

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

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

③-69



SU+PO SU-PO

Spiral Pointed Taps for Stainless Steels



Specification



•Product Name and Size.

SU+PO	~ M2.6
SU-PO	M3 ~, all U, all W

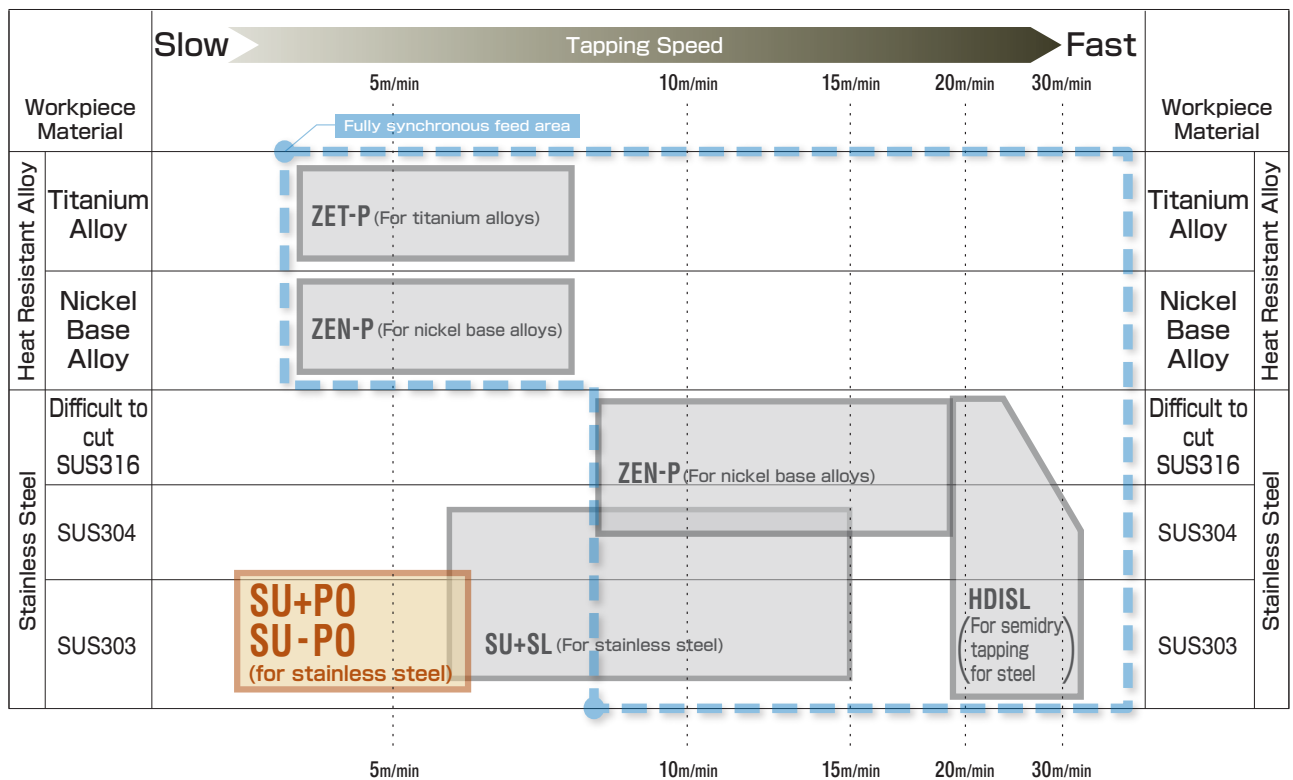
Tapping Speeds depending on Materials

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

Product Features

- The SU+PO/SU-PO taps are designed for stainless steel that causes work harden easily. The cutting geometry is also suited for tapping through holes in chromium steel and molybdenum steel.
- To prevent chip welding, the tap's surface is oxidized.

Comparison chart



Speed range for the SU+PO/SU-PO taps.

