

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

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

①-107

SU+SP SU-SP

Spiral Fluted Taps for Stainless Steels

Specification

HSS

OX
Oxide



• Product Name and Size.

SU+SP	M2 ~ M6 (coarse thread)
SU-SP	~ M1.7, M2 ~ M6 (fine thread), M8 ~ , all U, all W

Tapping Speeds depending on Materials

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)

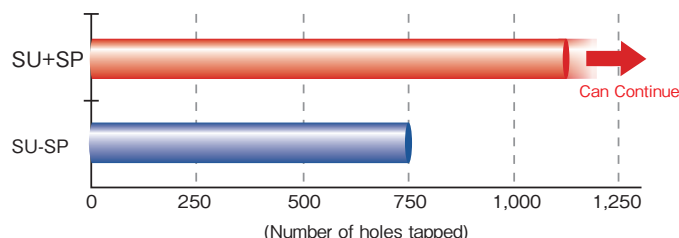
Product Features

- Ideal for blind hole machining in stainless steel, chromium steel, molybdenum steel. These materials have remarkably high work hardening properties.
- The optimum design of the thread section reduces the processing burden on each flutes cutting chamfer.
- Reduces cutting resistance and increases tool life.
- Chip discharge is stable and achieves a good surface finished.
- Improved strength and life expectancy is achieved.
- Use with either synchronous or asynchronous thread processing.

Tapping Data

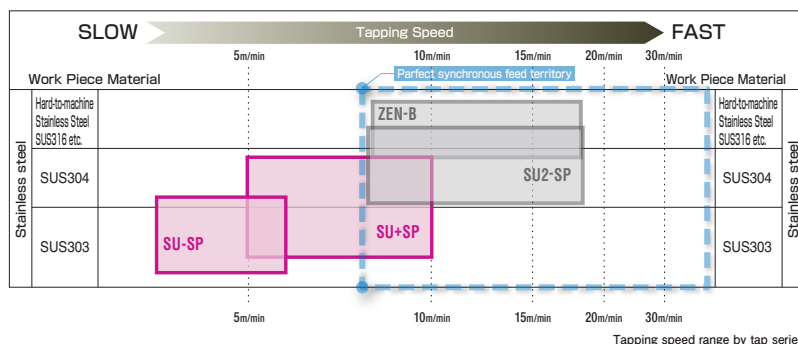
Tapping Conditions [M6×1]

Workpiece Material	SUS304 (90HRB)
Bored Hole Size	φ5.0
Tapping length	9mm, blind hole
Tapping Speed	8m/min
Machinery Type	Vertical machining center (perfect synchronous feed)
Tapping Fluid	Non-water soluble cutting oil (chlorine-free)



Speed chart

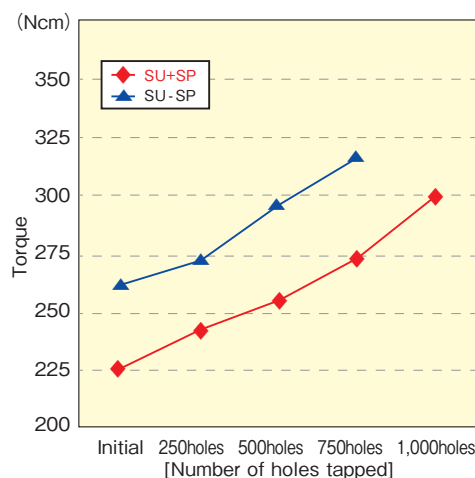
Taps for blind hole tapping of stainless steel.



Notes

When tapping SS400 materials and soft steel materials with SU+SP, use a synchronized feed machine. If they are tapped with a non-synchronized feed drilling machine or the like, the internal thread may widen.

Change in tapping torque



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L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

1

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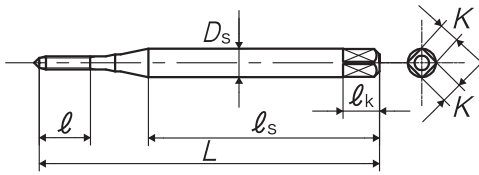
Precision Machinery/
Metal Surgical Instruments

