



PO

Spiral Pointed Taps

Specification

HSS

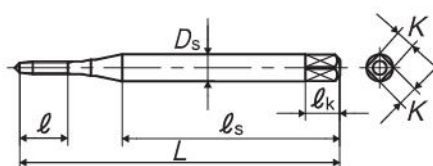


Recommended Tapping Speeds depending on Materials

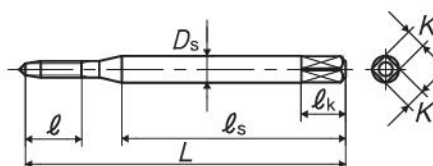
Medium carbon steels
中炭鋼
5~10
(m/min)

For icon explanation, refer to P.24

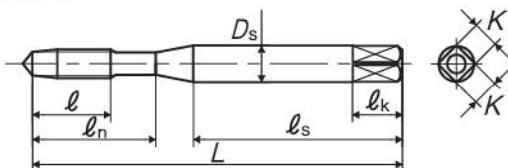
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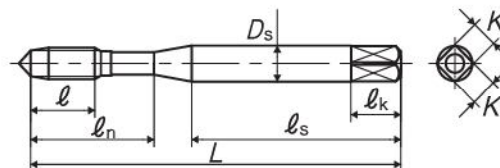
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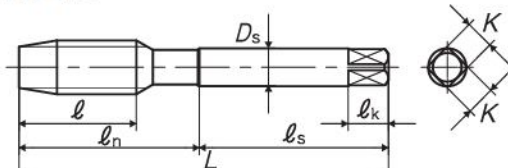
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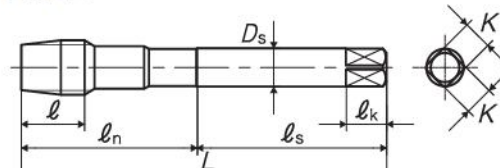
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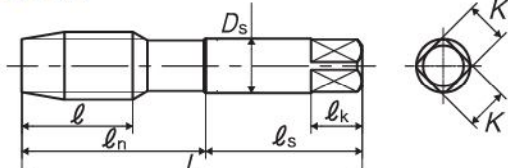
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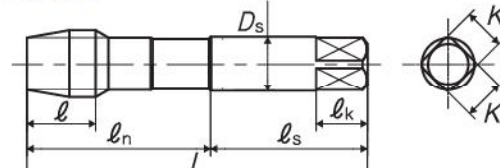
TYPE:6



