

Overall length	Chamfer+ full thread	Thread length	Thread+Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓt	ℓ	ℓn	ℓs	Ds	K	ℓk

SP OX

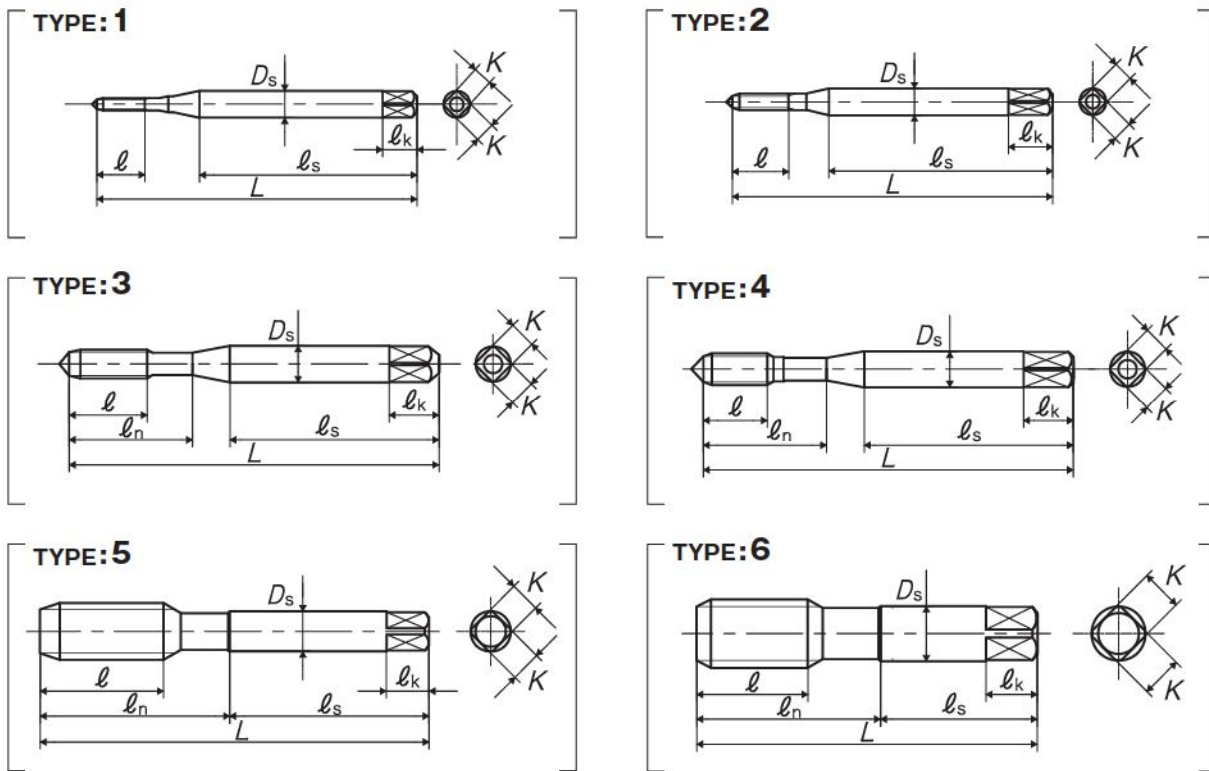
Spiral Fluted Taps, Oxided
Specification



Recommended Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼
5~10 (m/min)	5~10 (m/min)

For icon explanation, refer to P.24



○ Oversize

Segment : 1C

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Metric Threads													
M1.4 × 0.3	P1	SPP1.4CX	2.5P	36	5.4	-	24	3	2.5	5	2	1	△
M1.6 × 0.35	P1	SPP1.6DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	△
M1.7 × 0.35	P1	SPP1.7DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	△
M2 × 0.4	P1	SPP2.0EX	2.5P	42	7.2	12	27	3	2.5	5	2	3	△
M2.5 × 0.45	P1	SPP2.5FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
M2.6 × 0.45	P1	SPP2.6FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
M3 × 0.5	P1	SPP3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	◎
	P2	SPQ3.0GX											△
	P3	SPR3.0GX											△
3M0.6	P1	SPP3.0HX	2.5P	46	9	14	26	4	3.2	6	3	3	△
M3.5 × 0.6	P1	SPP3.5HX	2.5P	52	11	16	29	5	4	7	3	3	△

◎=Standard ○=Semi standard △=Made to order
For improvement, spec may change without advance notice.

