

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 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)



## SU-HT

Hand Taps for Stainless Steels



### Specification



### Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼	Stainless steels ステンレス鋼
5~10 (m/min)	5~10 (m/min)	~5 (m/min)

### Product Features

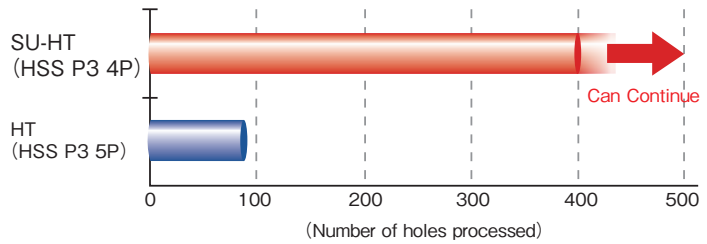
- The SU-HT is a hand tap suitable for machining of stainless steel, chromium steel, molybdenum steel. These materials have a tendency to work harden easily.
- To prevent welding, the taps surface is oxidized.

### Tapping Data

#### Tapping Conditions [M8×1.25]

Workpiece Material	SUS304 10mm thick
Tapping Speed	5m/min
Bored Hole Size	φ6.8 through hole
Cutting Fluid	JIS 2, No. 13
Machinery Type	Tapping machine

The figure on the right shows test data comparing the tool life in tapping SUS 304 with an oxidized standard M8 × 1.25, a standard bright hand tap and the oxidized SU - HT tap.



Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ <sub>n</sub>	ℓ <sub>s</sub>	D <sub>s</sub>	K	ℓ <sub>k</sub>

4

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

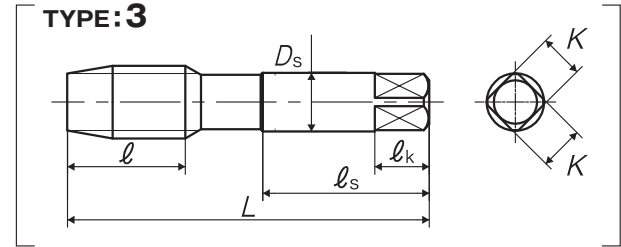
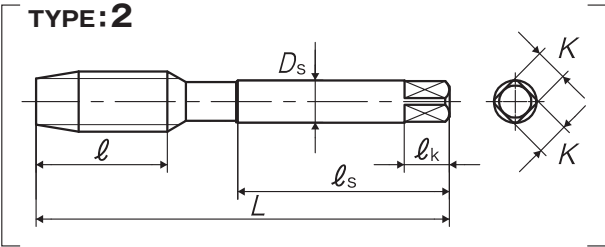
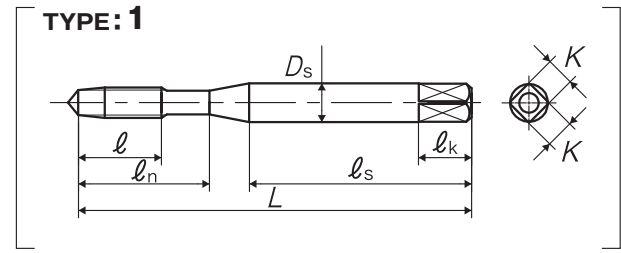
Thread Mills  
Premium Thread Mills ⑨