TYPE:7



TYPE:8



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

PO Spiral Pointed Taps

Oversize
Segment : 1E

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													
M1.2 × 0.25	P1	POP1.2B	5P	36	4.5	-	24	3	2.5	5	2	1	○
M1.4 × 0.3	P1	POP1.4C	5P	36	5.4	-	24	3	2.5	5	2	1	⊙
	P2	POQ1.4C											○
	P3	POR1.4C											△
M1.6 × 0.35	P2	POQ1.6D	5P	36	6.3	-	24	3	2.5	5	2	2	⊙
	P3	POR1.6D											△
M1.7 × 0.35	P2	POQ1.7D	5P	36	6.3	-	24	3	2.5	5	2	2	⊙
	P3	POR1.7D											○
	P4	POS1.7D											△
M1.8 × 0.35	P2	POQ1.8D	5P	42	6.3	-	27	3	2.5	5	2	2	△
M2 × 0.4	P2	POQ2.0E	5P	42	7.2	12	27	3	2.5	5	3	3	⊙
	P3	POR2.0E											○
	P4	POS2.0E											△
M2 × 0.25	P1	POP2.0B	5P	42	4.5	12	27	3	2.5	5	3	4	△
M2.2 × 0.45	P2	POQ2.2F	5P	42	8.1	12	27	3	2.5	5	3	3	○
M2.2 × 0.25	P2	POQ2.2B	5P	42	4.5	12	27	3	2.5	5	3	4	△
M2.3 × 0.4	P2	POQ2.3E	5P	42	7.2	12	27	3	2.5	5	3	3	○
	P3	POR2.3E											△
	P4	POS2.3E											△
M2.5 × 0.45	P2	POQ2.5F	5P	46	8.1	14	29	3	2.5	5	3	3	⊙
	P3	POR2.5F											○
	P4	POS2.5F											△
M2.5 × 0.35	P2	POQ2.5D	5P	46	6.3	14	29	3	2.5	5	3	4	△
M2.6 × 0.45	P2	POQ2.6F	5P	46	8.1	14	29	3	2.5	5	3	3	⊙
	P3	POR2.6F											○
	P4	POS2.6F											△
M2.6 × 0.35	P2	POQ2.6D	5P	46	6.3	14	29	3	2.5	5	3	4	△
M3 × 0.5	P2	POQ3.0G	5P	46	9	14	26	4	3.2	6	3	3	⊙
	P3	POR3.0G											○
	P4	POS3.0G											△
3M0.6	P2	POQ3.0H	5P	46	9	14	26	4	3.2	6	3	3	△
M3 × 0.35	P2	POQ3.0D	5P	46	6.5	14	26	4	3.2	6	3	4	△
M3.5 × 0.6	P2	POQ3.5H	5P	52	11	16	29	5	4	7	3	3	○
	P3	POR3.5H											△
	P4	POS3.5H											△
M3.5 × 0.35	P2	POQ3.5D	5P	52	6.5	16	29	5	4	7	3	4	△
M4 × 0.7	P2	POQ4.0I	5P	52	11	17	29	5	4	7	3	3	⊙
	P3	POR4.0I											○
	P4	POS4.0I											△
4M0.75	P2	POQ4.0J	5P	52	11	17	29	5	4	7	3	3	△
M4 × 0.5	P2	POQ4.0G	5P	52	9	17	29	5	4	7	3	4	○
M4.5 × 0.75	P2	POQ4.5J	5P	60	13	21	33	5.5	4.5	7	3	3	△
M4.5 × 0.5	P2	POQ4.5G	5P	60	9	21	33	5.5	4.5	7	3	4	△
M5 × 0.8	P2	POQ5.0K	5P	60	13	22	33	5.5	4.5	7	3	3	⊙
	P3	POR5.0K											○
	P4	POS5.0K											△
5M0.9	P2	POQ5.0L	5P	60	13	22	33	5.5	4.5	7	3	3	△

