

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

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P
I
S

Z-PRO
VUSP

Z-PRO
Coated Spiral Fluted Taps



Specification



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	Alloy steels 合金鋼	Stainless steels ステンレス鋼	Tool steels 工具鋼	Ductile cast irons 鋇期鑄鉄
10~20 (m/min)	10~30 (m/min)	10~30 (m/min)	10~20 (m/min)	3~10 (m/min)	5~10 (m/min)	10~30 (m/min)
Wrought aluminum アルミ圧延材	Aluminum alloy castings アルミ合金鋳物					
10~30 (m/min)	10~35 (m/min)					

*For long shank type, the recommended cutting speed is 30% less than the above.

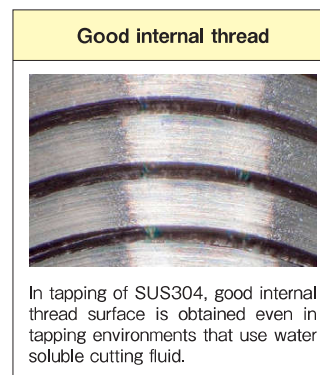
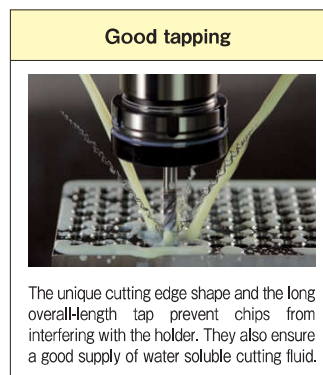
Product Features

- 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

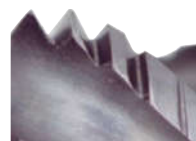
Tapping conditions [M8×1.25]

Work Material	SUS304
Tapping Length	16mm
Tapping Speed	10m/min
Machine	Machining center, vertical type
Tapping Fluid	Water soluble cutting fluid

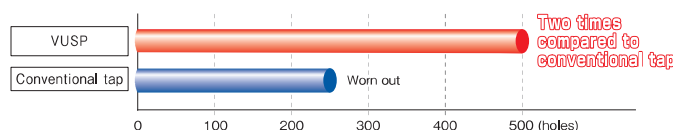


Tapping conditions [M3×0.5]

Work Material	S50C
Tapping Length	4.5mm
Tapping Speed	20m/min
Machine	Machining center, vertical type
Tapping Fluid	Water soluble cutting fluid



Close-up of VUSP after Tapping of 250 Holes



- Compatible with a wide range of work materials

This is compatible with a wide range of steel work materials including general structural steel, carbon steel, and alloy steel.

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Think threads with
YAMAWA

①-5

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L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

1

JIS

Spiral Fluted Taps
(for blind hole)

①

Spiral Fluted Taps
(for through hole)

②

Spiral Pointed Taps
(for through hole)

③

Hand Taps

④

Cemented
Carbide Taps

⑤

Roll Taps

⑥

Special Thread Taps
Simple Inspection Tools

⑦

Pipe Taps

⑧

Thread Mills
Premium Thread Mills

⑨

Dies

⑩

Center Drills
Centering Tools

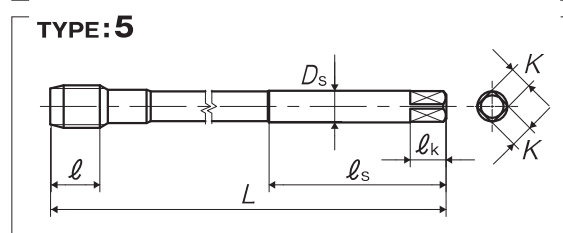
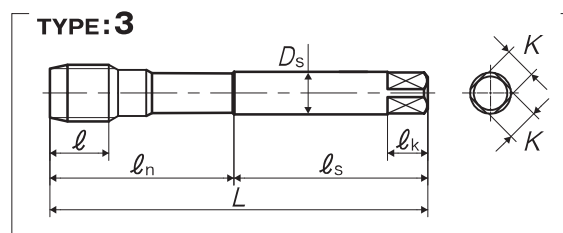
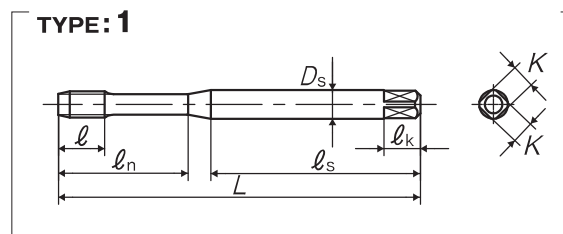
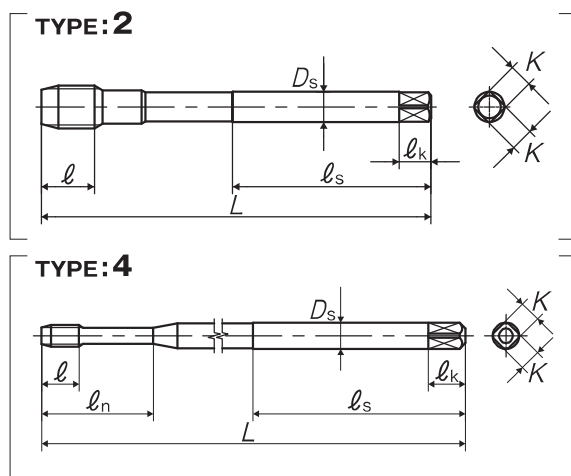
⑪