Think threads with
YAMAWA

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

Center Drills

Centering Tools

Centering Tools

SP-16

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Spiral Fluted Tap Series for blind hole

SP OX Spiral Fluted Taps, Oxidized

Spiral Fluted Taps (for blind hole)	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
	M4 × 0.7	P2	SPQ4.0IX	2.5P	52	11	17	29	5	4	7	3	3	⊙
		P3	SPR4.0IX											△
		P4	SPS4.0IX											△
M4 × 0.5	P1	SPP4.0GX	2.5P	52	9	17	29	5	4	7	3	4	△	
M4.5 × 0.5	P1	SPP4.5GX	2.5P	60	9	21	33	5.5	4.5	7	3	4	△	
Spiral Fluted Taps (for through hole)	M5 × 0.8	P2	SPQ5.0KX	2.5P	60	13	22	33	5.5	4.5	7	3	3	⊙
		P3	SPR5.0KX											△
		P4	SPS5.0KX											△
Spiral Pointed Taps (for through hole)	M6 × 1	P2	SPQ6.0MX	2.5P	62	15	26	33	6	4.5	7	3	3	⊙
		P3	SPR6.0MX											△
		P4	SPS6.0MX											△
Hand Taps	M6 × 0.75	P2	SPQ6.0JX	2.5P	62	15	26	33	6	4.5	7	3	3	△
	M7 × 1	P2	SPQ7.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	△
	M8 × 1.25	P2	SPQ8.0NX	2.5P	70	19	-	36	6.2	5	8	3	5	⊙
P3		SPR8.0NX	△											
P4		SPS8.0NX	△											
Cemented Carbide Taps	M8 × 1	P2	SPQ8.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	△
	M10 × 1.5	P2	SPQ0100X	2.5P	75	23	-	38	7	5.5	8	3	5	⊙
	M10 × 1.25	P2	SPQ010NX	2.5P	75	23	-	38	7	5.5	8	3	5	△
P3		SPR010NX	△											
Roll Taps		M10 × 1	P2	SPQ010MX	2.5P	75	23	-	38	7	5.5	8	3	5
	M12 × 1.75	P2	SPQ012PX	2.5P	82	26	-	42	8.5	6.5	9	3	5	⊙
	M12 × 1.5	P2	SPQ0120X	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
Special Thread Taps Simple Inspection Tools	M12 × 1.25	P2	SPQ012NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
	M12 × 1	P2	SPQ012MX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
	Pipe Taps	M14 × 2	P2	SPQ014QX	2.5P	88	26	-	45	10.5	8	11	3	5
M14 × 1.5		P2	SPQ0140X	2.5P	88	26	-	45	10.5	8	11	3	5	△
M14 × 1		P2	SPQ014MX	2.5P	88	26	-	45	10.5	8	11	3	5	△
Thread Mills	M16 × 2	P2	SPQ016QX	2.5P	95	26	-	48	12.5	10	13	3	5	⊙
	M16 × 1.5	P2	SPQ0160X	2.5P	95	26	-	48	12.5	10	13	4	5	△
	Dies	M18 × 2.5	P3	SPR018RX	2.5P	100	33	-	51	14	11	14	4	5
M18 × 1.5		P2	SPQ0180X	2.5P	100	33	-	51	14	11	14	4	5	△
Center Drills		M20 × 2.5	P3	SPR020RX	2.5P	105	33	-	50	15	12	15	4	6
	M20 × 1.5	P3	SPR0200X	2.5P	105	33	-	50	15	12	15	4	6	△
	Centering Tools	M22 × 2.5	P3	SPR022RX	2.5P	115	33	-	55	17	13	16	4	6
M22 × 1.5		P3	SPR0220X	2.5P	115	33	-	55	17	13	16	4	6	△
For Unified Threads		M24 × 3	P3	SPR024SX	2.5P	120	39	-	55	19	15	18	4	6
	M24 × 1.5	P3	SPR0240X	2.5P	120	39	-	55	19	15	18	4	6	△
	M27 × 3	P3	SPR027SX	2.5P	130	39	-	60	20	15	18	4	6	△
Centering Tools	M30 × 3.5	P4	SPS030TX	2.5P	135	46	-	62	23	17	20	4	6	△
	M30 × 1.5	P3	SPR0300X	2.5P	135	46	-	62	23	17	20	4	6	△
	For Unified Threads	M33 × 3.5	P4	SPS033TX	2.5P	145	46	-	67	25	19	22	4	6
M36 × 4		P4	SPS036UX	2.5P	155	52	-	71	28	21	24	4	6	△
For Unified Threads														
Centering Tools	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
	No.2-56UNC	P1	SPPUN2EX	2.5P	42	8.1	12	27	3	2.5	5	2	3	△
	No.4-40UNC	P1	SPPUN4HX	2.5P	46	9	14	26	4	3.2	6	2	3	△
	No.5-40UNC	P1	SPPUN5HX	2.5P	52	11	16	29	5	4	7	3	3	△
	No.6-32UNC	P2	SPQUN6JX	2.5P	52	11	16	29	5	4	7	3	3	△
No.8-32UNC	P2	SPQUN8JX	2.5P	60	13	21	33	5.5	4.5	7	3	3	△	