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

PO Spiral Pointed Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M5 × 0.5	P2	POQ5.0G	5P	60	9	22	33	5.5	4.5	7	3	4	○
	M5.5 × 0.9	P2	POQ5.5L	5P	62	15	26	33	6	4.5	7	3	3	△
	M5.5 × 0.5	P2	POQ5.5G	5P	62	9	26	33	6	4.5	7	3	4	△
Spiral Fluted Taps (for through hole)	M6 × 1	P2	POQ6.0M	5P	62	15	26	33	6	4.5	7	3	3	◎
		P3	POR6.0M											○
		P4	POS6.0M											○
Spiral Pointed Taps (for through hole)	M6 × 0.75	P2	POQ6.0J	5P	62	15	26	33	6	4.5	7	3	3	○
		P3	POR6.0J											△
	M6 × 0.5	P2	POQ6.0G	5P	62	9	26	33	6	4.5	7	3	4	△
Hand Taps	M7 × 1	P2	POQ7.0M	5P	70	19	-	36	6.2	5	8	3	5	○
		P3	POR7.0M											△
	M7 × 0.75	P2	POQ7.0J	5P	70	19	-	36	6.2	5	8	3	5	△
Cemented Carbide Taps	M7 × 0.5	P2	POQ7.0G	5P	70	10	-	36	6.2	5	8	3	6	△
		P3	POR8.0N											◎
	M8 × 1.25	P4	POS8.0N	5P	70	19	-	36	6.2	5	8	3	5	○
Roll Taps	M8 × 1	P3	POR8.0M	5P	70	19	-	36	6.2	5	8	3	5	○
		P4	POS8.0M											△
	M8 × 0.75	P3	POR8.0J	5P	70	19	-	36	6.2	5	8	3	5	○
Special Thread Taps Simple Inspection Tools	M8 × 0.5	P2	POQ8.0G	5P	70	10	-	36	6.2	5	8	3	6	△
	M9 × 1.25	P3	POR9.0N	5P	75	23	-	38	7	5.5	8	3	5	△
	M9 × 1	P3	POR9.0M	5P	75	23	-	38	7	5.5	8	3	5	△
Pipe Taps	M9 × 0.75	P3	POR9.0J	5P	75	13	-	38	7	5.5	8	3	6	△
	M9 × 0.5	P2	POQ9.0G	5P	75	11	-	38	7	5.5	8	3	6	△
	Thread Mills	M10 × 1.5	P3	POR0100	5P	75	23	-	38	7	5.5	8	3	5
P4			POS0100	○										
Dies	M10 × 1.25	P3	POR010N	5P	75	23	-	38	7	5.5	8	3	5	◎
		P4	POS010N											△
	M10 × 1	P3	POR010M	5P	75	23	-	38	7	5.5	8	3	5	○
Center Drills	M10 × 0.75	P3	POR010J	5P	75	13	-	38	7	5.5	8	3	6	△
		P2	POQ010G											△
	M10 × 0.5	P2	POQ010G	5P	75	11	-	38	7	5.5	8	3	6	△
Centering Tools	M11 × 1.5	P4	POS0110	5P	82	26	-	42	8.5	6.5	9	3	5	△
	M11 × 1.25	P3	POR011N	5P	82	26	-	42	8.5	6.5	9	3	5	△
	M11 × 1	P3	POR011M	5P	82	26	-	42	8.5	6.5	9	3	5	△
	M11 × 0.75	P3	POR011J	5P	82	14	-	42	8.5	6.5	9	3	6	△
		P2	POQ011G											△
	M11 × 0.5	P2	POQ011G	5P	82	12	-	42	8.5	6.5	9	3	6	△
	M12 × 1.75	P4	POS012P	5P	82	26	-	42	8.5	6.5	9	3	5	◎
		P5	POT012P											△
	Center Drills	M12 × 1.5	P3	POR0120	5P	82	26	-	42	8.5	6.5	9	3	5
P4			POS0120	△										
P5			POT0120	△										
Centering Tools	M12 × 1.25	P4	POS012N	5P	82	26	-	42	8.5	6.5	9	3	5	○
		P5	POT012N											△
	M12 × 1	P3	POR012M	5P	82	26	-	42	8.5	6.5	9	3	5	○
	M12 × 0.75	P3	POR012J	5P	82	14	-	42	8.5	6.5	9	3	6	△
		P4	POS012M											△
	M12 × 0.5	P2	POQ012G	5P	82	12	-	42	8.5	6.5	9	3	6	△
	M13 × 1.5	P3	POR0130	5P	88	26	-	45	10.5	8	11	3	5	△
	M13 × 1	P3	POR013M	5P	88	26	-	45	10.5	8	11	3	5	△

