

SP

Spiral Fluted Taps Specification



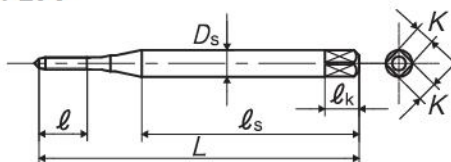
Recommended Tapping Speeds depending on Materials

Medium carbon steels
中炭鋼
5~10
(m/min)

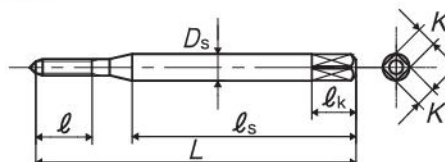
For icon explanation, refer to P.24



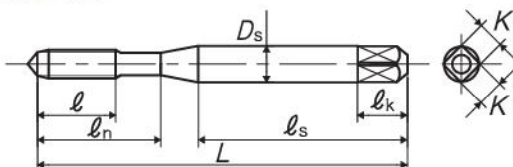
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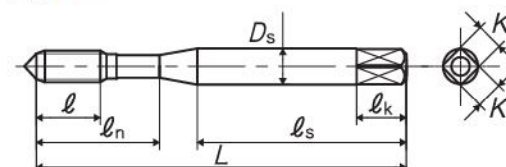
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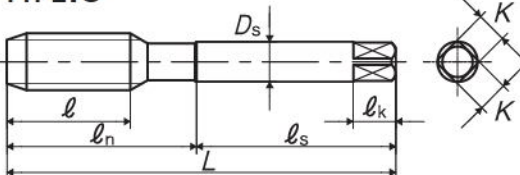
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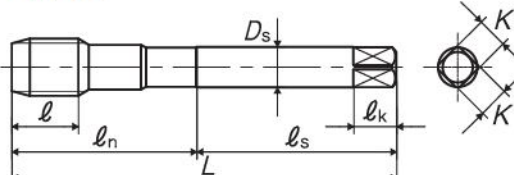
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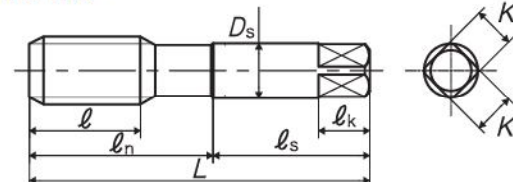
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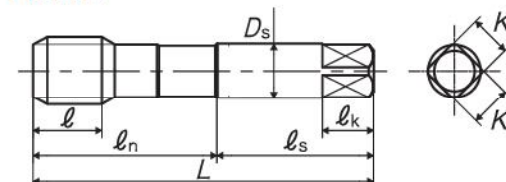
TYPE:6



TYPE:7



TYPE:8



Overall length	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 Spiral Fluted Taps

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													
M1.2 × 0.25	P1	SPP1.2B	2.5P	36	4.5	-	24	3	2.5	5	2	1	○
M1.4 × 0.3	P1	SPP1.4C	2.5P	36	5.4	-	24	3	2.5	5	2	1	◎
M1.6 × 0.35	P1	SPP1.6D	2.5P	36	6.3	-	24	3	2.5	5	2	2	◎
M1.7 × 0.35	P1	SPP1.7D	2.5P	36	6.3	-	24	3	2.5	5	2	2	◎
	P2	SPQ1.7D											○
	P3	SPR1.7D											△
M1.8 × 0.35	P1	SPP1.8D	2.5P	42	6.3	-	27	3	2.5	5	2	2	△
M2 × 0.4	P1	SPP2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	◎
	P2	SPQ2.0E											○
	P3	SPR2.0E											◎
	P4	SPS2.0E											△
M2 × 0.25	P1	SPP2.0B	2.5P	42	4.5	12	27	3	2.5	5	2	4	○
M2.2 × 0.45	P1	SPP2.2F	2.5P	42	8.1	12	27	3	2.5	5	2	3	○
	P3	SPR2.2F											△
M2.3 × 0.4	P1	SPP2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	○
	P2	SPQ2.3E											△
	P3	SPR2.3E											△
	P4	SPS2.3E											△
M2.3 × 0.25	P1	SPP2.3B	2.5P	42	4.5	12	27	3	2.5	5	2	4	△
M2.5 × 0.45	P1	SPP2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	◎
	P2	SPQ2.5F											○
	P3	SPR2.5F											○
	P4	SPS2.5F											○
M2.5 × 0.35	P1	SPP2.5D	2.5P	46	6.3	14	29	3	2.5	5	2	4	○
M2.6 × 0.45	P1	SPP2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	◎
	P2	SPQ2.6F											○
	P3	SPR2.6F											△
	P4	SPS2.6F											△
M2.6 × 0.35	P1	SPP2.6D	2.5P	46	6.3	14	29	3	2.5	5	2	4	△
M3 × 0.5	P1	SPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	◎
	P2	SPQ3.0G											○
	P3	SPR3.0G											○
	P4	SPS3.0G											○
3M0.6	P1	SPP3.0H	2.5P	46	9	14	26	4	3.2	6	3	3	△
M3 × 0.35	P1	SPP3.0D	2.5P	46	6.5	14	26	4	3.2	6	3	4	○
M3.5 × 0.6	P1	SPP3.5H	2.5P	52	11	16	29	5	4	7	3	3	○
	P2	SPQ3.5H											△
	P3	SPR3.5H											△
	P4	SPS3.5H											△
M3.5 × 0.35	P1	SPP3.5D	2.5P	52	6.5	16	29	5	4	7	3	4	△
M4 × 0.7	P2	SPQ4.0I	2.5P	52	11	17	29	5	4	7	3	3	◎
	P3	SPR4.0I											○
	P4	SPS4.0I											○
4M0.75	P2	SPQ4.0J	2.5P	52	11	17	29	5	4	7	3	3	○
M4 × 0.5	P1	SPP4.0G	2.5P	52	9	17	29	5	4	7	3	4	○
M4.5 × 0.75	P2	SPQ4.5J	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
M4.5 × 0.5	P1	SPP4.5G	2.5P	60	9	21	33	5.5	4.5	7	3	4	△
M5 × 0.8	P2	SPQ5.0K	2.5P	60	13	22	33	5.5	4.5	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

