

1 Spiral Fluted Tap Series for blind hole

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

JIS

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

⑩ Dies

⑪ Center Drills
Centering Tools

SP OX

Spiral Fluted Taps, Oxidized



Specification



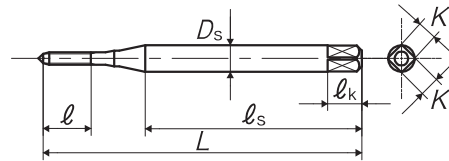
Recommended Tapping Speeds depending on Materials

Low carbon steels 低碳素鋼	Medium carbon steels 中碳素鋼	High carbon steels 高碳素鋼
5~10 (m/min)	5~10 (m/min)	5~10 (m/min)

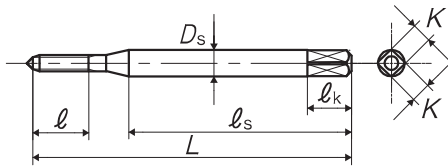
For icon explanation, refer to icon-1

■ The SP OX is a spiral flute tap for blind hole tapping. These taps have an applied oxidation treatment to prevent chip welding on the surface of the taps threaded portion. They are suitable for thread processing of soft steel materials where the chips easily weld to the tap like low carbon.

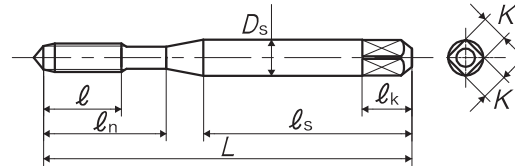
TYPE: 1



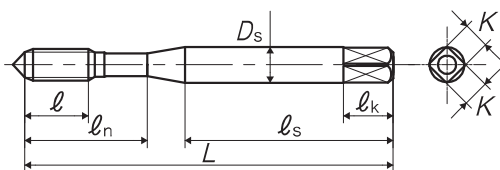
TYPE: 2



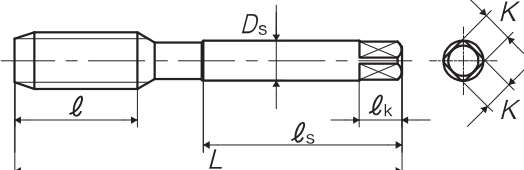
TYPE: 3



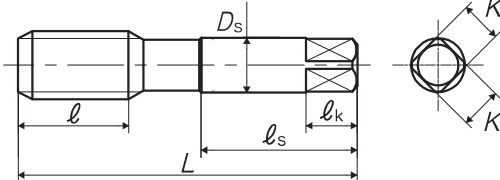
TYPE: 4



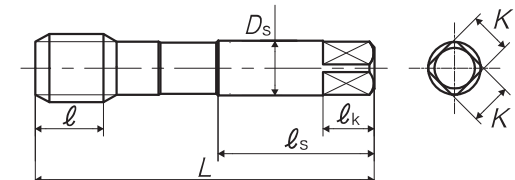
TYPE: 5



TYPE: 6



TYPE: 7



JIS

①-39

Think threads with
YAMAWA

For improvement, spec may change without advance notice.