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

PO Spiral Pointed Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M14 × 2	P4	POS014Q	5P	88	26	-	45	10.5	8	11	3	5	○
	P5	POT014Q											△
M14 × 1.5	P3	POR014O	5P	88	26	-	45	10.5	8	11	3	5	○
	P4	POS014O											△
	P5	POT014O											△
M14 × 1.25	P3	POR014N	5P	88	26	-	45	10.5	8	11	3	5	△
M14 × 1	P3	POR014M	5P	88	26	-	45	10.5	8	11	3	5	○
M14 × 0.75	P3	POR014J	5P	88	15	-	45	10.5	8	11	3	6	△
M15 × 2	P4	POS015Q	5P	95	26	-	48	12.5	10	13	3	5	△
M15 × 1.5	P3	POR015O	5P	95	26	-	48	12.5	10	13	3	5	△
M15 × 1	P3	POR015M	5P	95	26	-	48	12.5	10	13	3	5	△
M16 × 2	P4	POS016Q	5P	95	26	-	48	12.5	10	13	3	5	◎
	P5	POT016Q											△
M16 × 1.5	P3	POR016O	5P	95	26	-	48	12.5	10	13	3	5	○
	P4	POS016O											△
	P5	POT016O											△
M16 × 1	P3	POR016M	5P	95	26	-	48	12.5	10	13	3	5	○
M18 × 2.5	P4	POS018R	5P	100	33	-	51	14	11	14	3	5	○
	P5	POT018R											△
M18 × 2	P4	POS018Q	5P	100	33	-	51	14	11	14	3	5	△
M18 × 1.5	P4	POS018O	5P	100	33	-	51	14	11	14	3	5	○
	P5	POT018O											△
M18 × 1	P3	POR018M	5P	100	18	-	51	14	11	14	3	6	○
M20 × 2.5	P4	POS020R	5P	105	33	-	50	15	12	15	3	7	◎
	P5	POT020R											△
M20 × 2	P4	POS020Q	5P	105	33	-	50	15	12	15	3	7	△
M20 × 1.5	P4	POS020O	5P	105	33	-	50	15	12	15	3	7	○
	P5	POT020O											△
M20 × 1	P3	POR020M	5P	105	18	-	50	15	12	15	3	8	○
M22 × 2.5	P4	POS022R	5P	115	33	-	55	17	13	16	3	7	○
	P5	POT022R											△
M22 × 2	P4	POS022Q	5P	115	33	-	55	17	13	16	3	7	△
M22 × 1.5	P4	POS022O	5P	115	33	-	55	17	13	16	3	7	○
	P5	POT022O											△
M22 × 1	P3	POR022M	5P	115	19	-	55	17	13	16	3	8	△
M24 × 3	P4	POS024S	5P	120	39	-	55	19	15	18	3	7	◎
	P5	POT024S											△
M24 × 2	P4	POS024Q	5P	120	39	-	55	19	15	18	3	7	○
M24 × 1.5	P4	POS024O	5P	120	39	-	55	19	15	18	3	7	○
	P5	POT024O											△
M24 × 1	P3	POR024M	5P	120	19	-	55	19	15	18	3	8	△
M25 × 2	P4	POS025Q	5P	125	39	-	58	19	15	18	3	7	△
M25 × 1.5	P4	POS025O	5P	125	39	-	58	19	15	18	3	7	○
M26 × 2	P4	POS026Q	5P	130	39	-	60	20	15	18	4	7	△
M26 × 1.5	P4	POS026O	5P	130	39	-	60	20	15	18	4	7	○
M26 × 1	P3	POR026M	5P	130	20	-	60	20	15	18	4	8	△
M27 × 3	P4	POS027S	5P	130	39	-	60	20	15	18	4	7	○
M27 × 1.5	P4	POS027O	5P	130	39	-	60	20	15	18	4	7	○
M27 × 1	P3	POR027M	5P	130	20	-	60	20	15	18	4	8	△
M28 × 2	P4	POS028Q	5P	135	46	-	62	23	17	20	4	7	△