SP-4

Spiral Fluted Tap Series for blind hole

SP Spiral Fluted 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 × 0.8	P3	SPR5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	○	
		P4	SPS5.0K											○	
Spiral Fluted Taps (for through hole)	5M0.9	P2	SPQ5.0L	2.5P	60	13	22	33	5.5	4.5	7	3	3	△	
	M5 × 0.75	P2	SPQ5.0J	2.5P	60	13	22	33	5.5	4.5	7	3	3	△	
	M5 × 0.5	P1	SPP5.0G	2.5P	60	9	22	33	5.5	4.5	7	3	4	○	
	M5.5 × 0.9	P2	SPQ5.5L	2.5P	62	15	26	33	6	4.5	7	3	3	△	
	M5.5 × 0.5	P1	SPP5.5G	2.5P	62	9	26	33	6	4.5	7	3	4	△	
	Spiral Pointed Taps (for through hole)	M6 × 1	P2	SPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	◎
			SPQ6.0M-T												
P3			SPR6.0M	○											
P4			SPS6.0M												
Hand Taps	M6 × 0.75	P2	SPQ6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	○	
		P3	SPR6.0J											△	
Cemented Carbide Taps	M6 × 0.5	P1	SPP6.0G	2.5P	62	9	26	33	6	4.5	7	3	4	○	
		P2	SPQ6.0G											△	
		P3	SPR6.0G												
	Roll Taps	M7 × 1	P2	SPQ7.0M	2.5P	70	19	-	36	6.2	5	8	3	5	○
			P3	SPR7.0M											△
P4			SPS7.0M												
M7 × 0.75		P2	SPQ7.0J	2.5P	70	19	-	36	6.2	5	8	3	5	○	
M7 × 0.5	P2	SPQ7.0G	2.5P	70	10	-	36	6.2	5	8	3	6	△		
Special Thread Taps Simple Inspection Tools	M8 × 1.25	P2	SPQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	5	◎	
		P3	SPR8.0N											○	
		P4	SPS8.0N												
	M8 × 1	P2	SPQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	5	○	
		P3	SPR8.0M											△	
		P4	SPS8.0M												
Pipe Taps	M8 × 0.75	P2	SPQ8.0J	2.5P	70	19	-	36	6.2	5	8	3	5	○	
		P3	SPR8.0J											△	
	M8 × 0.5	P2	SPQ8.0G	2.5P	70	10	-	36	6.2	5	8	3	6	○	
	M9 × 1.25	P2	SPQ9.0N	2.5P	75	23	-	38	7	5.5	8	3	5	△	
Thread Mills	M9 × 1	P2	SPQ9.0M	2.5P	75	23	-	38	7	5.5	8	3	5	○	
	M9 × 0.75	P2	SPQ9.0J	2.5P	75	13	-	38	7	5.5	8	3	6	○	
	M9 × 0.5	P2	SPQ9.0G	2.5P	75	11	-	38	7	5.5	8	3	6	△	
	M10 × 1.5	P2	SPQ0100	2.5P	75	23	-	38	7	5.5	8	3	5	◎	
		P3	SPR0100											○	
		P4	SPS0100												
Dies	M10 × 1.25	P2	SPQ010N	2.5P	75	23	-	38	7	5.5	8	3	5	◎	
		P3	SPR010N											○	
		P4	SPS010N												
Center Drills	M10 × 1	P2	SPQ010M	2.5P	75	23	-	38	7	5.5	8	3	5	○	
		P3	SPR010M											△	
		P4	SPS010M												
	M10 × 0.75	P2	SPQ010J	2.5P	75	13	-	38	7	5.5	8	3	6	○	
Centering Tools	M10 × 0.5	P2	SPQ010G	2.5P	75	11	-	38	7	5.5	8	3	6	△	
	M11 × 1.5	P2	SPQ0110	2.5P	82	26	-	42	8.5	6.5	9	3	5	△	
	M11 × 1.25	P2	SPQ011N	2.5P	82	26	-	42	8.5	6.5	9	3	5	△	
	M11 × 1	P2	SPQ011M	2.5P	82	26	-	42	8.5	6.5	9	3	5	△	
	M11 × 0.75	P2	SPQ011J	2.5P	82	14	-	42	8.5	6.5	9	3	6	△	
	M12 × 1.75	P2	SPQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	5	◎	

