

# 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



## SP Spiral Fluted Taps

### Specification



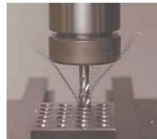
### Recommended Tapping Speeds depending on Materials

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

For icon explanation, refer to icon-1

### Product features

- The spiral flutes of the SP tap pull the small continuous curly chips back towards the tapping chuck and prevents chips from clogging in the hole. These taps are ideal for blind hole tapping.
- These taps cut easily into softer materials.
- Intermittent cutting into pilot holes with a keyway or grooves is possible.
- The flute strength is inferior to the HT tap. The HT flute shape is more suitable for high hardness materials.



Chip evacuation with a SP tap.

### The difference between a SP tap and a +SP tap

**SP** For low speed machining on drilling machines and machining centers.

Standard tap series SP (for blind holes).

Old name	New Name	Size Range
N-SP	SP	M1.2~M64

Effective tapping on drill machines.

**+SP** Medium speed machining/Synchronous feed tapping is recommended on Machining Centers.

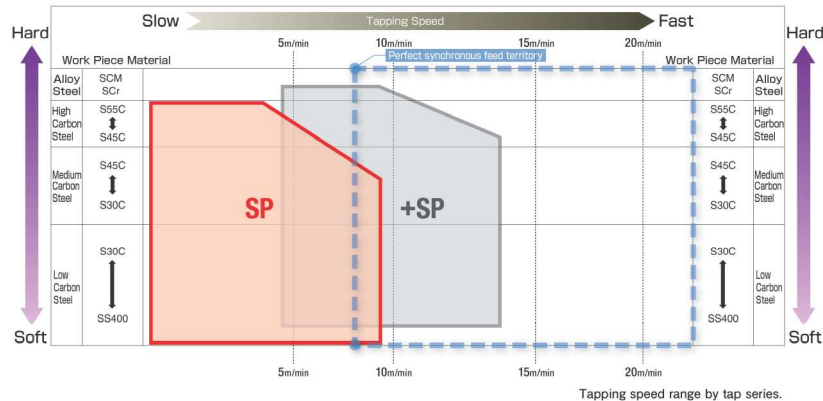
Plus series +SP for blind holes.

Old Name	New Name	Size Range
N+SP	+SP	M2~M12

Effective for use with synchronous feed (rigid) tapping on CNC machining centers.

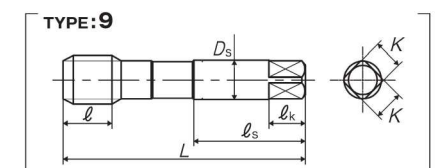
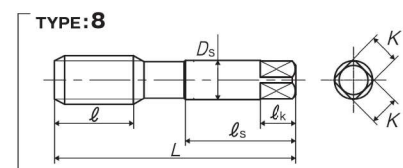
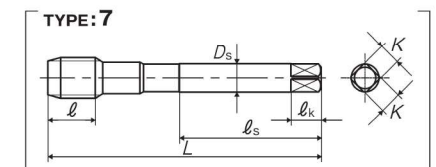
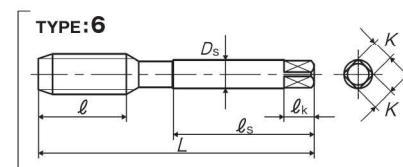
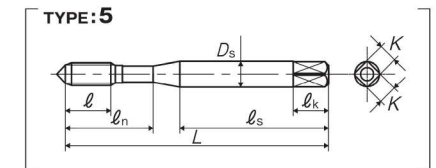
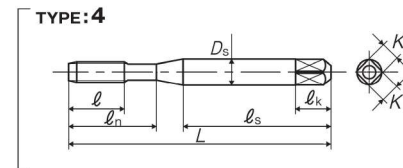
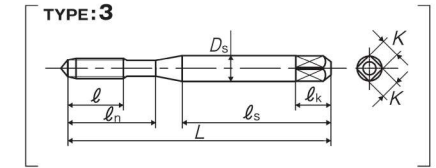
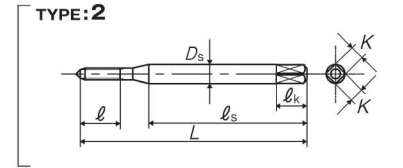
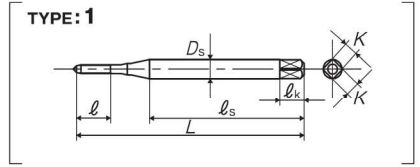
\* Both are general purpose spiral flute taps developed for varying tapping environments.