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

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	MSRP
For Metric Threads													
M1.4 × 0.3	P1	SPP1.4CX	2.5P	36	5.4	-	24	3	2.5	5	2	1	¥ 2,970*
M1.6 × 0.35	P1	SPP1.6DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,830*
M1.7 × 0.35	P1	SPP1.7DX	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,830*
M2 × 0.4	P1	SPP2.0EX	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,260*
M2.5 × 0.45	P1	SPP2.5FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,740*
M2.6 × 0.45	P1	SPP2.6FX	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,740*
M3 × 0.5	P1	SPP3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,210
M3 × 0.5	P2	SPQ3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,210*
M3 × 0.5	P3	SPR3.0GX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,210*
3M0.6	P1	SPP3.0HX	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,210*
M3.5 × 0.6	P1	SPP3.5HX	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,210*
M4 × 0.7	P2	SPQ4.0IX	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,210
M4 × 0.7	P3	SPR4.0IX	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,210*
M4 × 0.5	P1	SPP4.0GX	2.5P	52	9	17	29	5	4	7	3	4	¥ 1,780*
M4.5 × 0.5	P1	SPP4.5GX	2.5P	60	9	21	33	5.5	4.5	7	3	4	¥ 1,780*
M5 × 0.8	P2	SPQ5.0KX	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,220
M5 × 0.8	P3	SPR5.0KX	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,220*
M6 × 1	P2	SPQ6.0MX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,350
M6 × 1	P3	SPR6.0MX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,350*
M6 × 0.75	P2	SPQ6.0JX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,890*
M7 × 1	P2	SPQ7.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 1,640*
M8 × 1.25	P2	SPQ8.0NX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 1,880
M8 × 1.25	P3	SPR8.0NX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 1,880*
M8 × 1	P2	SPQ8.0MX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,140*
M10 × 1.5	P2	SPQ0100X	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 2,400
M10 × 1.25	P2	SPQ010NX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 2,400*
M10 × 1.25	P3	SPR010NX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 2,400*
M10 × 1	P2	SPQ010MX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 2,850*
M12 × 1.75	P2	SPQ012PX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 3,400
M12 × 1.5	P2	SPQ0120X	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 3,400*
M12 × 1.25	P2	SPQ012NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 3,400*
M12 × 1	P2	SPQ012MX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 3,990*
M14 × 2	P2	SPQ0140X	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 4,640*
M14 × 1.5	P2	SPQ0140X	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 4,640*
M14 × 1.25	P2	SPQ014NX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 5,380*
M14 × 1	P2	SPQ014MX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 5,380*
M16 × 2	P2	SPQ0160X	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 6,190
M16 × 1.5	P2	SPQ0160X	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 6,190*
M16 × 1.25	P2	SPQ016NX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 7,380*
M16 × 1	P2	SPQ016MX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 7,380*
M18 × 2.5	P3	SPR018RX	2.5P	100	33	-	51	14	11	14	4	5	¥ 8,270*
M18 × 1.5	P2	SPQ0180X	2.5P	100	33	-	51	14	11	14	4	5	¥ 8,270*
M20 × 2.5	P3	SPR020RX	2.5P	105	33	-	50	15	12	15	4	6	¥ 11,300
M20 × 1.5	P3	SPR0200X	2.5P	105	33	-	50	15	12	15	4	6	¥ 11,300*
M20 × 1	P2	SPQ020MX	2.5P	105	18	-	50	15	12	15	4	7	¥ 14,300*
M22 × 2.5	P3	SPR022RX	2.5P	115	33	-	55	17	13	16	4	6	¥ 14,400*
M22 × 1.5	P3	SPR0220X	2.5P	115	33	-	55	17	13	16	4	6	¥ 14,400*
M24 × 3	P3	SPR024SX	2.5P	120	39	-	55	19	15	18	4	6	¥ 18,000*

* = Specified Distribution Items. Made to order products.
For improvement, spec may change without advance notice.

