

3 Spiral Pointed Tap Series for through hole

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

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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)

JIS
3-31

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PO OX

Spiral Pointed Taps, Oxidized



Specification



■ The +PO is a spiral pointed tap for through hole tapping and is suitable for synchronous feed processing in middle to high thread processing of soft steel materials whose chips easily weld to the taps thread such as low carbon steels.

Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to icon-1

○ 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	MSRP
For Metric Threads													
M1.4 × 0.3	P1	POP1.4CX	5P	36	5.4	-	24	3	2.5	5	2	1	¥ 2,970*
M1.4 × 0.3	P2	POQ1.4CX	5P	36	5.4	-	24	3	2.5	5	2	1	¥ 2,970*
M1.6 × 0.35	P2	POQ1.6DX	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,830*
M1.7 × 0.35	P2	POQ1.7DX	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,830*
M2 × 0.4	P2	POQ2.0EX	5P	42	7.2	12	27	3	2.5	5	3	3	¥ 2,260*
M2 × 0.4	P3	POR2.0EX	5P	42	7.2	12	27	3	2.5	5	3	3	¥ 2,260*
M2.3 × 0.4	P2	POQ2.3EX	5P	42	7.2	12	27	3	2.5	5	3	3	¥ 2,060*
M2.5 × 0.45	P2	POQ2.5FX	5P	46	8.1	14	29	3	2.5	5	3	3	¥ 1,740*
M2.6 × 0.45	P2	POQ2.6FX	5P	46	8.1	14	29	3	2.5	5	3	3	¥ 1,740*
M2.6 × 0.45	P3	POR2.6FX	5P	46	8.1	14	29	3	2.5	5	3	3	¥ 1,740*
M3 × 0.5	P2	POQ3.0GX	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,210*
M3 × 0.5	P3	POR3.0GX	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,210*
3M0.6	P2	POQ3.0HX	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,210*
M3.5 × 0.6	P2	POQ3.5HX	5P	52	11	16	29	5	4	7	3	3	¥ 1,210*
M4 × 0.7	P2	POQ4.0IX	5P	52	11	17	29	5	4	7	3	3	¥ 1,210*
M4 × 0.7	P3	POR4.0IX	5P	52	11	17	29	5	4	7	3	3	¥ 1,210*
4M0.75	P2	POQ4.0JX	5P	52	11	17	29	5	4	7	3	3	¥ 1,210*
M5 × 0.8	P2	POQ5.0KX	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,220*
M5 × 0.8	P3	POR5.0KX	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,220*
5M0.9	P2	POQ5.0LX	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,220*
M6 × 1	P2	POQ6.0MX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,350*
M6 × 1	P3	POR6.0MX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,350*
M6 × 1	P4	POS6.0MX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,350*
M7 × 1	P2	POQ7.0MX	5P	70	19	-	36	6.2	5	8	3	4	¥ 1,640*
M8 × 1.25	P3	POR8.0NX	5P	70	19	-	36	6.2	5	8	3	4	¥ 1,880*
M8 × 1.25	P4	POS8.0NX	5P	70	19	-	36	6.2	5	8	3	4	¥ 1,880*
M8 × 1	P3	POR8.0MX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,140*
M8 × 1.5	P2	POQ8.0GX	5P	70	10	-	36	6.2	5	8	3	5	¥ 3,020*
M10 × 0.5	P3	POR10.0X	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,400*
M10 × 1.5	P4	POS10.0X	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,400*
M10 × 1.25	P3	POR10.1NX	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,400*
M10 × 1	P3	POR10.1MX	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,850*

Think threads with
YAMAWA

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

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

3

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1 Spiral Fluted Taps (for blind hole)

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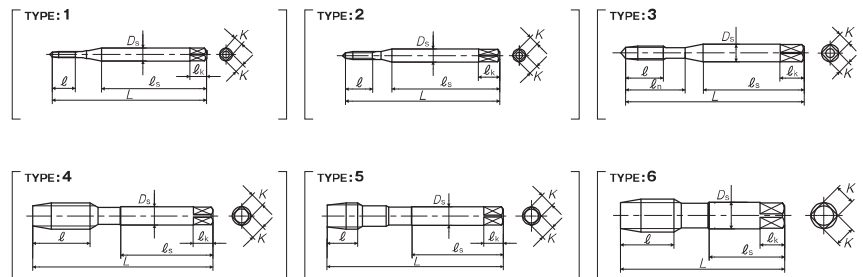
8 Pipe Taps