### Speed chart



Tapping speed range by tap series.

Overall length	Thread length	Thread + 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 Coated 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)

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1-13

1

JIS

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2 Spiral Fluted Taps (for through hole)

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JIS

1-14

# 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
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## SP Spiral Fluted Taps

Segment : 1C  
 Oversize

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													
M1.2 × 0.25	P1	SPP1.2B	2.5P	36	4.5	-	24	3	2.5	5	2	1	¥ 3,450
M1.4 × 0.3	P1	SPP1.4C	2.5P	36	5.4	-	24	3	2.5	5	2	1	¥ 2,820
M1.6 × 0.35	P1	SPP1.6D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,690
M1.7 × 0.35	P1	SPP1.7D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,690
M1.7 × 0.35	P2	SPQ1.7D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,690
M1.7 × 0.35	P3	SPR1.7D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 2,690*
M1.8 × 0.35	P1	SPP1.8D	2.5P	42	6.3	-	27	3	2.5	5	2	2	¥ 2,690*
M2 × 0.4	P1	SPP2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,150
M2 × 0.4	P2	SPQ2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,150
M2 × 0.4	P3	SPR2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,150
M2 × 0.4	P4	SPS2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,150*
M2 × 0.45	P1	SPP2.0B	2.5P	42	4.5	12	27	3	2.5	5	2	5	¥ 3,300
M2.2 × 0.45	P1	SPP2.2F	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 1,960
M2.2 × 0.45	P3	SPR2.2F	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 1,960*
M2.3 × 0.4	P1	SPP2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 1,960
M2.3 × 0.4	P2	SPQ2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 1,960*
M2.3 × 0.4	P3	SPR2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 1,960*
M2.3 × 0.4	P4	SPS2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 1,960*
M2.3 × 0.25	P1	SPP2.3D	2.5P	42	4.5	12	27	3	2.5	5	2	5	¥ 3,300*
M2.5 × 0.45	P1	SPP2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650
M2.5 × 0.45	P2	SPQ2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650
M2.5 × 0.45	P3	SPR2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650
M2.5 × 0.45	P4	SPS2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650
M2.5 × 0.35	P1	SPP2.5D	2.5P	46	6.3	14	29	3	2.5	5	2	5	¥ 2,430
M2.6 × 0.45	P1	SPP2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650
M2.6 × 0.45	P2	SPQ2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650
M2.6 × 0.45	P3	SPR2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650
M2.6 × 0.45	P4	SPS2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,650*
M2.6 × 0.35	P1	SPP2.6D	2.5P	46	6.3	14	29	3	2.5	5	2	5	¥ 2,430*
M3 × 0.5	P1	SPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,150
M3 × 0.5	P2	SPQ3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,150
M3 × 0.5	P3	SPR3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,150
M3 × 0.5	P4	SPS3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,150
3M0.6	P1	SPP3.0H	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,150*
M3 × 0.35	P1	SPP3.0D	2.5P	46	6.5	14	26	4	3.2	6	3	5	¥ 1,970
M3.5 × 0.6	P1	SPP3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,150
M3.5 × 0.6	P2	SPQ3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,150*
M3.5 × 0.6	P3	SPR3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,150*
M3.5 × 0.6	P4	SPS3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,150*
M3.5 × 0.35	P1	SPP3.5D	2.5P	52	6.5	16	29	5	4	7	3	5	¥ 1,970*
M4 × 0.7	P2	SPQ4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,150
M4 × 0.7	P3	SPR4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,150
M4 × 0.7	P4	SPS4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,150
4M0.75	P2	SPQ4.0J	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,150
M4 × 0.5	P1	SPP4.0G	2.5P	52	9	17	29	5	4	7	3	5	¥ 1,690
M4.5 × 0.75	P2	SPQ4.5J	2.5P	60	13	21	33	5.5	4.5	7	3	3	¥ 1,160*
M4.5 × 0.5	P1	SPP4.5G	2.5P	60	9	21	33	5.5	4.5	7	3	5	¥ 1,690*
M5 × 0.8	P2	SPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,160