Dies ⑩

Center Drills  
Centering Tools ⑪

Precision Machinery/  
Metal Surgical Instruments ⑫

JIS ④-90



Segment : 1A

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ <sub>n</sub> (mm)	ℓ <sub>s</sub> (mm)	D <sub>s</sub> (mm)	K (mm)	ℓ <sub>k</sub> (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M2 × 0.4	P2	TUMQ2.0E4	4P	42	7.2	12	27	3	2.5	5	3	1	¥ 2,470
M2 × 0.4	P2	TUMQ2.0E1	1.5P	42	7.2	12	27	3	2.5	5	3	1	¥ 2,470
M2.3 × 0.4	P2	TUMQ2.3E4	4P	42	7.2	12	27	3	2.5	5	3	1	¥ 2,240 <sup>*</sup>
M2.3 × 0.4	P2	TUMQ2.3E1	1.5P	42	7.2	12	27	3	2.5	5	3	1	¥ 2,240 <sup>*</sup>
M2.5 × 0.45	P2	TUMQ2.5F4	4P	46	8.1	14	29	3	2.5	5	3	1	¥ 1,890 <sup>*</sup>
M2.5 × 0.45	P2	TUMQ2.5F1	1.5P	46	8.1	14	29	3	2.5	5	3	1	¥ 1,890 <sup>*</sup>
M2.6 × 0.45	P2	TUMQ2.6F4	4P	46	8.1	14	29	3	2.5	5	3	1	¥ 1,890 <sup>*</sup>
M2.6 × 0.45	P2	TUMQ2.6F1	1.5P	46	8.1	14	29	3	2.5	5	3	1	¥ 1,890 <sup>*</sup>
M3 × 0.5	P2	TUMQ3.0G4	4P	46	9	14	26	4	3.2	6	3	1	¥ 1,330
M3 × 0.5	P2	TUMQ3.0G1	1.5P	46	9	14	26	4	3.2	6	3	1	¥ 1,330
M3.5 × 0.6	P2	TUMQ3.5H4	4P	52	11	16	29	5	4	7	3	1	¥ 1,330 <sup>*</sup>
M3.5 × 0.6	P2	TUMQ3.5H1	1.5P	52	11	16	29	5	4	7	3	1	¥ 1,330 <sup>*</sup>
M4 × 0.7	P2	TUMQ4.0I4	4P	52	11	17	29	5	4	7	3	1	¥ 1,330
M4 × 0.7	P2	TUMQ4.0I1	1.5P	52	11	17	29	5	4	7	3	1	¥ 1,330
M5 × 0.8	P2	TUMQ5.0K4	4P	60	13	22	33	5.5	4.5	7	3	1	¥ 1,340
M5 × 0.8	P2	TUMQ5.0K1	1.5P	60	13	22	33	5.5	4.5	7	3	1	¥ 1,340
M6 × 1	P2	TUMQ6.0M4	4P	62	15	26	33	6	4.5	7	3	1	¥ 1,470
M6 × 1	P2	TUMQ6.0M1	1.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,470
M6 × 0.75	P2	TUMQ6.0J4	4P	62	15	26	33	6	4.5	7	3	1	¥ 2,060 <sup>*</sup>
M6 × 0.75	P2	TUMQ6.0J1	1.5P	62	15	26	33	6	4.5	7	3	1	¥ 2,060 <sup>*</sup>
M8 × 1.25	P3	TUMR8.0N4	4P	70	19	-	36	6.2	5	8	3	2	¥ 2,010
M8 × 1.25	P3	TUMR8.0N1	1.5P	70	19	-	36	6.2	5	8	4	2	¥ 2,010
M8 × 1	P3	TUMR8.0M4	4P	70	19	-	36	6.2	5	8	3	2	¥ 2,280 <sup>*</sup>
M8 × 1	P3	TUMR8.0M1	1.5P	70	19	-	36	6.2	5	8	4	2	¥ 2,280 <sup>*</sup>
M10 × 1.5	P3	TUMR010O4	4P	75	23	-	38	7	5.5	8	3	2	¥ 2,560
M10 × 1.5	P3	TUMR010O1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 2,560
M10 × 1.25	P3	TUMR010N4	4P	75	23	-	38	7	5.5	8	3	2	¥ 2,560 <sup>*</sup>
M10 × 1.25	P3	TUMR010N1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 2,560 <sup>*</sup>
M10 × 1	P3	TUMR010M4	4P	75	23	-	38	7	5.5	8	3	2	¥ 3,040 <sup>*</sup>
M10 × 1	P3	TUMR010M1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 3,040 <sup>*</sup>
M12 × 1.75	P4	TUMS012P4	4P	82	26	-	42	8.5	6.5	9	3	2	¥ 3,630
M12 × 1.75	P4	TUMS012P1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 3,630
M12 × 1.5	P3	TUMR012O4	4P	82	26	-	42	8.5	6.5	9	3	2	¥ 3,630 <sup>*</sup>
M12 × 1.5	P3	TUMR012O1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 3,630 <sup>*</sup>

