

Overall length	Chamfer + full thread	Thread length	Thread+Neck length	Shank length	Shank dia.	Size of square	Length of square
L	lt	ℓ	ℓn	ℓs	Ds	K	ℓk

SP-VA

Spiral Fluted Taps for Stainless Steels Specification

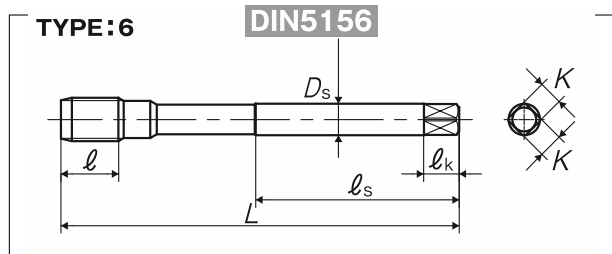
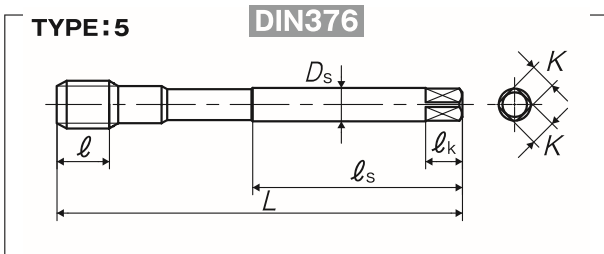
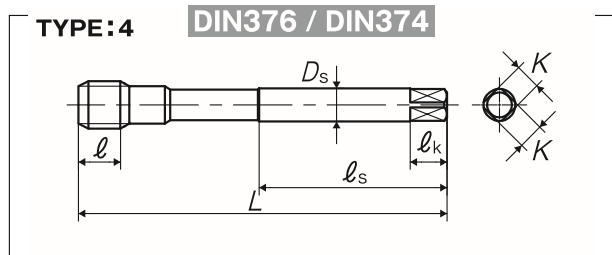
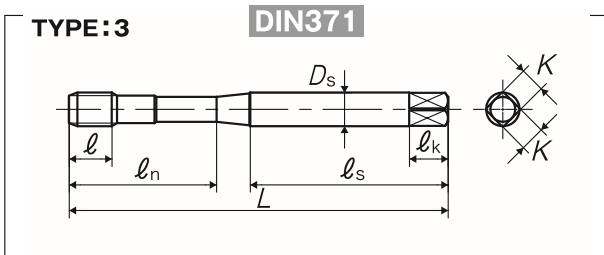
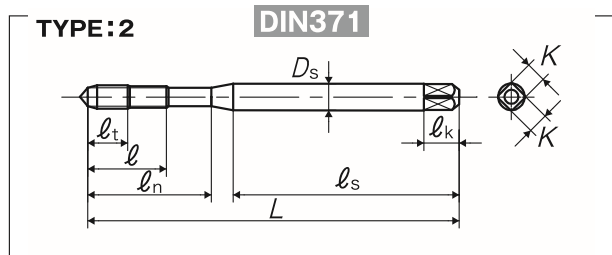
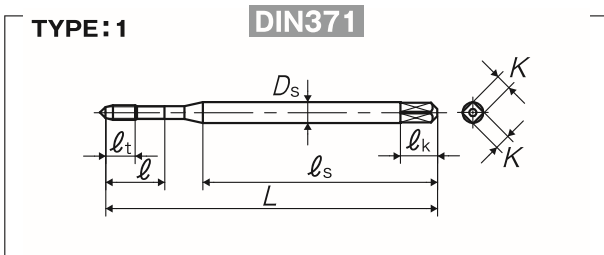


■ Most suitable for stainless steels, sticky and tending to work-harden, as well as chrome steels and molybdenum steels, blind hole use.

Recommended Tapping Speeds depending on Materials

High alloy steel ISO P4 ~10 (m/min)	Ferritic and austenitic stainless steel ISO M1~M2 ~10 (m/min)
--	--

For icon explanation, refer to P.50



Oversize

Segment : 1D

Size	Class	Code	Chamfer	L (mm)	lt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Metric Threads														
M2 × 0.4	ISO2	SD2.0EAGEX	2.5P	45	4	8	-	32	2.8	2.1	5	2	1	●
M2.5 × 0.45	ISO2	SD2.5FAGEX	2.5P	50	4	8	15	33	2.8	2.1	5	2	2	●
M3 × 0.5	ISO2	SD3.0GAGEX	2.5P	56	5	9	18	34	3.5	2.7	6	2	2	●
	ISO3	SD3.0MGEX	2.5P	56	5	9	18	34	3.5	2.7	6	2	2	●
M4 × 0.7	ISO2	SD4.0IAGEX	2.5P	63	7	13	21	38	4.5	3.4	6	3	2	●
	ISO3	SD4.0IMGEX	2.5P	63	7	13	21	38	4.5	3.4	6	3	2	●
M5 × 0.8	ISO2	SD5.0KAGEX	2.5P	70	9	14	25	39	6	4.9	8	3	2	●
	ISO3	SD5.0KMGEX	2.5P	70	9	14	25	39	6	4.9	8	3	2	●
M6 × 1	ISO2	SD6.0MAGEX	2.5P	80	11	15	30	45	6	4.9	8	3	2	●
	ISO3	SD6.0MMGEX	2.5P	80	11	15	30	45	6	4.9	8	3	2	●