Think threads with **YAMAWA**

\* = 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 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	MSRP
M5 × 0.8	P3	SPR5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,160
M5 × 0.8	P4	SPS5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,160
5M0.9	P2	SPQ5.0L	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,160*
M5 × 0.75	P2	SPQ5.0J	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,690*
M5 × 0.5	P1	SPP5.0G	2.5P	60	9	22	33	5.5	4.5	7	3	5	¥ 1,690
M5.5 × 0.9	P2	SPQ5.5L	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,280*
M5.5 × 0.5	P1	SPP5.5G	2.5P	62	9	26	33	6	4.5	7	3	5	¥ 1,800*
M6 × 1	P2	SPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,280
M6 × 1	P2	SPQ6.0M-T	2.5P	62	15	26	33	6	4.5	7	3	4	¥ 1,280
M6 × 1	P3	SPR6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,280
M6 × 1	P4	SPS6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,280
M6 × 0.75	P2	SPQ6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,800
M6 × 0.75	P3	SPR6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,800*
M6 × 0.5	P1	SPR6.0G	2.5P	62	9	26	33	6	4.5	7	3	5	¥ 1,800
M6 × 0.5	P2	SPQ6.0G	2.5P	62	9	26	33	6	4.5	7	3	5	¥ 1,800*
M6 × 0.5	P3	SPR6.0G	2.5P	62	9	26	33	6	4.5	7	3	5	¥ 1,800*
M7 × 1	P2	SPQ7.0M	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 1,560
M7 × 1	P3	SPR7.0M	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 1,560*
M7 × 1	P4	SPS7.0M	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 1,560*
M7 × 0.75	P2	SPQ7.0J	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,300
M7 × 0.5	P2	SPQ7.0G	2.5P	70	10	-	36	6.2	5	8	3	7	¥ 2,870*
M8 × 1.25	P2	SPQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 1,790
M8 × 1.25	P3	SPR8.0N	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 1,790
M8 × 1.25	P4	SPS8.0N	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 1,790
M8 × 1	P2	SPQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,030
M8 × 1	P3	SPR8.0M	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,030*
M8 × 1	P4	SPS8.0M	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,030*
M8 × 0.75	P2	SPQ8.0J	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,300
M8 × 0.75	P3	SPR8.0J	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,300*
M8 × 0.5	P2	SPQ8.0G	2.5P	70	10	-	36	6.2	5	8	3	7	¥ 2,870
M9 × 1.25	P2	SPQ9.0N	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,280*
M9 × 1	P2	SPQ9.0M	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,710
M9 × 0.75	P2	SPQ9.0J	2.5P	75	13	-	38	7	5.5	8	3	7	¥ 3,290
M9 × 0.5	P2	SPQ9.0G	2.5P	75	11	-	38	7	5.5	8	3	7	¥ 3,580*
M10 × 1.5	P2	SPQ10.0N	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,280
M10 × 1.5	P3	SPR10.0N	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,280
M10 × 1.5	P4	SPS10.0N	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,280
M10 × 1.25	P2	SPQ10.0M	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,280
M10 × 1.25	P3	SPR10.0M	2.5P	75	23	-	38	7	5.5	8			

