

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

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 ~ 10 (m/min)	High carbon steels 高炭素鋼 ~ 10 (m/min)	Alloy steels 合金鋼 ~ 10 (m/min)	Stainless steels ステンレス鋼 ~ 10 (m/min)
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For icon explanation, refer to icon-1

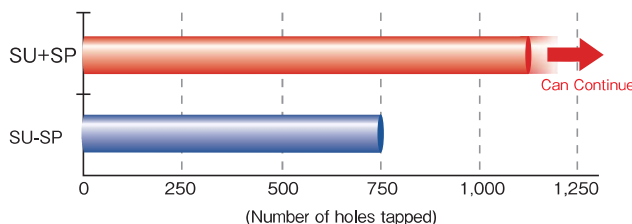
Product features

- 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

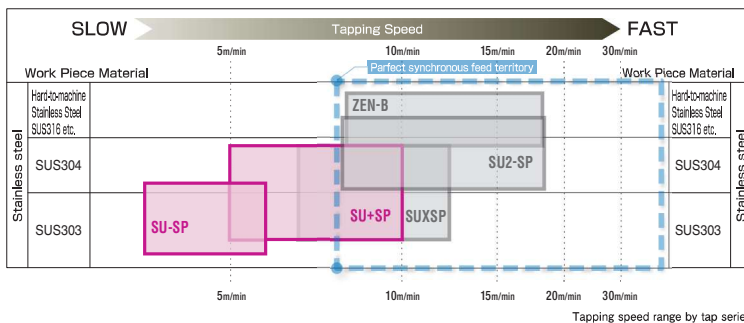
Tapping Conditions [M6×1]

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)

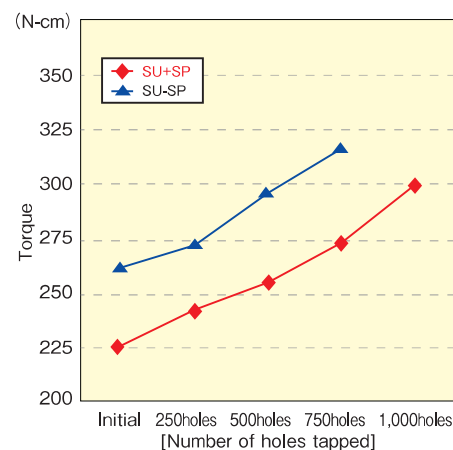


Speed chart

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.

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①-75

Think threads with
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For improvement, spec may change without advance notice.

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L	ℓ	ℓ _n	ℓ _s	D _s	K	ℓ _k

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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

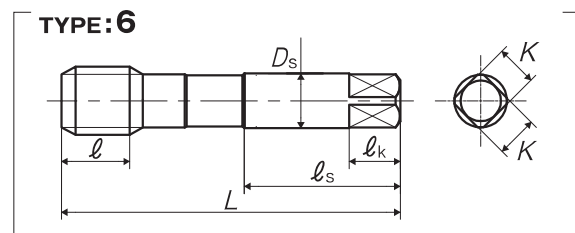
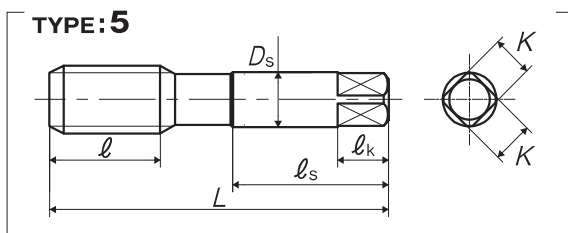
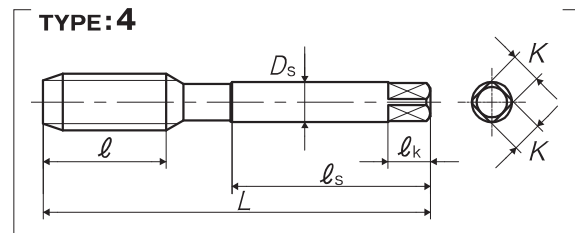
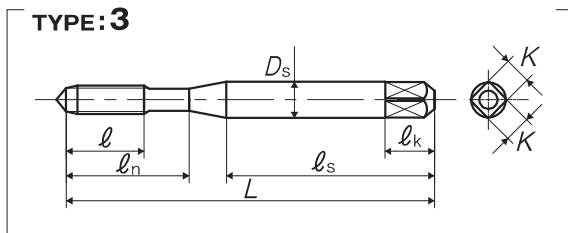
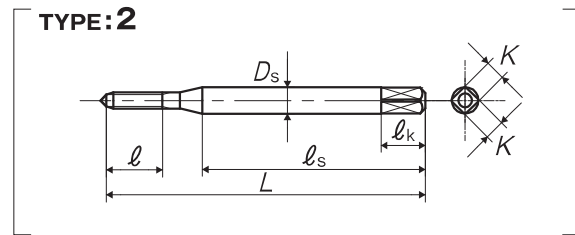
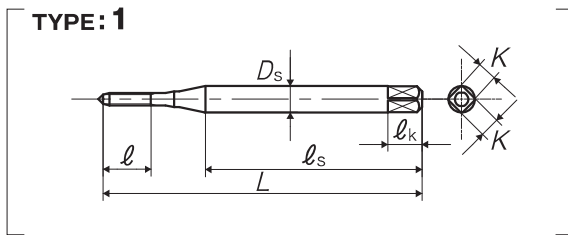
⑨

