

1 Spiral Fluted Tap Series for blind hole

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

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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

①-87

SP LH

Spiral Fluted Taps for Left Hand Threads



Specification

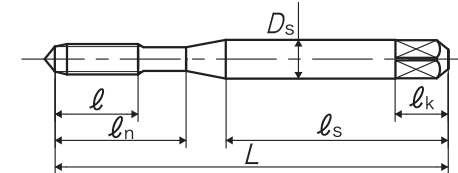


Tapping Speeds depending on Materials

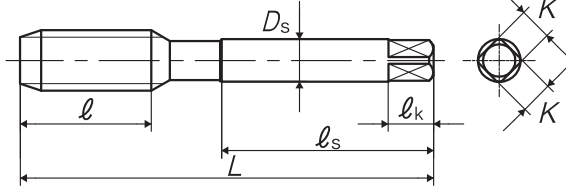
Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼
5~10 (m/min)	5~10 (m/min)

■ The SP LH is a spiral flute tap for tapping left hand thread blind holes.

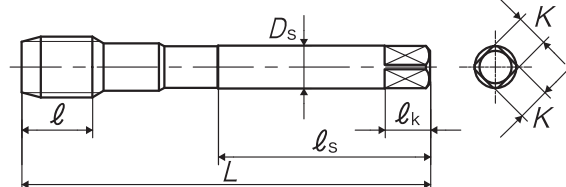
TYPE: 1



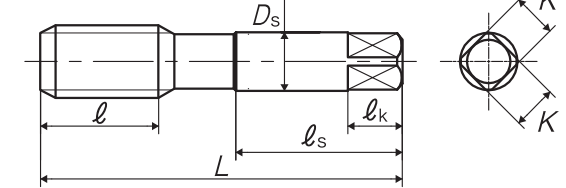
TYPE: 2



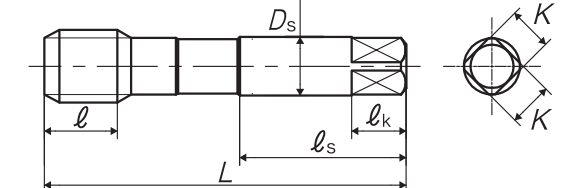
TYPE: 3



TYPE: 4



TYPE: 5



Segment : 1C

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	MSRP
For Metric Threads													
M2 × 0.4	P1	SPP2.0E-L	2.5P	42	7.2	12	27	3	2.5	5	2	1	¥ 3,680 ※
M2.3 × 0.4	P1	SPP2.3E-L	2.5P	42	7.2	12	27	3	2.5	5	2	1	¥ 3,350 ※
M2.5 × 0.45	P1	SPP2.5F-L	2.5P	46	8.1	14	29	3	2.5	5	2	1	¥ 2,810 ※
M2.6 × 0.45	P1	SPP2.6F-L	2.5P	46	8.1	14	29	3	2.5	5	2	1	¥ 2,810 ※
M3 × 0.5	P1	SPP3.0G-L	2.5P	46	9	14	26	4	3.2	6	3	1	¥ 1,970
M4 × 0.7	P2	SPQ4.0I-L	2.5P	52	11	17	29	5	4	7	3	1	¥ 1,970
M5 × 0.8	P2	SPQ5.0K-L	2.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 2,000
M6 × 1	P2	SPQ6.0M-L	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 2,190
M7 × 1	P2	SPQ7.0M-L	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 2,620 ※
M8 × 1.25	P2	SPQ8.0N-L	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 3,000
M8 × 1	P2	SPQ8.0M-L	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 3,410 ※
M10 × 1.5	P2	SPQ010O-L	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,820
M10 × 1.25	P2	SPQ010N-L	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 3,820
M10 × 1	P2	SPQ010M-L	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 4,530 ※
M12 × 1.75	P2	SPQ012P-L	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 5,400
M12 × 1.5	P2	SPQ012O-L	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 5,400 ※
M12 × 1.25	P2	SPQ012N-L	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 5,400 ※

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.