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L	ℓ	ℓn	ℓs	Ds	K	ℓk

JIS

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Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M12 × 1.75	P4	SPS012P	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,230
M12 × 1.5	P2	SPQ0120	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,230
M12 × 1.5	P3	SPR0120	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,230*
M12 × 1.5	P4	SPS0120	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,230*
M12 × 1.25	P2	SPQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,230
M12 × 1.25	P3	SPR012N	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,230
M12 × 1.25	P4	SPS012N	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,230*
M12 × 1	P2	SPQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,800
M12 × 1	P3	SPR012M	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,800*
M12 × 1	P4	SPS012M	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,800*
M12 × 0.75	P2	SPQ012J	2.5P	82	14	-	42	8.5	6.5	9	3	7	¥ 4,850*
M12 × 0.5	P2	SPQ012G	2.5P	82	12	-	42	8.5	6.5	9	3	7	¥ 4,850*
M13 × 1.75	P2	SPQ013P	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 5,120*
M13 × 1.5	P2	SPQ0130	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 5,120*
M13 × 1.25	P2	SPQ013N	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 5,120*
M13 × 1	P2	SPQ013M	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 5,120*
M14 × 2	P2	SPQ014Q	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 4,410
M14 × 2	P3	SPR014Q	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 4,410*
M14 × 2	P4	SPS014Q	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 4,410*
M14 × 1.5	P2	SPQ0140	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 4,410
M14 × 1.5	P3	SPR0140	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 4,410*
M14 × 1.5	P4	SPS0140	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 4,410*
M14 × 1.25	P2	SPQ014N	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 5,120
M14 × 1	P2	SPQ014M	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 5,120
M15 × 2	P2	SPQ015Q	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
M15 × 1.5	P2	SPQ0150	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
M15 × 1	P2	SPQ015M	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 7,020*
M16 × 2	P2	SPQ016Q	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890
M16 × 2	P3	SPR016Q	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
M16 × 2	P4	SPS016Q	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
M16 × 2	P5	SPT016Q	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
M16 × 1.5	P2	SPQ0160	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890
M16 × 1.5	P3	SPR0160	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
M16 × 1.5	P4	SPS0160	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
M16 × 1.25	P2	SPQ016N	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 7,020*
M16 × 1	P2	SPQ016M	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 7,020*
M17 × 1.5	P2	SPQ0170	2.5P	100	33	-	51	14	11	14	4	6	¥ 7,870*
M17 × 1	P2	SPQ017M	2.5P	100	18	-	51	14	11	14	4	7	¥ 10,100*
M18 × 2.5	P3	SPR018R	2.5P	100	33	-	51	14	11	14	4	6	¥ 7,870
M18 × 2.5	P4	SPS018R	2.5P	100	33	-	51	14	11	14	4	6	¥ 7,870*
M18 × 2	P3	SPR018Q	2.5P	100	33	-	51	14	11	14	4	6	¥ 7,870*
M18 × 1.5	P2	SPQ0180	2.5P	100	33	-	51	14	11	14	4	6	¥ 7,870
M18 × 1.5	P3	SPR0180	2.5P	100	33	-	51	14	11	14	4	6	¥ 7,870*
M18 × 1.5	P4	SPS0180	2.5P	100	33	-	51	14	11	14	4	6	¥ 7,870*
M18 × 1.25	P2	SPQ018N	2.5P	100	33	-	51	14	11	14	4	6	¥ 10,100*
M18 × 1	P2	SPQ018M	2.5P	100	18	-	51	14	11	14	4	7	¥ 10,100
M19 × 1.5	P3	SPR0190	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700*
M19 × 1	P2	SPQ019M	2.5P	105	18	-	50	15	12	15	4	9	¥ 13,600*
M20 × 2.5	P3	SPR020R	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700
M20 × 2.5	P4	SPS020R	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700*

JIS  
①-17

Think threads with **YAMAWA**  
\* = 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

