

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

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/
Medical Surgical Instruments ⑫

JIS

①-72

S
P
OX

SP OX

Spiral Fluted Taps, Oxidized



Specification

HSS

OX
Oxide



Tapping Speeds depending on Materials

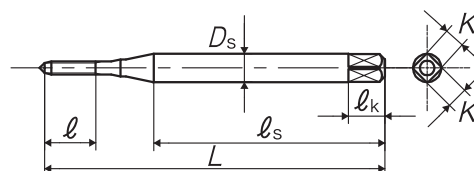
Low carbon steels
低炭素鋼
5~10
(m/min)

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

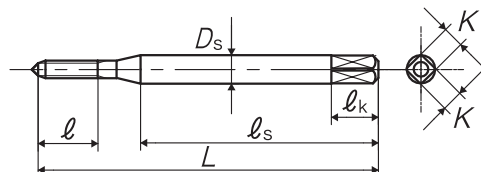
High carbon steels
高炭素鋼
5~10
(m/min)

■The SP OX is a spiral flute tap for blind hole tapping. These taps have an applied oxidation treatment to prevent chip welding on the surface of the taps threaded portion. They are suitable for thread processing of soft steel materials where the chips easily weld to the tap like low carbon.

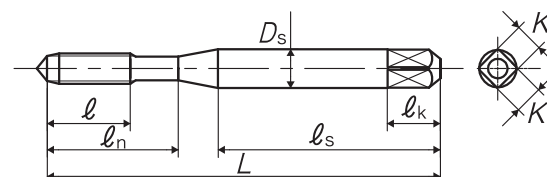
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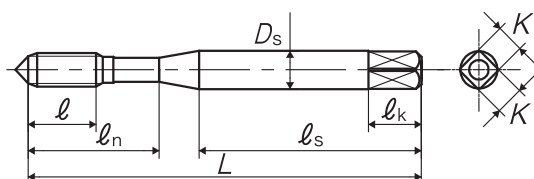
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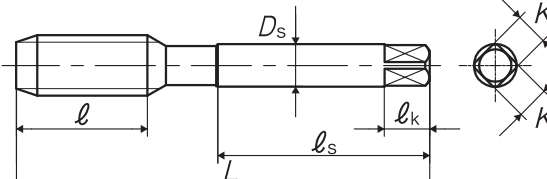
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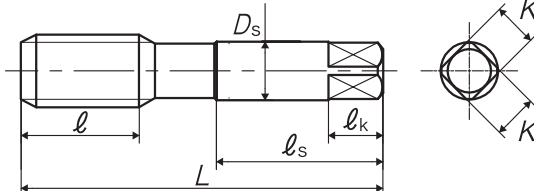
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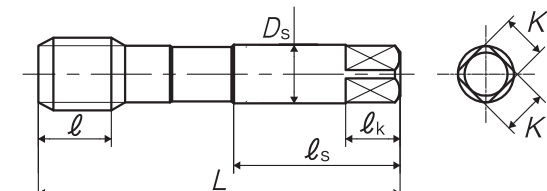
TYPE:5



