

1 Spiral Fluted Tap Series for blind hole

Overall length	Thread length	Thread + Neck length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_n	Ds	K	ℓ_k

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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

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ZELX FR

Spiral Fluted Taps for High Speed Tapping



Specification



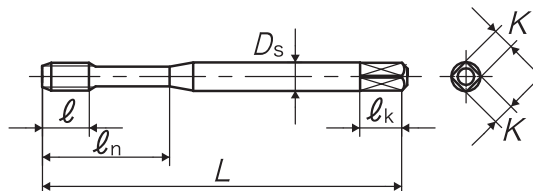
■ Spiral fluted tap applicable for such high speed tapping as 15m/min to 25m/min. Under low tapping speed, poor chip shape and poor chip ejection may occur and cause tapping troubles.

Tapping Speed depending on Materials

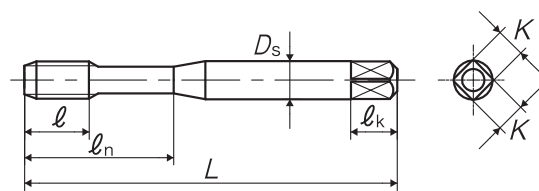
Low carbon steels
低炭素鋼
15~25
(m/min)

Medium carbon steels
中炭素鋼
15~25
(m/min)

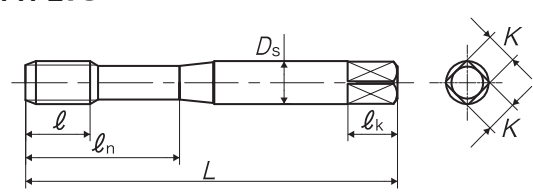
TYPE:1



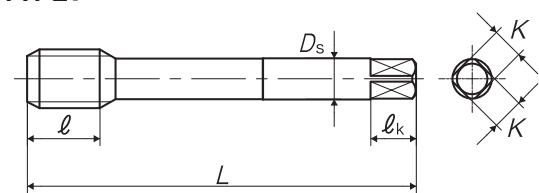
TYPE:2



TYPE:3



TYPE:4



Segment : 1D

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓ_n (inch)	Ds (inch)	K (inch)	ℓ_k (inch)	No. of flutes	TYPE
For Unified Threads											
No.4-40UNC	GH2	Y84401	2.5P	1.875	0.236	0.562	0.141	0.11	0.187	3	1
No.5-40UNC	GH2	Y84403	2.5P	1.937	0.236	0.625	0.141	0.11	0.187	3	1
No.6-32UNC	GH3	Y84405	2.5P	2	0.276	0.687	0.141	0.11	0.187	3	1
No.8-32UNC	GH3	Y84407	2.5P	2.125	0.276	0.75	0.168	0.131	0.25	3	1
No.10-24UNC	GH3	Y84409	2.5P	2.375	0.354	0.875	0.194	0.152	0.25	3	1
No.10-32UNF	GH3	Y84410	2.5P	2.375	0.276	0.875	0.194	0.152	0.25	3	1
1/4-20UNC	GH3	Y84413	2.5P	2.5	0.433	1	0.255	0.191	0.312	3	2
1/4-28UNF	GH3	Y84414	2.5P	2.5	0.354	1	0.255	0.191	0.312	3	2
5/16-18UNC	GH3	Y84415	2.5P	2.718	0.472	1.125	0.318	0.238	0.375	3	3
5/16-24UNF	GH3	Y84416	2.5P	2.718	0.394	1.125	0.318	0.238	0.375	3	3
3/8-16UNC	GH3	Y84417	2.5P	2.937	0.551	1.25	0.381	0.286	0.437	3	3
3/8-24UNF	GH3	Y84418	2.5P	2.937	0.394	1.25	0.381	0.286	0.437	3	3
7/16-14UNC	GH3	Y84419	2.5P	3.156	0.591	-	0.323	0.242	0.406	3	4
7/16-20UNF	GH3	Y84420	2.5P	3.156	0.472	-	0.323	0.242	0.406	3	4
1/2-13UNC	GH3	Y84421	2.5P	3.375	0.63	-	0.367	0.275	0.437	3	4
1/2-20UNF	GH3	Y84422	2.5P	3.375	0.472	-	0.367	0.275	0.437	3	4
5/8-11UNC	GH3	Y84425	2.5P	3.812	0.748	-	0.48	0.36	0.562	3	4

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Think threads with
YAMAWA

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

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L	ℓ	ℓn	Ds	K	ℓk

Size	Class	Code	Chamfer	L (inch)	ℓ (inch)	ℓn (inch)	Ds (inch)	K (inch)	ℓk (inch)	No. of flutes	TYPE
5/8-18UNF	GH3	Y84426	2.5P	3.812	0.512	-	0.48	0.36	0.562	3	4
3/4-10UNC	GH3	Y84427	2.5P	4.25	0.827	-	0.59	0.442	0.687	4	4
3/4-16UNF	GH3	Y84428	2.5P	4.25	0.591	-	0.59	0.442	0.687	4	4

1

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(for blind hole) ①Spiral Fluted Taps
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(for through hole) ③

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Cemented
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Thread Mills
Premium Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

ANSI

①-192