SP-17



Think threads with
 ⊙=Standard ○=Semi standard △=Made to order
 For improvement, spec may change without advance notice.

SP OX Spiral Fluted Taps, Oxidized

Overall length	Chamfer+ full thread	Thread length	Thread+Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓt	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	Stock
No.10-24UNC	P2	SPQUNAMX	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
No.10-32UNF	P2	SPQUNAJX	2.5P	60	13	22	33	5.5	4.5	7	3	3	△
1/4-20UNC	P2	SPQU04NX	2.5P	62	15	26	33	6	4.5	7	3	3	△
1/4-28UNF	P2	SPQU04KX	2.5P	62	15	26	33	6	4.5	7	3	3	△
5/16-18UNC	P2	SPQU050X	2.5P	70	19	-	36	6.2	5	8	3	5	△
5/16-24UNF	P2	SPQU05MX	2.5P	70	19	-	36	6.2	5	8	3	5	△
3/8-16UNC	P2	SPQU06PX	2.5P	75	23	-	38	7	5.5	8	3	5	△
3/8-24UNF	P2	SPQU06MX	2.5P	75	23	-	38	7	5.5	8	3	5	△
7/16-14UNC	P3	SPRU07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
7/16-20UNF	P2	SPQU07NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
1/2-13UNC	P2	SPRU08RX	2.5P	88	26	-	45	10.5	8	11	3	5	△
1/2-20UNF	P2	SPQU08NX	2.5P	88	26	-	45	10.5	8	11	3	5	△
5/8-11UNC	P3	SPRU10UX	2.5P	95	26	-	48	12.5	10	13	3	5	△
5/8-18UNF	P2	SPQU100X	2.5P	95	26	-	48	12.5	10	13	3	5	△
3/4-10UNC	P3	SPRU12VX	2.5P	105	33	-	50	15	12	15	4	6	△
3/4-16UNF	P3	SPRU12PX	2.5P	105	33	-	50	15	12	15	4	6	△
7/8-9UNC	P3	SPRU14WX	2.5P	115	33	-	55	17	13	16	4	6	△
7/8-14UNF	P3	SPRU14QX	2.5P	115	33	-	55	17	13	16	4	6	△
1 -8UNC	P3	SPRU16XX	2.5P	125	39	-	58	19	15	18	4	6	△
1 -12UNF	P3	SPRU16SX	2.5P	125	39	-	58	19	15	18	4	6	△
For Whitworth Threads													
Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
3/16W24	P2	SPQW03MX	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
1/4W20	P2	SPQW04NX	2.5P	62	15	26	33	6	4.5	7	3	3	△
5/16W18	P2	SPQW050X	2.5P	70	19	-	36	6.2	5	8	3	5	△
3/8W16	P2	SPQW06PX	2.5P	75	23	-	38	7	5.5	8	3	5	△
7/16W14	P3	SPRW07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
1/2W12	P3	SPRW08SX	2.5P	88	26	-	45	10.5	8	11	3	5	△
5/8W11	P3	SPRW10UX	2.5P	95	26	-	48	12.5	10	13	3	5	△
3/4W10	P3	SPRW12VX	2.5P	105	33	-	50	15	12	15	4	6	△
7/8W9	P3	SPRW14WX	2.5P	115	33	-	55	17	13	16	4	6	△
1 W8	P3	SPRW16XX	2.5P	125	39	-	58	19	15	18	4	6	△