TYPE:6



TYPE:7



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	ℓn	ℓs	Ds	K	ℓk

JIS

SP OX Spiral Fluted Taps, Oxidized

○ Oversize

Segment : 1C

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M1.4 × 0.3	P1	SPP1.4CX	2.5P	36	5.4	-	24	3	2.5	5	2	1	¥ 4,070 ※
M1.6 × 0.35	P1	SPP1.6DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,890 ※
M1.7 × 0.35	P1	SPP1.7DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,890 ※
M2 × 0.4	P1	SPP2.0EX	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 3,110 ※
M2.5 × 0.45	P1	SPP2.5FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,380 ※
M2.6 × 0.45	P1	SPP2.6FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,380 ※
M3 × 0.5	P1	SPP3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,670
M3 × 0.5	P2	SPQ3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,670 ※
M3 × 0.5	P3	SPR3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,670 ※
3M0.6	P1	SPP3.0HX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,670 ※
M3.5 × 0.6	P1	SPP3.5HX	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,670 ※
M4 × 0.7	P2	SPQ4.0IX	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,670 ※
M4 × 0.7	P3	SPR4.0IX	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,670 ※
M4 × 0.5	P1	SPP4.0GX	2.5P	52	9	17	29	5	4	7	3	4	¥ 2,450 ※
M4.5 × 0.5	P1	SPP4.5GX	2.5P	60	9	21	33	5.5	4.5	7	3	4	¥ 2,450 ※
M5 × 0.8	P2	SPQ5.0KX	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680
M5 × 0.8	P3	SPR5.0KX	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※
M6 × 1	P2	SPQ6.0MX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,850
M6 × 1	P3	SPR6.0MX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,850 ※
M6 × 0.75	P2	SPQ6.0JX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,610 ※
M7 × 1	P2	SPQ7.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,210 ※
M8 × 1.25	P2	SPQ8.0NX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,550
M8 × 1.25	P3	SPR8.0NX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,550 ※
M8 × 1	P2	SPQ8.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,880 ※
M10 × 1.5	P2	SPQ10.0OX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 3,230
M10 × 1.25	P2	SPQ10.0NX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 3,230 ※
M10 × 1.25	P3	SPR10.0NX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 3,230 ※
M10 × 1	P2	SPQ10.0MX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 3,830 ※
M12 × 1.75	P2	SPQ12.0PX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 4,580
M12 × 1.5	P2	SPQ12.0OX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 4,580 ※
M12 × 1.25	P2	SPQ12.0NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 4,580 ※
M12 × 1	P2	SPQ12.0MX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 5,380 ※
M14 × 2	P2	SPQ14.0QX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 6,240 ※
M14 × 1.5	P2	SPQ14.0OX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 6,240 ※
M14 × 1.25	P2	SPQ14.0NX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 7,240 ※
M14 × 1	P2	SPQ14.0MX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 7,240 ※
M16 × 2	P2	SPQ16.0QX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 8,340
M16 × 1.5	P2	SPQ16.0OX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 8,340 ※
M16 × 1.25	P2	SPQ16.0NX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 9,940 ※
M16 × 1	P2	SPQ16.0MX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 9,940 ※
M18 × 2.5	P3	SPR18.0RX	2.5P	100	33	-	51	14	11	14	4	5	¥ 11,200 ※
M18 × 1.5	P2	SPQ18.0OX	2.5P	100	33	-	51	14	11	14	4	5	¥ 11,200 ※
M20 × 2.5	P3	SPR20.0RX	2.5P	105	33	-	50	15	12	15	4	6	¥ 15,300
M20 × 1.5	P3	SPR20.0OX	2.5P	105	33	-	50	15	12	15	4	6	¥ 15,300 ※
M20 × 1	P2	SPQ20.0MX	2.5P	105	18	-	50	15	12	15	4	7	¥ 19,400 ※
M22 × 2.5	P3	SPR22.0RX	2.5P	115	33	-	55	17	13	16	4	6	¥ 19,500 ※
M22 × 1.5	P3	SPR22.0OX	2.5P	115	33	-	55	17	13	16	4	6	¥ 19,500 ※
M24 × 3	P3	SPR24.0SX	2.5P	120	39	-	55	19	15	18	4	6	¥ 24,300 ※

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※ = 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