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 Fluted Tap Series

SP-VA Spiral Fluted Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M8 × 1.25	ISO2	SD8.0NAGEX	2.5P	90	-	12	35	47	8	6.2	9	3	3	●
		SG8.0NAGEX	2.5P	90	-	12	-	46	6	4.9	8	3	4	●
	ISO3	SD8.0NMGEX	2.5P	90	-	12	35	47	8	6.2	9	3	3	●
M8 × 1	ISO2	SM8.0MAGEX	2.5P	90	-	12	-	46	6	4.9	8	3	4	●
M10 × 1.5	ISO2	SD010OAGEX	2.5P	100	-	13	39	52	10	8	11	3	3	●
		SG010OAGEX	2.5P	100	-	13	-	51	7	5.5	8	3	4	●
	ISO3	SD010OMGEX	2.5P	100	-	13	39	52	10	8	11	3	3	●
M10 × 1.25	ISO2	SM010NAGEX	2.5P	100	-	13	-	51	7	5.5	8	3	4	●
M10 × 1	ISO2	SM010MAGEX	2.5P	90	-	13	-	46	7	5.5	8	3	4	●
M12 × 1.75	ISO2	SG012PAGEX	2.5P	110	-	15	-	56	9	7	10	3	5	●
	ISO3	SG012PMGEX	2.5P	110	-	15	-	56	9	7	10	3	5	●
M12 × 1.5	ISO2	SM012OAGEX	2.5P	100	-	15	-	51	9	7	10	3	4	●
M12 × 1.25	ISO2	SM012NAGEX	2.5P	100	-	15	-	51	9	7	10	3	4	●
M12 × 1	ISO2	SM012MAGEX	2.5P	100	-	15	-	51	9	7	10	3	4	●
M14 × 2	ISO2	SG014QAGEX	2.5P	110	-	18	-	56	11	9	12	3	5	●
M14 × 1.5	ISO2	SM014OAGEX	2.5P	100	-	14	-	51	11	9	12	3	4	●
M14 × 1	ISO2	SM014MAGEX	2.5P	100	-	14	-	51	11	9	12	3	4	●
M16 × 2	ISO2	SG016QAGEX	2.5P	110	-	18	-	56	12	9	12	3	5	●
M16 × 1.5	ISO2	SM016OAGEX	2.5P	100	-	14	-	51	12	9	12	3	4	●
M18 × 2.5	ISO2	SG018RAGEX	2.5P	125	-	20	-	64	14	11	14	4	5	●
M18 × 1.5	ISO2	SM018OAGEX	2.5P	110	-	14	-	56	14	11	14	4	4	●
M20 × 2.5	ISO2	SG020RAGEX	2.5P	140	-	20	-	71	16	12	15	4	5	●
M20 × 1.5	ISO2	SM020OAGEX	2.5P	125	-	14	-	64	16	12	15	4	4	●
M22 × 2.5	ISO2	SG022RAGEX	2.5P	140	-	20	-	71	18	14.5	17	4	5	●
M22 × 1.5	ISO2	SM022OAGEX	2.5P	125	-	14	-	64	18	14.5	17	4	4	●
M24 × 3	ISO2	SG024SAGEX	2.5P	160	-	25	-	82	18	14.5	17	4	5	●
M24 × 1.5	ISO2	SM024OAGEX	2.5P	140	-	18	-	71	18	14.5	17	4	4	●
M27 × 3	ISO2	SG027SAGEX	2.5P	160	-	25	-	82	20	16	19	4	5	●
M30 × 3.5	ISO2	SG030TAGEX	2.5P	180	-	30	-	92	22	18	21	4	5	●
M36 × 4	ISO2	SG036UAGEX	2.5P	200	-	40	-	102	28	22	25	4	5	●
Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Unified Threads														
NO.4-40UNC	2B	SDUN4HXGEX	2.5P	56	5	9	18	34	3.5	2.7	6	2	2	●
NO.6-32UNC	2B	SDUN6JXGEX	2.5P	56	7	11	19	32	4	3	6	3	2	●
NO.8-32UNC	2B	SDUN8JXGEX	2.5P	63	7	13	21	38	4.5	3.4	6	3	2	●
NO.10-24UNC	2B	SDUNAMXGEX	2.5P	70	9	14	24	39	6	4.9	8	3	2	●
NO.10-32UNF	2B	SDUNAJXGEX	2.5P	70	9	14	24	39	6	4.9	8	3	2	●
1/4-20UNC	2B	SDU04NXGEX	2.5P	80	11	15	30	42	7	5.5	8	3	2	●
1/4-28UNF	2B	SDU04KXGEX	2.5P	80	11	15	30	42	7	5.5	8	3	2	●
5/16-18UNC	2B	SDU05OXGEX	2.5P	90	-	12	35	47	8	6.2	9	3	3	●
5/16-24UNF	2B	SMU05MXGEX	2.5P	90	-	12	-	46	6	4.9	8	3	4	●
3/8-16UNC	2B	SDU06PXGEX	2.5P	100	-	13	39	54	9	7	10	3	3	●
3/8-24UNF	2B	SMU06MXGEX	2.5P	100	-	13	-	51	7	5.5	8	3	4	●
7/16-14UNC	2B	SGU07QXGEX	2.5P	100	-	13	-	51	8	6.2	9	3	5	●
7/16-20UNF	2B	SMU07NXGEX	2.5P	100	-	13	-	51	8	6.2	9	3	4	●
1/2-13UNC	2B	SGU08RXGEX	2.5P	110	-	15	-	56	9	7	10	3	5	●
1/2-20UNF	2B	SMU08NXGEX	2.5P	100	-	15	-	51	9	7	10	3	4	●
9/16-12UNC	2B	SGU09SXGEX	2.5P	110	-	18	-	56	11	9	12	3	5	●
9/16-18UNF	2B	SMU09OXGEX	2.5P	100	-	14	-	51	11	9	12	3	4	●