※External center is removed

SP-5

Think threads with
YAMAWA

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

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 Spiral Fluted Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M12 × 1.75	P3	SPR012P	2.5P	82	26	-	42	8.5	6.5	9	3	5	○
	P4	SPS012P											○
M12 × 1.5	P2	SPQ0120	2.5P	82	26	-	42	8.5	6.5	9	3	5	◎
	P3	SPR0120											△
M12 × 1.25	P4	SPS0120	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
	P2	SPQ012N											◎
M12 × 1	P3	SPR012N	2.5P	82	26	-	42	8.5	6.5	9	3	5	○
	P4	SPS012N											△
M12 × 0.75	P2	SPQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	5	○
	P3	SPR012M											△
M12 × 0.5	P4	SPS012M	2.5P	82	14	-	42	8.5	6.5	9	3	6	△
	P2	SPQ012J											△
M13 × 1	P2	SPQ012G	2.5P	82	12	-	42	8.5	6.5	9	3	6	△
M13 × 1	P2	SPQ013M	2.5P	88	26	-	45	10.5	8	11	3	5	△
	P2	SPQ014Q											◎
M14 × 2	P3	SPR014Q	2.5P	88	26	-	45	10.5	8	11	3	5	△
	P4	SPS014Q											△
M14 × 1.5	P2	SPQ0140	2.5P	88	26	-	45	10.5	8	11	3	5	◎
	P3	SPR0140											△
M14 × 1.25	P4	SPS0140	2.5P	88	26	-	45	10.5	8	11	3	5	○
	P2	SPQ014N											○
M14 × 1	P2	SPQ014M	2.5P	88	26	-	45	10.5	8	11	3	5	○
M15 × 2	P2	SPQ015Q	2.5P	95	26	-	48	12.5	10	13	3	5	△
M15 × 1.5	P2	SPQ0150	2.5P	95	26	-	48	12.5	10	13	3	5	△
M15 × 1	P2	SPQ015M	2.5P	95	26	-	48	12.5	10	13	3	5	△
	P2	SPQ016Q											◎
M16 × 2	P3	SPR016Q	2.5P	95	26	-	48	12.5	10	13	3	5	○
	P4	SPS016Q											△
M16 × 1.5	P5	SPT016Q	2.5P	95	26	-	48	12.5	10	13	3	5	△
	P2	SPQ0160											◎
M16 × 1	P3	SPR0160	2.5P	95	26	-	48	12.5	10	13	3	5	△
	P4	SPS0160											○
M16 × 1	P2	SPQ016M	2.5P	95	26	-	48	12.5	10	13	3	5	○
M17 × 1.5	P2	SPQ0170	2.5P	100	33	-	51	14	11	14	4	5	△
M17 × 1	P2	SPQ017M	2.5P	100	18	-	51	14	11	14	4	6	△
M18 × 2.5	P3	SPR018R	2.5P	100	33	-	51	14	11	14	4	5	◎
	P4	SPS018R											△
M18 × 2	P3	SPR018Q	2.5P	100	33	-	51	14	11	14	4	5	△
M18 × 1.5	P2	SPQ0180	2.5P	100	33	-	51	14	11	14	4	5	◎
	P3	SPR0180											△
M18 × 1.25	P4	SPS0180	2.5P	100	33	-	51	14	11	14	4	5	△
	P2	SPQ018N											△
M18 × 1	P2	SPQ018M	2.5P	100	18	-	51	14	11	14	4	6	○
M19 × 1.5	P3	SPR0190	2.5P	105	33	-	50	15	12	15	4	7	△
M19 × 1	P2	SPQ019M	2.5P	105	18	-	50	15	12	15	4	8	△
M20 × 2.5	P3	SPR020R	2.5P	105	33	-	50	15	12	15	4	7	◎
	P4	SPS020R											○
M20 × 2	P3	SPR020Q	2.5P	105	33	-	50	15	12	15	4	7	○
M20 × 1.5	P3	SPR0200	2.5P	105	33	-	50	15	12	15	4	7	◎
	P4	SPS0200											△

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 Fluted Tap Series for blind hole

