

Overall length	Thread length	Thread + Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓ	ℓ_n	ℓ_s	Ds	K	ℓ_k

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

AL-SP STI

Spiral Fluted Taps for Aluminum Materials (for Helical Coil Wire Screw Thread Inserts)



Specification

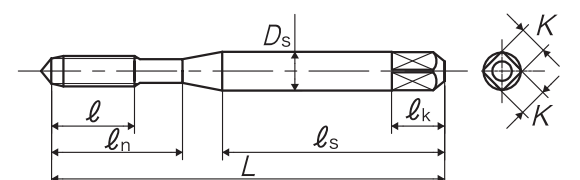


Tapping Speed depending on Materials

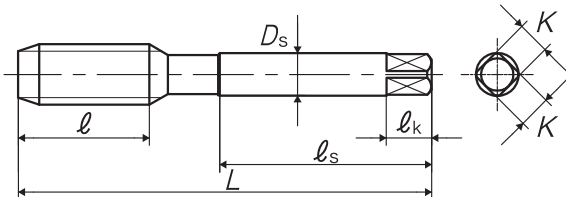
Brass 黄銅 10~25 (m/min)	Brass castings 黄銅鑄物 10~25 (m/min)	Bronze 青銅 10~25 (m/min)	Wrought aluminum アルミ圧延材 10~25 (m/min)	Aluminum alloy castings アルミ合金鑄物 10~25 (m/min)	Magnesium alloy die castings マグネシウム合金鑄物 10~25 (m/min)	Zinc alloy castings 亜鉛合金鑄物 10~25 (m/min)
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- This is used to cut a comparatively soft material, such as aluminum, and create an internal thread for accommodating a helical coil wire screw thread insert, in order to reinforce the internal thread and increase durability.
- Diameter of the internal screw threads into which the insert coil is inserted, is larger than that of the corresponding external screw threads by the thickness of the coil. Therefore, the internal screw thread diameter of the insert coil thread tap is also larger than its nominal diameter.
- The bored hole size needs to be also larger. Make sure to prepare an appropriate bored hole size before tapping.
- The shank diameter is also larger. Make sure to use an appropriate tap holder.
- Oversize taps of Ib+30 are also available to allow for shrinkage of internal threads.

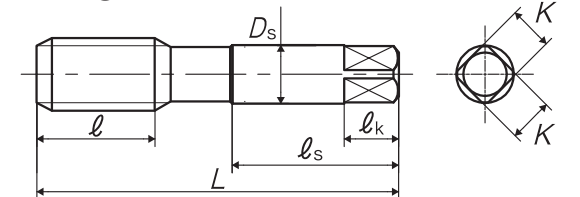
TYPE:1



TYPE:2



TYPE:3



Oversize

Segment : 1C

Size	Class	Code	Chamfer	Basic major dia (mm)	L (mm)	ℓ (mm)	ℓ_n (mm)	ℓ_s (mm)	Ds (mm)	K (mm)	ℓ_k (mm)	No. of flutes	TYPE	MSRP
For Metric Threads														
M3 × 0.5	Ib	SW3.0G1LEN	2.5P	3.650	52	7.5	17	29	5	4	7	3	1	¥ 2,450
M3 × 0.5	Ib+30	SW3.0G3LEN	2.5P	3.650	52	7.5	17	29	5	4	7	3	1	¥ 2,450
M4 × 0.7	Ib	SW4.0I1LEN	2.5P	4.909	60	13	22	33	5.5	4.5	7	3	1	¥ 2,330
M4 × 0.7	Ib+30	SW4.0I3LEN	2.5P	4.909	60	13	22	33	5.5	4.5	7	3	1	¥ 2,330
M5 × 0.8	Ib	SW5.0K1LEN	2.5P	6.039	62	15	26	33	6	4.5	7	3	1	¥ 2,230
M5 × 0.8	Ib+30	SW5.0K3LEN	2.5P	6.039	62	15	26	33	6	4.5	7	3	1	¥ 2,230
M6 × 1	Ib	SW6.0M1LEN	2.5P	7.299	70	19	-	36	6.2	5	8	3	2	¥ 2,280
M6 × 1	Ib+30	SW6.0M3LEN	2.5P	7.299	70	19	-	36	6.2	5	8	3	2	¥ 2,280
M8 × 1.25	Ib	SW8.0N1LEN	2.5P	9.624	75	23	-	38	7	5.5	8	3	2	¥ 3,200
M8 × 1.25	Ib+30	SW8.0N3LEN	2.5P	9.624	75	23	-	38	7	5.5	8	3	2	¥ 3,200
M10 × 1.5	Ib	SW010O1LEN	2.5P	11.948	82	26	-	42	8.5	6.5	9	3	2	¥ 4,300
M10 × 1.5	Ib+30	SW010O3LEN	2.5P	11.948	82	26	-	42	8.5	6.5	9	3	2	¥ 4,300
M10 × 1.25	Ib	SW010N1LEN	2.5P	11.624	82	26	-	42	8.5	6.5	9	3	2	¥ 4,300 *
M12 × 1.75	Ib	SW012P1LEN	2.5P	14.273	95	26	-	48	12.5	10	13	3	2	¥ 5,910
M12 × 1.5	Ib	SW012O1LEN	2.5P	13.948	88	26	-	45	10.5	8	11	3	2	¥ 5,910 *
M12 × 1.25	Ib	SW012N1LEN	2.5P	13.624	88	26	-	45	10.5	8	11	3	2	¥ 5,910 *

Think threads with
YAMAWA

* = Specified Distribution Items. Made to order products.

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L	ℓ	ℓn	ℓs	Ds	K	ℓk

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JIS

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M14 × 2	I b	SW014Q1LEN	2.5P	16.598	100	33	-	51	14	11	14	3	2	¥ 7,780 ※
M14 × 1.5	I b	SW014O1LEN	2.5P	15.948	95	26	-	48	12.5	10	13	3	2	¥ 7,780 ※
M16 × 2	I b	SW016Q1LEN	2.5P	18.598	105	33	-	50	15	12	15	4	3	¥ 11,300
M16 × 1.5	I b	SW016O1LEN	2.5P	17.948	100	33	-	51	14	11	14	4	2	¥ 11,300 ※
M18 × 2.5	I b	SW018R1LEN	2.5P	21.248	115	33	-	55	17	13	16	4	3	¥ 18,600 ※
M18 × 1.5	I b	SW018O1LEN	2.5P	19.948	105	33	-	50	15	12	15	4	3	¥ 18,600 ※
M20 × 2.5	I b	SW020R1LEN	2.5P	23.248	120	39	-	55	19	15	18	4	3	¥ 22,100
M20 × 1.5	I b	SW020O1LEN	2.5P	21.948	115	33	-	55	17	13	16	4	3	¥ 22,100 ※
M22 × 2.5	I b	SW022R1LEN	2.5P	25.248	125	39	-	58	19	15	18	4	3	¥ 28,800 ※
M24 × 3	I b	SW024S1LEN	2.5P	27.897	135	46	-	62	23	17	20	4	3	¥ 35,600

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Thread Mills
Premium Thread Mills

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Dies

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Center Drills
Centering Tools

⑪

Precision Machinery/
Medical Surgical Instruments

⑫

JIS

⑦-14

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YAMAWA