

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)

JIS

1-75

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SU+SP/SU-SP

Spiral Fluted Taps for Stainless Steels



Specification



• Product Name and Size.

SU+SP	M2~M6 (coarse thread)
SU-SP	~M1.7, M2~M6 (fine thread), M8~, all U, all W

Recommended Tapping Speeds depending on Materials

Medium carbon steels 中炭素鋼	High carbon steels 高炭素鋼	Alloy steels 合金鋼	Stainless steels ステンレス鋼
~10 (m/min)	~10 (m/min)	~10 (m/min)	~10 (m/min)

For icon explanation, refer to icon-1

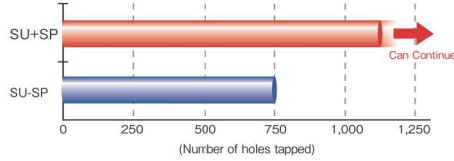
Product features

- Ideal for blind hole machining in stainless steel, chromium steel, molybdenum steel. These materials have remarkably high work hardening properties.
- The optimum design of the thread section reduces the processing burden on each flutes cutting chamfer.
- Reduces cutting resistance and increases tool life.
- Chip discharge is stable and achieves a good surface finished.
- Improved strength and life expectancy is achieved.
- Use with either synchronous or asynchronous thread processing.

Tapping data

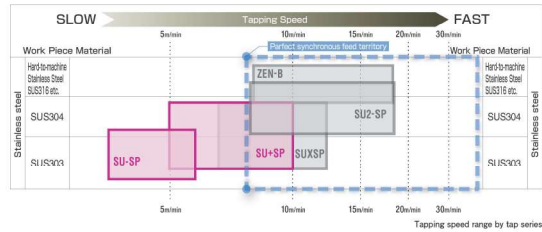
Tapping Conditions [M6×1]

Workpiece Material	SUS304 (90HRB)
Bored Hole Size	φ5.0
Tapping length	9mm, blind hole
Tapping Speed	8m/min
Machinery Type	Vertical machining center (perfect synchronous feed)
Tapping Fluid	Insoluble cutting fluid (chlorine-free)

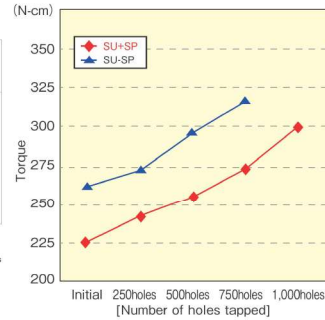


Speed chart

Taps for blind hole tapping of stainless steel.



Change in tapping torque



Notes

When tapping SS400 materials and soft steel materials with SU+SP, use a synchronized feed machine. If they are tapped with a non-synchronized feed drilling machine or the like, the internal thread may widen.

Think threads with YAMAWA

For improvement, spec may change without advance notice.

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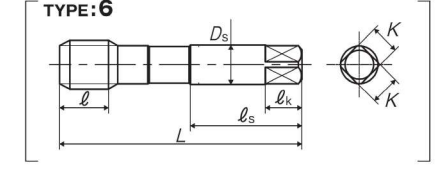
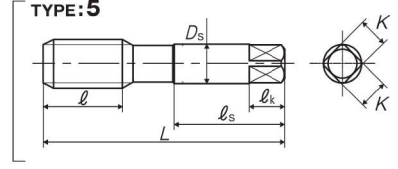
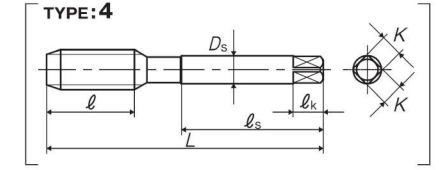
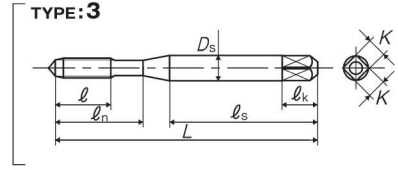
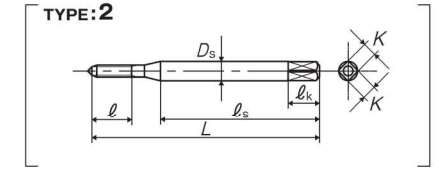
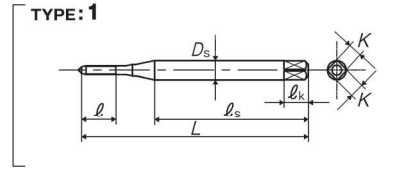
9 Thread Mills

10 Dies

11 Center Drills (Centering tools)

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1-76



○ 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	SUMP1.4C	2.5P	36	5.4	-	24	3	2.5	5	2	1	¥ 3,250*
M1.6 × 0.35	P1	SUMP1.6D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,100*
M1.7 × 0.35	P1	SUMP1.7D	2.5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,100*
M2 × 0.4	P1	SUPP2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,480
M2 × 0.4	P2	SUPP2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,480*
M2 × 0.4	P3	SUPP2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,480*
M2.3 × 0.4	P1	SUPP2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,260*
M2.3 × 0.4	P2	SUPP2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,260*
M2.3 × 0.4	P3	SUPP2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,260*
M2.5 × 0.45	P1	SUPP2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900
M2.5 × 0.45	P2	SUPP2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900*
M2.5 × 0.45	P3	SUPP2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900*
M2.6 × 0.45	P1	SUPP2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900
M2.6 × 0.45	P2	SUPP2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900*
M2.6 × 0.45	P3	SUPP2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900*
M3 × 0.5	P1	SUPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,330
M3 × 0.5	P2	SUPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,330*
M3 × 0.5	P3	SUPP3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,330*
3M0.6	P1	SUPP3.0H	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,330*
M3.5 × 0.6	P1	SUPP3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,330*
M3.5 × 0.6	P2	SUPP3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,330*
M3.5 × 0.6	P3	SUPP3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,330*
M4 × 0.7	P2	SUPP4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,330
M4 × 0.7	P3	SUPP4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,330*
M4 × 0.7	P4	SUPP4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,330*

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

Think threads with YAMAWA

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7/8-9UNC	P3	SUMRU14W	2.5P	115	33	-	55	17	13	16	4	5	¥ 17,400*
7/8-14UNF	P3	SUMRU14Q	2.5P	115	33	-	55	17	13	16	4	5	¥ 17,400*
1-8UNC	P3	SUMRU16X	2.5P	125	39	-	58	19	15	18	4	5	¥ 25,900*
1-12UNF	P3	SUMRU16S	2.5P	125	39	-	58	19	15	18	4	5	¥ 25,900*
For Whitworth Threads													
3/16W24	P2	SUMQW03M	2.5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,570*
1/4W20	P2	SUMQW04N	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,680*
5/16W18	P2	SUMQW05D	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,370*
3/8W16	P2	SUMQW06P	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,040*
7/16W14	P3	SUMRW07Q	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,280*
1/2W12	P3	SUMRW08S	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 4,550*
9/16W12	P3	SUMRW09S	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780*
5/8W11	P3	SUMRW10U	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780*
3/4W10	P3	SUMRW12V	2.5P	105	33	-	50	15	12	15	4	5	¥ 12,400*
7/8W9	P3	SUMRW14W	2.5P	115	33	-	55	17	13	16	4	5	¥ 17,400*
1 W8	P3	SUMRW16X	2.5P	125	39	-	58	19	15	18	4	5	¥ 25,900*

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⑨ Thread Mills

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⑪ Center Drills (Centering Tools)

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①-79



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