# 1

JIS

## 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	MSRP
M20 × 2	P3	SPR020Q	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700
M20 × 1.5	P3	SPR0200	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700
M20 × 1.5	P4	SPS0200	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700*
M20 × 1.5	P5	SPT0200	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700*
M20 × 1.25	P2	SPQ020N	2.5P	105	18	-	50	15	12	15	4	9	¥ 13,600*
M20 × 1	P2	SPQ020M	2.5P	105	18	-	50	15	12	15	4	9	¥ 13,600
M22 × 2.5	P3	SPR022R	2.5P	115	33	-	55	17	13	16	4	8	¥ 13,700
M22 × 2.5	P4	SPS022R	2.5P	115	33	-	55	17	13	16	4	8	¥ 13,700*
M22 × 2	P3	SPR022Q	2.5P	115	33	-	55	17	13	16	4	8	¥ 13,700*
M22 × 1.5	P3	SPR0220	2.5P	115	33	-	55	17	13	16	4	8	¥ 13,700
M22 × 1.5	P4	SPS0220	2.5P	115	33	-	55	17	13	16	4	8	¥ 13,700*
M22 × 1.5	P5	SPT0220	2.5P	115	33	-	55	17	13	16	4	8	¥ 13,700*
M22 × 1	P2	SPQ022M	2.5P	115	19	-	55	17	13	16	4	9	¥ 17,700
M23 × 1.5	P3	SPR0230	2.5P	120	39	-	55	19	15	18	4	8	¥ 17,100*
M24 × 3	P3	SPR024S	2.5P	120	39	-	55	19	15	18	4	8	¥ 17,100
M24 × 3	P4	SPS024S	2.5P	120	39	-	55	19	15	18	4	8	¥ 17,100*
M24 × 2	P3	SPR024Q	2.5P	120	39	-	55	19	15	18	4	8	¥ 17,100
M24 × 1.5	P3	SPR0240	2.5P	120	39	-	55	19	15	18	4	8	¥ 17,100*
M24 × 1.5	P4	SPS0240	2.5P	120	39	-	55	19	15	18	4	8	¥ 17,100*
M24 × 1	P2	SPQ024M	2.5P	120	19	-	55	19	15	18	4	9	¥ 21,800
M25 × 2	P3	SPR025Q	2.5P	125	39	-	58	19	15	18	4	8	¥ 22,500*
M25 × 1.5	P3	SPR0250	2.5P	125	39	-	58	19	15	18	4	8	¥ 22,500*
M25 × 1	P2	SPQ025M	2.5P	125	20	-	58	19	15	18	4	9	¥ 26,700*
M26 × 3	P3	SPR026S	2.5P	130	39	-	60	20	15	18	4	8	¥ 24,200*
M26 × 2	P3	SPR026Q	2.5P	130	39	-	60	20	15	18	4	8	¥ 24,200*
M26 × 1.5	P3	SPR0260	2.5P	130	39	-	60	20	15	18	4	8	¥ 24,200
M26 × 1	P2	SPQ026M	2.5P	130	20	-	60	20	15	18	4	9	¥ 29,900*
M27 × 3	P3	SPR027S	2.5P	130	39	-	60	20	15	18	4	8	¥ 24,200
M27 × 2	P3	SPR027Q	2.5P	130	39	-	60	20	15	18	4	8	¥ 24,200
M27 × 1.5	P3	SPR0270	2.5P	130	39	-	60	20	15	18	4	8	¥ 24,200
M27 × 1	P2	SPQ027M	2.5P	130	20	-	60	20	15	18	4	9	¥ 29,900*
M28 × 2	P3	SPR028Q	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900
M28 × 1.5	P3	SPR0280	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900
M28 × 1	P2	SPQ028M	2.5P	135	20	-	62	23	17	20	4	9	¥ 38,600*
M30 × 3.5	P4	SPS030T	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900
M30 × 3	P3	SPR030S	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900
M30 × 2	P3	SPR030Q	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900
M30 × 1.5	P3	SPR0300	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900
M30 × 1	P2	SPQ030M	2.5P	135	21	-	62	23	17	20	4	9	¥ 38,600*
M32 × 3	P3	SPMR032S	2.5P	145	46	-	67	24	19	22	4	8	¥ 36,000*
M32 × 2	P3	SPMR032Q	2.5P	145	46	-	67	24	19	22	4	8	¥ 36,000*
M32 × 1.5	P3	SPMR0320	2.5P	145	46	-	67	24	19	22	4	8	¥ 36,000*
M32 × 1	P2	SPMQ032M	2.5P	145	21	-	67	24	19	22	4	9	¥ 44,300*
M33 × 3.5	P4	SPMS033T	2.5P	145	46	-	67	25	19	22	4	8	¥ 36,000*
M33 × 3	P3	SPMR033S	2.5P	145	46	-	67	25	19	22	4	8	¥ 36,000*
M33 × 2	P3	SPMR033Q	2.5P	145	46	-	67	25	19	22	4	8	¥ 36,000*
M33 × 1.5	P3	SPMR0330	2.5P	145	46	-	67	25	19	22	4	8	¥ 36,000*
M33 × 1	P2	SPMQ033M	2.5P	145	21	-	67	25	19	22	4	9	¥ 44,300*
M34 × 3	P3	SPMR034S	2.5P	155	52	-							