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

3

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

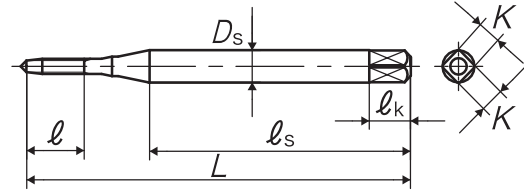
Precision Machinery/
Metal Surgical Instruments

⑫

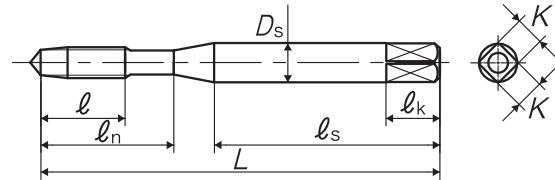
JIS

③-70

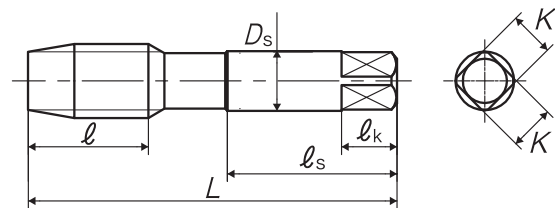
TYPE:1



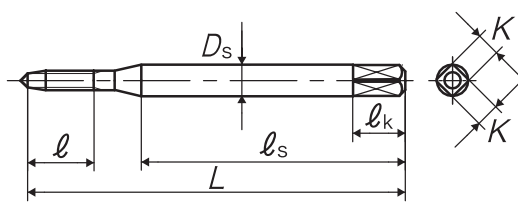
TYPE:3



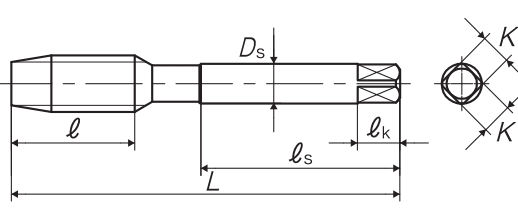
TYPE:5



TYPE:2



TYPE:4



SU+PO Spiral Pointed Taps for Stainless Steels

Oversize

Segment : 1E

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M1.4 × 0.3	P1	PUPP1.4C	5P	36	5.4	-	24	3	2.5	5	2	1	¥ 4,050 *
M1.6 × 0.35	P2	PUPQ1.6D	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,870 *
M1.7 × 0.35	P2	PUPQ1.7D	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,870 *
M2 × 0.4	P2	PUPQ2.0E	5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,910
M2 × 0.4	P3	PUPR2.0E	5P	42	7.2	12	27	3	2.5	5	2	3	¥ 3,090 *
M2.3 × 0.4	P2	PUPQ2.3E	5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,820
M2.3 × 0.4	P3	PUPR2.3E	5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,820 *
M2.5 × 0.45	P2	PUPQ2.5F	5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360
M2.5 × 0.45	P3	PUPR2.5F	5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360 *
M2.6 × 0.45	P2	PUPQ2.6F	5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360
M2.6 × 0.45	P3	PUPR2.6F	5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360 *

SU-PO Spiral Pointed Taps for Stainless Steels

Oversize

Segment : 1E

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M3 × 0.5	P2	PUMQ3.0G	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,560
M3 × 0.5	P3	PUMR3.0G	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,660 *
M3 × 0.5	P4	PUMS3.0G	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,660 *
3M0.6	P2	PUMQ3.0H	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,660 *
M3.5 × 0.6	P2	PUMQ3.5H	5P	52	11	16	29	5	4	7	3	3	¥ 1,660
M4 × 0.7	P2	PUMQ4.0I	5P	52	11	17	29	5	4	7	3	3	¥ 1,560
M4 × 0.7	P3	PUMR4.0I	5P	52	11	17	29	5	4	7	3	3	¥ 1,660 *
M4 × 0.7	P4	PUMS4.0I	5P	52	11	17	29	5	4	7	3	3	¥ 1,660 *

* = Specified Distribution Items. Made to order products.

 Think threads with
YAMAWA

③ Spiral Pointed Tap Series for through 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