SP Spiral Fluted 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)	M20 × 1.5	P5	SPT0200	2.5P	105	33	-	50	15	12	15	4	7	△
	M20 × 1.25	P2	SPQ020N	2.5P	105	18	-	50	15	12	15	4	8	△
	M20 × 1	P2	SPQ020M	2.5P	105	18	-	50	15	12	15	4	8	○
Spiral Fluted Taps (for through hole)	M22 × 2.5	P3	SPR022R	2.5P	115	33	-	55	17	13	16	4	7	◎
		P4	SPS022R											△
Spiral Fluted Taps (for through hole)	M22 × 2	P3	SPR022Q	2.5P	115	33	-	55	17	13	16	4	7	△
	M22 × 1.5	P3	SPR022Q	2.5P	115	33	-	55	17	13	16	4	7	○
		P4	SPS022Q											△
Spiral Pointed Taps (for through hole)		P5	SPT022Q											△
	M22 × 1	P2	SPQ022M	2.5P	115	19	-	55	17	13	16	4	8	○
Hand Taps	M23 × 1.5	P3	SPR023Q	2.5P	120	39	-	55	19	15	18	4	7	△
	M24 × 3	P3	SPR024S	2.5P	120	39	-	55	19	15	18	4	7	◎
		P4	SPS024S											△
Cemented Carbide Taps	M24 × 2	P3	SPR024Q	2.5P	120	39	-	55	19	15	18	4	7	○
	M24 × 1.5	P3	SPR024Q	2.5P	120	39	-	55	19	15	18	4	7	○
		P4	SPS024Q											△
Roll Taps	M24 × 1	P2	SPQ024M	2.5P	120	19	-	55	19	15	18	4	8	○
	M25 × 2	P3	SPR025Q	2.5P	125	39	-	58	19	15	18	4	7	△
	M25 × 1.5	P3	SPR025Q	2.5P	125	39	-	58	19	15	18	4	7	○
Special Thread Taps Simple Inspection Tools	M25 × 1	P2	SPQ025M	2.5P	125	20	-	58	19	15	18	4	8	△
	M26 × 3	P3	SPR026S	2.5P	130	39	-	60	20	15	18	4	7	△
	M26 × 2	P3	SPR026Q	2.5P	130	39	-	60	20	15	18	4	7	△
Pipe Taps	M26 × 1.5	P3	SPR026Q	2.5P	130	39	-	60	20	15	18	4	7	○
	M26 × 1	P2	SPQ026M	2.5P	130	20	-	60	20	15	18	4	8	△
	M27 × 3	P3	SPR027S	2.5P	130	39	-	60	20	15	18	4	7	○
Thread Mills	M27 × 2	P3	SPR027Q	2.5P	130	39	-	60	20	15	18	4	7	○
	M27 × 1.5	P3	SPR027Q	2.5P	130	39	-	60	20	15	18	4	7	○
	M27 × 1	P2	SPQ027M	2.5P	130	20	-	60	20	15	18	4	8	△
Dies	M28 × 2	P3	SPR028Q	2.5P	135	46	-	62	23	17	20	4	7	○
	M28 × 1.5	P3	SPR028Q	2.5P	135	46	-	62	23	17	20	4	7	○
	M28 × 1	P2	SPQ028M	2.5P	135	20	-	62	23	17	20	4	8	△
Center Drills	M30 × 3.5	P4	SPS030T	2.5P	135	46	-	62	23	17	20	4	7	◎
	M30 × 3	P3	SPR030S	2.5P	135	46	-	62	23	17	20	4	7	○
	M30 × 2	P3	SPR030Q	2.5P	135	46	-	62	23	17	20	4	7	○
Centering Tools	M30 × 1.5	P3	SPR030Q	2.5P	135	46	-	62	23	17	20	4	7	○
	M30 × 1	P2	SPQ030M	2.5P	135	21	-	62	23	17	20	4	8	△
	M32 × 3	P3	SPMR032S	2.5P	145	46	-	67	24	19	22	4	7	△
	M32 × 2	P3	SPMR032Q	2.5P	145	46	-	67	24	19	22	4	7	△
	M32 × 1.5	P3	SPMR032Q	2.5P	145	46	-	67	24	19	22	4	7	△
	M32 × 1	P2	SPMQ032M	2.5P	145	21	-	67	24	19	22	4	8	△
	M33 × 3.5	P4	SPMS033T	2.5P	145	46	-	67	25	19	22	4	7	○
	M33 × 3	P3	SPMR033S	2.5P	145	46	-	67	25	19	22	4	7	△
	M33 × 2	P3	SPMR033Q	2.5P	145	46	-	67	25	19	22	4	7	△
	M33 × 1.5	P3	SPMR033Q	2.5P	145	46	-	67	25	19	22	4	7	△
	M33 × 1	P2	SPMQ033M	2.5P	145	21	-	67	25	19	22	4	8	△
	M34 × 3	P3	SPMR034S	2.5P	155	52	-	71	28	21	24	4	7	△
	M34 × 2	P3	SPMR034Q	2.5P	155	52	-	71	28	21	24	4	7	△
	M34 × 1.5	P3	SPMR034Q	2.5P	155	26	-	71	28	21	24	4	8	△
	M34 × 1	P2	SPMQ034M	2.5P	155	26	-	71	28	21	24	4	8	△
	M35 × 3	P3	SPMR035S	2.5P	155	52	-	71	28	21	24	4	7	△