Dies

⑩

Center Drills
Centering Tools

⑪



Oversize

Segment : 1C

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													
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 ^{**}
M1.7 × 0.35	P2	SUMQ1.7D	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	SUPQ2.0E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,480 ^{**}
M2 × 0.4	P3	SUPR2.0E	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	SUPQ2.3E	2.5P	42	7.2	12	27	3	2.5	5	2	3	¥ 2,260 ^{**}
M2.3 × 0.4	P3	SUPR2.3E	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	SUPQ2.5F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900 ^{**}
M2.5 × 0.45	P3	SUPR2.5F	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	SUPQ2.6F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 1,900 ^{**}
M2.6 × 0.45	P3	SUPR2.6F	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	SUPQ3.0G	2.5P	46	9	14	26	4	3.2	6	3	3	¥ 1,330 ^{**}
M3 × 0.5	P3	SUPR3.0G	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	P3	SUPR3.5H	2.5P	52	11	16	29	5	4	7	3	3	¥ 1,330 ^{**}
M4 × 0.7	P2	SUPQ4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,330
M4 × 0.7	P3	SUPR4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,330 ^{**}
M4 × 0.7	P4	SUPS4.0I	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,330 ^{**}

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Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
4M0.75	P2	SUPQ4.0J	2.5P	52	11	17	29	5	4	7	3	3	¥ 1,330**
M5 × 0.8	P2	SUPQ5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,340
M5 × 0.8	P3	SUPR5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,340**
M5 × 0.8	P4	SUPR5.0K	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,340**
5M0.9	P2	SUPQ5.0L	2.5P	60	13	22	33	5.5	4.5	7	3	3	¥ 1,340**
M6 × 1	P2	SUPQ6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,480
M6 × 1	P3	SUPR6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,480**
M6 × 1	P4	SUPR6.0M	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,480**
M6 × 0.75	P2	SUMQ6.0J	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 2,070**
M8 × 1.25	P2	SUMQ8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,060
M8 × 1.25	P3	SUMR8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,060**
M8 × 1.25	P4	SUMS8.0N	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,060**
M8 × 1	P2	SUMQ8.0M	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,340**
M8 × 0.75	P2	SUMQ8.0J	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,650**
M10 × 1.5	P2	SUMQ0100	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 2,630
M10 × 1.5	P3	SUMR0100	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 2,630**
M10 × 1.5	P4	SUMS0100	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 2,630**
M10 × 1.25	P2	SUMQ010N	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 2,630
M10 × 1.25	P3	SUMR010N	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 2,630**
M10 × 1.25	P4	SUMS010N	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 2,630**
M10 × 1	P2	SUMQ010M	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,120**
M10 × 1	P4	SUMS010M	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,120**
M12 × 1.75	P2	SUMQ012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720
M12 × 1.75	P3	SUMR012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720**
M12 × 1.75	P4	SUMS012P	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720**
M12 × 1.5	P2	SUMQ0120	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720
M12 × 1.5	P3	SUMR0120	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720**
M12 × 1.5	P4	SUMS0120	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720**
M12 × 1.25	P2	SUMQ012N	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720
M12 × 1.25	P3	SUMR012N	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 3,720**
M12 × 1	P2	SUMQ012M	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,370**
M14 × 2	P2	SUMQ014Q	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,080
M14 × 2	P3	SUMR014Q	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,080**
M14 × 2	P4	SUMS014Q	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,080**
M14 × 1.5	P2	SUMQ0140	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,080
M14 × 1.5	P4	SUMS0140	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,080**
M14 × 1	P2	SUMQ014M	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 5,890**
M16 × 2	P2	SUMQ016Q	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780
M16 × 2	P3	SUMR016Q	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780**
M16 × 2	P4	SUMS016Q	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780**
M16 × 1.5	P2	SUMQ0160	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780
M16 × 1.5	P4	SUMS0160	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780**
M18 × 2.5	P3	SUMR018R	2.5P	100	33	-	51	14	11	14	4	4	¥ 9,060
M18 × 2.5	P4	SUMS018R	2.5P	100	33	-	51	14	11	14	4	4	¥ 9,060**
M18 × 1.5	P2	SUMQ0180	2.5P	100	33	-	51	14	11	14	4	4	¥ 9,060
M18 × 1.5	P4	SUMS0180	2.5P	100	33	-	51	14	11	14	4	4	¥ 9,060**
M20 × 2.5	P3	SUMR020R	2.5P	105	33	-	50	15	12	15	4	5	¥ 12,400
M20 × 2.5	P4	SUMS020R	2.5P	105	33	-	50	15	12	15	4	5	¥ 12,400**
M20 × 1.5	P3	SUMR0200	2.5P	105	33	-	50	15	12	15	4	5	¥ 12,400
M20 × 1.5	P4	SUMS0200	2.5P	105	33	-	50	15	12	15	4	5	¥ 12,400**

