

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

- 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



SP-VA



Spiral Fluted Taps for Stainless Steels

Specification

HSS

OX
Oxide

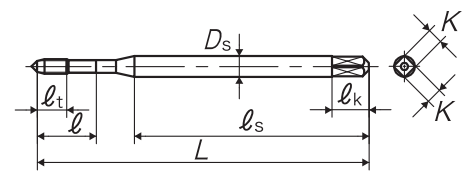
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■ Most suitable for stainless steels, sticky and tending to work-harden, as well as chrome steels and molybdenum steels, blind hole use.

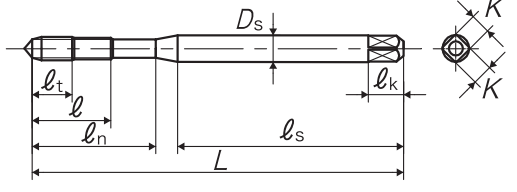
Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼
~10 (m/min)	~10 (m/min)	~10 (m/min)	~10 (m/min)

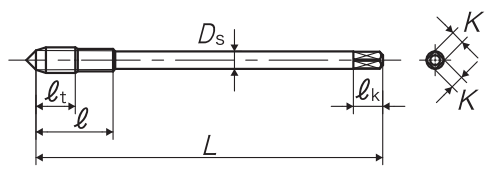
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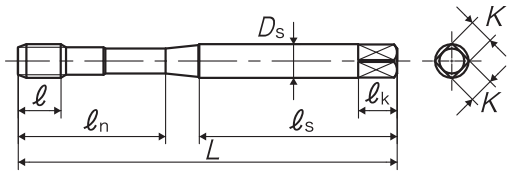
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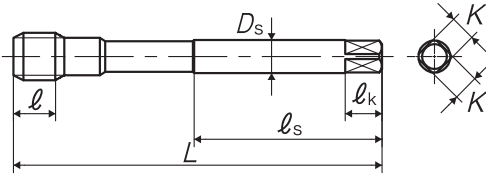
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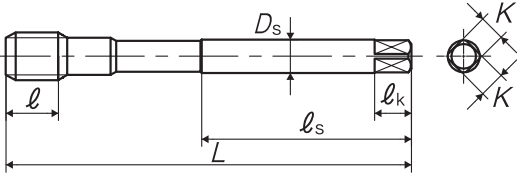
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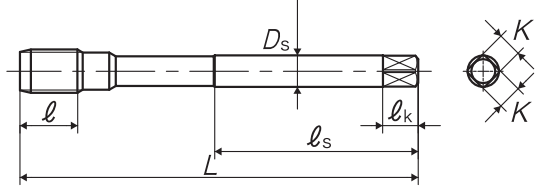
TYPE: 5



TYPE: 6



TYPE: 7



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

Segment : 1D (G=1H)

Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
For Metric Threads													
M2 × 0.4	ISO2	SD2.0EAGEX	2.5P	45	4	8	-	32	2.8	2.1	5	2	1
M2.5 × 0.45	ISO2	SD2.5FAGEX	2.5P	50	4	8	15	33	2.8	2.1	5	2	2
M3 × 0.5	ISO2	SD3.0GAGEX	2.5P	56	5	9	18	34	3.5	2.7	6	2	2
M3 × 0.5	ISO3	SD3.0MGEX	2.5P	56	5	9	18	34	3.5	2.7	6	2	2
M4 × 0.7	ISO2	SD4.0IAGEX	2.5P	63	7	13	21	38	4.5	3.4	6	3	2
M4 × 0.7	ISO3	SD4.0IMGEX	2.5P	63	7	13	21	38	4.5	3.4	6	3	2
M5 × 0.8	ISO2	SD5.0KAGEX	2.5P	70	9	14	25	39	6	4.9	8	3	2
M5 × 0.8	ISO3	SD5.0KMGEX	2.5P	70	9	14	25	39	6	4.9	8	3	2
M6 × 1	ISO2	SD6.0MAGEX	2.5P	80	11	15	30	45	6	4.9	8	3	2
M6 × 1	ISO3	SD6.0MMGEX	2.5P	80	11	15	30	45	6	4.9	8	3	2
M6 × 0.75	ISO2	SM6.0JAGEX	2.5P	80	8	13	-	-	4.5	3.4	6	3	3
M8 × 1.25	ISO2	SD8.0NAGEX	2.5P	90	-	12	35	47	8	6.2	9	3	4
M8 × 1.25	ISO2	SG8.0NAGEX	2.5P	90	-	12	-	46	6	4.9	8	3	5
M8 × 1.25	ISO3	SD8.0NMGEX	2.5P	90	-	12	35	47	8	6.2	9	3	4
M8 × 1	ISO2	SM8.0MAGEX	2.5P	90	-	12	-	46	6	4.9	8	3	5
M8 × 0.75	ISO2	SM8.0JAGEX	2.5P	80	-	12	-	41	6	4.9	8	3	5
M10 × 1.5	ISO2	SD10.0OAGEX	2.5P	100	-	13	39	52.5	10	8	11	3	4
M10 × 1.5	ISO2	SG10.0OAGEX	2.5P	100	-	13	-	51	7	5.5	8	3	5
M10 × 1.5	ISO3	SD10.0OMGEX	2.5P	100	-	13	39	52.5	10	8	11	3	4
M10 × 1.25	ISO2	SM10.0NAGEX	2.5P	100	-	13	-	51	7	5.5	8	3	5
M10 × 1	ISO2	SM10.0MAGEX	2.5P	90	-	13	-	46	7	5.5	8	3	5
M12 × 1.75	ISO2	SG12.0PAGEX	2.5P	110	-	15	-	56	9	7	10	3	6
M12 × 1.75	ISO3	SG12.0PMGEX	2.5P	110	-	15	-	56	9	7	10	3	6
M12 × 1.5	ISO2	SM12.0OAGEX	2.5P	100	-	15	-	51	9	7	10	3	5
M12 × 1.25	ISO2	SM12.0NAGEX	2.5P	100	-	15	-	51	9	7	10	3	5
M12 × 1	ISO2	SM12.0MAGEX	2.5P	100	-	15	-	51	9	7	10	3	5
M14 × 2	ISO2	SG14.0QAGEX	2.5P	110	-	18	-	56	11	9	12	3	6
M14 × 1.5	ISO2	SM14.0OAGEX	2.5P	100	-	14	-	51	11	9	12	3	5
M14 × 1	ISO2	SM14.0MAGEX	2.5P	100	-	14	-	51	11	9	12	3	5
M16 × 2	ISO2	SG16.0QAGEX	2.5P	110	-	18	-	56	12	9	12	3	6
M16 × 1.5	ISO2	SM16.0OAGEX	2.5P	100	-	14	-	51	12	9	12	3	5
M16 × 1	ISO2	SM16.0MAGEX	2.5P	100	-	14	-	51	12	9	12	3	5
M18 × 2.5	ISO2	SG18.0RAGEX	2.5P	125	-	20	-	64	14	11	14	4	6
M18 × 1.5	ISO2	SM18.0OAGEX	2.5P	110	-	14	-	56	14	11	14	4	5
M20 × 2.5	ISO2	SG20.0RAGEX	2.5P	140	-	20	-	71	16	12	15	4	6
M20 × 1.5	ISO2	SM20.0OAGEX	2.5P	125	-	14	-	64	16	12	15	4	5
M22 × 2.5	ISO2	SG22.0RAGEX	2.5P	140	-	20	-	71	18	14.5	17	4	6
M22 × 1.5	ISO2	SM22.0OAGEX	2.5P	125	-	14	-	64	18	14.5	17	4	5
M24 × 3	ISO2	SG24.0SAGEX	2.5P	160	-	25	-	82	18	14.5	17	4	6
M24 × 2	ISO2	SM24.0QAGEX	2.5P	140	-	18	-	71	18	14.5	17	4	5
M24 × 1.5	ISO2	SM24.0OAGEX	2.5P	140	-	18	-	71	18	14.5	17	4	5
M27 × 3	ISO2	SG27.0SAGEX	2.5P	160	-	25	-	82	20	16	19	4	6
M27 × 2	ISO2	SM27.0QAGEX	2.5P	140	-	20	-	71	20	16	19	4	5
M30 × 3.5	ISO2	SG30.0TAGEX	2.5P	180	-	30	-	92	22	18	21	4	6
M30 × 2	ISO2	SM30.0QAGEX	2.5P	150	-	20	-	77	22	18	21	4	5
M30 × 1.5	ISO2	SM30.0OAGEX	2.5P	150	-	20	-	77	22	18	21	4	5
M36 × 4	ISO2	SG36.0UAGEX	2.5P	200	-	40	-	102	28	22	25	4	6
For Unified Threads													
No.4-40UNC	2B	SDUN4HXGEX	2.5P	56	11	5	18	34	3.5	2.7	6	2	2