⑫

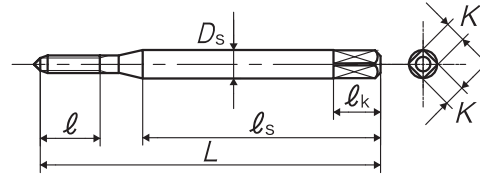
JIS

①-108

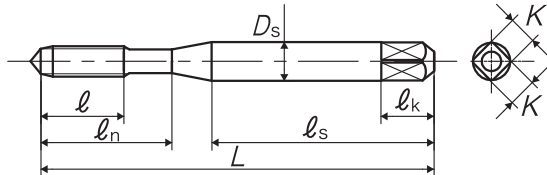
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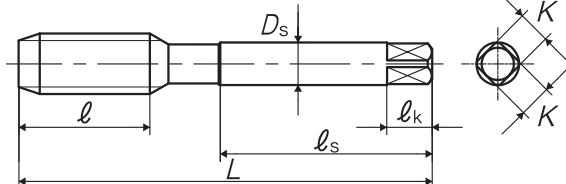
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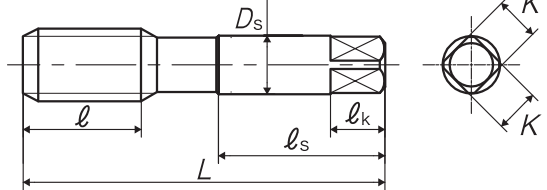
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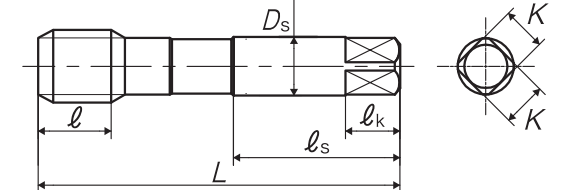
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TYPE:5



TYPE:6



SU+SP Spiral Fluted Taps for Stainless Steels

○ Oversize

Segment : 1C

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													
M2 × 0.4	P1	SUPP2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,910
M2 × 0.4	P2	SUPQ2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 3,090 *
M2 × 0.4	P3	SUPR2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 3,090 *
M2.3 × 0.4	P1	SUPP2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,820 *
M2.3 × 0.4	P2	SUPQ2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,820 *
M2.3 × 0.4	P3	SUPR2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,820 *
M2.5 × 0.45	P1	SUPP2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360
M2.5 × 0.45	P2	SUPQ2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360 *
M2.5 × 0.45	P3	SUPR2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360 *
M2.6 × 0.45	P1	SUPP2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360
M2.6 × 0.45	P2	SUPQ2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360 *
M2.6 × 0.45	P3	SUPR2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,360 *
M3 × 0.5	P1	SUPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,560
M3 × 0.5	P2	SUPQ3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,660 *
M3 × 0.5	P3	SUPR3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,660 *
3M0.6	P1	SUPP3.0H	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,660 *
M3.5 × 0.6	P1	SUPP3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,660 *
M3.5 × 0.6	P3	SUPR3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,660 *
M4 × 0.7	P2	SUPQ4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,560
M4 × 0.7	P3	SUPR4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,660 *
M4 × 0.7	P4	SUPS4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,660 *
4M0.75	P2	SUPQ4.0J	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,660 *
M5 × 0.8	P2	SUPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,590
M5 × 0.8	P3	SUPR5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 *

* = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

1 Spiral Fluted Tap Series for blind hole

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SU+SP Spiral Fluted 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
M5 × 0.8	P4	SUPS5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※
5M0.9	P2	SUPQ5.0L	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※
M6 × 1	P2	SUPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,720
M6 × 1	P3	SUPR6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,840 ※
M6 × 1	P4	SUPS6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,840 ※