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SU+SP/SU-SP Spiral Fluted Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
M22 × 2.5	P3	SUMR022R	2.5P	115	33	-	55	17	13	16	4	5	¥ 15,800
M22 × 2.5	P4	SUMS022R	2.5P	115	33	-	55	17	13	16	4	5	¥ 15,800*
M22 × 2.5	P5	SUMT022R	2.5P	115	33	-	55	17	13	16	4	5	¥ 15,800*
M22 × 1.5	P3	SUMR0220	2.5P	115	33	-	55	17	13	16	4	5	¥ 15,800*
M22 × 1.5	P4	SUMS0220	2.5P	115	33	-	55	17	13	16	4	5	¥ 15,800*
M24 × 3	P3	SUMR024S	2.5P	120	39	-	55	19	15	18	4	5	¥ 19,700
M24 × 3	P4	SUMS024S	2.5P	120	39	-	55	19	15	18	4	5	¥ 19,700*
M24 × 3	P5	SUMT024S	2.5P	120	39	-	55	19	15	18	4	5	¥ 19,700*
M24 × 2	P3	SUMR024Q	2.5P	120	39	-	55	19	15	18	4	5	¥ 19,700*
M24 × 1.5	P3	SUMR0240	2.5P	120	39	-	55	19	15	18	4	5	¥ 19,700*
M24 × 1.5	P4	SUMS0240	2.5P	120	39	-	55	19	15	18	4	5	¥ 19,700*
M27 × 3	P3	SUMR027S	2.5P	130	39	-	60	20	15	18	4	5	¥ 27,900*
M27 × 1.5	P3	SUMR0270	2.5P	130	39	-	60	20	15	18	4	5	¥ 27,900*
M30 × 3.5	P4	SUMS030T	2.5P	135	46	-	62	23	17	20	4	5	¥ 35,600*
M30 × 1.5	P3	SUMR0300	2.5P	135	46	-	62	23	17	20	4	5	¥ 35,600*
M33 × 3.5	P4	SUMS033T	2.5P	145	46	-	67	25	19	22	4	5	¥ 41,400*
M36 × 4	P4	SUMS036U	2.5P	155	52	-	71	28	21	24	4	5	¥ 48,000*
M39 × 4	P4	SUMS039U	2.5P	165	52	-	76	30	23	26	4	5	¥ 55,000*
M42 × 4.5	P4	SUMS042V	2.5P	175	59	-	81	32	26	30	4	5	¥ 66,900*
M42 × 1.5	P3	SUMR0420	2.5P	175	27	-	81	32	26	30	4	6	¥ 66,900*
M45 × 4.5	P4	SUMS045V	2.5P	180	59	-	83	35	26	30	4	5	¥ 77,400*
M48 × 5	P4	SUMS048W	2.5P	185	65	-	85	38	29	32	4	5	¥ 96,800*
For Unified Threads													
No.2-56UNC	P1	SUMPUN2E	2.5P	42	8.1	12	27	3	2.5	5	2	3	¥ 2,590*
No.3-48UNC	P1	SUMPUN3F	2.5P	46	8.1	14	29	3	2.5	5	2	3	¥ 2,190*
No.4-40UNC	P1	SUMPUN4H	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 1,670*
No.4-48UNF	P1	SUMPUN4F	2.5P	46	9	14	25	4	3.2	6	2	3	¥ 1,670*
No.5-40UNC	P1	SUMPUN5H	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,560*
No.5-44UNF	P1	SUMPUN5G	2.5P	52	11	16	28	5	4	7	3	3	¥ 1,560*
No.6-32UNC	P2	SUMQUN6J	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,560*