Overall length	Chamfer + full thread	Thread length	Thread+Neck length	Shank length	Shank dia.	Size of square	Length of square
L	ℓt	ℓ	ℓn	ℓs	Ds	K	ℓk

SP-VA Spiral Fluted Taps for Stainless Steels

Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
5/8-11UNC	2B	SGU10UXGEX	2.5P	110	-	18	-	56	12	9	12	3	5	●
5/8-18UNF	2B	SMU100XGEX	2.5P	100	-	14	-	51	12	9	12	3	4	●
3/4-10UNC	2B	SGU12VXGEX	2.5P	125	-	20	-	64	14	11	14	4	5	●
3/4-16UNF	2B	SMU12PXGEX	2.5P	110	-	14	-	56	14	11	14	4	4	●
7/8-9UNC	2B	SGU14WXGEX	2.5P	140	-	20	-	71	18	14.5	17	4	5	●
7/8-14UNF	2B	SMU14QXGEX	2.5P	125	-	20	-	64	18	14.5	17	4	4	●
1-8UNC	2B	SGU16XXGEX	2.5P	160	-	25	-	82	18	14.5	17	4	5	●
1-12UNF	2B	SMU16SXGEX	2.5P	140	-	18	-	71	18	14.5	17	4	4	●
1 1/8-7UNC	2B	SGU18YXGEX	2.5P	180	-	30	-	92	22	18	21	4	5	●
1 1/8-8UN	2B	SMU18XXGEX	2.5P	180	-	28	-	92	22	18	21	4	4	●
1 1/8-12UNF	2B	SMU18SXGEX	2.5P	150	-	20	-	77	22	18	21	4	4	●
1 1/4-7UNC	2B	SGU20YXGEX	2.5P	180	-	30	-	92	22	18	21	4	5	●
1 1/4-8UN	2B	SMU20XXGEX	2.5P	180	-	28	-	92	22	18	21	4	4	●
1 1/4-12UNF	2B	SMU20SXGEX	2.5P	150	-	20	-	77	22	18	21	4	4	●
1 3/8-6UNC	2B	SGU22ZXGEX	2.5P	200	-	40	-	102	28	22	25	4	5	●
1 3/8-8UN	2B	SMU22XXGEX	2.5P	200	-	30	-	102	28	22	25	4	4	●
1 3/8-12UNF	2B	SMU22SXGEX	2.5P	170	-	20	-	87	28	22	25	4	4	●
1 1/2-6UNC	2B	SGU24ZXGEX	2.5P	200	-	40	-	102	32	24	27	4	5	●
1 1/2-8UN	2B	SMU24XXGEX	2.5P	200	-	30	-	102	32	24	27	4	4	●
1 1/2-12UNF	2B	SMU24SXGEX	2.5P	170	-	20	-	87	32	24	27	4	4	●
1 5/8-8UN	2B	SMU26XXGEX	2.5P	200	-	30	-	102	32	24	27	4	4	●
1 3/4-8UN	2B	SMU28XXGEX	2.5P	200	-	40	-	102	36	29	32	4	4	●
2-8UN	2B	SMU32XXGEX	2.5P	225	-	40	-	115	40	32	35	4	4	●
Size	Class	Code	Chamfer	L (mm)	ℓt (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For G Threads														
G1/8-28	-	SVG0020GEX	2.5P	90	-	12	-	46	7	5.5	8	3	6	●
G1/4-19	-	SVG0040GEX	2.5P	100	-	14	-	51	11	9	12	3	6	●
G3/8-19	-	SVG0060GEX	2.5P	100	-	14	-	51	12	9	12	3	6	●
G1/2-14	-	SVG0080GEX	2.5P	125	-	18	-	64	16	12	15	4	6	●
G3/4-14	-	SVG0120GEX	2.5P	140	-	20	-	71	20	16	19	4	6	●

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