# 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 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	MSRP
M34 × 1.5	P3	SPMR0340	2.5P	155	26	-	71	28	21	24	4	9	¥ 41,700*
M34 × 1	P2	SPMQ034M	2.5P	155	26	-	71	28	21	24	4	9	¥ 49,400*
M35 × 3	P3	SPMR035S	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
M35 × 2	P3	SPMR035Q	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
M35 × 1.5	P3	SPMR035Q	2.5P	155	26	-	71	28	21	24	4	9	¥ 41,700*
M35 × 1	P2	SPMQ035M	2.5P	155	26	-	71	28	21	24	4	9	¥ 49,400*
M36 × 4	P4	SPMS036U	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
M36 × 3	P3	SPMR036S	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
M36 × 2	P3	SPMR036Q	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
M36 × 1.5	P3	SPMR036Q	2.5P	155	26	-	71	28	21	24	4	9	¥ 41,700*
M36 × 1	P2	SPMQ036M	2.5P	155	26	-	71	28	21	24	4	9	¥ 49,400*
M38 × 3	P3	SPMR038S	2.5P	165	52	-	76	30	23	26	4	8	¥ 47,800*
M38 × 2	P3	SPMR038Q	2.5P	165	52	-	76	30	23	26	4	8	¥ 47,800*
M38 × 1.5	P3	SPMR038Q	2.5P	165	26	-	76	30	23	26	4	9	¥ 47,800*
M39 × 4	P4	SPMS039U	2.5P	165	52	-	76	30	23	26	4	8	¥ 47,800*
M39 × 3	P3	SPMR039S	2.5P	165	52	-	76	30	23	26	4	8	¥ 47,800*
M39 × 2	P3	SPMR039Q	2.5P	165	52	-	76	30	23	26	4	8	¥ 47,800*
M39 × 1.5	P3	SPMR039Q	2.5P	165	26	-	76	30	23	26	4	9	¥ 47,800*
M40 × 3	P3	SPMR040S	2.5P	175	59	-	81	32	26	30	4	8	¥ 58,100*
M40 × 2	P3	SPMR040Q	2.5P	175	59	-	81	32	26	30	4	8	¥ 58,100*
M40 × 1.5	P3	SPMR040Q	2.5P	175	27	-	81	32	26	30	4	9	¥ 58,100*
M42 × 4.5	P4	SPMS042V	2.5P	175	59	-	81	32	26	30	4	8	¥ 58,100*
M42 × 3	P3	SPMR042S	2.5P	175	59	-	81	32	26	30	4	8	¥ 58,100*
M42 × 2	P3	SPMR042Q	2.5P	175	59	-	81	32	26	30	4	8	¥ 58,100*
M42 × 1.5	P3	SPMR042Q	2.5P	175	27	-	81	32	26	30	4	9	¥ 58,100*
M45 × 4.5	P4	SPMS045V	2.5P	180	59	-	83	35	26	30	4	8	¥ 67,300*
M45 × 3	P3	SPMR045S	2.5P	180	59	-	83	35	26	30	4	8	¥ 67,300*
M45 × 2	P3	SPMR045Q	2.5P	180	59	-	83	35	26	30	4	8	¥ 67,300*
M45 × 1.5	P3	SPMR045Q	2.5P	180	27	-	83	35	26	30	4	9	¥ 67,300*
M48 × 5	P4	SPMS048W	2.5P	185	65	-	85	38	29	32	4	8	¥ 84,100*
M48 × 4	P4	SPMS048U	2.5P	185	65	-	85	38	29	32	4	8	¥ 84,100*
M48 × 3	P3	SPMR048S	2.5P	185	65	-	85	38	29	32	4	8	¥ 84,100*
M48 × 2	P3	SPMR048Q	2.5P	185	65	-	85	38	29	32	4	8	¥ 84,100*
M48 × 1.5	P3	SPMR048Q	2.5P	185	28	-	85	38	29	32	4	9	¥ 84,100*
M52 × 5	P4	SPS052W	2.5P	195	70	-	86	42	32	35	4	8	¥ 104,000*
M56 × 5.5	P4	SPS056X	2.5P	205	70	-	91	44	35	38	4	8	¥ 119,000*
M60 × 5.5	P4	SPS060X	2.5P	215	76	-	96	46	35	38	4	8	¥ 143,000*
M64 × 6	P4	SPS064Y	2.5P	225	79	-	100	48	38	42	4	8	¥ 170,000*
For Unified Threads													
No.1-64UNC	P1	SPPUN1D	2.5P	42	7.2	-	27	3	2.5	5	2	2	¥ 3,200*
No.2-56UNC	P1	SPPUN2E	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 2,250*
No.2-64UNF	P1	SPPUN2D	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 2,250*
No.3-48UNC	P1	SPPUN3F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900*
No.3-56UNF	P1	SPPUN3E	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900*
No.4-40UNC	P1	SPPUN4H	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 1,450*
No.4-48UNF	P1	SPPUN4F	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 1,450*
No.5-40UNC	P1	SPPUN5H	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,350*
No.5-44UNF	P1	SPPUN5G	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,350*
No.6-32UNC	P2	SPQUN6J	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,350*
No.6-40UNF	P1	SPPUN6H	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,350*

