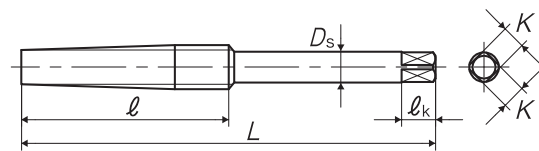


■ The SL Tr is a spiral flute tap for through hole trapezoidal threads. The thread angle is 30°. The thread symbol is represented by Tr.

Tapping Speeds depending on Materials

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

TYPE: 1



Segment: 1S

Size	Code	Chamfer	L (mm)	ℓ (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Trapezoidal threads										
Tr 10 × 2	LYT10Q0HEB	26P	160	70	7.8	6	9	3	1	¥ 57,200*
Tr 12 × 3	LYT12S0HEB	23P	190	95	9	7	10	3	1	¥ 75,600*
Tr 12 × 2	LYT12Q0HEB	30P	170	80	9	7	10	3	1	¥ 75,600*
Tr 14 × 3	LYT14S0HEB	23P	190	95	11	9	12	3	1	¥ 94,000*
Tr 16 × 4	LYT16U0HEB	22.5P	220	120	12	9	12	3	1	¥ 114,000*
Tr 16 × 3	LYT16S0HEB	25P	200	100	13	10	13	3	1	¥ 114,000*
Tr 18 × 4	LYT18U0HEB	22.5P	220	120	14	11	14	4	1	¥ 142,000*
Tr 20 × 4	LYT20U0HEB	24.5P	230	130	16	12	15	4	1	¥ 165,000*
Tr 22 × 5	LYT22W0HEB	22P	250	150	18	14	17	4	1	¥ 191,000*
Tr 24 × 5	LYT24W0HEB	24P	260	160	19	15	18	4	1	¥ 218,000*
Tr 25 × 5	LYT25W0HEB	25P	270	170	20	15	18	4	1	¥ 234,000*
Tr 26 × 5	LYT26W0HEB	27P	280	180	21	17	20	4	1	¥ 249,000*
Tr 28 × 5	LYT28W0HEB	28P	290	190	22	17	20	4	1	¥ 279,000*
Tr 30 × 6	LYT30Y0HEB	25P	300	200	24	19	22	4	1	¥ 304,000*

■ The specifications of Tr threads and TM threads

TM screws have become the old JIS 30 degree trapezoidal thread standard, but they have already been abolished.

Currently, it is the standard for Tr screws (Metric trapezoidal screws).

● Tr thread specifications.

The Tr thread specifications clearly specify tolerances for major diameters, pitch diameters, and minor diameters as shown in the table below.

<Tr thread specifications> Engagement length: N, Tolerance class: 7H Unit: mm

Size	Major Diameter		Pitch Diameter				Minor Diameter		
	Dmax	Dmin	Dmax	Dmin	TD2	Dmax	Dmin	TD1	
Tr 10 × 2	Not specified	10.500	9.250	9.000	0.250	8.236	8.000	0.236	
Tr 14 × 3		14.500	12.800	12.500	0.300	11.315	11.000	0.315	
Tr 20 × 4		20.500	18.355	18.000	0.355	16.375	16.000	0.375	
Tr 22 × 5		22.500	19.875	19.500	0.375	17.450	17.000	0.450	
Tr 30 × 6		31.000	27.450	27.000	0.450	24.500	24.000	0.500	

● TM thread specifications.

The TM thread specifications specify only basic sizes for major diameters, pitch diameters, and minor diameters as shown in the table below.

"Dimensional tolerances" necessary for actual machining were normally discussed and determined between the client and contractor.

<TM thread specifications> Unit: mm

Size	Major Diameter	Pitch Diameter	Minor Diameter
TM 10 × 2	10.500	9.000	8.500
TM 14 × 3	14.500	12.500	11.500
TM 20 × 4	20.500	18.000	16.500
TM 22 × 5	22.500	19.500	18.000
TM 30 × 6	30.500	27.000	25.000

- 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 / Metal Surgical Instruments