1

DIN

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

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	ℓt	ℓ	ℓn	ℓs	Ds	K	ℓk

DIN

SP-VA Spiral Fluted Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
No.6-32UNC	2B	SDUN6JXGEX	2.5P	56	7	11	19	32	4	3	6	3	2
No.8-32UNC	2B	SDUN8JXGEX	2.5P	63	7	13	21	38	4.5	3.4	6	3	2
No.10-24UNC	2B	SDUNAMXGEX	2.5P	70	9	14	24	39	6	4.9	8	3	2
No.10-32UNF	2B	SDUNAJXGEX	2.5P	70	9	14	24	39	6	4.9	8	3	2
1/4-20UNC	2B	SDU04NXGEX	2.5P	80	11	15	30	42	7	5.5	8	3	2
1/4-28UNF	2B	SDU04KXGEX	2.5P	80	11	15	30	42	7	5.5	8	3	2
5/16-18UNC	2B	SDU05OXGEX	2.5P	90	-	12	35	47	8	6.2	9	3	4
5/16-24UNF	2B	SMU05MXGEX	2.5P	90	-	12	-	46	6	4.9	8	3	5
3/8-16UNC	2B	SDU06PXGEX	2.5P	100	-	13	39	54.5	9	7	10	3	4
3/8-24UNF	2B	SMU06MXGEX	2.5P	100	-	13	-	51	7	5.5	8	3	5
7/16-14UNC	2B	SGU07QXGEX	2.5P	100	-	13	-	51	8	6.2	9	3	6
7/16-20UNF	2B	SMU07NXGEX	2.5P	100	-	13	-	51	8	6.2	9	3	5
1/2-13UNC	2B	SGU08RXGEX	2.5P	110	-	15	-	56	9	7	10	3	6
1/2-20UNF	2B	SMU08NXGEX	2.5P	100	-	15	-	51	9	7	10	3	5
9/16-12UNC	2B	SGU09SXGEX	2.5P	110	-	18	-	56	11	9	12	3	6
9/16-18UNF	2B	SMU09OXGEX	2.5P	100	-	14	-	51	11	9	12	3	5
5/8-11UNC	2B	SGU10UXGEX	2.5P	110	-	18	-	56	12	9	12	3	6
5/8-18UNF	2B	SMU10OXGEX	2.5P	100	-	14	-	51	12	9	12	3	5
3/4-10UNC	2B	SGU12VXGEX	2.5P	125	-	20	-	64	14	11	14	4	6
3/4-16UNF	2B	SMU12PXGEX	2.5P	110	-	14	-	56	14	11	14	4	5
7/8-9UNC	2B	SGU14WXGEX	2.5P	140	-	20	-	71	18	14.5	17	4	6
7/8-14UNF	2B	SMU14QXGEX	2.5P	125	-	20	-	64	18	14.5	17	4	5
1 -8UNC	2B	SGU16XXGEX	2.5P	160	-	25	-	82	18	14.5	17	4	6
1 -12UNF	2B	SMU16SXGEX	2.5P	140	-	18	-	71	18	14.5	17	4	5
1 1/8-7UNC	2B	SGU18YXGEX	2.5P	180	-	30	-	92	22	18	21	4	6
1 1/8-8UN	2B	SMU18XXGEX	2.5P	180	-	28	-	92	22	18	21	4	5
1 1/8-12UNF	2B	SMU18SXGEX	2.5P	150	-	20	-	77	22	18	21	4	5
1 1/4-7UNC	2B	SGU20YXGEX	2.5P	180	-	30	-	92	22	18	21	4	6
1 1/4-8UN	2B	SMU20XXGEX	2.5P	180	-	28	-	92	22	18	21	4	5
1 1/4-12UNF	2B	SMU20SXGEX	2.5P	150	-	20	-	77	22	18	21	4	5
1 3/8-6UNC	2B	SGU22ZXGEX	2.5P	200	-	40	-	102	28	22	25	4	6
1 3/8-8UN	2B	SMU22XXGEX	2.5P	200	-	30	-	102	28	22	25	4	5
1 3/8-12UNF	2B	SMU22SXGEX	2.5P	170	-	20	-	87	28	22	25	4	5
1 1/2-6UNC	2B	SGU24ZXGEX	2.5P	200	-	40	-	102	32	24	27	4	6
1 1/2-8UN	2B	SMU24XXGEX	2.5P	200	-	30	-	102	32	24	27	4	5
1 1/2-12UNF	2B	SMU24SXGEX	2.5P	170	-	20	-	87	32	24	27	4	5
1 5/8-8UN	2B	SMU26XXGEX	2.5P	200	-	30	-	102	32	24	27	4	5
1 3/4-8UN	2B	SMU28XXGEX	2.5P	200	-	40	-	102	36	29	32	4	5
2 -8UN	2B	SMU32XXGEX	2.5P	225	-	40	-	115	40	32	35	4	5
For PF Threads													
G 1/8-28	-	SVG0020GEX	2.5P	90	-	12	-	46	7	5.5	8	3	7
G 1/4-19	-	SVG0040GEX	2.5P	100	-	14	-	51	11	9	12	3	7
G 3/8-19	-	SVG0060GEX	2.5P	100	-	14	-	51	12	9	12	3	7
G 1/2-14	-	SVG0080GEX	2.5P	125	-	18	-	64	16	12	15	4	7
G 3/4-14	-	SVG0120GEX	2.5P	140	-	20	-	71	20	16	19	4	7
G 1 -11	-	SVG0160GEX	2.5P	160	-	20	-	82	25	20	23	4	7

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