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

+SP OX

Plus Series Spiral Fluted Taps, Oxidized

Specification



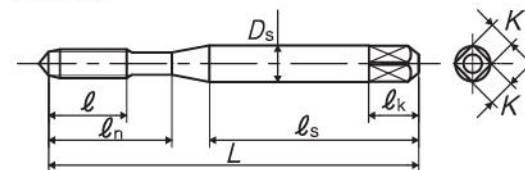
Recommended Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼	Medium carbon steels 中炭素鋼
10~15 (m/min)	10~15 (m/min)

For icon explanation, refer to P.24



TYPE: 1



Oversize Segment : 1C													
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	Stock
For Metric Threads													
M2 × 0.4	P1	SNPP2.0EX	2.5P	42	7.2	12	27	3	2.5	5	2	1	△
	P2	SNPQ2.0EX											
	P3	SNPR2.0EX											
	P4	SNPS2.0EX											
M2.5 × 0.45	P1	SNPP2.5FX	2.5P	46	8.1	14	29	3	2.5	5	2	1	△
	P2	SNPQ2.5FX											
	P3	SNPR2.5FX											
	P4	SNPS2.5FX											
M2.6 × 0.45	P1	SNPP2.6FX	2.5P	46	8.1	14	29	3	2.5	5	2	1	△
	P2	SNPQ2.6FX											
	P3	SNPR2.6FX											
	P4	SNPS2.6FX											
M3 × 0.5	P1	SNPP3.0GX	2.5P	46	9	14	26	4	3.2	6	3	1	△
	P2	SNPQ3.0GX											
	P3	SNPR3.0GX											
	P4	SNPS3.0GX											
M3.5 × 0.6	P1	SNPP3.5HX	2.5P	52	11	16	29	5	4	7	3	1	△
M4 × 0.7	P2	SNPQ4.0IX	2.5P	52	11	17	29	5	4	7	3	1	△
	P3	SNPR4.0IX											
	P4	SNPS4.0IX											
	P2	SNPQ5.0KX											
M5 × 0.8	P3	SNPR5.0KX	2.5P	60	13	22	33	5.5	4.5	7	3	1	△
	P4	SNPS5.0KX											
	P2	SNPQ6.0MX											
	P3	SNPR6.0MX											
M6 × 1	P4	SNPS6.0MX	2.5P	62	15	26	33	6	4.5	7	3	1	△
	P2	SNPQ6.0MX											