SU-PO Spiral Pointed 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
4M0.75	P2	PUMQ4.0J	5P	52	11	17	29	5	4	7	3	3	¥ 1,660 ※
M5 × 0.8	P2	PUMQ5.0K	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,590
M5 × 0.8	P3	PUMR5.0K	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※
M5 × 0.8	P4	PUMS5.0K	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※
5M0.9	P2	PUMQ5.0L	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※
M6 × 1	P2	PUMQ6.0M	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,720
M6 × 1	P3	PUMR6.0M	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,840 ※
M6 × 1	P4	PUMS6.0M	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,840 ※
M6 × 0.75	P2	PUMQ6.0J	5P	62	15	26	33	6	4.5	7	3	3	¥ 2,590 ※
M7 × 1	P2	PUMQ7.0M	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,240 ※
M8 × 1.25	P3	PUMR8.0N	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,420
M8 × 1.25	P4	PUMS8.0N	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,570 ※
M8 × 1.25	P5	PUMT8.0N	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,570 ※
M8 × 1	P3	PUMR8.0M	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,920
M10 × 1.5	P3	PUMR010O	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,060
M10 × 1.5	P4	PUMS010O	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,260 ※
M10 × 1.5	P5	PUMT010O	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,260 ※
M10 × 1.25	P3	PUMR010N	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,060
M10 × 1.25	P4	PUMS010N	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,260 ※
M10 × 1	P3	PUMR010M	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,880 ※
M12 × 1.75	P4	PUMS012P	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,340
M12 × 1.75	P5	PUMT012P	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1.5	P3	PUMR012O	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,340 ※
M12 × 1.5	P5	PUMT012O	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1.25	P4	PUMS012N	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,340
M12 × 1.25	P5	PUMT012N	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1	P3	PUMR012M	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,450 ※
M14 × 2	P4	PUMS014Q	5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300
M14 × 2	P5	PUMT014Q	5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300 ※
M14 × 1.5	P3	PUMR014O	5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300
M14 × 1.5	P5	PUMT014O	5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300 ※
M14 × 1	P3	PUMR014M	5P	88	26	-	45	10.5	8	11	3	4	¥ 7,320 ※
M15 × 1.5	P3	PUMR015O	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
M15 × 1	P3	PUMR015M	5P	95	26	-	48	12.5	10	13	3	4	¥ 10,100 ※
M16 × 2	P4	PUMS016Q	5P	95	26	-	48	12.5	10	13	3	4	¥ 7,920
M16 × 2	P5	PUMT016Q	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
M16 × 2	P6	PUMU016Q	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
M16 × 1.5	P3	PUMR016O	5P	95	26	-	48	12.5	10	13	3	4	¥ 7,920
M16 × 1.5	P5	PUMT016O	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
M16 × 1	P3	PUMR016M	5P	95	26	-	48	12.5	10	13	3	4	¥ 10,100 ※
M18 × 2.5	P4	PUMS018R	5P	100	33	-	51	14	11	14	3	4	¥ 11,300 ※
M18 × 2.5	P5	PUMT018R	5P	100	33	-	51	14	11	14	3	4	¥ 11,300 ※
M18 × 2.5	P6	PUMU018R	5P	100	33	-	51	14	11	14	3	4	¥ 11,300 ※
M18 × 1.5	P4	PUMS018O	5P	100	33	-	51	14	11	14	3	4	¥ 11,300 ※
M18 × 1.5	P5	PUMT018O	5P	100	33	-	51	14	11	14	3	4	¥ 11,300 ※
M20 × 2.5	P4	PUMS020R	5P	105	33	-	50	15	12	15	3	5	¥ 15,500
M20 × 2.5	P5	PUMT020R	5P	105	33	-	50	15	12	15	3	5	¥ 15,500 ※
M20 × 2.5	P6	PUMU020R	5P	105	33	-	50	15	12	15	3	5	¥ 15,500 ※
M20 × 1.5	P4	PUMS020O	5P	105	33	-	50	15	12	15	3	5	¥ 15,500 ※
M20 × 1.5	P5	PUMT020O	5P	105	33	-	50	15	12	15	3	5	¥ 15,500 ※