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①-19



\* = 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

# 1

JIS

## 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	MSRP
No.8-32UNC	P2	SPQUN8J	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,360
No.8-36UNF	P2	SPQUN8I	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,360*
No.10-24UNC	P2	SPQUN8I	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,360
No.10-32UNF	P2	SPQUNAJ	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,360
No.12-24UNC	P2	SPQUNCM	2.5P	62	15	26	32	6	4.5	7	3	3	¥ 1,460*
No.12-28UNF	P2	SPQUNCK	2.5P	62	15	26	32	6	4.5	7	3	3	¥ 1,460*
1/4-20UNC	P2	SPQU04N	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,460
1/4-28UNF	P2	SPQU04K	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,460
1/4-32UNEF	P2	SPQU04J	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,170*
5/16-18UNC	P2	SPQU05O	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,060
5/16-24UNF	P2	SPQU05M	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,060
5/16-32UNEF	P2	SPQU05J	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,870*
3/8-16UNC	P2	SPQU06P	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,640
3/8-24UNF	P2	SPQU06M	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,640
3/8-32UNEF	P2	SPQU06J	2.5P	75	13	-	38	7	5.5	8	3	7	¥ 3,290*
7/16-14UNC	P3	SPRU07Q	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,720
7/16-20UNF	P2	SPQU07N	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,720
7/16-28UNEF	P2	SPQU07K	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 4,850*
1/2-13UNC	P3	SPRU08R	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 3,950
1/2-20UNF	P2	SPQU08N	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 3,950
1/2-28UNEF	P2	SPQU08K	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 5,830*
9/16-12UNC	P3	SPRU09S	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
9/16-18UNF	P2	SPQU09O	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890
9/16-24UNEF	P2	SPQU09M	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 8,430*
5/8-11UNC	P3	SPRU10U	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890
5/8-18UNF	P2	SPQU10O	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890
5/8-24UNEF	P2	SPQU10M	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 8,430*
3/4-10UNC	P3	SPRU12V	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700
3/4-16UNF	P3	SPRU12P	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700
3/4-20UNEF	P2	SPQU12N	2.5P	105	33	-	50	15	12	15	4	8	¥ 13,600*
7/8-9UNC	P3	SPRU14W	2.5P	115	33	-	55	17	13	16	4	8	¥ 15,100
7/8-14UNF	P3	SPRU14Q	2.5P	115	33	-	55	17	13	16	4	8	¥ 15,100
7/8-20UNEF	P2	SPQU14N	2.5P	115	33	-	55	17	13	16	4	8	¥ 21,200*
1-8UNC	P3	SPRU16X	2.5P	125	39	-	58	19	15	18	4	8	¥ 22,500
1-12UNF	P3	SPRU16S	2.5P	125	39	-	58	19	15	18	4	8	¥ 22,500*
1-14UNS	P3	SPRU16O	2.5P	125	39	-	58	19	15	18	4	8	¥ 29,900*
1-20UNEF	P2	SPQU16N	2.5P	125	39	-	58	19	15	18	4	8	¥ 29,900*
1 1/8-7UNC	P4	SPSU18Y	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900*
1 1/8-8UN	P3	SPRU18X	2.5P	135	46	-	62	23	17	20	4	8	¥ 37,000*
1 1/8-12UNF	P3	SPRU18S	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900*
1 1/8-14UNS	P3	SPRU18Q	2.5P	135	46	-	62	23	17	20	4	8	¥ 37,000*
1 1/4-7UNC	P4	SPMSU20Y	2.5P	145	46	-	67	24	19	22	4	8	¥ 36,000*
1 1/4-8UN	P3	SPMRU20X	2.5P	145	46	-	67	24	19	22	4	8	¥ 43,100*
1 1/4-12UNF	P3	SPMRU20S	2.5P	145	46	-	67	24	19	22	4	8	¥ 36,000*
1 3/8-6UNC	P4	SPMSU22Z	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
1 3/8-8UN	P3	SPMRU22X	2.5P	155	52	-	71	28	21	24	4	8	¥ 50,000*
1 3/8-12UNF	P3	SPMRU22S	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
1 1/2-6UNC	P4	SPMSU24Z	2.5P	165	52	-	76	30	23	26	4	8	¥ 59,700*
1 1/2-8UN	P3	SPMRU24X	2.5P	165	52	-	76	30	23	26	4	8	¥ 59,700*
1 1/2-12UNF	P3												