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

Spiral Pointed Tap Series for through hole

PO Spiral Pointed Taps

	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Spiral Fluted Taps (for blind hole)	M28 × 1.5	P4	POS0280	5P	135	46	-	62	23	17	20	4	7	△
	M30 × 3.5	P5	POT030T	5P	135	46	-	62	23	17	20	4	7	○
	M30 × 3	P4	POS030S	5P	135	46	-	62	23	17	20	4	7	△
Spiral Fluted Taps (for through hole)	M30 × 2	P4	POS030Q	5P	135	46	-	62	23	17	20	4	7	○
	M30 × 1.5	P4	POS0300	5P	135	46	-	62	23	17	20	4	7	○
	M30 × 1	P3	POR030M	5P	135	21	-	62	23	17	20	4	8	△
Spiral Pointed Taps (for through hole)	M32 × 3	P4	POMS032S	5P	145	46	-	67	24	19	22	4	7	△
	M32 × 2	P4	POMS032Q	5P	145	46	-	67	24	19	22	4	7	△
	M32 × 1.5	P4	POMS0320	5P	145	46	-	67	24	19	22	4	7	△
Hand Taps	M33 × 3.5	P5	POMT033T	5P	145	46	-	67	25	19	22	4	7	○
	M33 × 3	P4	POMS033S	5P	145	46	-	67	25	19	22	4	7	△
	M33 × 2	P4	POMS033Q	5P	145	46	-	67	25	19	22	4	7	△
Cemented Carbide Taps	M33 × 1.5	P4	POMS0330	5P	145	46	-	67	25	19	22	4	7	△
	M35 × 2	P4	POMS035Q	5P	155	52	-	71	28	21	24	4	7	△
	M35 × 1.5	P4	POMS0350	5P	155	26	-	71	28	21	24	4	8	△
Roll Taps	M36 × 4	P5	POMT036U	5P	155	52	-	71	28	21	24	4	7	○
	M36 × 3	P4	POMS036S	5P	155	52	-	71	28	21	24	4	7	△
	M36 × 2	P4	POMS036Q	5P	155	52	-	71	28	21	24	4	7	△
Special Thread Taps Simple Inspection Tools	M36 × 1.5	P4	POMS0360	5P	155	26	-	71	28	21	24	4	8	△
	M38 × 2	P4	POMS038Q	5P	165	52	-	76	30	23	26	4	7	△
	M38 × 1.5	P4	POMS0380	5P	165	26	-	76	30	23	26	4	8	△
Pipe Taps	M39 × 4	P5	POMT039U	5P	165	52	-	76	30	23	26	4	7	△
	M39 × 2	P4	POMS039Q	5P	165	52	-	76	30	23	26	4	7	△
	M39 × 1.5	P4	POMS0390	5P	165	26	-	76	30	23	26	4	8	△
Thread Mills	M40 × 3	P4	POMS040S	5P	175	59	-	81	32	26	30	4	7	△
	M40 × 2	P4	POMS040Q	5P	175	59	-	81	32	26	30	4	7	△
	M40 × 1.5	P4	POMS0400	5P	175	27	-	81	32	26	30	4	8	△
Dies	M42 × 4.5	P5	POMT042V	5P	175	59	-	81	32	26	30	4	7	△
	M42 × 2	P4	POMS042Q	5P	175	59	-	81	32	26	30	4	7	△
	M42 × 1.5	P4	POMS0420	5P	175	27	-	81	32	26	30	4	8	△
Center Drills	M45 × 4.5	P5	POMT045V	5P	180	59	-	83	35	26	30	4	7	△
	M45 × 2	P4	POMS045Q	5P	180	59	-	83	35	26	30	4	7	△
	M45 × 1.5	P4	POMS0450	5P	180	27	-	83	35	26	30	4	8	△
Centering Tools	M48 × 5	P5	POMT048W	5P	185	65	-	85	38	29	32	4	7	△
	M48 × 3	P4	POMS048S	5P	185	65	-	85	38	29	32	4	7	△
	M48 × 1.5	P4	POMS0480	5P	185	28	-	85	38	29	32	4	8	△
For Unified Threads														
	Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
Centering Tools	No.0-80UNF	P1	POPUN0B	5P	36	6.3	-	24	3	2.5	5	2	2	△
	No.1-64UNC	P1	POPUN1D	5P	42	7.2	-	27	3	2.5	5	2	2	△
	No.1-72UNF	P1	POPUN1C	5P	42	7.2	-	27	3	2.5	5	2	2	△
Centering Tools	No.2-56UNC	P1	POPUN2E	5P	42	8.1	12	27	3	2.5	5	3	3	○
	No.2-64UNF	P1	POPUN2D	5P	42	8.1	12	27	3	2.5	5	3	3	△
	No.3-48UNC	P1	POPUN3F	5P	46	8.1	14	29	3	2.5	5	3	3	△
Centering Tools	No.3-56UNF	P1	POPUN3E	5P	46	8.1	14	29	3	2.5	5	3	3	△
	No.4-40UNC	P2	POQUN4H	5P	46	9	14	26	4	3.2	6	3	3	○
	No.4-48UNF	P1	POPUN4F	5P	46	9	14	26	4	3.2	6	3	3	△
Centering Tools	No.5-40UNC	P2	POQUN5H	5P	52	11	16	29	5	4	7	3	3	△
	No.5-44UNF	P1	POPUN5G	5P	52	11	16	29	5	4	7	3	3	△
	No.6-32UNC	P2	POQUN6J	5P	52	11	16	29	5	4	7	3	3	○

PO-7



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