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

JIS

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M12 × 1	P2	SPQ012M-L	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 6,360 ※
M14 × 2	P2	SPQ014Q-L	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 7,370 ※
M14 × 1.5	P2	SPQ014O-L	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 7,370 ※
M14 × 1	P2	SPQ014M-L	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 8,560 ※
M16 × 2	P2	SPQ016Q-L	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 9,860
M16 × 1.5	P2	SPQ016O-L	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 9,860 ※
M16 × 1	P2	SPQ016M-L	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 11,800 ※
M18 × 2.5	P3	SPR018R-L	2.5P	100	33	-	51	14	11	14	4	2	¥ 13,200 ※
M18 × 2	P3	SPR018Q-L	2.5P	100	33	-	51	14	11	14	4	2	¥ 13,200 ※
M18 × 1.5	P2	SPQ018O-L	2.5P	100	33	-	51	14	11	14	4	2	¥ 13,200 ※
M18 × 1	P2	SPQ018M-L	2.5P	100	18	-	51	14	11	14	4	3	¥ 17,100 ※
M20 × 2.5	P3	SPR020R-L	2.5P	105	33	-	50	15	12	15	4	4	¥ 18,000
M20 × 1.5	P3	SPR020O-L	2.5P	105	33	-	50	15	12	15	4	4	¥ 18,000 ※
M20 × 1	P2	SPQ020M-L	2.5P	105	18	-	50	15	12	15	4	5	¥ 22,800 ※
M22 × 2.5	P3	SPR022R-L	2.5P	115	33	-	55	17	13	16	4	4	¥ 23,100 ※
M22 × 1.5	P3	SPR022O-L	2.5P	115	33	-	55	17	13	16	4	4	¥ 23,100 ※
M24 × 3	P3	SPR024S-L	2.5P	120	39	-	55	19	15	18	4	4	¥ 28,600
M24 × 2	P3	SPR024Q-L	2.5P	120	39	-	55	19	15	18	4	4	¥ 28,600 ※
M24 × 1.5	P3	SPR024O-L	2.5P	120	39	-	55	19	15	18	4	4	¥ 28,600 ※
M27 × 3	P3	SPR027S-L	2.5P	130	39	-	60	20	15	18	4	4	¥ 39,900 ※
M27 × 1.5	P3	SPR027O-L	2.5P	130	39	-	60	20	15	18	4	4	¥ 39,900 ※
M30 × 3.5	P4	SPS030T-L	2.5P	135	46	-	62	23	17	20	4	4	¥ 50,800 ※
M30 × 2	P3	SPR030Q-L	2.5P	135	46	-	62	23	17	20	4	4	¥ 50,800 ※
M30 × 1.5	P3	SPR030O-L	2.5P	135	46	-	62	23	17	20	4	4	¥ 50,800 ※
For Unified Threads													
1/4-20UNC	P2	SPQU04N-L	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 2,500 ※
1/4-28UNF	P2	SPQU04K-L	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 2,500 ※
5/16-18UNC	P2	SPQU05O-L	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 3,460 ※
5/16-24UNF	P2	SPQU05M-L	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 3,460 ※
3/8-16UNC	P2	SPQU06P-L	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 4,420 ※
3/8-24UNF	P2	SPQU06M-L	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 4,420 ※
7/16-14UNC	P3	SPRU07Q-L	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 6,230 ※
7/16-20UNF	P2	SPQU07N-L	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 6,230 ※
1/2-13UNC	P3	SPRU08R-L	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 6,600 ※
1/2-20UNF	P2	SPQU08N-L	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 6,600 ※
5/8-11UNC	P3	SPRU10U-L	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 9,860 ※
5/8-18UNF	P2	SPQU10O-L	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 9,860 ※
3/4-10UNC	P3	SPRU12V-L	2.5P	105	33	-	50	15	12	15	4	4	¥ 18,000 ※
3/4-16UNF	P3	SPRU12P-L	2.5P	105	33	-	50	15	12	15	4	4	¥ 18,000 ※
7/8-9UNC	P3	SPRU14W-L	2.5P	115	33	-	55	17	13	16	4	4	¥ 25,400 ※
7/8-14UNF	P3	SPRU14Q-L	2.5P	115	33	-	55	17	13	16	4	4	¥ 25,400 ※
1 -8UNC	P3	SPRU16X-L	2.5P	125	39	-	58	19	15	18	4	4	¥ 37,100 ※
1 -12UNF	P3	SPRU16S-L	2.5P	125	39	-	58	19	15	18	4	4	¥ 37,100 ※
For Whitworth Threads													
1/4W20	P2	SPQW04N-L	2.5P	62	15	26	33	6	4.5	7	3	1	¥ 2,500 ※
5/16W18	P2	SPQW05O-L	2.5P	70	19	-	36	6.2	5	8	3	2	¥ 3,460 ※
3/8W16	P2	SPQW06P-L	2.5P	75	23	-	38	7	5.5	8	3	2	¥ 4,420 ※
7/16W14	P3	SPRW07Q-L	2.5P	82	26	-	42	8.5	6.5	9	3	2	¥ 6,230 ※
1/2W12	P3	SPRW08S-L	2.5P	88	26	-	45	10.5	8	11	3	2	¥ 6,600 ※
5/8W11	P3	SPRW10U-L	2.5P	95	26	-	48	12.5	10	13	3	2	¥ 9,860 ※
3/4W10	P3	SPRW12V-L	2.5P	105	33	-	50	15	12	15	4	4	¥ 18,000 ※

Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented
Carbide Taps ⑤

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Special Thread Taps
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Thread Mills
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Center Drills
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①-88

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