

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	Ds	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

Z-PRO
VUSP

Z-PRO
Coated Spiral Fluted Taps

Specification

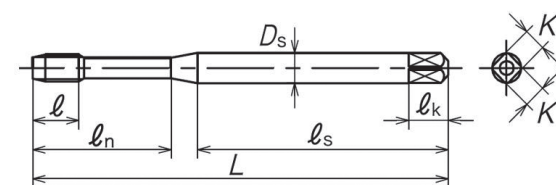


- Durability is improved by premium powder HSS and special coating.
- Chip ejection efficiency is improved and cutting resistance is reduced by the unique cutting edge shape, achieving a good internal thread and long tool life.

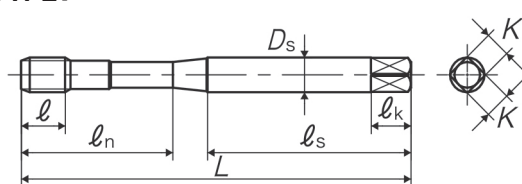
Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 10~20 (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 10~20 (m/min)	Stainless steels ステンレス鋼 3~10 (m/min)	Tool steels 工具鋼 5~10 (m/min)	Ductile cast irons 強靱鑄鉄 10~30 (m/min)
Wrought aluminum アルミ圧延材 10~30 (m/min)	Aluminum alloy castings アルミ合金鑄物 10~35 (m/min)					

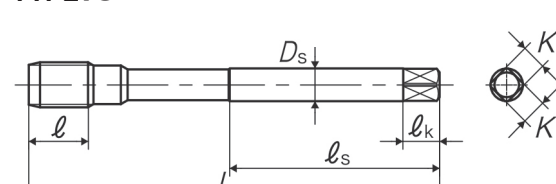
TYPE: 1



TYPE: 2



TYPE: 3



Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE
For Metric Threads												
M2 × 0.4	ISO2X	3101101021	2.5P	45	4	10	32	2.8	2.1	5	2	1
M2.2 × 0.45	ISO2X	3101101024	2.5P	45	4	11	32	2.8	2.1	5	2	1
M2.3 × 0.4	ISO2X	3101101026	2.5P	45	4	11	32	2.8	2.1	5	2	1
M2.5 × 0.45	ISO2X	3101101029	2.5P	50	4	15	33	2.8	2.1	5	2	1
M2.6 × 0.45	ISO2X	3101101032	2.5P	50	4	15	33	2.8	2.1	5	2	1
M3 × 0.5	ISO2X	3101101035	2.5P	56	5	18	34	3.5	2.7	6	3	1
M3 × 0.5	ISO3X	3101201035	2.5P	56	5	18	34	3.5	2.7	6	3	1
M3 × 0.5	7GX	3101301035	2.5P	56	5	18	34	3.5	2.7	6	3	1
M3 × 0.5	ISO2X+100	3101501035	2.5P	56	5	18	34	3.5	2.7	6	3	1
M3 × 0.35	ISO2X	3101101036	2.5P	56	5	18	34	3.5	2.7	6	3	1
M4 × 0.7	ISO2X	3101101042	2.5P	63	7	21	38	4.5	3.4	6	3	1
M4 × 0.7	ISO3X	3101201042	2.5P	63	7	21	38	4.5	3.4	6	3	1
M4 × 0.7	7GX	3101301042	2.5P	63	7	21	38	4.5	3.4	6	3	1
M4 × 0.7	ISO2X+100	3101501042	2.5P	63	7	21	38	4.5	3.4	6	3	1
M4 × 0.5	ISO2X	3101101043	2.5P	63	5	21	38	4.5	3.4	6	3	1
M5 × 0.8	ISO2X	3101101049	2.5P	70	9	25	39	6	4.9	8	3	1

