

PO-VA

Spiral Pointed Taps for Stainless Steels

Specification

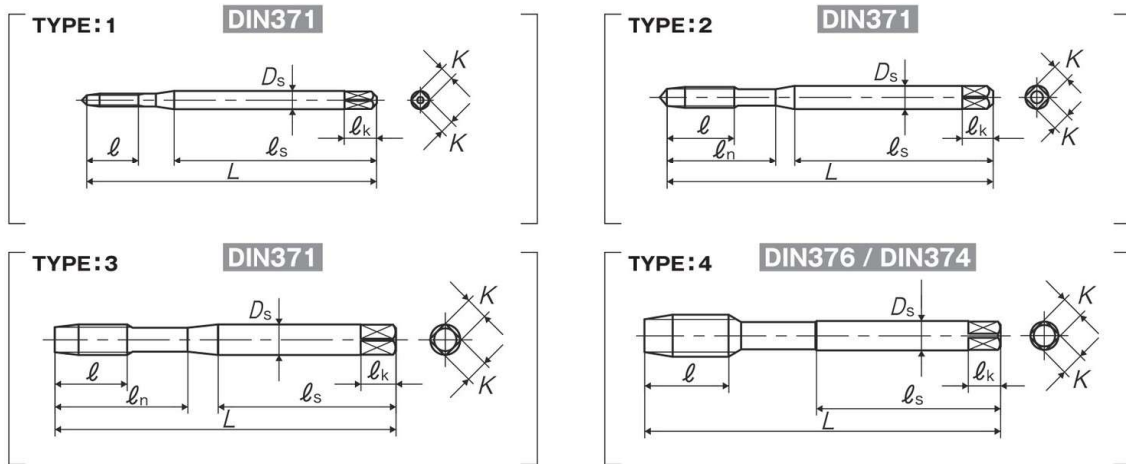


■ Suitable for stainless steels tending to work harden and sticky, as well as chrome steels and molybdenum steels. Through hole use.

Recommended Tapping Speeds depending on Materials

Free cutting and structural steel ISO P1 ~10 (m/min)	Carbon steel and low alloy steel ISO P2 ~10 (m/min)	Medium alloy steel and heat treated steel ISO P3 ~5 (m/min)	High alloy steel ISO P4 ~5 (m/min)	Ferritic and austenitic stainless steel ISO M1~M3 ~10 (m/min)
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For icon explanation, refer to P.50



Segment : 1F

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	Stock
For Metric Threads													
M2 × 0.4	ISO2X	PD2.0EBGEX	4.5P	45	8	-	32	2.8	2.1	5	2	1	●
M2.5 × 0.45	ISO2X	PD2.5FBGEX	4.5P	50	8	15	33	2.8	2.1	5	2	2	●
M3 × 0.5	ISO2X	PD3.0GBGEX	4.5P	56	9	18	34	3.5	2.7	6	3	2	●
M4 × 0.7	ISO2X	PD4.0IBGEX	4.5P	63	13	21	38	4.5	3.4	6	3	2	●
M5 × 0.8	ISO2X	PD5.0KBGEX	4.5P	70	14	25	39	6	4.9	8	3	2	●
M6 × 1	ISO2X	PD6.0MBGEX	4.5P	80	15	30	45	6	4.9	8	3	2	●
M8 × 1.25	ISO2X	PD8.0NBGEX	4.5P	90	19	35	47	8	6.2	9	3	3	●
		PG8.0NBGEX	4.5P	90	19	-	46	6	4.9	8	3	4	●
M8 × 1	ISO2X	PM8.0MBGEX	4.5P	90	19	-	46	6	4.9	8	3	4	●
M10 × 1.5	ISO2X	PD10.0QBGEX	4.5P	100	23	39	52	10	8	11	3	3	●
		PG10.0QBGEX	4.5P	100	23	-	51	7	5.5	8	3	4	●
M10 × 1.25	ISO2X	PM10.0NBGEX	4.5P	100	23	-	51	7	5.5	8	3	4	●
M10 × 1	ISO2X	PM10.0MBGEX	4.5P	90	19	-	46	7	5.5	8	3	4	●
M12 × 1.75	ISO2X	PG12.0PBGEX	4.5P	110	26	-	56	9	7	10	3	4	●
M12 × 1.5	ISO2X	PM12.0NBGEX	4.5P	100	21	-	51	9	7	10	3	4	●
M12 × 1.25	ISO2X	PM12.0NBGEX	4.5P	100	21	-	51	9	7	10	3	4	●
M12 × 1	ISO2X	PM12.0MBGEX	4.5P	100	21	-	51	9	7	10	3	4	●
M14 × 2	ISO2X	PG14.0QBGEX	4.5P	110	26	-	56	11	9	12	3	4	●
M14 × 1.5	ISO2X	PM14.0QBGEX	4.5P	100	21	-	51	11	9	12	3	4	●

Think threads with
YAMAWA

DIN
PO-14

127

Spiral Fluted Taps
(for blind hole)

