

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 LH

Spiral Fluted Taps for Left Hand Threads

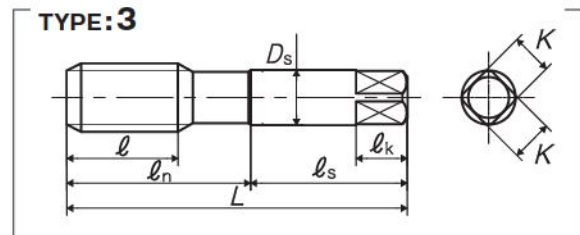
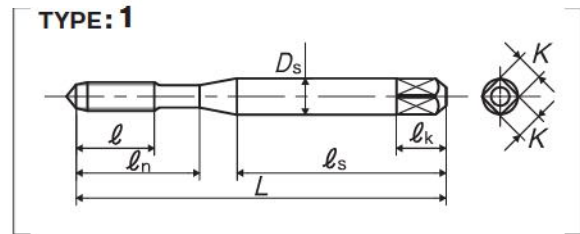
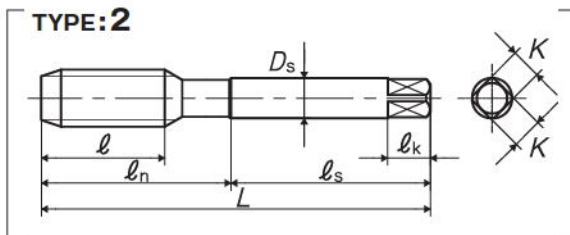
Specification



Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to P.24



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													
M2 × 0.4	P1	SPP2.0E--L	2.5P	42	7.2	12	27	3	2.5	5	2	1	△
M2.3 × 0.4	P1	SPP2.3E--L	2.5P	42	7.2	12	27	3	2.5	5	2	1	△
M2.5 × 0.45	P1	SPP2.5F--L	2.5P	46	8.1	14	29	3	2.5	5	2	1	△
M2.6 × 0.45	P1	SPP2.6F--L	2.5P	46	8.1	14	29	3	2.5	5	2	1	△
M3 × 0.5	P1	SPP3.0G--L	2.5P	46	9	14	26	4	3.2	6	3	1	○
M4 × 0.7	P2	SPQ4.0I--L	2.5P	52	11	17	29	5	4	7	3	1	○
M5 × 0.8	P2	SPQ5.0K--L	2.5P	60	13	22	33	5.5	4.5	7	3	1	○
M6 × 1	P2	SPQ6.0M--L	2.5P	62	15	26	33	6	4.5	7	3	1	○
M7 × 1	P2	SPQ7.0M--L	2.5P	70	19	-	36	6.2	5	8	3	2	△
M8 × 1.25	P2	SPQ8.0N--L	2.5P	70	19	-	36	6.2	5	8	3	2	○
M8 × 1	P2	SPQ8.0M--L	2.5P	70	19	-	36	6.2	5	8	3	2	△
M10 × 1.5	P2	SPQ0100--L	2.5P	75	23	-	38	7	5.5	8	3	2	○
M10 × 1.25	P2	SPQ010N--L	2.5P	75	23	-	38	7	5.5	8	3	2	○
M10 × 1	P2	SPQ010M--L	2.5P	75	23	-	38	7	5.5	8	3	2	△
M12 × 1.75	P2	SPQ012P--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	○
M12 × 1.5	P2	SPQ0120--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M12 × 1.25	P2	SPQ012N--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M12 × 1	P2	SPQ012M--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M14 × 2	P2	SPQ014Q--L	2.5P	88	26	-	45	10.5	8	11	3	2	△
M14 × 1.5	P2	SPQ0140--L	2.5P	88	26	-	45	10.5	8	11	3	2	△
M16 × 2	P2	SPQ016Q--L	2.5P	95	26	-	48	12.5	10	13	3	2	○
M16 × 1.5	P2	SPQ0160--L	2.5P	95	26	-	48	12.5	10	13	3	2	△
M18 × 2.5	P3	SPR018R--L	2.5P	100	33	-	51	14	11	14	4	2	△

○=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

SP-20