# 4 Hand Tap Series

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

## SU-HT Hand Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M12 × 1.25	P4	TUMS012N4	4P	82	26	-	42	8.5	6.5	9	3	2	¥ 3,630 ※
M12 × 1.25	P4	TUMS012N1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 3,630 ※
M12 × 1	P3	TUMR012M4	4P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,260 ※
M12 × 1	P3	TUMR012M1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 4,260 ※
M14 × 2	P4	TUMS014Q4	4P	88	26	-	45	10.5	8	11	4	2	¥ 4,940 ※
M14 × 2	P4	TUMS014Q1	1.5P	88	26	-	45	10.5	8	11	4	2	¥ 4,940 ※
M14 × 1.5	P3	TUMR014O4	4P	88	26	-	45	10.5	8	11	4	2	¥ 4,940 ※
M14 × 1.5	P3	TUMR014O1	1.5P	88	26	-	45	10.5	8	11	4	2	¥ 4,940 ※
M14 × 1.25	P3	TUMR014N4	4P	88	26	-	45	10.5	8	11	4	2	¥ 5,740 ※
M14 × 1.25	P3	TUMR014N1	1.5P	88	26	-	45	10.5	8	11	4	2	¥ 5,740 ※
M14 × 1	P3	TUMR014M4	4P	88	26	-	45	10.5	8	11	4	2	¥ 5,740 ※
M14 × 1	P3	TUMR014M1	1.5P	88	26	-	45	10.5	8	11	4	2	¥ 5,740 ※
M16 × 2	P4	TUMS016Q4	4P	95	26	-	48	12.5	10	13	4	2	¥ 6,610
M16 × 2	P4	TUMS016Q1	1.5P	95	26	-	48	12.5	10	13	4	2	¥ 6,610
M16 × 1.5	P3	TUMR016O4	4P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 ※
M16 × 1.5	P3	TUMR016O1	1.5P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 ※
M16 × 1	P3	TUMR016M4	4P	95	26	-	48	12.5	10	13	4	2	¥ 7,870 ※
M16 × 1	P3	TUMR016M1	1.5P	95	26	-	48	12.5	10	13	4	2	¥ 7,870 ※
M18 × 2.5	P4	TUMS018R4	4P	100	33	-	51	14	11	14	4	2	¥ 8,810 ※
M18 × 2.5	P4	TUMS018R1	1.5P	100	33	-	51	14	11	14	4	2	¥ 8,810 ※
M18 × 1.5	P4	TUMS018O4	4P	100	33	-	51	14	11	14	4	2	¥ 8,810 ※
M18 × 1.5	P4	TUMS018O1	1.5P	100	33	-	51	14	11	14	4	2	¥ 8,810 ※
M20 × 2.5	P4	TUMS020R4	4P	105	33	-	50	15	12	15	4	3	¥ 12,000