Spiral Fluted Taps
(for through hole)

Spiral Pointed Taps
(for through hole)

Hand Taps

Cemented
Carbide Taps

Roll Taps

Special Thread Taps
Simple Inspection Tools

Pipe Taps

Thread Mills

Dies

Center Drills

Centering Tools

Spiral Pointed Tap Series

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-VA Spiral Pointed 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	Stock
M16 × 2	IS02X	PG016QBGEX	4.5P	110	26	-	56	12	9	12	3	4	●
M16 × 1.5	IS02X	PM0160BGEX	4.5P	100	21	-	51	12	9	12	3	4	●
M18 × 2.5	IS02X	PG018RBGEX	4.5P	125	33	-	64	14	11	14	3	4	●
M18 × 1.5	IS02X	PM0180BGEX	4.5P	110	24	-	56	14	11	14	3	4	●
M20 × 2.5	IS02X	PG020RBGEX	4.5P	140	33	-	71	16	12	15	3	4	●
M20 × 1.5	IS02X	PM0200BGEX	4.5P	125	24	-	64	16	12	15	3	4	●
M22 × 2.5	IS02X	PG022RBGEX	4.5P	140	33	-	71	18	14.5	17	3	4	●
M22 × 1.5	IS02X	PM0220BGEX	4.5P	125	24	-	64	18	14.5	17	3	4	●
M24 × 3	IS02X	PG024SBGEX	4.5P	160	37	-	82	18	14.5	17	3	4	●
M24 × 1.5	IS02X	PM0240BGEX	4.5P	140	27	-	71	18	14.5	17	3	4	●
M27 × 3	IS02X	PG027SBGEX	4.5P	160	37	-	82	20	16	19	4	4	●
M30 × 3.5	IS02X	PG030TBGEX	4.5P	180	44	-	92	22	18	21	4	4	●
M36 × 4	IS02X	PG036UBGEX	4.5P	200	52	-	102	28	22	25	4	4	●
Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Unified Threads													
NO.4-40UNC	2BX	PDUN4HYGEX	4.5P	56	9	18	34	3.5	2.7	6	3	2	●
NO.6-32UNC	2BX	PDUN6JYGEX	4.5P	56	11	19	32	4	3	6	3	2	●
NO.8-32UNC	2BX	PDUN8JYGEX	4.5P	63	13	21	38	4.5	3.4	6	3	2	●
NO.10-24UNC	2BX	PDUNAMYGEX	4.5P	70	14	24	39	6	4.9	8	3	2	●
NO.10-32UNF	2BX	PDUNAJYGEX	4.5P	70	14	24	39	6	4.9	8	3	2	●
1/4-20UNC	2BX	PDU04NYGEX	4.5P	80	15	30	42	7	5.5	8	3	2	●
1/4-28UNF	2BX	PDU04KYGEX	4.5P	80	15	30	42	7	5.5	8	3	2	●
5/16-18UNC	2BX	PDU050YGEX	4.5P	90	19	35	47	8	6.2	9	3	3	●
5/16-24UNF	2BX	PMU05MYGEX	4.5P	90	19	-	46	6	4.9	8	3	4	●
3/8-16UNC	2BX	PDU06PYGEX	4.5P	100	23	39	54	9	7	10	3	3	●
3/8-24UNF	2BX	PMU06MYGEX	4.5P	100	23	-	51	7	5.5	8	3	4	●
7/16-14UNC	2BX	PGU07QYGEX	4.5P	100	23	-	51	8	6.2	9	3	4	●
1/2-13UNC	2BX	PGU08RYGEX	4.5P	110	26	-	56	9	7	10	3	4	●
1/2-20UNF	2BX	PMU08NYGEX	4.5P	100	21	-	51	9	7	10	3	4	●
9/16-12UNC	2BX	PGU09SYGEX	4.5P	110	26	-	56	11	9	12	3	4	●
9/16-18UNF	2BX	PMU090YGEX	4.5P	100	21	-	51	11	9	12	3	4	●
5/8-11UNC	2BX	PGU10UYGEX	4.5P	110	26	-	56	12	9	12	3	4	●
5/8-18UNF	2BX	PMU100YGEX	4.5P	100	21	-	51	12	9	12	3	4	●
3/4-10UNC	2BX	PGU12VYGEX	4.5P	125	33	-	64	14	11	14	3	4	●
3/4-16UNF	2BX	PMU12PYGEX	4.5P	110	24	-	56	14	11	14	3	4	●
7/8-9UNC	2BX	PGU14WYGEX	4.5P	140	33	-	71	18	14.5	17	3	4	●
7/8-14UNF	2BX	PMU14QYGEX	4.5P	125	24	-	64	18	14.5	17	3	4	●
1-8UNC	2BX	PGU16XYGEX	4.5P	160	37	-	82	18	14.5	17	3	4	●
1-12UNF	2BX	PMU16SYGEX	4.5P	140	27	-	71	18	14.5	17	3	4	●

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