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

PO OX

Spiral Pointed Taps, Oxidized

Specification

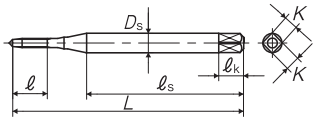
HSS | OX Oxide

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)

■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.

TYPE:1



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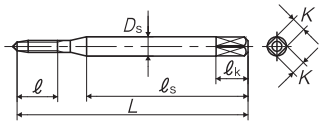

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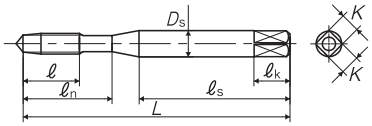

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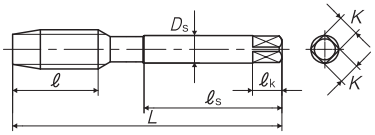

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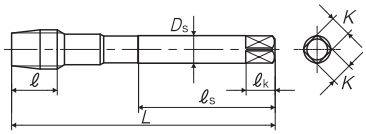

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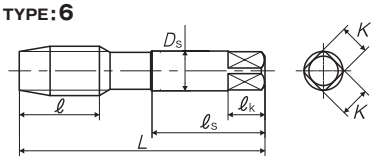

Oversize

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	¥ 4,070 ※
M1.4 × 0.3	P2	POQ1.4CX	5P	36	5.4	-	24	3	2.5	5	2	1	¥ 4,070 ※
M1.6 × 0.35	P2	POQ1.6DX	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,890 ※
M1.7 × 0.35	P2	POQ1.7DX	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 3,890 ※
M2 × 0.4	P2	POQ2.0EX	5P	42	7.2	12	27	3	2.5	5	3	3	¥ 3,110
M2 × 0.4	P3	POR2.0EX	5P	42	7.2	12	27	3	2.5	5	3	3	¥ 3,110 ※
M2.3 × 0.4	P2	POQ2.3EX	5P	42	7.2	12	27	3	2.5	5	3	3	¥ 2,840 ※
M2.5 × 0.45	P2	POQ2.5FX	5P	46	8.1	14	29	3	2.5	5	3	3	¥ 2,380 ※
M2.6 × 0.45	P2	POQ2.6FX	5P	46	8.1	14	29	3	2.5	5	3	3	¥ 2,380 ※
M2.6 × 0.45	P3	POR2.6FX	5P	46	8.1	14	29	3	2.5	5	3	3	¥ 2,380 ※
M3 × 0.5	P2	POQ3.0GX	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,670
M3 × 0.5	P3	POR3.0GX	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,670 ※
3M0.6	P2	POQ3.0HX	5P	46	9	14	26	4	3.2	6	3	3	¥ 1,670 ※
M3.5 × 0.6	P2	POQ3.5HX	5P	52	11	16	29	5	4	7	3	3	¥ 1,670 ※
M4 × 0.7	P2	POQ4.0IX	5P	52	11	17	29	5	4	7	3	3	¥ 1,670
M4 × 0.7	P3	POR4.0IX	5P	52	11	17	29	5	4	7	3	3	¥ 1,670 ※
4M0.75	P2	POQ4.0JX	5P	52	11	17	29	5	4	7	3	3	¥ 1,670 ※
M5 × 0.8	P2	POQ5.0KX	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680
M5 × 0.8	P3	POR5.0KX	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※

※ = Specified Distribution Items. Made to order products.

