

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	ℓ _n	ℓ _s	D _s	K	ℓ _k

DIN

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

③-9

Z-PRO VUPO

Z-PRO Coated Spiral Pointed Taps



Specification



- Durability is improved by premium powder HSS and special coating.
- Chip ejection efficiency is improved and cutting resistance is reduced by the unique cutting edge shape, achieving a good internal thread and long tool life.

Tapping Speeds depending on Materials

Low carbon steels
低炭素鋼
10~30
(m/min)

Medium carbon steels
中炭素鋼
10~30
(m/min)

High carbon steels
高炭素鋼
10~30
(m/min)

Alloy steels
合金鋼
10~30
(m/min)

Stainless steels
ステンレス鋼
5~15
(m/min)

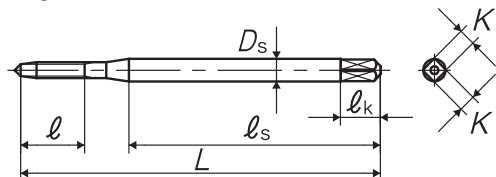
Tool steels
工具鋼
5~15
(m/min)

Ductile cast irons
強靱鑄鉄
10~35
(m/min)

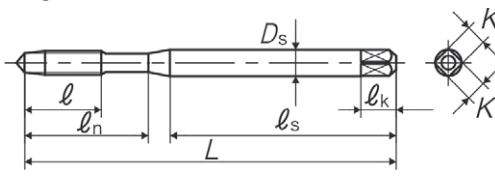
Wrought aluminum
アルミ圧延材
10~35
(m/min)

Aluminum alloy castings
アルミ合金鑄物
10~35
(m/min)

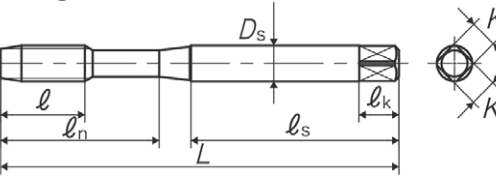
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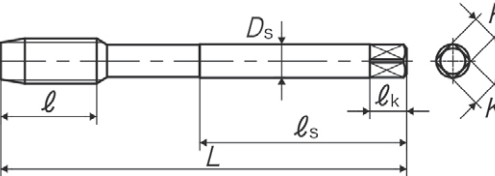
TYPE:2



TYPE:3



TYPE:4



Segment : 1F

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
For Metric Threads												
M2 × 0.4	ISO2X	3102101021	5P	45	8	-	32	2.8	2.1	5	2	1
M2.2 × 0.45	ISO2X	3102101024	5P	45	9	-	32	2.8	2.1	5	2	1
M2.3 × 0.4	ISO2X	3102101026	5P	45	9	-	32	2.8	2.1	5	2	1
M2.5 × 0.45	ISO2X	3102101029	5P	50	8	15	33	2.8	2.1	5	2	2
M2.6 × 0.45	ISO2X	3102101032	5P	50	8	15	33	2.8	2.1	5	2	2
M3 × 0.5	ISO2X	3102101035	5P	56	9	18	34	3.5	2.7	6	3	2
M3 × 0.5	ISO3X	3102201035	5P	56	9	18	34	3.5	2.7	6	3	2
M3 × 0.5	7GX	3102301035	5P	56	9	18	34	3.5	2.7	6	3	2
M3 × 0.5	ISO2X+100	3102501035	5P	56	9	18	34	3.5	2.7	6	3	2
M3 × 0.35	ISO2X	3102101036	5P	56	6.5	18	34	3.5	2.7	6	3	2
M4 × 0.7	ISO2X	3102101042	5P	63	13	21	38	4.5	3.4	6	3	2
M4 × 0.7	ISO3X	3102201042	5P	63	13	21	38	4.5	3.4	6	3	2
M4 × 0.7	7GX	3102301042	5P	63	13	21	38	4.5	3.4	6	3	2
M4 × 0.7	ISO2X+100	3102501042	5P	63	13	21	38	4.5	3.4	6	3	2