# 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 Spiral Fluted Taps

① Spiral Fluted Taps (for blind hole)

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
1 3/4-5UNC	P4	SPMSU280	2.5P	180	59	-	83	35	26	30	4	8	¥ 83,300*
1 3/4-12UN	P3	SPMRU28S	2.5P	180	59	-	83	35	26	30	4	8	¥ 83,300*
2-4.5UNC	P5	SPTU329	2.5P	195	70	-	85	40	32	35	4	8	¥ 131,000*
2-12UN	P3	SPRU32S	2.5P	145	45	-	82	40	32	35	4	8	¥ 131,000*

② Spiral Fluted Taps (for through hole)

For Whitworth Threads													
1/8W40	P1	SPPW02H	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,680
5/32W32	P2	SPQW2HJ	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,350*
3/16W24	P2	SPQW03M	2.5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,360
7/32W24	P2	SPQW3HM	2.5P	62	15	26	32	6	4.5	7	3	3	¥ 1,460*

③ Spiral Pointed Taps (for through hole)

1/4W20	P2	SPQW04N	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,460
5/16W18	P2	SPQW05O	2.5P	70	19	-	36	6.2	5	8	3	6	¥ 2,060
3/8W16	P2	SPQW06P	2.5P	75	23	-	38	7	5.5	8	3	6	¥ 2,640
7/16W14	P3	SPRW07Q	2.5P	82	26	-	42	8.5	6.5	9	3	6	¥ 3,720*

④ Hand Taps

1/2W12	P3	SPRW08S	2.5P	88	26	-	45	10.5	8	11	3	6	¥ 3,950
9/16W12	P3	SPRW09S	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890*
5/8W11	P3	SPRW10U	2.5P	95	26	-	48	12.5	10	13	3	6	¥ 5,890
3/4W10	P3	SPRW12V	2.5P	105	33	-	50	15	12	15	4	8	¥ 10,700

⑤ Coated Carbide Taps

7/8W9	P3	SPRW14W	2.5P	115	33	-	55	17	13	16	4	8	¥ 15,100
1 W8	P3	SPRW16X	2.5P	125	39	-	58	19	15	18	4	8	¥ 22,500
1 1/8W7	P4	SPSW18Y	2.5P	135	46	-	62	23	17	20	4	8	¥ 30,900*
1 1/4W7	P4	SPMSW20Y	2.5P	145	46	-	67	24	19	22	4	8	¥ 36,000*

⑥ Roll Taps

1 3/8W6	P4	SPMSW22Z	2.5P	155	52	-	71	28	21	24	4	8	¥ 41,700*
1 1/2W6	P4	SPMSW24Z	2.5P	165	52	-	76	30	23	26	4	8	¥ 59,700*
1 5/8W5	P4	SPMSW26O	2.5P	175	59	-	81	32	26	30	4	8	¥ 61,100*
1 3/4W5	P4	SPMSW28O	2.5P	180	59	-	83	35	26	30	4	8	¥ 83,300*

⑦ Special Thread Taps (Simple Inspection Tools)

1 7/8W4.5	P4	SPMSW309	2.5P	185	65	-	85	38	29	32	4	8	¥ 96,400*
2 W4.5	P4	SPSW329	2.5P	195	70	-	85	40	32	35	4	8	¥ 131,000*

⑧ Pipe Taps

For Screw Threads used on Sewing Machines													
3/32SM56	P1	SPPS06E	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,290*
1/8SM40	P1	SPPS08H	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,680*
1/8SM44	P1	SPPS08G	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,680
9/64SM40	P1	SPPS09H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,680

⑨ Thread Mills

11/64SM40	P1	SPPS11H	2.5P	60	13	21	33	5.5	4.5	7	3	3	¥ 1,640
3/16SM28	P2	SPQS12K	2.5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,640*
3/16SM32	P2	SPQS12J	2.5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,640*
7/32SM32	P2	SPQS14J	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,760*

⑩ Dies

15/64SM28	P2	SPQS15K	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,760*
1/4SM24	P2	SPQS16M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,760*
1/4SM40	P1	SPPS16H	2.5P	62	8.6	26	33	6	4.5	7	3	5	¥ 2,530*

⑪ Center Drills (Centering Tools)

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