Precision Machinery/
Medical Surgical Instruments

⑫

JIS

①-6



Oversize

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	1101101035	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900
M3 × 0.5	P3	1101201035	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900
M3 × 0.5	P4	1101301035	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 2,900*
M3 × 0.35	P2	1101101036	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070
M3 × 0.35	P3	1101201036	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070*
M3 × 0.35	P4	1101301036	2.5P	56	5	18	32	4	3.2	6	3	1	¥ 4,070*
M4 × 0.7	P2	1101101042	2.5P	63	7	21	36	5	4	7	3	1	¥ 2,850
M4 × 0.7	P3	1101201042	2.5P	63	7	21	36	5	4	7	3	1	¥ 2,850
M4 × 0.7	P4	1101301042	2.5P	63	7	21	36	5	4	7	3	1	¥ 2,850*
M4 × 0.5	P2	1101101043	2.5P	63	5	21	36	5	4	7	3	1	¥ 3,560
M4 × 0.5	P3	1101201043	2.5P	63	5	21	36	5	4	7	3	1	¥ 3,560*
M4 × 0.5	P4	1101301043	2.5P	63	5	21	36	5	4	7	3	1	¥ 3,560*
M5 × 0.8	P2	1101101049	2.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880
M5 × 0.8	P3	1101201049	2.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880
M5 × 0.8	P4	1101301049	2.5P	70	9	25	40	5.5	4.5	7	3	1	¥ 2,880*
M5 × 0.5	P2	1101101051	2.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690
M5 × 0.5	P3	1101201051	2.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690*
M5 × 0.5	P4	1101301051	2.5P	70	6	25	40	5.5	4.5	7	3	1	¥ 3,690*
M6 × 1	P2	1101101055	2.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180
M6 × 1	P3	1101201055	2.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180
M6 × 1	P4	1101301055	2.5P	80	11	30	45	6	4.5	7	3	1	¥ 3,180*
M6 × 0.75	P2	1101101056	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190
M6 × 0.75	P3	1101201056	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190*
M6 × 0.75	P4	1101301056	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190*
M6 × 0.5	P2	1101101057	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190
M6 × 0.5	P3	1101201057	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190*
M6 × 0.5	P4	1101301057	2.5P	80	8	30	45	6	4.5	7	3	1	¥ 4,190*

* = Specified Distribution Items. Made to order products.

Think threads with
YAMAWA

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VUSP Z-PRO Coated Spiral Fluted Taps