SU-SP Spiral Fluted Taps for Stainless Steels

○ 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	SUMP1.4C	2.5P	36	5.4	-	24	3	2.5	5	2	1	¥ 4,050 ※
M1.6 × 0.35	P1	SUMP1.6D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,870 ※
M1.7 × 0.35	P1	SUMP1.7D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,870 ※
M1.7 × 0.35	P2	SUMQ1.7D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,870 ※
M6 × 0.75	P2	SUMQ6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,590 ※
M7 × 1	P2	SUMQ7.0M	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,240 ※
M8 × 1.25	P2	SUMQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,420
M8 × 1.25	P3	SUMR8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,570 ※
M8 × 1.25	P4	SUMS8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,570 ※
M8 × 1	P2	SUMQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,920 ※
M8 × 0.75	P2	SUMQ8.0J	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 3,310 ※
M10 × 1.5	P2	SUMQ010O	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,060
M10 × 1.5	P3	SUMR010O	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,260 ※
M10 × 1.5	P4	SUMS010O	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,260 ※
M10 × 1.25	P2	SUMQ010N	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,060
M10 × 1.25	P3	SUMR010N	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,260 ※
M10 × 1.25	P4	SUMS010N	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,260 ※
M10 × 1	P2	SUMQ010M	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,880 ※
M10 × 1	P4	SUMS010M	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,880 ※
M12 × 1.75	P2	SUMQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,340
M12 × 1.75	P3	SUMR012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1.75	P4	SUMS012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1.5	P2	SUMQ012O	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620
M12 × 1.5	P3	SUMR012O	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1.5	P4	SUMS012O	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1.25	P2	SUMQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620
M12 × 1.25	P3	SUMR012N	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1.25	P4	SUMS012N	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,620 ※
M12 × 1	P2	SUMQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,450 ※
M14 × 2	P2	SUMQ014Q	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300
M14 × 2	P3	SUMR014Q	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300 ※
M14 × 2	P4	SUMS014Q	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300 ※
M14 × 1.5	P2	SUMQ014O	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300
M14 × 1.5	P4	SUMS014O	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 6,300 ※
M14 × 1	P2	SUMQ014M	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 7,320 ※
M16 × 2	P2	SUMQ016Q	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 7,920
M16 × 2	P3	SUMR016Q	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
M16 × 2	P4	SUMS016Q	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※

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※ = Specified Distribution Items. Made to order products.

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L	ℓ	ℓn	ℓs	Ds	K	ℓk

SU-SP Spiral Fluted 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
M16 × 1.5	P2	SUMQ016O	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430
M16 × 1.5	P4	SUMS016O	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 *
M18 × 2.5	P3	SUMR018R	2.5P	100	33	-	51	14	11	14	4	4	¥ 11,300
M18 × 2.5	P4	SUMS018R	2.5P	100	33	-	51	14	11	14	4	4	¥ 11,300 *
M18 × 1.5	P2	SUMQ018O	2.5P	100	33	-	51	14	11	14	4	4	¥ 11,300
M18 × 1.5	P4	SUMS018O	2.5P	100	33	-	51	14	11	14	4	4	¥ 11,300 *
M20 × 2.5	P3	SUMR020R	2.5P	105	33	-	50	15	12	15	4	5	¥ 15,500
M20 × 2.5	P4	SUMS020R	2.5P	105	33	-	50	15	12	15	4	5	¥ 15,500 *
M20 × 1.5	P3	SUMR020O	2.5P	105	33	-	50	15	12	15	4	5	¥ 15,500
M20 × 1.5	P4	SUMS020O	2.5P	105	33	-	50	15	12	15	4	5	¥ 15,500 *
M22 × 2.5	P3	SUMR022R	2.5P	115	33	-	55	17	13	16	4	5	¥ 19,800
M22 × 2.5	P4	SUMS022R	2.5P	115	33	-	55	17	13	16	4	5	¥ 19,800 *
M22 × 2.5	P5	SUMT022R	2.5P	115	33	-	55	17	13	16	4	5	¥ 19,800 *
M22 × 1.5	P3	SUMR022O	2.5P	115	33	-	55	17	13	16	4	5	¥ 19,800 *
M22 × 1.5	P4	SUMS022O	2.5P	115	33	-	55	17	13	16	4	5	¥ 19,800 *
M24 × 3	P3	SUMR024S	2.5P	120	39	-	55	19	15	18	4	5	¥ 24,500
M24 × 3	P4	SUMS024S	2.5P	120	39	-	55	19	15	18	4	5	¥ 24,500 *
M24 × 3	P5	SUMT024S	2.5P	120	39	-	55	19	15	18	4	5	¥ 24,500 *
M24 × 2	P3	SUMR024Q	2.5P	120	39	-	55	19	15	18	4	5	¥ 24,500 *
M24 × 1.5	P3	SUMR024O	2.5P	120	39	-	55	19	15	18	4	5	¥ 24,500 *
M24 × 1.5	P4	SUMS024O	2.5P	120	39	-	55	19	15	18	4	5	¥ 24,500 *
M27 × 3	P3	SUMR027S	2.5P	130	39	-	60	20	15	18	4	5	¥ 34,400 *
M27 × 1.5	P3	SUMR027O	2.5P	130	39	-	60	20	15	18	4	5	¥ 34,400 *
M30 × 3.5	P4	SUMS030T	2.5P	135	46	-	62	23	17	20	4	5	¥ 43,800 *
M30 × 1.5	P3	SUMR030O	2.5P	135	46	-	62	23	17	20	4	5	¥ 43,800 *
M33 × 3.5	P4	SUMS033T	2.5P	145	46	-	67	25	19	22	4	5	¥ 50,900 *
M36 × 4	P4	SUMS036U	2.5P	155	52	-	71	28	21	24	4	5	¥ 59,000 *
M39 × 4	P4	SUMS039U	2.5P	165	52	-	76	30	23	26	4	5	¥ 67,700 *
M42 × 4.5	P4	SUMS042V	2.5P	175	59	-	81	32	26	30	4	5	¥ 82,300 *
M42 × 1.5	P3	SUMR042O	2.5P	175	27	-	81	32	26	30	4	6	¥ 82,300 *
M45 × 4.5	P4	SUMS045V	2.5P	180	59	-	83	35	26	30	4	5	¥ 95,300 *
M48 × 5	P4	SUMS048W	2.5P	185	65	-	85	38	29	32	4	5	¥ 120,000 *
For Unified Threads													
No.2-56UNC	P1	SUMPUN2E	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 3,230 *
No.3-48UNC	P1	SUMPUN3F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,740 *
No.4-40UNC	P1	SUMPUN4H	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 2,090 *
No.4-48UNF	P1	SUMPUN4F	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 2,090 *
No.5-40UNC	P1	SUMPUN5H	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,950 *
No.5-44UNF	P1	SUMPUN5G	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,950 *
No.6-32UNC	P2	SUMQUN6J	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,950 *
No.6-40UNF	P1	SUMPUN6H	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,950 *
No.8-32UNC	P2	SUMQUN8J	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,970 *
No.8-36UNF	P2	SUMQUN8I	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,970 *
No.10-24UNC	P2	SUMQUNAM	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 *
No.10-32UNF	P2	SUMQUNAJ	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 *
No.12-24UNC	P2	SUMQUNCM	2.5P	62	15	26	32	6	4.5	7	3	3	¥ 2,100 *
No.12-28UNF	P2	SUMQUNCK	2.5P	62	15	26	32	6	4.5	7	3	3	¥ 2,100 *
1/4-20UNC	P2	SUMQU04N	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,100 *
1/4-28UNF	P2	SUMQU04K	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,100 *

