

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

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

DIN

1-96

DIN

SP V

Spiral Fluted Taps, Coated



Specification



■ This is a coated spiral fluted tap for blind holes.

Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
10~20
(m/min)

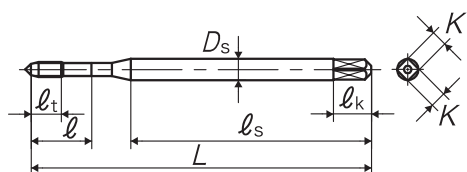
Medium carbon steels
中炭素鋼
10~20
(m/min)

High carbon steels
高炭素鋼
10~20
(m/min)

Alloy steels
合金鋼
10~20
(m/min)

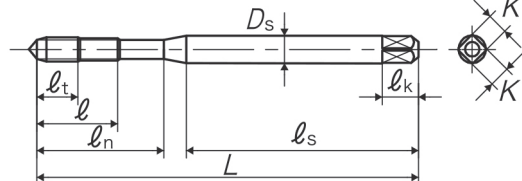
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DIN371



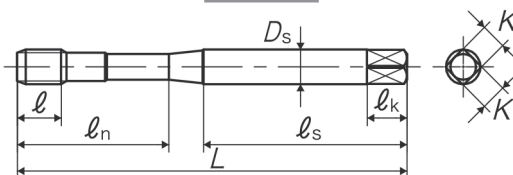
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DIN371



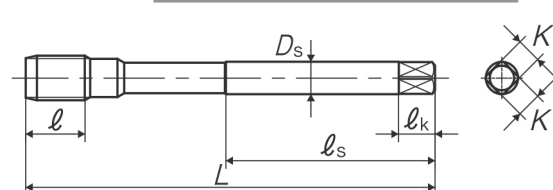
TYPE: 3

DIN371



TYPE: 4

DIN376/DIN374/DIN5156



Segment : 1D (G=1H)

Size	Class	Code	Chamfer	L (mm)	ℓ_t (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads													
M2 × 0.4	ISO2	96402.0TI	2.5P	45	4	8	-	32	2.8	2.1	5	2	1
M3 × 0.5	ISO2	96403.0TI	2.5P	56	5	9	18	34	3.5	2.7	6	3	2
M4 × 0.7	ISO2	96404.0TI	2.5P	63	7	13	21	38	4.5	3.4	6	3	2
M5 × 0.8	ISO2	96405.0TI	2.5P	70	9	14	25	39	6	4.9	8	3	2
M6 × 1	ISO2	96406.0TI	2.5P	80	11	15	30	45	6	4.9	8	3	2
M8 × 1.25	ISO2	96408.0TI	2.5P	90	-	12	35	47	8	6.2	9	3	3
M8 × 1	ISO2	98408.0MTI	2.5P	90	-	12	-	46	6	4.9	8	3	4
M10 × 1.5	ISO2	9640010TI	2.5P	100	-	13	39	52.5	10	8	11	3	3
M10 × 1.25	ISO2	9840010NTI	2.5P	100	-	13	-	51	7	5.5	8	3	4
M10 × 1	ISO2	9840010MTI	2.5P	90	-	13	-	46	7	5.5	8	3	4
M12 × 1.75	ISO2	9740012TI	2.5P	110	-	15	-	56	9	7	10	3	4
M12 × 1.5	ISO2	9840012OTI	2.5P	100	-	15	-	51	9	7	10	3	4
M12 × 1.25	ISO2	9840012NTI	2.5P	100	-	15	-	51	9	7	10	3	4
M14 × 2	ISO2	9740014TI	2.5P	110	-	18	-	56	11	9	12	3	4
M14 × 1.5	ISO2	9840014OTI	2.5P	100	-	14	-	51	11	9	12	3	4
M16 × 2	ISO2	9740016TI	2.5P	110	-	18	-	56	12	9	12	3	4
M16 × 1.5	ISO2	9840016OTI	2.5P	100	-	14	-	51	12	9	12	3	4

• This product is different from JIS products in shape and dimensions, please be careful when using.

Think threads with
YAMAWA

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 V Spiral Fluted Taps, Coated

Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M18 × 2.5	ISO2	9740018TI	2.5P	125	-	20	-	64	14	11	14	4	4
M18 × 1.5	ISO2	9840018OTI	2.5P	110	-	14	-	56	14	11	14	4	4
M20 × 2.5	ISO2	9740020TI	2.5P	140	-	20	-	71	16	12	15	4	4
M20 × 1.5	ISO2	9840020OTI	2.5P	125	-	14	-	64	16	12	15	4	4
M22 × 2.5	ISO2	9740022TI	2.5P	140	-	20	-	71	18	14.5	17	4	4
M22 × 1.5	ISO2	9840022OTI	2.5P	125	-	14	-	64	18	14.5	17	4	4
M24 × 3	ISO2	9740024TI	2.5P	160	-	25	-	82	18	14.5	17	4	4
For G Threads													
G 1/8-28	-	9940R02TI	2.5P	90	-	12	-	46	7	5.5	8	3	4
G 1/4-19	-	9940R04TI	2.5P	100	-	14	-	51	11	9	12	3	4
G 3/8-19	-	9940R06TI	2.5P	100	-	14	-	51	12	9	12	3	4
G 1/2-14	-	9940R08TI	2.5P	125	-	18	-	64	16	12	15	4	4

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

DIN

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