SP-7



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

SP Spiral Fluted Taps

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
M35 × 2	P3	SPMR035Q	2.5P	155	52	-	71	28	21	24	4	7	△
M35 × 1.5	P3	SPMR035O	2.5P	155	26	-	71	28	21	24	4	8	△
M35 × 1	P2	SPMQ035M	2.5P	155	26	-	71	28	21	24	4	8	△
M36 × 4	P4	SPMS036U	2.5P	155	52	-	71	28	21	24	4	7	◎
M36 × 3	P3	SPMR036S	2.5P	155	52	-	71	28	21	24	4	7	△
M36 × 2	P3	SPMR036Q	2.5P	155	52	-	71	28	21	24	4	7	△
M36 × 1.5	P3	SPMR036O	2.5P	155	26	-	71	28	21	24	4	8	△
M36 × 1	P2	SPMQ036M	2.5P	155	26	-	71	28	21	24	4	8	△
M38 × 3	P3	SPMR038S	2.5P	165	52	-	76	30	23	26	4	7	△
M38 × 2	P3	SPMR038Q	2.5P	165	52	-	76	30	23	26	4	7	△
M38 × 1.5	P3	SPMR038O	2.5P	165	26	-	76	30	23	26	4	8	△
M39 × 4	P4	SPMS039U	2.5P	165	52	-	76	30	23	26	4	7	△
M39 × 3	P3	SPMR039S	2.5P	165	52	-	76	30	23	26	4	7	△
M39 × 2	P3	SPMR039Q	2.5P	165	52	-	76	30	23	26	4	7	△
M39 × 1.5	P3	SPMR039O	2.5P	165	26	-	76	30	23	26	4	8	△
M40 × 3	P3	SPMR040S	2.5P	175	59	-	81	32	26	30	4	7	△
M40 × 2	P3	SPMR040Q	2.5P	175	59	-	81	32	26	30	4	7	△
M40 × 1.5	P3	SPMR040O	2.5P	175	27	-	81	32	26	30	4	8	△
M42 × 4.5	P4	SPMS042V	2.5P	175	59	-	81	32	26	30	4	7	△
M42 × 3	P3	SPMR042S	2.5P	175	59	-	81	32	26	30	4	7	△
M42 × 2	P3	SPMR042Q	2.5P	175	59	-	81	32	26	30	4	7	△
M42 × 1.5	P3	SPMR042O	2.5P	175	27	-	81	32	26	30	4	8	△
M45 × 4.5	P4	SPMS045V	2.5P	180	59	-	83	35	26	30	4	7	△
M45 × 3	P3	SPMR045S	2.5P	180	59	-	83	35	26	30	4	7	△
M45 × 2	P3	SPMR045Q	2.5P	180	59	-	83	35	26	30	4	7	△
M45 × 1.5	P3	SPMR045O	2.5P	180	27	-	83	35	26	30	4	8	△
M48 × 5	P4	SPMS048W	2.5P	185	65	-	85	38	29	32	4	7	△
M48 × 4	P4	SPMS048U	2.5P	185	65	-	85	38	29	32	4	7	△
M48 × 3	P3	SPMR048S	2.5P	185	65	-	85	38	29	32	4	7	△
M48 × 2	P3	SPMR048Q	2.5P	185	65	-	85	38	29	32	4	7	△
M48 × 1.5	P3	SPMR048O	2.5P	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
No.1-64UNC	P1	SPPUN1D	2.5P	42	7.2	-	27	3	2.5	5	2	2	△
No.2-56UNC	P1	SPPUN2E	2.5P	42	8.1	12	27	3	2.5	5	2	3	△
No.2-64UNF	P1	SPPUN2D	2.5P	42	8.1	12	27	3	2.5	5	2	3	△
No.3-48UNC	P1	SPPUN3F	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
No.3-56UNF	P1	SPPUN3E	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
No.4-40UNC	P1	SPPUN4H	2.5P	46	9	14	26	4	3.2	6	2	3	○
No.4-48UNF	P1	SPPUN4F	2.5P	46	9	14	26	4	3.2	6	2	3	△
No.5-40UNC	P1	SPPUN5H	2.5P	52	11	16	29	5	4	7	3	3	○
No.5-44UNF	P1	SPPUN5G	2.5P	52	11	16	29	5	4	7	3	3	△
No.6-32UNC	P2	SPQUN6J	2.5P	52	11	16	29	5	4	7	3	3	○
No.6-40UNF	P1	SPPUN6H	2.5P	52	11	16	29	5	4	7	3	3	△
No.8-32UNC	P2	SPQUN8J	2.5P	60	13	21	33	5.5	4.5	7	3	3	○
No.8-36UNF	P2	SPQUN8I	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
No.10-24UNC	P2	SPQUNAM	2.5P	60	13	22	33	5.5	4.5	7	3	3	○
No.10-32UNF	P2	SPQUNAJ	2.5P	60	13	22	33	5.5	4.5	7	3	3	○
No.12-24UNC	P2	SPQUNCM	2.5P	62	15	26	33	6	4.5	7	3	3	△
No.12-28UNF	P2	SPQUNCK	2.5P	62	15	26	33	6	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