No.6-40UNF	P1	SUMPUN6H	2.5P	52	11	17	27	5	4	7	3	3	¥ 1,560*
No.8-32UNC	P2	SUMQUN8J	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,570*
No.8-36UNF	P2	SUMQUN8I	2.5P	60	13	22	31	5.5	4.5	7	3	3	¥ 1,600*
No.10-24UNC	P2	SUMQUNAM	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,600*
No.10-32UNF	P2	SUMQUAJ	2.5P	60	13	22	32	5.5	4.5	7	3	3	¥ 1,600*
1/4-20UNC	P2	SUMQU04N	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,700*
1/4-28UNF	P2	SUMQU04K	2.5P	62	15	26	33	6	4.5	7	3	3	¥ 1,700*
5/16-18UNC	P2	SUMQU05O	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,370*
5/16-24UNF	P2	SUMQU05M	2.5P	70	19	-	36	6.2	5	8	3	4	¥ 2,370*
3/8-16UNC	P2	SUMQU06P	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,040*
3/8-24UNF	P2	SUMQU06M	2.5P	75	23	-	38	7	5.5	8	3	4	¥ 3,040*
7/16-14UNC	P3	SUMRU07Q	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,280*
7/16-20UNF	P2	SUMQU07N	2.5P	82	26	-	42	8.5	6.5	9	3	4	¥ 4,280*
1/2-13UNC	P3	SUMRU08R	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 4,550*
1/2-20UNF	P2	SUMQU08N	2.5P	88	26	-	45	10.5	8	11	3	4	¥ 4,550*
5/8-11UNC	P3	SUMRU10U	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780*
5/8-18UNF	P2	SUMQU100	2.5P	95	26	-	48	12.5	10	13	3	4	¥ 6,780*
3/4-10UNC	P3	SUMRU12V	2.5P	105	33	-	50	15	12	15	4	5	¥ 12,400*
3/4-16UNF	P3	SUMRU12P	2.5P	105	33	-	50	15	12	15	4	5	¥ 12,400*

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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

⑨

Dies

⑩

Center Drills
Centering Tools

⑪

JIS

①-78

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

SU+SP/SU-SP Spiral Fluted Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	TYPE	MSRP
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	SUMQW05O	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

⑩ Dies

⑪ Center Drills Centering Tools

JIS

①-79



Think threads with
YAMAWA

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

M E M O

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