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

PO OX Spiral Pointed 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
5M0.9	P2	POQ5.0LX	5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,680 ※
M6 × 1	P2	POQ6.0MX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,850
M6 × 1	P3	POR6.0MX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,850 ※
M6 × 1	P4	POS6.0MX	5P	62	15	26	33	6	4.5	7	3	3	¥ 1,850 ※
M7 × 1	P2	POQ7.0MX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,210 ※
M8 × 1.25	P3	POR8.0NX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,550
M8 × 1.25	P4	POS8.0NX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,550 ※
M8 × 1	P3	POR8.0MX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,880 ※
M8 × 0.5	P2	POQ8.0GX	5P	70	10	-	36	6.2	5	8	3	5	¥ 4,070 ※
M10 × 1.5	P3	POR010OX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,230
M10 × 1.5	P4	POS010OX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,230 ※
M10 × 1.25	P3	POR010NX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,230 ※
M10 × 1	P3	POR010MX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,830 ※
M10 × 1	P4	POS010MX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,830 ※
M12 × 1.75	P4	POS012PX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,580
M12 × 1.5	P3	POR012OX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,580 ※
M12 × 1.25	P4	POS012NX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,580 ※
M14 × 2	P4	POS014QX	5P	88	26	-	45	10.5	8	11	3	4	¥ 6,240 ※
M14 × 1.5	P3	POR014OX	5P	88	26	-	45	10.5	8	11	3	4	¥ 6,240 ※
M14 × 1.25	P3	POR014NX	5P	88	26	-	45	10.5	8	11	3	4	¥ 7,240 ※
M14 × 1	P3	POR014MX	5P	88	26	-	45	10.5	8	11	3	4	¥ 7,240 ※
M16 × 2	P4	POS016QX	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,340
M16 × 1.5	P3	POR016OX	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,340 ※
M18 × 2.5	P4	POS018RX	5P	100	33	-	51	14	11	14	3	4	¥ 11,200 ※
M18 × 2	P4	POS018QX	5P	100	33	-	51	14	11	14	3	4	¥ 11,200 ※
M18 × 1.5	P4	POS018OX	5P	100	33	-	51	14	11	14	3	4	¥ 11,200 ※
M20 × 2.5	P4	POS020RX	5P	105	33	-	50	15	12	15	3	6	¥ 15,300
M20 × 1.5	P4	POS020OX	5P	105	33	-	50	15	12	15	3	6	¥ 15,300 ※
M22 × 2.5	P4	POS022RX	5P	115	33	-	55	17	13	16	3	6	¥ 19,500 ※
M22 × 1.5	P4	POS022OX	5P	115	33	-	55	17	13	16	3	6	¥ 19,500 ※
M24 × 3	P4	POS024SX	5P	120	39	-	55	19	15	18	3	6	¥ 24,300 ※
M25 × 1.5	P4	POS025OX	5P	125	39	-	58	19	15	18	3	6	¥ 31,400 ※
M26 × 3	P4	POS026SX	5P	130	39	-	60	20	15	18	4	6	¥ 33,800 ※
M27 × 3	P4	POS027SX	5P	130	39	-	60	20	15	18	4	6	¥ 33,800 ※
M30 × 3.5	P5	POT030TX	5P	135	46	-	62	23	17	20	4	6	¥ 43,000 ※
M30 × 3	P4	POS030SX	5P	135	46	-	62	23	17	20	4	6	¥ 43,000 ※
M32 × 2	P4	POMS032QX	5P	145	46	-	67	24	19	22	4	6	¥ 50,000 ※
M32 × 1.5	P4	POMS032OX	5P	145	46	-	67	24	19	22	4	6	¥ 50,000 ※
M33 × 3.5	P5	POMT033TX	5P	145	46	-	67	25	19	22	4	6	¥ 50,000 ※
M33 × 3	P4	POMS033SX	5P	145	46	-	67	25	19	22	4	6	¥ 50,000 ※
M36 × 4	P5	POMT036UX	5P	155	52	-	71	28	21	24	4	6	¥ 57,900 ※
M36 × 3	P4	POMS036SX	5P	155	52	-	71	28	21	24	4	6	¥ 57,900 ※
M42 × 4.5	P5	POMT042VX	5P	175	59	-	81	32	26	30	4	6	¥ 80,800 ※
For Unified Threads													
No.0-80UNF	P1	POPUN0BX	5P	36	6.3	-	24	3	2.5	5	2	2	¥ 4,610 ※
No.2-56UNC	P1	POPUN2EX	5P	42	8.1	12	27	3	2.5	5	3	3	¥ 3,260 ※
No.4-40UNC	P2	POQUN4HX	5P	46	9	14	25	4	3.2	6	3	3	¥ 2,100 ※
No.5-40UNC	P2	POQUN5HX	5P	52	11	16	28	5	4	7	3	3	¥ 1,960 ※
No.6-32UNC	P2	POQUN6JX	5P	52	11	17	27	5	4	7	3	3	¥ 1,960 ※
No.6-40UNF	P2	POQUN6HX	5P	52	11	17	27	5	4	7	3	3	¥ 1,960 ※
No.8-32UNC	P2	POQUN8JX	5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,970 ※