Spiral Fluted Tap Series for blind hole

SP Spiral Fluted 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)	1/4-20UNC	P2	SPQU04N	2.5P	62	15	26	33	6	4.5	7	3	3	◎
	1/4-28UNF	P2	SPQU04K	2.5P	62	15	26	33	6	4.5	7	3	3	○
	1/4-32UNEF	P2	SPQU04J	2.5P	62	15	26	33	6	4.5	7	3	3	△
Spiral Fluted Taps (for through hole)	5/16-18UNC	P2	SPQU05O	2.5P	70	19	-	36	6.2	5	8	3	5	◎
	5/16-24UNF	P2	SPQU05M	2.5P	70	19	-	36	6.2	5	8	3	5	○
	5/16-32UNEF	P2	SPQU05J	2.5P	70	19	-	36	6.2	5	8	3	5	△
Spiral Pointed Taps (for through hole)	3/8-16UNC	P2	SPQU06P	2.5P	75	23	-	38	7	5.5	8	3	5	◎
	3/8-24UNF	P2	SPQU06M	2.5P	75	23	-	38	7	5.5	8	3	5	○
	7/16-14UNC	P3	SPRU07Q	2.5P	82	26	-	42	8.5	6.5	9	3	5	○
Hand Taps	7/16-20UNF	P2	SPQU07N	2.5P	82	26	-	42	8.5	6.5	9	3	5	○
	1/2-13UNC	P3	SPRU08R	2.5P	88	26	-	45	10.5	8	11	3	5	○
	1/2-20UNF	P2	SPQU08N	2.5P	88	26	-	45	10.5	8	11	3	5	○
Cemented Carbide Taps	9/16-12UNC	P3	SPRU09S	2.5P	95	26	-	48	12.5	10	13	3	5	△
	9/16-18UNF	P2	SPQU09O	2.5P	95	26	-	48	12.5	10	13	3	5	○
	9/16-24UNEF	P2	SPQU09M	2.5P	95	26	-	48	12.5	10	13	3	5	△
Roll Taps	5/8-11UNC	P3	SPRU10U	2.5P	95	26	-	48	12.5	10	13	3	5	○
	5/8-18UNF	P2	SPQU10O	2.5P	95	26	-	48	12.5	10	13	3	5	○
	5/8-24UNEF	P2	SPQU10M	2.5P	95	26	-	48	12.5	10	13	3	5	△
Special Thread Taps Simple Inspection Tools	3/4-10UNC	P3	SPRU12V	2.5P	105	33	-	50	15	12	15	4	7	○
	3/4-16UNF	P3	SPRU12P	2.5P	105	33	-	50	15	12	15	4	7	○
	3/4-20UNEF	P2	SPQU12N	2.5P	105	33	-	50	15	12	15	4	7	△
Pipe Taps	7/8-9UNC	P3	SPRU14W	2.5P	115	33	-	55	17	13	16	4	7	○
	7/8-14UNF	P3	SPRU14Q	2.5P	115	33	-	55	17	13	16	4	7	○
	7/8-20UNEF	P2	SPQU14N	2.5P	115	33	-	55	17	13	16	4	7	△
Thread Mills	1 -8UNC	P3	SPRU16X	2.5P	125	39	-	58	19	15	18	4	7	○
	1 -12UNF	P3	SPRU16S	2.5P	125	39	-	58	19	15	18	4	7	△
	1 -14UNS	P3	SPRU16Q	2.5P	125	39	-	58	19	15	18	4	7	△
Dies	1 -20UNEF	P2	SPQU16N	2.5P	125	39	-	58	19	15	18	4	7	△
	1 1/8-7UNC	P4	SPSU18Y	2.5P	135	46	-	62	23	17	20	4	7	△
	1 1/8-12UNF	P3	SPRU18S	2.5P	135	46	-	62	23	17	20	4	7	△
Center Drills	1 1/4-7UNC	P4	SPMSU20Y	2.5P	145	46	-	67	24	19	22	4	7	△
	1 1/4-8UN	P3	SPMRU20X	2.5P	145	46	-	67	24	19	22	4	7	△
	1 1/4-12UNF	P3	SPMRU20S	2.5P	145	46	-	67	24	19	22	4	7	△
Centering Tools	1 3/8-6UNC	P4	SPMSU22Z	2.5P	155	52	-	71	28	21	24	4	7	△
	1 3/8-8UN	P3	SPMRU22X	2.5P	155	52	-	71	28	21	24	4	7	△
	1 3/8-12UNF	P3	SPMRU22S	2.5P	155	52	-	71	28	21	24	4	7	△
	1 1/2-6UNC	P4	SPMSU24Z	2.5P	165	52	-	76	30	23	26	4	7	△
	1 1/2-12UNF	P3	SPMRU24S	2.5P	165	52	-	76	30	23	26	4	7	△
	1 3/4-5UNC	P4	SPMSU28O	2.5P	180	59	-	83	35	26	30	4	7	△
	1 3/4-12UN	P3	SPMRU28S	2.5P	180	59	-	83	35	26	30	4	7	△
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
	1/8W40	P1	SPPW02H	2.5P	52	11	17	29	5	4	7	3	3	○
	5/32W32	P2	SPQW2HJ	2.5P	52	11	17	29	5	4	7	3	3	△
	3/16W24	P2	SPQW03M	2.5P	60	13	21	33	5.5	4.5	7	3	3	○
	7/32W24	P2	SPQW3HM	2.5P	62	15	26	33	6	4.5	7	3	3	△
	1/4W20	P2	SPQW04N	2.5P	62	15	26	33	6	4.5	7	3	3	○
	5/16W18	P2	SPQW05O	2.5P	70	19	-	36	6.2	5	8	3	5	○
	3/8W16	P2	SPQW06P	2.5P	75	23	-	38	7	5.5	8	3	5	○

