

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
- 10 Dies
- 11 Center Drills (Centering Tools)



Z-PRO VUSP



Z-PRO Spiral Fluted Taps, Coated

Specification



Recommended Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼 10~20 (m/min)	Medium carbon steels 中炭素鋼 10~25 (m/min)	High carbon steels 高炭素鋼 10~25 (m/min)	Alloy steels 合金鋼 10~20 (m/min)	Stainless steels ステンレス鋼 5~10 (m/min)
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For icon explanation, refer to icon-1

Product Features

- 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 oil.

Tapping Data

Tapping conditions [M8×1.25]

Work Material	SUS304
Tapping Speed	10m/min
Machine	Machining center, vertical type
Tapping Fluid	Water-soluble cutting oil

Good tapping

The unique cutting edge shape and the long overall-length tap prevent chips from interfering with the holder. They also ensure a good supply of water-soluble oil.

Good internal thread

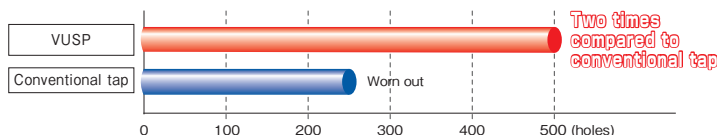
In tapping of SUS304, good internal thread surface is obtained even in tapping environments that use water-soluble oil.

Tapping conditions [M3×0.5]

Work Material	S50C
Tapping Length	4.5mm
Tapping Speed	20m/min
Machine	Machining center, vertical type
Tapping Fluid	Water-soluble cutting oil



Close-up of VUSP after Tapping of 250 Holes



●Compatible with a wide range of work materials

This is compatible with a wide range of steel work materials including general structural steel, carbon steel, and alloy steel.

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

1

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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

⑨

Dies

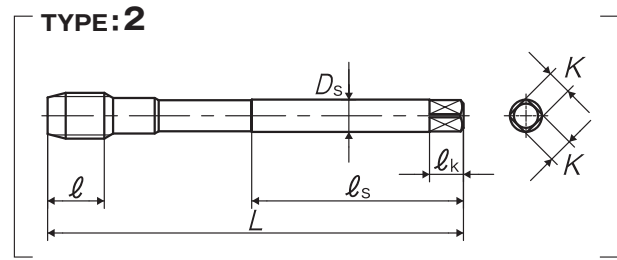
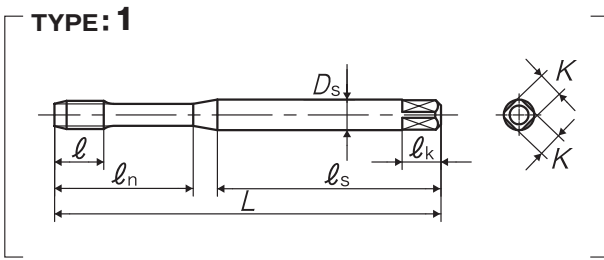
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Center Drills
Centering Tools

⑪

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①-2



Oversize

Segment : 1D

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													
M3 × 0.5	P2	1101101035	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900
M3 × 0.5	P3	1101201035	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900
M3 × 0.5	P4	1101301035	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900 [*]
M3 × 0.35	P2	1101101036	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070
M3 × 0.35	P3	1101201036	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070 [*]
M3 × 0.35	P4	1101301036	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070 [*]
M4 × 0.7	P2	1101101042	2.5P	63	7	21	36	5	4	7	3	1	¥ 2,850
M4 × 0.7	P3	1101201042	2.5P	63	7	21	36	5	4	7	3	1	¥ 2,850
M4 × 0.7	P4	1101301042	2.5P	63	7	21	36	5	4	7	3	1	¥ 2,850 [*]
M4 × 0.5	P2	1101101043	2.5P	63	5	21	36	5	4	7	3	1	¥ 3,560
M4 × 0.5	P3	1101201043	2.5P	63	5	21	36	5	4	7	3	1	¥ 3,560 [*]
M4 × 0.5	P4	1101301043	2.5P	63	5	21	36	5	4	7	3	1	¥ 3,560 [*]
M5 × 0.8	P2	1101101049	2.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880
M5 × 0.8	P3	1101201049	2.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880
M5 × 0.8	P4	1101301049	2.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880 [*]
M5 × 0.5	P2	1101101051	2.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690
M5 × 0.5	P3	1101201051	2.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690 [*]
M5 × 0.5	P4	1101301051	2.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690 [*]
M6 × 1	P2	1101101055	2.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180
M6 × 1	P3	1101201055	2.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180
M6 × 1	P4	1101301055	2.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180 [*]
M6 × 0.75	P2	1101101056	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190
M6 × 0.75	P3	1101201056	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190 [*]
M6 × 0.75	P4	1101301056	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190 [*]
M6 × 0.5	P2	1101101057	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190
M6 × 0.5	P3	1101201057	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190 [*]
M6 × 0.5	P4	1101301057	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190 [*]
M8 × 1.25	P3	1101101064	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190
M8 × 1.25	P4	1101201064	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190
M8 × 1.25	P5	1101301064	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190 [*]
M8 × 1	P3	1101101065	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950
M8 × 1	P4	1101201065	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950 [*]
M8 × 1	P5	1101301065	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950 [*]
M10 × 1.5	P3	1101101078	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.5	P4	1101201078	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.5	P5	1101301078	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290 [*]
M10 × 1.25	P3	1101101079	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.25	P4	1101201079	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.25	P5	1101301079	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290 [*]
M10 × 1	P3	1101101080	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280

* = Specified Distribution Items. Made to order products.
For improvement, spec may change without advance notice.

Think threads with
YAMAWA

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

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VUSP Z-PRO Spiral Fluted Taps, Coated

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M10 × 1	P4	1101201080	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280 [*]
M10 × 1	P5	1101301080	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280 [*]
M12 × 1.75	P4	1101101088	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.75	P5	1101201088	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.75	P6	1101301088	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900 [*]
M12 × 1.5	P3	1101101089	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.5	P4	1101201089	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.5	P5	1101301089	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900 [*]
M12 × 1.25	P3	1101101090	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.25	P4	1101201090	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.25	P5	1101301090	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900 [*]
M14 × 2	P4	1101101100	2.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 2	P5	1101201100	2.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 2	P6	1101301100	2.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450 [*]
M14 × 1.5	P3	1101101102	2.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 1.5	P4	1101201102	2.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 1.5	P5	1101301102	2.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450 [*]
M16 × 2	P4	1101101114	2.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 2	P5	1101201114	2.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 2	P6	1101301114	2.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300 [*]
M16 × 1.5	P3	1101101116	2.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 1.5	P4	1101201116	2.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 1.5	P5	1101301116	2.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300 [*]

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1-3



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