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Premium Thread Mills

⑩ Dies

⑪ Center Drills
Centering Tools

⑫ Precision Machinery/
Medical Surgical Instruments

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M8 × 1.25	P3	1101101064	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190
M8 × 1.25	P4	1101201064	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190
M8 × 1.25	P5	1101301064	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,190**
M8 × 1	P3	1101101065	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950
M8 × 1	P4	1101201065	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950**
M8 × 1	P5	1101301065	2.5P	90	12	-	46	6.2	5	8	3	2	¥ 4,950**
M10 × 1.5	P3	1101101078	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.5	P4	1101201078	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.5	P5	1101301078	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290**
M10 × 1.25	P3	1101101079	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.25	P4	1101201079	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290
M10 × 1.25	P5	1101301079	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 5,290**
M10 × 1	P3	1101101080	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280
M10 × 1	P4	1101201080	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280**
M10 × 1	P5	1101301080	2.5P	100	13	-	51	7	5.5	8	3	2	¥ 6,280**
M12 × 1.75	P4	1101101088	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.75	P5	1101201088	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.75	P6	1101301088	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900**
M12 × 1.5	P3	1101101089	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.5	P4	1101201089	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.5	P5	1101301089	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900**
M12 × 1.25	P3	1101101090	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.25	P4	1101201090	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900
M12 × 1.25	P5	1101301090	2.5P	110	15	-	56	8.5	6.5	9	3	2	¥ 6,900**
M14 × 2	P4	1101101100	2.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 2	P5	1101201100	2.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 2	P6	1101301100	2.5P	110	18	-	56	10.5	8	11	3	2	¥ 9,450**
M14 × 1.5	P3	1101101102	2.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 1.5	P4	1101201102	2.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450
M14 × 1.5	P5	1101301102	2.5P	110	14	-	56	10.5	8	11	3	2	¥ 9,450**
M16 × 2	P4	1101101114	2.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 2	P5	1101201114	2.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 2	P6	1101301114	2.5P	110	18	-	56	12.5	10	13	3	2	¥ 12,300**
M16 × 1.5	P3	1101101116	2.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 1.5	P4	1101201116	2.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300
M16 × 1.5	P5	1101301116	2.5P	110	14	-	56	12.5	10	13	3	2	¥ 12,300**
M18 × 2.5	P5	1101101128	2.5P	125	20	-	64	14	11	14	4	2	¥ 15,500
M18 × 1.5	P4	1101101130	2.5P	125	14	-	64	14	11	14	3	2	¥ 15,500
M20 × 2.5	P5	1101101141	2.5P	140	20	-	71	15	12	15	4	3	¥ 22,400
M20 × 1.5	P4	1101101144	2.5P	140	14	-	71	15	12	15	3	3	¥ 22,400
M22 × 2.5	P5	1101101156	2.5P	140	20	-	71	17	13	16	4	3	¥ 27,000
M22 × 1.5	P4	1101101158	2.5P	140	14	-	71	17	13	16	3	3	¥ 27,000
M24 × 3	P5	1101101167	2.5P	160	25	-	82	19	15	18	4	3	¥ 32,900
M24 × 1.5	P4	1101101170	2.5P	160	18	-	82	19	15	18	3	3	¥ 32,900
Long shank, for Metric Threads													
M3 × 0.5	P2	2101101035	2.5P	100	5	18	32	4	3.2	6	3	4	¥ 5,260
M3 × 0.35	P2	2101101036	2.5P	100	5	18	32	4	3.2	6	3	4	¥ 7,370**
M4 × 0.7	P2	2101101042	2.5P	100	7	21	36	5	4	7	3	4	¥ 4,800
M4 × 0.5	P2	2101101043	2.5P	100	5	21	36	5	4	7	3	4	¥ 6,240**
M5 × 0.8	P2	2101101049	2.5P	100	9	25	40	5.5	4.5	7	3	4	¥ 4,310

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VUSP Z-PRO Coated 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 × 0.5	P2	2101101051	2.5P	100	6	25	40	5.5	4.5	7	3	4	¥ 5,390 ^{**}
M6 × 1	P2	2101101055	2.5P	100	11	30	45	6	4.5	7	3	4	¥ 4,410
M6 × 0.75	P2	2101101056	2.5P	100	8	30	45	6	4.5	7	3	4	¥ 5,520
M6 × 0.5	P2	2101101057	2.5P	100	8	30	45	6	4.5	7	3	4	¥ 5,520 ^{**}
M8 × 1.25	P3	2101101064	2.5P	150	12	-	46	6.2	5	8	3	5	¥ 7,600
M8 × 1	P3	2101101065	2.5P	150	12	-	46	6.2	5	8	3	5	¥ 8,740
M10 × 1.5	P3	2101101078	2.5P	150	13	-	51	7	5.5	8	3	5	¥ 8,890
M10 × 1.25	P3	2101101079	2.5P	150	13	-	51	7	5.5	8	3	5	¥ 8,890
M10 × 1	P3	2101101080	2.5P	150	13	-	51	7	5.5	8	3	5	¥ 10,300
M12 × 1.75	P4	2101101088	2.5P	150	15	-	56	8.5	6.5	9	3	5	¥ 10,600
M12 × 1.5	P3	2101101089	2.5P	150	15	-	56	8.5	6.5	9	3	5	¥ 10,600
M12 × 1.25	P3	2101101090	2.5P	150	15	-	56	8.5	6.5	9	3	5	¥ 10,600
M14 × 2	P4	2101101100	2.5P	150	18	-	56	10.5	8	11	3	5	¥ 14,200
M14 × 1.5	P3	2101101102	2.5P	150	14	-	56	10.5	8	11	3	5	¥ 14,200
M16 × 2	P4	2101101114	2.5P	150	18	-	56	12.5	10	13	3	5	¥ 14,900
M16 × 1.5	P3	2101101116	2.5P	150	14	-	56	12.5	10	13	3	5	¥ 14,900

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JIS

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Dies ⑩

Center Drills
Centering Tools ⑪Precision Machinery/
Medical Surgical Instruments ⑫

JIS

①-8