M20 × 2.5	P4	TUMS020R1	1.5P	105	33	-	50	15	12	15	4	3	¥ 12,000
M20 × 1.5	P4	TUMS020O4	4P	105	33	-	50	15	12	15	4	3	¥ 12,000 ※
M20 × 1.5	P4	TUMS020O1	1.5P	105	33	-	50	15	12	15	4	3	¥ 12,000 ※
M22 × 2.5	P4	TUMS022R4	4P	115	33	-	55	17	13	16	4	3	¥ 15,500 ※
M22 × 2.5	P4	TUMS022R1	1.5P	115	33	-	55	17	13	16	4	3	¥ 15,500 ※
M22 × 1.5	P4	TUMS022O4	4P	115	33	-	55	17	13	16	4	3	¥ 15,500 ※
M22 × 1.5	P4	TUMS022O1	1.5P	115	33	-	55	17	13	16	4	3	¥ 15,500 ※
M24 × 3	P4	TUMS024S4	4P	120	39	-	55	19	15	18	4	3	¥ 19,300 ※
M24 × 3	P4	TUMS024S1	1.5P	120	39	-	55	19	15	18	4	3	¥ 19,300 ※
M24 × 1.5	P4	TUMS024O4	4P	120	39	-	55	19	15	18	4	3	¥ 19,300 ※
M24 × 1.5	P4	TUMS024O1	1.5P	120	39	-	55	19	15	18	4	3	¥ 19,300 ※
M27 × 3	P4	TUMS027S4	4P	130	39	-	60	20	15	18	4	3	¥ 26,700 ※
M27 × 3	P4	TUMS027S1	1.5P	130	39	-	60	20	15	18	4	3	¥ 26,700 ※
M27 × 1.5	P4	TUMS027O4	4P	130	39	-	60	20	15	18	4	3	¥ 26,700 ※
M27 × 1.5	P4	TUMS027O1	1.5P	130	39	-	60	20	15	18	4	3	¥ 26,700 ※
M30 × 3.5	P5	TUMT030T4	4P	135	46	-	62	23	17	20	4	3	¥ 34,000 ※
M30 × 3.5	P5	TUMT030T1	1.5P	135	46	-	62	23	17	20	4	3	¥ 34,000 ※
M30 × 1.5	P4	TUMS030O4	4P	135	46	-	62	23	17	20	4	3	¥ 34,000 ※
M30 × 1.5	P4	TUMS030O1	1.5P	135	46	-	62	23	17	20	4	3	¥ 34,000 ※
For Unified Threads													
1/4-20UNC	P2	TUMQU04N4	4P	62	15	26	33	6	4.5	7	3	1	¥ 1,670 ※
1/4-20UNC	P2	TUMQU04N1	1.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,670 ※
1/4-28UNF	P2	TUMQU04K4	4P	62	15	26	33	6	4.5	7	3	1	¥ 1,670 ※
1/4-28UNF	P2	TUMQU04K1	1.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,670 ※
5/16-18UNC	P3	TUMRU05O4	4P	70	19	-	36	6.2	5	8	3	2	¥ 2,320 ※
5/16-18UNC	P3	TUMRU05O1	1.5P	70	19	-	36	6.2	5	8	4	2	¥ 2,320 ※
5/16-24UNF	P2	TUMQU05M4	4P	70	19	-	36	6.2	5	8	3	2	¥ 2,320 ※

