

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	ℓ _n	ℓ _s	D _s	K	ℓ _k

- ANSI
- 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

ANSI

Z-PRO

VUSP 1.5P



Z-PRO

Coated Spiral Fluted Taps 1.5P

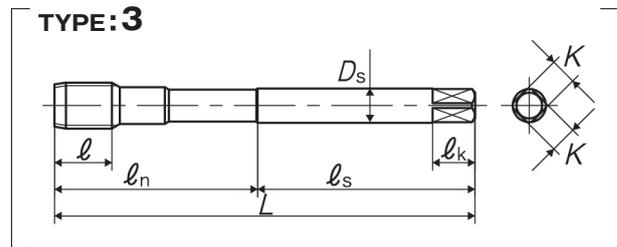
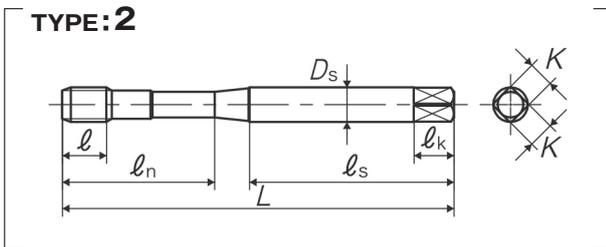
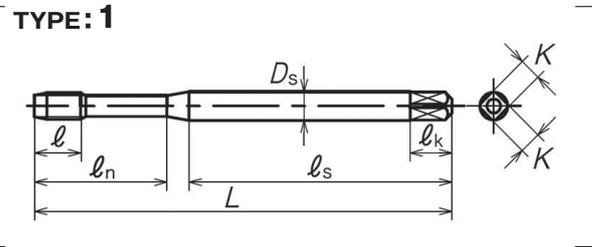
Specification



- Lead length of 1.5P makes it ideal for blind hole drilling, in which there is no tolerance for prepared hole depth and effective thread length.
- 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	Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼	Tool steels 工具鋼	Ductile cast irons 強靱鑄鉄
5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	5~15 (m/min)	3~10 (m/min)	5~10 (m/min)	5~15 (m/min)
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物					
5~20 (m/min)	5~20 (m/min)					



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ _n (inch)	ℓ _s (inch)	D _s (inch)	K (inch)	ℓ _k (inch)	No. of flutes	TYPE
For Metric Threads												
M3 × 0.5	D4	5103101035	1.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	3	1
M3 × 0.35	D4	5103101036	1.5P	2.205	0.197	0.736	1.339	0.141	0.11	0.187	3	1
M4 × 0.7	D5	5103101042	1.5P	2.48	0.276	0.815	1.535	0.168	0.131	0.25	3	1
M4 × 0.5	D4	5103101043	1.5P	2.48	0.197	0.815	1.535	0.168	0.131	0.25	3	1
M5 × 0.8	D5	5103101049	1.5P	2.756	0.354	0.984	1.654	0.194	0.152	0.25	3	1
M5 × 0.5	D4	5103101051	1.5P	2.756	0.236	0.984	1.654	0.194	0.152	0.25	3	1
M6 × 1	D6	5103101055	1.5P	3.15	0.433	1.181	1.713	0.255	0.191	0.312	3	1
M6 × 0.75	D6	5103101056	1.5P	3.15	0.315	1.181	1.713	0.255	0.191	0.312	3	1
M6 × 0.5	D4	5103101057	1.5P	3.15	0.315	1.181	1.713	0.255	0.191	0.312	3	1
M8 × 1.25	D7	5103101064	1.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	2
M8 × 1	D6	5103101065	1.5P	3.543	0.472	1.378	1.831	0.318	0.238	0.375	3	2
M10 × 1.5	D8	5103101078	1.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M10 × 1.25	D6	5103101079	1.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M10 × 1	D6	5103101080	1.5P	3.937	0.512	1.535	2.126	0.381	0.286	0.437	3	2
M12 × 1.75	D8	5103101088	1.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3
M12 × 1.5	D7	5103101089	1.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3

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Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	ℓs (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
M12 × 1.25	D7	5103101090	1.5P	4.331	0.591	-	2.205	0.367	0.275	0.437	3	3
M14 × 2	D9	5103101100	1.5P	4.331	0.709	-	2.205	0.429	0.322	0.5	3	3
M14 × 1.5	D8	5103101102	1.5P	4.331	0.551	-	2.205	0.429	0.322	0.5	3	3
M16 × 2	D9	5103101114	1.5P	4.331	0.709	-	2.205	0.48	0.36	0.562	3	3
M16 × 1.5	D8	5103101116	1.5P	4.331	0.551	-	2.205	0.48	0.36	0.562	3	3

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Spiral Fluted Taps
(for blind hole) ①Spiral Fluted Taps
(for through hole) ②Spiral 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 ⑪Precision Machinery/
Metal Surgical Instruments ⑫

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