

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
Premium Thread Mills

⑩

Dies

⑪

Center Drills
Centering Tools

⑫

Precision Machinery/
Medical Surgical Instruments

JIS

①-15



Z-PRO

VUSP 1.5P



Z-PRO

Coated Spiral Fluted Taps 1.5P

Specification



Tapping Speeds depending on Materials

Low carbon steels 低炭素鋼 5~15 (m/min)	Medium carbon steels 中炭素鋼 5~15 (m/min)	High carbon steels 高炭素鋼 5~15 (m/min)	Alloy steels 合金鋼 5~15 (m/min)	Stainless steels ステンレス鋼 3~10 (m/min)	Tool steels 工具鋼 5~10 (m/min)	Ductile cast irons 強靱鑄鉄 5~15 (m/min)
Wrought aluminum アルミ圧延材 5~20 (m/min)	Aluminum alloy castings アルミ合金鋳物 5~20 (m/min)					

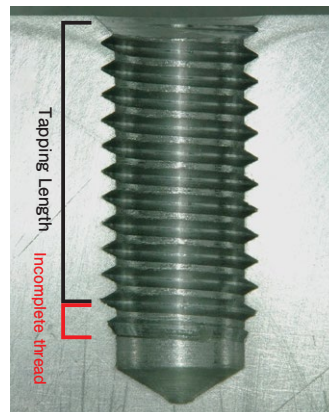
Product Features

- The chamfer length is 1.5 pitches, making it ideal for machining blind holes where there is little room between the bored hole depth and the full thread length.
- Durability is improved by premium powder HSS and special coating.
- Chip ejection efficiency is improved and cutting resistance is reduced by the unique cutting edge shape, achieving a good internal thread and long tool life.
- Proper tool projection length is secured, preventing chips from interfering with the holder.
- This is most suitable for tapping with water soluble cutting fluid.

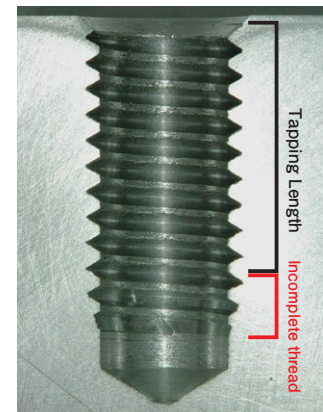
Tapping Data

Tapping condition [M6×1]

Work Material	S50C
Tapping Speed	15m/min
Machine	Machining center, vertical type
Tapping Fluid	Water soluble cutting fluid
Tapping Length	13mm, blind hole



VUSP 1.5P
Internal thread surface



VUSP (Chamfer 2.5P)
Internal thread surface

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L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

1

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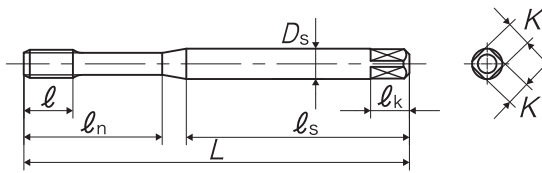
Precision Machinery/
Medical Surgical Instruments

⑫

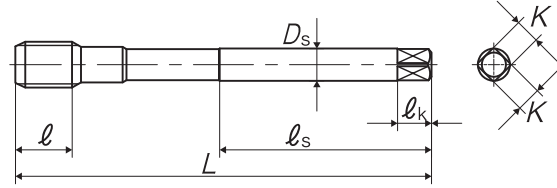
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①-16

TYPE: 1



TYPE: 2



Segment : 1D

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓ _n (mm)	ℓ _s (mm)	D _s (mm)	K (mm)	ℓ _k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads													
M3 × 0.5	P2	1103101035	1.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900
M3 × 0.35	P2	1103101036	1.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070 *
M4 × 0.7	P2	1103101042	1.5P	63	7	21	36	5	4	7	3	1	¥ 2,850
M4 × 0.5	P2	1103101043	1.5P	63	5	21	36	5	4	7	3	1	¥ 3,560 *
M5 × 0.8	P2	1103101049	1.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880
M5 × 0.5	P2	1103101051	1.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690 *
M6 × 1	P2	1103101055	1.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180
M6 × 0.75	P2	1103101056	1.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190 *
M6 × 0.5	P2	1103101057	1.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190 *
M8 × 1.25	P3	1103101064	1.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190
M8 × 1	P3	1103101065	1.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950 *
M10 × 1.5	P3	1103101078	1.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.25	P3	1103101079	1.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1	P3	1103101080	1.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280 *
M12 × 1.75	P4	1103101088	1.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.5	P3	1103101089	1.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.25	P3	1103101090	1.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M14 × 2	P4	1103101100	1.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 1.5	P3	1103101102	1.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450
M16 × 2	P4	1103101114	1.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 1.5	P3	1103101116	1.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300

* = Specified Distribution Items. Made to order products.

 Think threads with
YAMAWA