Think threads with
YAMAWA

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

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

DIN

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M4 × 0.5	ISO2X	3102101043	5P	63	9	21	38	4.5	3.4	6	3	2
M5 × 0.8	ISO2X	3102101049	5P	70	14	25	39	6	4.9	8	3	2
M5 × 0.8	ISO3X	3102201049	5P	70	14	25	39	6	4.9	8	3	2
M5 × 0.8	7GX	3102301049	5P	70	14	25	39	6	4.9	8	3	2
M5 × 0.8	ISO2X+100	3102501049	5P	70	14	25	39	6	4.9	8	3	2
M5 × 0.5	ISO2X	3102101051	5P	70	9	25	39	6	4.9	8	3	2
M6 × 1	ISO2X	3102101055	5P	80	15	30	45	6	4.9	8	3	2
M6 × 1	ISO3X	3102201055	5P	80	15	30	45	6	4.9	8	3	2
M6 × 1	7GX	3102301055	5P	80	15	30	45	6	4.9	8	3	2
M6 × 1	ISO2X+100	3102501055	5P	80	15	30	45	6	4.9	8	3	2
M6 × 0.75	ISO2X	3102101056	5P	80	15	30	45	6	4.9	8	3	2
M6 × 0.5	ISO2X	3102101057	5P	80	9	30	45	6	4.9	8	3	2
M8 × 1.25	ISO2X	3102101064	5P	90	19	35	47	8	6.2	9	3	3
M8 × 1.25	ISO3X	3102201064	5P	90	19	35	47	8	6.2	9	3	3
M8 × 1.25	7GX	3102301064	5P	90	19	35	47	8	6.2	9	3	3
M8 × 1.25	ISO2X+100	3102501064	5P	90	19	35	47	8	6.2	9	3	3
M8 × 1	ISO2X	3102101065	5P	90	19	-	46	6	4.9	8	3	4
M10 × 1.5	ISO2X	3102101078	5P	100	23	39	52.5	10	8	11	3	3
M10 × 1.5	ISO3X	3102201078	5P	100	23	39	52.5	10	8	11	3	3
M10 × 1.5	7GX	3102301078	5P	100	23	39	52.5	10	8	11	3	3
M10 × 1.5	ISO2X+100	3102501078	5P	100	23	39	52.5	10	8	11	3	3
M10 × 1.25	ISO2X	3102101079	5P	100	23	-	51	7	5.5	8	3	4
M10 × 1	ISO2X	3102101080	5P	90	19	-	46	7	5.5	8	3	4
M12 × 1.75	ISO2X	3102101088	5P	110	26	-	56	9	7	10	3	4
M12 × 1.75	ISO3X	3102201088	5P	110	26	-	56	9	7	10	3	4
M12 × 1.75	7GX	3102301088	5P	110	26	-	56	9	7	10	3	4
M12 × 1.75	ISO2X+100	3102501088	5P	110	26	-	56	9	7	10	3	4
M12 × 1.5	ISO2X	3102101089	5P	100	21	-	51	9	7	10	3	4
M12 × 1.25	ISO2X	3102101090	5P	100	21	-	51	9	7	10	3	4
M14 × 2	ISO2X	3102101100	5P	110	26	-	56	11	9	12	3	4
M14 × 2	ISO3X	3102201100	5P	110	26	-	56	11	9	12	3	4
M14 × 2	7GX	3102301100	5P	110	26	-	56	11	9	12	3	4
M14 × 2	ISO2X+100	3102501100	5P	110	26	-	56	11	9	12	3	4
M14 × 1.5	ISO2X	3102101102	5P	100	21	-	51	11	9	12	3	4
M16 × 2	ISO2X	3102101114	5P	110	26	-	56	12	9	12	3	4
M16 × 2	ISO3X	3102201114	5P	110	26	-	56	12	9	12	3	4
M16 × 2	7GX	3102301114	5P	110	26	-	56	12	9	12	3	4
M16 × 2	ISO2X+100	3102501114	5P	110	26	-	56	12	9	12	3	4
M16 × 1.5	ISO2X	3102101116	5P	100	21	-	51	12	9	12	3	4
M18 × 2.5	ISO2X	3102101128	5P	125	33	-	64	14	11	14	3	4
M18 × 1.5	ISO2X	3102101130	5P	110	24	-	56	14	11	14	3	4
M20 × 2.5	ISO2X	3102101141	5P	140	33	-	71	16	12	15	3	4
M20 × 1.5	ISO2X	3102101144	5P	125	24	-	64	16	12	15	3	4
M22 × 2.5	ISO2X	3102101156	5P	140	33	-	71	18	14.5	17	3	4
M22 × 1.5	ISO2X	3102101158	5P	125	24	-	64	18	14.5	17	3	4
M24 × 3	ISO2X	3102101167	5P	160	37	-	82	18	14.5	17	3	4
M24 × 1.5	ISO2X	3102101170	5P	140	27	-	71	18	14.5	17	3	4
For Unified Threads												
No.5-40UNC	2BX	3102103021	5P	56	11	18	34	3.5	2.7	6	2	2
No.5-44UNF	2BX	3102103022	5P	56	11	18	34	3.5	2.7	6	2	2