- ① Spiral Fluted Taps (for blind hole)
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- 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

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓn	ℓs	Ds	K	ℓk

### SU-HT Hand Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
5/16-24UNF	P2	TUMQU05M1	1.5P	70	19	-	36	6.2	5	8	4	2	¥ 2,320 <sup>*</sup>
3/8-16UNC	P3	TUMRU06P4	4P	75	23	-	38	7	5.5	8	3	2	¥ 2,970 <sup>*</sup>
3/8-16UNC	P3	TUMRU06P1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 2,970 <sup>*</sup>
3/8-24UNF	P2	TUMQU06M4	4P	75	23	-	38	7	5.5	8	3	2	¥ 2,970 <sup>*</sup>
3/8-24UNF	P2	TUMQU06M1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 2,970 <sup>*</sup>
7/16-14UNC	P3	TUMRU07Q4	4P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,170 <sup>*</sup>
7/16-14UNC	P3	TUMRU07Q1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 4,170 <sup>*</sup>
7/16-20UNF	P3	TUMRU07N4	4P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,170 <sup>*</sup>
7/16-20UNF	P3	TUMRU07N1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 4,170 <sup>*</sup>
1/2-13UNC	P3	TUMRU08R4	4P	88	26	-	45	10.5	8	11	3	2	¥ 4,420 <sup>*</sup>
1/2-13UNC	P3	TUMRU08R1	1.5P	88	26	-	45	10.5	8	11	4	2	¥ 4,420 <sup>*</sup>
1/2-20UNF	P3	TUMRU08N4	4P	88	26	-	45	10.5	8	11	3	2	¥ 4,420 <sup>*</sup>
1/2-20UNF	P3	TUMRU08N1	1.5P	88	26	-	45	10.5	8	11	4	2	¥ 4,420 <sup>*</sup>
5/8-11UNC	P3	TUMRU10U4	4P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 <sup>*</sup>
5/8-11UNC	P3	TUMRU10U1	1.5P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 <sup>*</sup>
5/8-18UNF	P3	TUMRU10O4	4P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 <sup>*</sup>
5/8-18UNF	P3	TUMRU10O1	1.5P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 <sup>*</sup>
3/4-10UNC	P4	TUMSU12V4	4P	105	33	-	50	15	12	15	4	3	¥ 12,000 <sup>*</sup>
3/4-10UNC	P4	TUMSU12V1	1.5P	105	33	-	50	15	12	15	4	3	¥ 12,000 <sup>*</sup>
3/4-16UNF	P3	TUMRU12P4	4P	105	33	-	50	15	12	15	4	3	¥ 12,000 <sup>*</sup>
3/4-16UNF	P3	TUMRU12P1	1.5P	105	33	-	50	15	12	15	4	3	¥ 12,000 <sup>*</sup>
For Whitworth Threads													
1/4W20	P3	TUMRW04N4	4P	62	15	26	33	6	4.5	7	3	1	¥ 1,670 <sup>*</sup>
1/4W20	P3	TUMRW04N1	1.5P	62	15	26	33	6	4.5	7	3	1	¥ 1,670 <sup>*</sup>
5/16W18	P3	TUMRW05O4	4P	70	19	-	36	6.2	5	8	3	2	¥ 2,320 <sup>*</sup>
5/16W18	P3	TUMRW05O1	1.5P	70	19	-	36	6.2	5	8	4	2	¥ 2,320 <sup>*</sup>
3/8W16	P3	TUMRW06P4	4P	75	23	-	38	7	5.5	8	3	2	¥ 2,970 <sup>*</sup>
3/8W16	P3	TUMRW06P1	1.5P	75	23	-	38	7	5.5	8	4	2	¥ 2,970 <sup>*</sup>
7/16W14	P3	TUMRW07Q4	4P	82	26	-	42	8.5	6.5	9	3	2	¥ 4,170 <sup>*</sup>
7/16W14	P3	TUMRW07Q1	1.5P	82	26	-	42	8.5	6.5	9	4	2	¥ 4,170 <sup>*</sup>
1/2W12	P3	TUMRW08S4	4P	88	26	-	45	10.5	8	11	3	2	¥ 4,420 <sup>*</sup>
1/2W12	P3	TUMRW08S1	1.5P	88	26	-	45	10.5	8	11	4	2	¥ 4,420 <sup>*</sup>
5/8W11	P3	TUMRW10U4	4P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 <sup>*</sup>
5/8W11	P3	TUMRW10U1	1.5P	95	26	-	48	12.5	10	13	4	2	¥ 6,610 <sup>*</sup>
3/4W10	P4	TUMSW12V4	4P	105	33	-	50	15	12	15	4	3	¥ 12,000 <sup>*</sup>
3/4W10	P4	TUMSW12V1	1.5P	105	33	-	50	15	12	15	4	3	¥ 12,000 <sup>*</sup>

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- ⑨ Thread Mills Premium Thread Mills
- ⑩ Dies
- ⑪ Center Drills Centering Tools
- ⑫ Precision Machinery/Metal/Surgical Instruments