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
M5 × 0.8	ISO3X	3101201049	2.5P	70	9	25	39	6	4.9	8	3	1
M5 × 0.8	7GX	3101301049	2.5P	70	9	25	39	6	4.9	8	3	1
M5 × 0.8	ISO2X+100	3101501049	2.5P	70	9	25	39	6	4.9	8	3	1
M5 × 0.5	ISO2X	3101101051	2.5P	70	6	25	39	6	4.9	8	3	1
M6 × 1	ISO2X	3101101055	2.5P	80	11	30	45	6	4.9	8	3	1
M6 × 1	ISO3X	3101201055	2.5P	80	11	30	45	6	4.9	8	3	1
M6 × 1	7GX	3101301055	2.5P	80	11	30	45	6	4.9	8	3	1
M6 × 1	ISO2X+100	3101501055	2.5P	80	11	30	45	6	4.9	8	3	1
M6 × 0.75	ISO2X	3101101056	2.5P	80	8	30	45	6	4.9	8	3	1
M6 × 0.5	ISO2X	3101101057	2.5P	80	8	30	45	6	4.9	8	3	1
M8 × 1.25	ISO2X	3101101064	2.5P	90	12	35	47	8	6.2	9	3	2
M8 × 1.25	ISO3X	3101201064	2.5P	90	12	35	47	8	6.2	9	3	2
M8 × 1.25	7GX	3101301064	2.5P	90	12	35	47	8	6.2	9	3	2
M8 × 1.25	ISO2X+100	3101501064	2.5P	90	12	35	47	8	6.2	9	3	2
M8 × 1	ISO2X	3101101065	2.5P	90	12	-	46	6	4.9	8	3	3
M10 × 1.5	ISO2X	3101101078	2.5P	100	13	39	52	10	8	11	3	2
M10 × 1.5	ISO3X	3101201078	2.5P	100	13	39	52	10	8	11	3	2
M10 × 1.5	7GX	3101301078	2.5P	100	13	39	52	10	8	11	3	2
M10 × 1.5	ISO2X+100	3101501078	2.5P	100	13	39	52	10	8	11	3	2
M10 × 1.25	ISO2X	3101101079	2.5P	100	13	-	51	7	5.5	8	3	3
M10 × 1	ISO2X	3101101080	2.5P	90	13	-	46	7	5.5	8	3	3
M12 × 1.75	ISO2X	3101101088	2.5P	110	15	-	56	9	7	10	3	3
M12 × 1.75	ISO3X	3101201088	2.5P	110	15	-	56	9	7	10	3	3
M12 × 1.75	7GX	3101301088	2.5P	110	15	-	56	9	7	10	3	3
M12 × 1.75	ISO2X+100	3101501088	2.5P	110	15	-	56	9	7	10	3	3
M12 × 1.5	ISO2X	3101101089	2.5P	100	15	-	51	9	7	10	3	3
M12 × 1.25	ISO2X	3101101090	2.5P	100	15	-	51	9	7	10	3	3
M14 × 2	ISO2X	3101101100	2.5P	110	18	-	56	11	9	12	3	3
M14 × 2	ISO3X	3101201100	2.5P	110	18	-	56	11	9	12	3	3
M14 × 2	7GX	3101301100	2.5P	110	18	-	56	11	9	12	3	3
M14 × 2	ISO2X+100	3101501100	2.5P	110	18	-	56	11	9	12	3	3
M14 × 1.5	ISO2X	3101101102	2.5P	100	14	-	51	11	9	12	3	3
M16 × 2	ISO2X	3101101114	2.5P	110	18	-	56	12	9	12	3	3
M16 × 2	ISO3X	3101201114	2.5P	110	18	-	56	12	9	12	3	3
M16 × 2	7GX	3101301114	2.5P	110	18	-	56	12	9	12	3	3
M16 × 2	ISO2X+100	3101501114	2.5P	110	18	-	56	12	9	12	3	3
M16 × 1.5	ISO2X	3101101116	2.5P	100	14	-	51	12	9	12	3	3
M18 × 2.5	ISO2X	3101101128	2.5P	125	20	-	64	14	11	14	4	3
M18 × 1.5	ISO2X	3101101130	2.5P	110	14	-	56	14	11	14	3	3
M20 × 2.5	ISO2X	3101101141	2.5P	140	20	-	71	16	12	15	4	3
M20 × 1.5	ISO2X	3101101144	2.5P	125	14	-	64	16	12	15	3	3
M22 × 2.5	ISO2X	3101101156	2.5P	140	20	-	71	18	14.5	17	4	3
M22 × 1.5	ISO2X	3101101158	2.5P	125	14	-	64	18	14.5	17	3	3
M24 × 3	ISO2X	3101101167	2.5P	160	25	-	82	18	14.5	17	4	3
M24 × 1.5	ISO2X	3101101170	2.5P	140	18	-	71	18	14.5	17	3	3
For Unified Threads												
No.5-40UNC	2BX	3101103021	2.5P	56	5	18	34	3.5	2.7	6	2	1
No.5-44UNF	2BX	3101103022	2.5P	56	5	18	34	3.5	2.7	6	2	1
No.6-32UNC	2BX	3101103023	2.5P	56	7	19	32	4	3	6	2	1
No.6-40UNF	2BX	3101103024	2.5P	56	7	19	32	4	3	6	2	1

1	DIN	Spiral Fluted Taps (for blind hole)	1
2		Spiral Fluted Taps (for through hole)	2
3		Spiral Pointed Taps (for through hole)	3
4		Hand Taps	4
5		Cemented Carbide Taps	5
6		Roll Taps	6
7		Special Thread Taps Simple Inspection Tools	7
8		Pipe Taps	8
9		Thread Mills Premium Thread Mills	9
10		Dies	10
11		Center Drills Centering Tools	11
12		Precision Machinery/ Medical Surgical Instruments	12

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

DIN

VUSP Z-PRO Coated Spiral Fluted Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE
No.8-32UNC	2BX	3101103029	2.5P	63	7	21	38	4.5	3.4	6	2	1
No.8-36UNF	2BX	3101103030	2.5P	63	7	21	38	4.5	3.4	6	2	1
No.10-24UNC	2BX	3101103039	2.5P	70	9	24	39	6	4.9	8	2	1
No.10-32UNF	2BX	3101103041	2.5P	70	9	24	39	6	4.9	8	2	1
No.12-24UNC	2BX	3101103047	2.5P	80	9	28	45	6	4.9	8	2	1
No.12-28UNF	2BX	3101103048	2.5P	80	9	28	45	6	4.9	8	2	1
1/4-20UNC	2BX	3101103058	2.5P	80	11	30	42	7	5.5	8	2	1
1/4-28UNF	2BX	3101103062	2.5P	80	11	30	42	7	5.5	8	2	1
5/16-18UNC	2BX	3101103071	2.5P	90	12	35	47	8	6.2	9	3	2
3/8-16UNC	2BX	3101103082	2.5P	100	13	39	54	9	7	10	3	2
7/16-14UNC	2BX	3101103098	2.5P	100	13	-	51	8	6.2	9	3	3
1/2-13UNC	2BX	3101103111	2.5P	110	15	-	56	9	7	10	3	3
9/16-12UNC	2BX	3101103126	2.5P	110	18	-	56	11	9	12	3	3
5/8-11UNC	2BX	3101103138	2.5P	110	18	-	56	12	9	12	3	3

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(for blind hole)

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Premium Thread Mills

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DIN

①-13

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