

# 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

- 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



**Z-PRO**

## VUSP 1.5P



Z-PRO

Coated Spiral Fluted Taps 1.5P

### Specification



### Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 <b>5~15</b> (m/min)	Medium carbon steels 中炭素鋼 <b>5~15</b> (m/min)	High carbon steels 高炭素鋼 <b>5~15</b> (m/min)	Alloy steels 合金鋼 <b>5~15</b> (m/min)	<b>Stainless steels</b> ステンレス鋼 <b>3~10</b> (m/min)	Tool steels 工具鋼 <b>5~10</b> (m/min)	Ductile cast irons 強靱鑄鉄 <b>5~15</b> (m/min)
Wrought aluminum アルミ圧延材 <b>5~20</b> (m/min)	Aluminum alloy castings アルミ合金鑄物 <b>5~20</b> (m/min)					

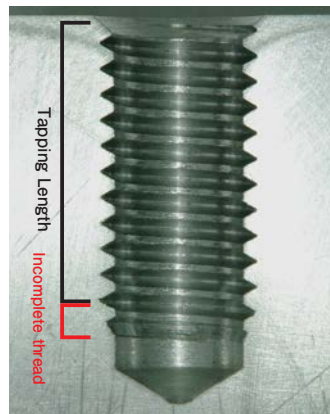
### Product Features

- The chamfer length is 1.5 pitches, making it ideal for machining blind holes where there is little room between the bored hole depth and the full 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.
- Proper tool projection length is secured, preventing chips from interfering with the holder.
- This is most suitable for tapping with water soluble cutting fluid.

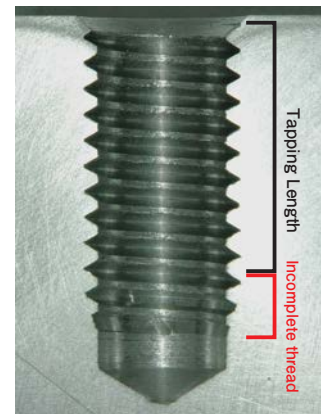
### Tapping Data

#### Tapping condition [M6×1]

Work Material	S50C
Tapping Speed	15m/min
Machine	Machining center, vertical type
Tapping Fluid	Water soluble cutting fluid
Tapping Length	13mm, blind hole



VUSP 1.5P  
Internal thread surface



VUSP (Chamfer 2.5P)  
Internal thread surface

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

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

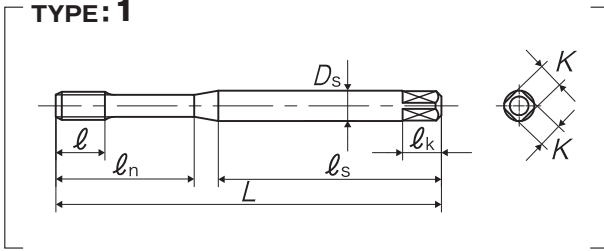
Precision Machinery/  
Metal Surgical Instruments

⑫

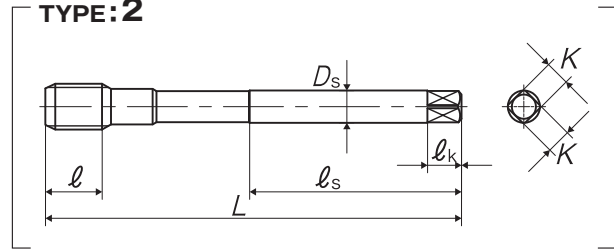
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①-16

TYPE: 1



TYPE: 2



Segment : 1D

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													
M3 × 0.5	P2	1103101035	1.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900
M3 × 0.35	P2	1103101036	1.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070*
M4 × 0.7	P2	1103101042	1.5P	63	7	21	36	5	4	7	3	1	¥ 2,850
M4 × 0.5	P2	1103101043	1.5P	63	5	21	36	5	4	7	3	1	¥ 3,560*
M5 × 0.8	P2	1103101049	1.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880
M5 × 0.5	P2	1103101051	1.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690*
M6 × 1	P2	1103101055	1.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180
M6 × 0.75	P2	1103101056	1.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190*
M6 × 0.5	P2	1103101057	1.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190*
M8 × 1.25	P3	1103101064	1.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190
M8 × 1	P3	1103101065	1.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950*
M10 × 1.5	P3	1103101078	1.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.25	P3	1103101079	1.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1	P3	1103101080	1.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280*
M12 × 1.75	P4	1103101088	1.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.5	P3	1103101089	1.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.25	P3	1103101090	1.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M14 × 2	P4	1103101100	1.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 1.5	P3	1103101102	1.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450
M16 × 2	P4	1103101114	1.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 1.5	P3	1103101116	1.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300

\* = Specified Distribution Items. Made to order products.

Think threads with YAMAWA