

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_n	ℓ_s	Ds	K	ℓ_k

1

DIN

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills
Premium Thread Mills

Dies

Center Drills
Centering Tools

Precision Machinery/
Medical Surgical Instruments

DIN

①-144

DIN

SP-BLF

Spiral Fluted Taps, Deep Hole Use (Coated)



Specification



■ The SP-BLF has a special thread portion to prevent chipping caused by the chip jamming. It is a spiral flute tap for tapping blind holes.

Tapping Speeds depending on Materials

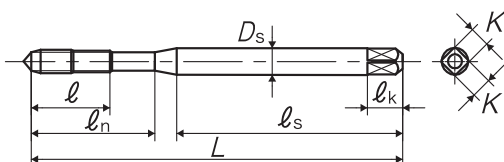
Low carbon steels
低炭素鋼
10~20
(m/min)

Medium carbon steels
中炭素鋼
10~20
(m/min)

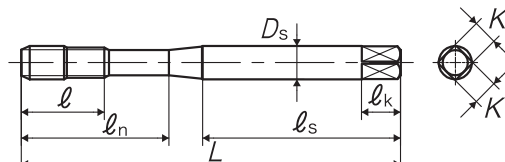
High carbon steels
高炭素鋼
10~20
(m/min)

Alloy steels
合金鋼
10~20
(m/min)

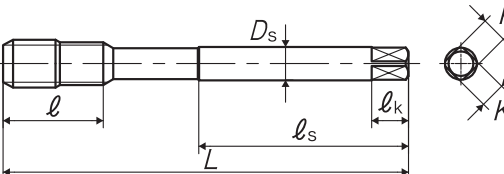
TYPE:1



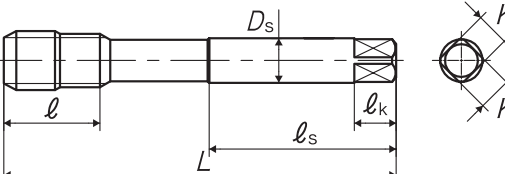
TYPE:2



TYPE:3



TYPE:4



Segment : 1D

Size	Class	Code	Chamfer	L (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	ISO2	96473.0TI	2.5P	56	9	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2	96474.0TI	2.5P	63	13	21	38	4.5	3.4	6	3	1
M5 × 0.8	ISO2	96475.0TI	2.5P	70	14	25	39	6	4.9	8	3	1
M6 × 1	ISO2	96476.0TI	2.5P	80	15	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2	96478.0TI	2.5P	90	19	35	47	8	6.2	9	3	2
M10 × 1.5	ISO2	9647010TI	2.5P	100	23	39	52.5	10	8	11	3	2
M12 × 1.75	ISO2	9747012TI	2.5P	110	26	-	56	9	7	10	3	3
M14 × 2	ISO2	9747014TI	2.5P	110	26	-	56	11	9	12	3	3
M16 × 2	ISO2	9747016TI	2.5P	110	26	-	56	12	9	12	3	3
M18 × 2.5	ISO2	9747018TI	2.5P	125	33	-	64	14	11	14	4	3
M20 × 2.5	ISO2	9747020TI	2.5P	140	33	-	71	16	12	15	4	3
M22 × 2.5	ISO2	9747022TI	2.5P	140	33	-	71	18	14.5	17	4	3
M24 × 3	ISO2	9747024TI	2.5P	160	37	-	82	18	14.5	17	4	4