Think threads with
YAMAWA

1

JIS

Spiral Fluted Taps
(for blind hole) ①

Spiral Fluted Taps
(for through hole) ②

Spiral Pointed Taps
(for through hole) ③

Hand Taps ④

Cemented Carbide Taps ⑤

Roll Taps ⑥

Special Thread Taps
Simple Inspection Tools ⑦

Pipe Taps ⑧

Thread Mills ⑨

Dies ⑩

Center Drills
Centering Tools ⑪

JIS

①-40

1 Spiral Fluted Tap Series for blind hole

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

JIS

SP OX Spiral Fluted Taps, Oxidized

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

⑩ Dies

⑪ Center Drills Centering Tools

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M24 × 1.5	P3	SPR0240X	2.5P	120	39	-	55	19	15	18	4	6	¥ 18,000**
M27 × 3	P3	SPR027SX	2.5P	130	39	-	60	20	15	18	4	6	¥ 25,500**
M27 × 2	P3	SPR027QX	2.5P	130	39	-	60	20	15	18	4	6	¥ 25,500**
M28 × 1.5	P3	SPR0280X	2.5P	135	46	-	62	23	17	20	4	6	¥ 32,500**
M30 × 3.5	P4	SPS030TX	2.5P	135	46	-	62	23	17	20	4	6	¥ 32,500**
M30 × 3	P3	SPR030SX	2.5P	135	46	-	62	23	17	20	4	6	¥ 32,500**
M30 × 2	P3	SPR030QX	2.5P	135	46	-	62	23	17	20	4	6	¥ 32,500**
M30 × 1.5	P3	SPR0300X	2.5P	135	46	-	62	23	17	20	4	6	¥ 32,500**
M32 × 2	P3	SPMR032QX	2.5P	145	46	-	67	24	19	22	4	6	¥ 37,800**
M33 × 3.5	P4	SPMS033TX	2.5P	145	46	-	67	25	19	22	4	6	¥ 37,800**
M36 × 4	P4	SPMS036UX	2.5P	155	52	-	71	28	21	24	4	6	¥ 43,800**
For Unified Threads													
No.2-56UNC	P1	SPPUN2EX	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 2,370**
No.4-40UNC	P1	SPPUN4HX	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 1,530**
No.5-40UNC	P1	SPPUN5HX	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,420**
No.6-32UNC	P2	SPQUN6JX	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,420**
No.8-32UNC	P2	SPQUN8JX	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,430**
No.10-24UNC	P2	SPQUNAMX	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,430**
No.10-32UNF	P2	SPQUNAJX	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,430**
1/4-20UNC	P2	SPQU04NX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,540**
1/4-28UNF	P2	SPQU04KX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,540**
5/16-18UNC	P2	SPQU050X	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,170**
5/16-24UNF	P2	SPQU05MX	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,170**
3/8-16UNC	P2	SPQU06PX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 2,780**
3/8-24UNF	P2	SPQU06MX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 2,780**
7/16-14UNC	P3	SPRU07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 3,910**
7/16-20UNF	P2	SPQU07NX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 3,910**
1/2-13UNC	P3	SPRU08RX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 4,150**
1/2-20UNF	P2	SPQU08NX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 4,150**
9/16-18UNF	P2	SPQU090X	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 6,190**
5/8-11UNC	P3	SPRU10UX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 6,190**
5/8-18UNF	P2	SPQU100X	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 6,190**
3/4-10UNC	P3	SPRU12VX	2.5P	105	33	-	50	15	12	15	4	6	¥ 11,300**
3/4-16UNF	P3	SPRU12PX	2.5P	105	33	-	50	15	12	15	4	6	¥ 11,300**
7/8-9UNC	P3	SPRU14WX	2.5P	115	33	-	55	17	13	16	4	6	¥ 15,900**
7/8-14UNF	P3	SPRU14QX	2.5P	115	33	-	55	17	13	16	4	6	¥ 15,900**
1-8UNC	P3	SPRU16XX	2.5P	125	39	-	58	19	15	18	4	6	¥ 23,700**
1-12UNF	P3	SPRU16SX	2.5P	125	39	-	58	19	15	18	4	6	¥ 23,700**
1 1/2-6UNC	P4	SPMSU24ZX	2.5P	165	52	-	76	30	23	26	4	6	¥ 62,700**
1 1/2-12UNF	P3	SPMRU24SX	2.5P	165	52	-	76	30	23	26	4	6	¥ 62,700**
For Whitworth Threads													
1/8W40	P1	SPPW02HX	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,770**
5/32W32	P2	SPQW2HJX	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,420**
3/16W24	P2	SPQW03MX	2.5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,430**
1/4W20	P2	SPQW04NX	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,540**
5/16W18	P2	SPQW050X	2.5P	70	19	-	36	6.2	5	8	3	5	¥ 2,170**
3/8W16	P2	SPQW06PX	2.5P	75	23	-	38	7	5.5	8	3	5	¥ 2,780**
7/16W14	P3	SPRW07QX	2.5P	82	26	-	42	8.5	6.5	9	3	5	¥ 3,910**
1/2W12	P3	SPRW08SX	2.5P	88	26	-	45	10.5	8	11	3	5	¥ 4,150**

JIS



Think threads with
** = Specified Distribution Items. Made to order products.
For improvement, spec may change without advance notice.

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

SP OX Spiral Fluted Taps, Oxidized

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
5/8W11	P3	SPRW10UX	2.5P	95	26	-	48	12.5	10	13	3	5	¥ 6,190**
3/4W10	P3	SPRW12VX	2.5P	105	33	-	50	15	12	15	4	6	¥ 11,300**
7/8W9	P3	SPRW14WX	2.5P	115	33	-	55	17	13	16	4	6	¥ 15,900**
1 W8	P3	SPRW16XX	2.5P	125	39	-	58	19	15	18	4	6	¥ 23,700**
1 1/4W7	P4	SPMSW20YX	2.5P	145	46	-	67	24	19	22	4	6	¥ 37,800**
1 1/2W6	P4	SPMSW24ZX	2.5P	165	52	-	76	30	23	26	4	6	¥ 62,700**

1

JIS

Spiral Fluted Taps
(for blind hole)

1

Spiral Fluted Taps
(for through hole)

2

Spiral Pointed Taps
(for through hole)

3

Hand Taps

4

Cemented
Carbide Taps

5

Roll Taps

6

Special Thread Taps
Simple Inspection Tools

7

Pipe Taps

8

Thread Mills

9

Dies

10

Center Drills
Centering Tools

11

JIS