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 Spiral Fluted Taps

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
7/16W14	P3	SPRW07Q	2.5P	82	26	-	42	8.5	6.5	9	3	5	△
1/2W12	P3	SPRW08S	2.5P	88	26	-	45	10.5	8	11	3	5	○
9/16W12	P3	SPRW09S	2.5P	95	26	-	48	12.5	10	13	3	5	△
5/8W11	P3	SPRW10U	2.5P	95	26	-	48	12.5	10	13	3	5	○
3/4W10	P3	SPRW12V	2.5P	105	33	-	50	15	12	15	4	7	○
7/8W9	P3	SPRW14W	2.5P	115	33	-	55	17	13	16	4	7	○
1 W8	P3	SPRW16X	2.5P	125	39	-	58	19	15	18	4	7	○
1 1/8W7	P4	SPSW18Y	2.5P	135	46	-	62	23	17	20	4	7	△
1 1/4W7	P4	SPMSW20Y	2.5P	145	46	-	67	24	19	22	4	7	△
1 3/8W6	P4	SPMSW22Z	2.5P	155	52	-	71	28	21	24	4	7	△
1 1/2W6	P4	SPMSW24Z	2.5P	165	52	-	76	30	23	26	4	7	△
1 5/8W5	P4	SPMSW260	2.5P	175	59	-	81	32	26	30	4	7	△
1 3/4W5	P4	SPMSW280	2.5P	180	59	-	83	35	26	30	4	7	△
For Screw Threads used on Sewing Machines													
Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
3/32SM56	P1	SPPS06E	2.5P	46	8.1	14	29	3	2.5	5	2	3	△
1/8SM40	P1	SPPS08H	2.5P	52	11	16	29	5	4	7	3	3	△
1/8SM44	P1	SPPS08G	2.5P	52	11	16	29	5	4	7	3	3	○
9/64SM40	P1	SPPS09H	2.5P	52	11	17	29	5	4	7	3	3	○
11/64SM40	P1	SPPS11H	2.5P	60	13	21	33	5.5	4.5	7	3	3	○
3/16SM28	P2	SPQS12K	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
3/16SM32	P2	SPQS12J	2.5P	60	13	21	33	5.5	4.5	7	3	3	△
7/32SM32	P2	SPQS14J	2.5P	62	15	26	33	6	4.5	7	3	3	△
15/64SM28	P2	SPQS15K	2.5P	62	15	26	33	6	4.5	7	3	3	△
1/4SM24	P2	SPQS16M	2.5P	62	15	26	33	6	4.5	7	3	3	△
1/4SM40	P1	SPPS16H	2.5P	62	8.6	26	33	6	4.5	7	3	4	△

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 1.5P

Spiral Fluted Taps 1.5P

Specification

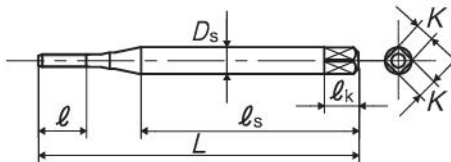


Recommended Tapping Speeds depending on Materials

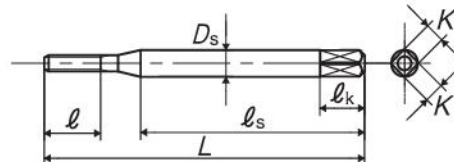
Medium carbon steels
中炭鋼
5~10
(m/min)

For icon explanation, refer to P.24

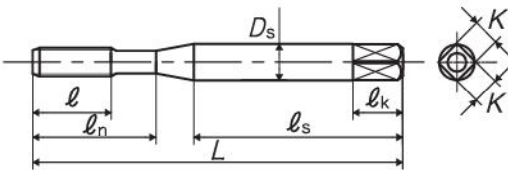
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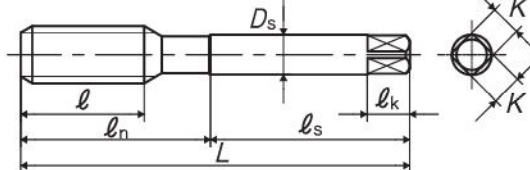
TYPE:2



TYPE:3



TYPE:4



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													
M1.2 × 0.25	P1	SY1.2BPNEBA	1.5P	36	4.5	-	24	3	2.5	5	2	1	△
M1.4 × 0.3	P1	SY1.4CPNEBA	1.5P	36	5.4	-	24	3	2.5	5	2	1	△
M1.6 × 0.35	P1	SY1.6DPNEBA	1.5P	36	6.3	-	24	3	2.5	5	2	2	○
M1.7 × 0.35	P1	SY1.7DPNEBA	1.5P	36	6.3	-	24	3	2.5	5	2	2	△
M1.8 × 0.35	P1	SY1.8DPNEBA	1.5P	42	6.3	-	27	3	2.5	5	2	2	△
M2 × 0.4	P1	SY2.0EPNEBA	1.5P	42	7.2	12	27	3	2.5	5	2	3	○
M2.3 × 0.4	P1	SY2.3EPNEBA	1.5P	42	7.2	12	27	3	2.5	5	2	3	△
M2.5 × 0.45	P1	SY2.5FPNEBA	1.5P	46	8.1	14	29	3	2.5	5	2	3	△
M2.6 × 0.45	P1	SY2.6FPNEBA	1.5P	46	8.1	14	29	3	2.5	5	2	3	△
M3 × 0.5	P1	SY3.0GPNEBA	1.5P	46	9	14	26	4	3.2	6	3	3	○
M3.5 × 0.6	P1	SY3.5HPNEBA	1.5P	52	11	16	29	5	4	7	3	3	△
M4 × 0.7	P2	SY4.0IQNEBA	1.5P	52	11	17	29	5	4	7	3	3	○
M5 × 0.8	P2	SY5.0KQNEBA	1.5P	60	13	22	33	5.5	4.5	7	3	3	○
M6 × 1	P2	SY6.0MQNEBA	1.5P	62	15	26	33	6	4.5	7	3	3	○
M8 × 1.25	P2	SY8.0NQNEBA	1.5P	70	19	-	36	6.2	5	8	3	4	○
M8 × 1	P2	SY8.0MQNEBA	1.5P	70	19	-	36	6.2	5	8	3	4	△
M10 × 1.5	P2	SY0100QNEBA	1.5P	75	23	-	38	7	5.5	8	3	4	○
M10 × 1.25	P2	SY010NQNEBA	1.5P	75	23	-	38	7	5.5	8	3	4	△
M10 × 1	P2	SY010MQNEBA	1.5P	75	23	-	38	7	5.5	8	3	4	△