SP OX Spiral Fluted Taps, Oxidized

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M24 × 1.5	P3	SPR024OX	2.5P	120	39	-	55	19	15	18	4	6	¥ 24,300 *
M27 × 3	P3	SPR027SX	2.5P	130	39	-	60	20	15	18	4	6	¥ 33,800 *
M27 × 2	P3	SPR027QX	2.5P	130	39	-	60	20	15	18	4	6	¥ 33,800 *
M28 × 1.5	P3	SPR028OX	2.5P	135	46	-	62	23	17	20	4	6	¥ 43,000 *
M30 × 3.5	P4	SPS030TX	2.5P	135	46	-	62	23	17	20	4	6	¥ 43,000 *
M30 × 3	P3	SPR030SX	2.5P	135	46	-	62	23	17	20	4	6	¥ 43,000 *
M30 × 2	P3	SPR030QX	2.5P	135	46	-	62	23	17	20	4	6	¥ 43,000 *
M30 × 1.5	P3	SPR030OX	2.5P	135	46	-	62	23	17	20	4	6	¥ 43,000 *
M32 × 2	P3	SPMR032QX	2.5P	145	46	-	67	24	19	22	4	6	¥ 50,000 *
M33 × 3.5	P4	SPMS033TX	2.5P	145	46	-	67	25	19	22	4	6	¥ 50,000 *
M36 × 4	P4	SPMS036UX	2.5P	155	52	-	71	28	21	24	4	6	¥ 57,900 *
For Unified Threads													
No.2-56UNC	P1	SPPUN2EX	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 3,260 *
No.4-40UNC	P1	SPPUN4HX	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 2,100 *
No.5-40UNC	P1	SPPUN5HX	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,960 *
No.6-32UNC	P2	SPQUN6JX	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,960 *
No.8-32UNC	P2	SPQUN8JX	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,970 *
No.10-24UNC	P2	SPQUNAMX	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 *
No.10-32UNF	P2	SPQUAJX	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 *
1/4-20UNC	P2	SPQU04NX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,120 *
1/4-28UNF	P2	SPQU04KX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,120 *
5/16-18UNC	P2	SPQU05OX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,930 *
5/16-24UNF	P2	SPQU05MX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,930 *
3/8-16UNC	P2	SPQU06PX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 3,750 *
3/8-24UNF	P2	SPQU06MX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 3,750 *
7/16-14UNC	P3	SPRU07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 5,270 *
7/16-20UNF	P2	SPQU07NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 5,270 *
1/2-13UNC	P3	SPRU08RX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 5,600 *
1/2-20UNF	P2	SPQU08NX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 5,600 *
9/16-18UNF	P2	SPQU09OX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 8,340 *
5/8-11UNC	P3	SPRU10UX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 8,340 *
5/8-18UNF	P2	SPQU10OX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 8,340 *
3/4-10UNC	P3	SPRU12VX	2.5P	105	33	-	50	15	12	15	4	6	¥ 15,300 *
3/4-16UNF	P3	SPRU12PX	2.5P	105	33	-	50	15	12	15	4	6	¥ 15,300 *
7/8-9UNC	P3	SPRU14WX	2.5P	115	33	-	55	17	13	16	4	6	¥ 21,500 *
7/8-14UNF	P3	SPRU14QX	2.5P	115	33	-	55	17	13	16	4	6	¥ 21,500 *
1 -8UNC	P3	SPRU16XX	2.5P	125	39	-	58	19	15	18	4	6	¥ 31,400 *
1 -12UNF	P3	SPRU16SX	2.5P	125	39	-	58	19	15	18	4	6	¥ 31,400 *
1 1/2 -6UNC	P4	SPMSU24ZX	2.5P	165	52	-	76	30	23	26	4	6	¥ 82,800 *
1 1/2 -12UNF	P3	SPMRU24SX	2.5P	165	52	-	76	30	23	26	4	6	¥ 82,800 *
For Whitworth Threads													
1/8W40	P1	SPPW02HX	2.5P	52	11	16	28	5	4	7	3	3	¥ 2,440 *
5/32W32	P2	SPQW2HJX	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,960 *
3/16W24	P2	SPQW03MX	2.5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,970 *
1/4W20	P2	SPQW04NX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,120 *
5/16W18	P2	SPQW05OX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,930 *
3/8W16	P2	SPQW06PX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 3,750 *
7/16W14	P3	SPRW07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 5,270 *
1/2W12	P3	SPRW08SX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 5,600 *

* = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

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JIS

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/
Metal Surgical Instruments

JIS

①-74

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	ℓn	ℓs	Ds	K	ℓk

JIS

SP OX Spiral Fluted Taps, Oxidized

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
5/8W11	P3	SPRW10UX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 8,340 ※
3/4W10	P3	SPRW12VX	2.5P	105	33	-	50	15	12	15	4	6	¥ 15,300 ※
7/8W9	P3	SPRW14WX	2.5P	115	33	-	55	17	13	16	4	6	¥ 21,500 ※
1 W8	P3	SPRW16XX	2.5P	125	39	-	58	19	15	18	4	6	¥ 31,400 ※
1 1/4W7	P4	SPMSW20YX	2.5P	145	46	-	67	24	19	22	4	6	¥ 50,000 ※
1 1/2W6	P4	SPMSW24ZX	2.5P	165	52	-	76	30	23	26	4	6	¥ 82,800 ※

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