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Think threads with
YAMAWA

1

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(for blind hole) ①

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①-110

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SU-SP Spiral Fluted 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
5/16-18UNC	P2	SUMQU05O	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,960 ※
5/16-24UNF	P2	SUMQU05M	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,960 ※
3/8-16UNC	P2	SUMQU06P	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,790 ※
3/8-24UNF	P2	SUMQU06M	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,790 ※
7/16-14UNC	P3	SUMRU07Q	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,330 ※
7/16-20UNF	P2	SUMQU07N	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,330 ※
1/2-13UNC	P3	SUMRU08R	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,650 ※
1/2-20UNF	P2	SUMQU08N	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,650 ※
5/8-11UNC	P3	SUMRU10U	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
5/8-18UNF	P2	SUMQU10O	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
3/4-10UNC	P3	SUMRU12V	2.5P	105	33	-	50	15	12	15	4	5	¥ 15,500 ※
3/4-16UNF	P3	SUMRU12P	2.5P	105	33	-	50	15	12	15	4	5	¥ 15,500 ※
7/8-9UNC	P3	SUMRU14W	2.5P	115	33	-	55	17	13	16	4	5	¥ 21,700 ※
7/8-14UNF	P3	SUMRU14Q	2.5P	115	33	-	55	17	13	16	4	5	¥ 21,700 ※
1 -8UNC	P3	SUMRU16X	2.5P	125	39	-	58	19	15	18	4	5	¥ 32,000 ※
1 -12UNF	P3	SUMRU16S	2.5P	125	39	-	58	19	15	18	4	5	¥ 32,000 ※
For Whitworth Threads													
3/16W24	P2	SUMQW03M	2.5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,970 ※
1/4W20	P2	SUMQW04N	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,100 ※
5/16W18	P2	SUMQW05O	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,960 ※
3/8W16	P2	SUMQW06P	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,790 ※
7/16W14	P3	SUMRW07Q	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,330 ※
1/2W12	P3	SUMRW08S	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,650 ※
9/16W12	P3	SUMRW09S	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
5/8W11	P3	SUMRW10U	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 8,430 ※
3/4W10	P3	SUMRW12V	2.5P	105	33	-	50	15	12	15	4	5	¥ 15,500 ※
7/8W9	P3	SUMRW14W	2.5P	115	33	-	55	17	13	16	4	5	¥ 21,700 ※
1 W8	P3	SUMRW16X	2.5P	125	39	-	58	19	15	18	4	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

Think threads with
YAMAWA

※ = Specified Distribution Items. Made to order products.