9 Thread Mills

10 Dies

11 Center Drills (Centering Tools)

JIS
3-32



Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M10 × 1	P4	POS10.1MX	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,850*
M12 × 1.75	P4	POS12.1PX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,400*
M12 × 1.5	P3	POR12.1DX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,400*
M12 × 1.25	P4	POS12.1NX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,400*
M14 × 2	P4	POS14.1DX	5P	88	26	-	45	10.5	8	11	3	4	¥ 4,640*
M14 × 1.5	P3	POR14.1DX	5P	88	26	-	45	10.5	8	11	3	4	¥ 4,640*
M14 × 1.25	P3	POR14.1NX	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,380*
M14 × 1	P3	POR14.1MX	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,380*
M16 × 2	P4	POS16.1DX	5P	95	26	-	48	12.5	10	13	3	4	¥ 6,190*
M16 × 1.5	P3	POR16.1DX	5P	95	26	-	48	12.5	10	13	3	4	¥ 6,190*
M18 × 2.5	P4	POS18.1RX	5P	100	33	-	51	14	11	14	3	4	¥ 8,270*
M18 × 2	P4	POS18.1GX	5P	100	33	-	51	14	11	14	3	4	¥ 8,270*
M18 × 1.5	P4	POS18.1GX	5P	100	33	-	51	14	11	14	3	4	¥ 8,270*
M20 × 2.5	P4	POS20.1RX	5P	105	33	-	50	15	12	15	3	6	¥ 11,300*
M20 × 1.5	P4	POS20.1GX	5P	105	33	-	50	15	12	15	3	6	¥ 11,300*
M22 × 2.5	P4	POS22.1RX	5P	115	33	-	55	17	13	16	3	6	¥ 14,400*
M22 × 1.5	P4	POS22.1GX	5P	115	33	-	55	17	13	16	3	6	¥ 14,400*
M24 × 3	P4	POS24.1SX	5P	120	39	-	55	19	15	18	3	6	¥ 18,000*
M25 × 1.5	P4	POS25.1GX	5P	125	39	-	58	19	15	18	3	6	¥ 23,700*
M26 × 3	P4	POS26.1SX	5P	130	39	-	60	20	15	18	4	6	¥ 25,500*
M27 × 3	P4	POS27.1SX	5P	130	39	-	60	20	15	18	4	6	¥ 25,500*
M30 × 3.5	P5	POT30.1TX	5P	135	46	-	62	23	17	20	4	6	¥ 32,500*
M30 × 3	P4	POS30.1SX	5P	135	46	-	62	23	17	20	4	6	¥ 32,500*
M32 × 2	P4	POMS32.1GX	5P	145	46	-	67	24	19	22	4	6	¥ 37,800*
M32 × 1.5	P4	POMS32.1GX	5P	145	46	-	67	24	19	22	4	6	¥ 37,800*
M33 × 3.5	P5	POMT33.1TX	5P	145	46	-	67	25	19	22	4	6	¥ 37,800*
M33 × 3	P4	POMS33.1SX	5P	145	46	-	67	25	19	22	4	6	¥ 37,800*
M36 × 4	P5	POMT36.1UX	5P	155	52	-	71	28	21	24	4	6	¥ 43,800*
M36 × 3	P4	POMS36.1SX	5P	155	52	-	71	28	21	24	4	6	¥ 43,800*
M42 × 4.5	P5	POMT42.1VX	5P	175	59	-	81	32	26	30	4	6	¥ 61,100*
For Unified Threads													
No.0-80UNF	P1	POPUN0BX	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,360*
No.2-56UNC	P1	POPUN2EX	5P	42	8.1	12	27	3	2.5	5	3	3	¥ 2,370*