Spiral Fluted Taps
(for blind hole)

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(for through hole)

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Simple Inspection Tools

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Pipe Taps

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Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

DIN

③-10

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

DIN

VUPO Z-PRO Coated Spiral Pointed Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
No.6-32UNC	2BX	3102103023	5P	56	11	19	32	4	3	6	2	2
No.6-40UNF	2BX	3102103024	5P	56	11	19	32	4	3	6	2	2
No.8-32UNC	2BX	3102103029	5P	63	13	21	38	4.5	3.4	6	2	2
No.8-36UNF	2BX	3102103030	5P	63	13	21	38	4.5	3.4	6	2	2
No.10-24UNC	2BX	3102103039	5P	70	14	24	39	6	4.9	8	2	2
No.10-32UNF	2BX	3102103041	5P	70	14	24	39	6	4.9	8	2	2
No.12-24UNC	2BX	3102103047	5P	80	15	28	45	6	4.9	8	2	2
No.12-28UNF	2BX	3102103048	5P	80	15	28	45	6	4.9	8	2	2
1/4-20UNC	2BX	3102103058	5P	80	15	30	42	7	5.5	8	3	2
1/4-28UNF	2BX	3102103062	5P	80	15	30	42	7	5.5	8	3	2
5/16-18UNC	2BX	3102103071	5P	90	19	35	47	8	6.2	9	3	3
5/16-24UNF	2BX	3102103074	5P	90	19	-	46	6	4.9	8	3	4
3/8-16UNC	2BX	3102103082	5P	100	23	39	54	9	7	10	3	3
3/8-24UNF	2BX	3102103085	5P	100	23	-	51	7	5.5	8	3	4
7/16-14UNC	2BX	3102103098	5P	100	23	-	51	8	6.2	9	3	4
7/16-20UNF	2BX	3102103101	5P	100	23	-	51	8	6.2	9	3	4
1/2-13UNC	2BX	3102103111	5P	110	26	-	56	9	7	10	3	4
1/2-20UNF	2BX	3102103115	5P	100	21	-	51	9	7	10	3	4
9/16-12UNC	2BX	3102103126	5P	110	26	-	56	11	9	12	3	4
9/16-18UNF	2BX	3102103129	5P	100	21	-	51	11	9	12	3	4
5/8-11UNC	2BX	3102103138	5P	110	26	-	56	12	9	12	3	4
5/8-18UNF	2BX	3102103142	5P	100	21	-	51	12	9	12	3	4
3/4-10UNC	2BX	3102103161	5P	125	33	-	64	14	11	14	3	4
3/4-16UNF	2BX	3102103164	5P	110	24	-	56	14	11	14	3	4
7/8-9UNC	2BX	3102103181	5P	140	33	-	71	18	14.5	17	3	4
7/8-14UNF	2BX	3102103184	5P	125	24	-	64	18	14.5	17	3	4

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③-11

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