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 1.5P Spiral Fluted Taps 1.5P

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M12 × 1.75	P2	SY012PQNEBA	1.5P	82	26	-	42	8.5	6.5	9	3	4	○
M12 × 1.5	P2	SY0120QNEBA	1.5P	82	26	-	42	8.5	6.5	9	3	4	△
M12 × 1.25	P2	SY012NQNEBA	1.5P	82	26	-	42	8.5	6.5	9	3	4	△
M14 × 2	P2	SY014QQNEBA	1.5P	88	26	-	45	10.5	8	11	3	4	△
M14 × 1.5	P2	SY0140QNEBA	1.5P	88	26	-	45	10.5	8	11	3	4	△
M16 × 2	P2	SY016QQNEBA	1.5P	95	26	-	48	12.5	10	13	3	4	△
M16 × 1.5	P2	SY0160QNEBA	1.5P	95	26	-	48	12.5	10	13	3	4	△

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

Plus Series Spiral Fluted Taps

Specification

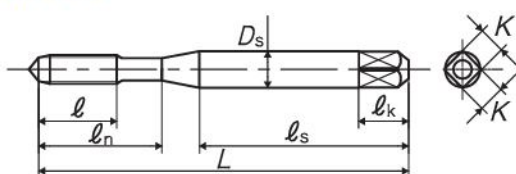


Recommended Tapping Speeds depending on Materials

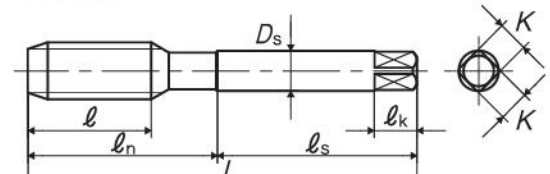
Medium carbon steels
中炭鋼
10~15
(m/min)

For icon explanation, refer to P.24

TYPE:1



TYPE:2



Segment : 1C

○ Oversize

Size	Class	Code	Chamfer	L (mm)	ln (mm)	ls (mm)	Ds (mm)	K (mm)	lk (mm)	No. of flutes	Type	Stock
For Metric Threads												
M2 × 0.4	P1	SNPP2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	1
	P2	SNPQ2.0E										
	P3	SNPR2.0E										
	P4	SNPS2.0E										
M2.2 × 0.45	P1	SNPP2.2F	2.5P	42	8.1	12	27	3	2.5	5	2	1
	P3	SNPR2.2F										
	P4	SNPS2.2F										
M2.3 × 0.4	P1	SNPP2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	1
	P2	SNPQ2.3E										
	P3	SNPR2.3E										
	P4	SNPS2.3E										
M2.5 × 0.45	P1	SNPP2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	1
	P2	SNPQ2.5F										
	P3	SNPR2.5F										
	P4	SNPS2.5F										
M2.6 × 0.45	P1	SNPP2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	1
	P2	SNPQ2.6F										
	P3	SNPR2.6F										
	P4	SNPS2.6F										
M3 × 0.5	P1	SNPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	1
	P2	SNPQ3.0G										
	P3	SNPR3.0G										
	P4	SNPS3.0G										
M3.5 × 0.6	P1	SNPP3.5H	2.5P	52	11	16	29	5	4	7	3	1
	P2	SNPQ3.5H										
	P3	SNPR3.5H										
	P4	SNPS3.5H										
M4 × 0.7	P2	SNPQ4.0I	2.5P	52	11	17	29	5	4	7	3	1

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 Plus Series Spiral Fluted Taps

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	P3	SNPR4.0I	2.5P	52	11	17	29	5	4	7	3	1	○
	P4	SNPS4.0I											○
M5 × 0.8	P2	SNPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	1	◎
	P3	SNPR5.0K											○
	P4	SNPS5.0K											○
M6 × 1	P2	SNPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	1	◎
	P3	SNPR6.0M											○
	P4	SNPS6.0M											○
M8 × 1.25	P2	SNPQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	2	◎
	P3	SNPR8.0N											○
	P4	SNPS8.0N											○
M10 × 1.5	P2	SNPQ0100	2.5P	75	23	-	38	7	5.5	8	3	2	◎
	P3	SNPR0100											○
	P4	SNPS0100											○
M10 × 1.25	P2	SNPQ010N	2.5P	75	23	-	38	7	5.5	8	3	2	◎
	P3	SNPR010N											○
	P4	SNPS010N											○
M12 × 1.75	P2	SNPQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	2	◎
	P3	SNPR012P											○
	P4	SNPS012P											○
M12 × 1.25	P2	SNPQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	2	◎
	P3	SNPR012N											○
	P4	SNPS012N											○

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