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No.4-40UNC	P2	POQUN4HX	5P	46	9	14	25	4	3.2	6	3	3	¥ 1,530 [※]
No.5-40UNC	P2	POQUN5HX	5P	52	11	16	28	5	4	7	3	3	¥ 1,420 [※]
No.6-32UNC	P2	POQUN6JX	5P	52	11	17	27	5	4	7	3	3	¥ 1,420 [※]
No.6-40UNF	P2	POQUN6HX	5P	52	11	17	27	5	4	7	3	3	¥ 1,420 [※]
No.8-32UNC	P2	POQUN8JX	5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,430 [※]
No.10-24UNC	P2	POQUNAMX	5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,430 [※]
No.10-32UNF	P2	POQUNAJX	5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,430 [※]
No.12-24UNC	P2	POQUNCMX	5P	62	15	26	32	6	4.5	7	3	3	¥ 1,540 [※]
No.12-28UNF	P2	POQUNCKX	5P	62	15	26	32	6	4.5	7	3	3	¥ 1,540 [※]
1/4-20UNC	P2	POQU04NX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,540 [※]
1/4-28UNF	P2	POQU04KX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,540 [※]
5/16-18UNC	P3	PORU050X	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,170 [※]
5/16-24UNF	P2	POQU05MX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,170 [※]
3/8-16UNC	P3	PORU06PX	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,780 [※]
3/8-24UNF	P2	POQU06MX	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,780 [※]
7/16-14UNC	P3	PORU070X	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,910 [※]
7/16-20UNF	P3	PORU07NX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,910 [※]
1/2-13UNC	P3	PORU08RX	5P	88	26	-	45	10.5	8	11	3	4	¥ 4,150 [※]
1/2-20UNF	P3	PORU08NX	5P	88	26	-	45	10.5	8	11	3	4	¥ 4,150 [※]
9/16-18UNF	P3	PORU090X	5P	95	26	-	48	12.5	10	13	3	4	¥ 6,190 [※]
5/8-11UNC	P3	PORU10UX	5P	95	26	-	48	12.5	10	13	3	4	¥ 6,190 [※]
5/8-18UNF	P3	PORU100X	5P	95	26	-	48	12.5	10	13	3	4	¥ 6,190 [※]
3/4-10UNC	P4	POSU12VX	5P	105	33	-	50	15	12	15	3	6	¥ 11,300 [※]
3/4-16UNF	P3	PORU12PX	5P	105	33	-	50	15	12	15	3	6	¥ 11,300 [※]
7/8-9UNC	P4	POSU14WX	5P	115	33	-	55	17	13	16	3	6	¥ 15,900 [※]
7/8-14UNF	P3	PORU14QX	5P	115	33	-	55	17	13	16	3	6	¥ 15,900 [※]
1-8UNC	P4	POSU16XX	5P	125	39	-	58	19	15	18	3	6	¥ 23,700 [※]
1 3/8-12UNF	P4	POMSU22SX	5P	155	52	-	71	28	21	24	4	6	¥ 43,800 [※]
1 1/2-12UNF	P4	POMSU24SX	5P	165	52	-	76	30	23	26	4	6	¥ 62,700 [※]
For Whitworth Threads													
1/8W40	P2	POQW02HX	5P	52	11	16	28	5	4	7	3	3	¥ 1,770 [※]
5/32W32	P2	POQW2HJX	5P	52	11	17	29	5	4	7	3	3	¥ 1,420 [※]
3/16W24	P2	POQW03MX	5P	60	13	21	33	5.5	4.5	7	3	3	¥ 1,430 [※]
1/4W20	P3	PORW04NX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,540 [※]
5/16W18	P3	PORW050X	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,170 [※]
3/8W16	P3	PORW06PX	5P	75	23	-	38	7	5.5	8	3	4	¥ 2,780 [※]
7/16W14	P3	PORW070X	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,910 [※]
1/2W12	P3	PORW08SX	5P	88	26	-	45	10.5	8	11	3	4	¥ 4,150 [※]
5/8W11	P3	PORW10UX	5P	95	26	-	48	12.5	10	13	3	4	¥ 6,190 [※]
3/4W10	P4	POSW12VX	5P	105	33	-	50	15	12	15	3	6	¥ 11,300 [※]
7/8W9	P4	POSW14WX	5P	115	33	-	55	17	13	16	3	6	¥ 15,900 [※]
1 W8	P4	POSW16XX	5P	125	39	-	58	19	15	18	3	6	¥ 23,700 [※]
1 1/4W7	P4	POMSW20YX	5P	145	46	-	67	24	19	22	4	6	¥ 37,800 [※]

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3-33



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