JIS



※ = 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

3

JIS

SU-PO Spiral Pointed 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
M22 × 2.5	P4	PUMS022R	5P	115	33	-	55	17	13	16	3	5	¥ 19,800 *
M22 × 2.5	P5	PUMT022R	5P	115	33	-	55	17	13	16	3	5	¥ 19,800 *
M22 × 2.5	P6	PUMU022R	5P	115	33	-	55	17	13	16	3	5	¥ 19,800 *
M22 × 1.5	P4	PUMS022O	5P	115	33	-	55	17	13	16	3	5	¥ 19,800 *
M22 × 1.5	P5	PUMT022O	5P	115	33	-	55	17	13	16	3	5	¥ 19,800 *
M24 × 3	P4	PUMS024S	5P	120	39	-	55	19	15	18	3	5	¥ 24,500 *
M24 × 3	P5	PUMT024S	5P	120	39	-	55	19	15	18	3	5	¥ 24,500 *
M24 × 3	P6	PUMU024S	5P	120	39	-	55	19	15	18	3	5	¥ 24,500 *
M24 × 1.5	P4	PUMS024O	5P	120	39	-	55	19	15	18	3	5	¥ 24,500 *
M27 × 3	P4	PUMS027S	5P	130	39	-	60	20	15	18	4	5	¥ 34,400 *
M27 × 1.5	P4	PUMS027O	5P	130	39	-	60	20	15	18	4	5	¥ 34,400 *
M30 × 3.5	P5	PUMT030T	5P	135	46	-	62	23	17	20	4	5	¥ 43,800 *
M30 × 1.5	P4	PUMS030O	5P	135	46	-	62	23	17	20	4	5	¥ 43,800 *
M33 × 3.5	P5	PUMT033T	5P	145	46	-	67	25	19	22	4	5	¥ 50,900 *
M36 × 4	P5	PUMT036U	5P	155	52	-	71	28	21	24	4	5	¥ 59,000 *
M39 × 4	P5	PUMT039U	5P	165	52	-	76	30	23	26	4	5	¥ 67,700 *
M42 × 4.5	P5	PUMT042V	5P	175	59	-	81	32	26	30	4	5	¥ 82,300 *
For Unified Threads													
No.2-56UNC	P1	PUMPUN2E	5P	42	8.1	12	27	3	2.5	5	2	3	¥ 3,230 *
No.4-40UNC	P2	PUMQUN4H	5P	46	9	14	25	4	3.2	6	2	3	¥ 2,090 *
No.4-48UNF	P1	PUMPUN4F	5P	46	9	14	25	4	3.2	6	2	3	¥ 2,090 *
No.5-40UNC	P2	PUMQUN5H	5P	52	11	16	28	5	4	7	3	3	¥ 1,950 *
No.5-44UNF	P1	PUMPUN5G	5P	52	11	16	28	5	4	7	3	3	¥ 1,950 *
No.6-32UNC	P2	PUMQUN6J	5P	52	11	17	27	5	4	7	3	3	¥ 1,950 *
No.6-40UNF	P2	PUMQUN6H	5P	52	11	17	27	5	4	7	3	3	¥ 1,950 *
No.8-32UNC	P2	PUMQUN8J	5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,970 *
No.8-36UNF	P2	PUMQUN8I	5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,970 *
No.10-24UNC	P2	PUMQUNAM	5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 *
No.10-32UNF	P2	PUMQUNAJ	5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 *
No.12-24UNC	P2	PUMQUNCM	5P	62	15	26	32	6	4.5	7	3	3	¥ 2,100 *
No.12-28UNF	P2	PUMQUNCK	5P	62	15	26	32	6	4.5	7	3	3	¥ 2,100 *
1/4-20UNC	P2	PUMQU04N	5P	62	15	26	33	6	4.5	7	3	3	¥ 2,100 *
1/4-28UNF	P2	PUMQU04K	5P	62	15	26	33	6	4.5	7	3	3	¥ 2,100 *
5/16-18UNC	P3	PUMRU05O	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,960 *
5/16-24UNF	P2	PUMQU05M	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,960 *
3/8-16UNC	P3	PUMRU06P	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,790 *
3/8-24UNF	P2	PUMQU06M	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,790 *
7/16-14UNC	P3	PUMRU07Q	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,330 *
7/16-20UNF	P3	PUMRU07N	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,330 *
1/2-13UNC	P3	PUMRU08R	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,650 *
1/2-20UNF	P3	PUMRU08N	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,650 *
9/16-18UNF	P3	PUMRU09O	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 *
5/8-11UNC	P3	PUMRU10U	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 *
5/8-18UNF	P3	PUMRU10O	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 *
3/4-10UNC	P4	PUMSU12V	5P	105	33	-	50	15	12	15	3	5	¥ 15,500 *
3/4-16UNF	P3	PUMRU12P	5P	105	33	-	50	15	12	15	3	5	¥ 15,500 *
For Whitworth Threads													
3/16W24	P2	PUMQW03M	5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,970 *
1/4W20	P3	PUMRW04N	5P	62	15	26	33	6	4.5	7	3	3	¥ 2,100 *
5/16W18	P3	PUMRW05O	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,960 *

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

③-72

※ = Specified Distribution Items. Made to order products.

 Think threads with
YAMAWA

③ Spiral Pointed Tap Series for through 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

SU-PO Spiral Pointed 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
3/8W16	P3	PUMRW06P	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,790 ※
7/16W14	P3	PUMRW07Q	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,330 ※
1/2W12	P3	PUMRW08S	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,650 ※
5/8W11	P3	PUMRW10U	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
3/4W10	P4	PUMSW12V	5P	105	33	-	50	15	12	15	3	5	¥ 15,500 ※
1 W8	P4	PUMSW16X	5P	125	39	-	58	19	15	18	3	5	¥ 32,000 ※

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 ③-73