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

PO OX Spiral Pointed 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
No.10-24UNC	P2	POQUNAMX	5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 ※
No.10-32UNF	P2	POQUNAJX	5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,970 ※
No.12-24UNC	P2	POQUNCMX	5P	62	15	26	32	6	4.5	7	3	3	¥ 2,120 ※
No.12-28UNF	P2	POQUNCKX	5P	62	15	26	32	6	4.5	7	3	3	¥ 2,120 ※
1/4-20UNC	P2	POQU04NX	5P	62	15	26	33	6	4.5	7	3	3	¥ 2,120 ※
1/4-28UNF	P2	POQU04KX	5P	62	15	26	33	6	4.5	7	3	3	¥ 2,120 ※
5/16-18UNC	P3	PORU05OX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,930 ※
5/16-24UNF	P2	POQU05MX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,930 ※
3/8-16UNC	P3	PORU06PX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,750 ※
3/8-24UNF	P2	POQU06MX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,750 ※
7/16-14UNC	P3	PORU07QX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,270 ※
7/16-20UNF	P3	PORU07NX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,270 ※
1/2-13UNC	P3	PORU08RX	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,600 ※
1/2-20UNF	P3	PORU08NX	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,600 ※
9/16-18UNF	P3	PORU09OX	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,340 ※
5/8-11UNC	P3	PORU10UX	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,340 ※
5/8-18UNF	P3	PORU10OX	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,340 ※
3/4-10UNC	P4	POSU12VX	5P	105	33	-	50	15	12	15	3	6	¥ 15,300 ※
3/4-16UNF	P3	PORU12PX	5P	105	33	-	50	15	12	15	3	6	¥ 15,300 ※
7/8-9UNC	P4	POSU14WX	5P	115	33	-	55	17	13	16	3	6	¥ 21,500 ※
7/8-14UNF	P3	PORU14QX	5P	115	33	-	55	17	13	16	3	6	¥ 21,500 ※
1 -8UNC	P4	POSU16XX	5P	125	39	-	58	19	15	18	3	6	¥ 31,400 ※
1 3/8-12UNF	P4	POMSU22SX	5P	155	52	-	71	28	21	24	4	6	¥ 57,900 ※
1 1/2-12UNF	P4	POMSU24SX	5P	165	52	-	76	30	23	26	4	6	¥ 82,800 ※
For Whitworth Threads													
1/8W40	P2	POQW02HX	5P	52	11	16	28	5	4	7	3	3	¥ 2,440 ※
5/32W32	P2	POQW2HJX	5P	52	11	17	29	5	4	7	3	3	¥ 1,960 ※
3/16W24	P2	POQW03MX	5P	60	13	21	32	5.5	4.5	7	3	3	¥ 1,970 ※
1/4W20	P3	PORW04NX	5P	62	15	26	33	6	4.5	7	3	3	¥ 2,120 ※
5/16W18	P3	PORW05OX	5P	70	19	-	36	6.2	5	8	3	4	¥ 2,930 ※
3/8W16	P3	PORW06PX	5P	75	23	-	38	7	5.5	8	3	4	¥ 3,750 ※
7/16W14	P3	PORW07QX	5P	82	26	-	42	8.5	6.5	9	3	4	¥ 5,270 ※
1/2W12	P3	PORW08SX	5P	88	26	-	45	10.5	8	11	3	4	¥ 5,600 ※
5/8W11	P3	PORW10UX	5P	95	26	-	48	12.5	10	13	3	4	¥ 8,340 ※
3/4W10	P4	POSW12VX	5P	105	33	-	50	15	12	15	3	6	¥ 15,300 ※
7/8W9	P4	POSW14WX	5P	115	33	-	55	17	13	16	3	6	¥ 21,500 ※
1 W8	P4	POSW16XX	5P	125	39	-	58	19	15	18	3	6	¥ 31,400 ※
1 1/4W7	P4	POMSW20YX	5P	145	46	-	67	24	19	22	4	6	¥ 50,000 ※

※ = Specified Distribution Items. Made to order products.