

# M I-GP LONG SHANK SPIRAL POINT TAPS for GENERAL PURPOSE

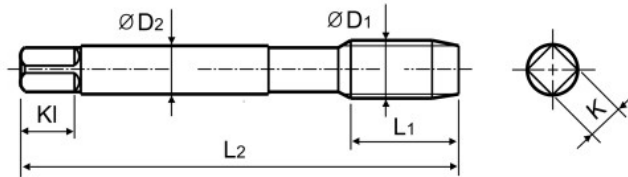
## I-GP 长柄普通先端丝锥

► Suitable for tapping Through holes in Carbon Steels and Alloy Steels, where chips are produced in a continuous coil state.

► 适用于碳钢和合金钢的通孔加工, 优异排屑



up to M8 : Male Center



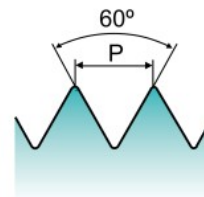
### Long Shank

Hole type

孔类型



3.0×D



p. B65



Plain Shank Page  
TAPPING ER CHUCK D215 -220  
TAPPING CHUCK D221 -228  
ONE STEP TAPPING CHUCK D211 -213

► 120mm

Tap Limits: p.B230

Unit(单位) : mm

SIZE	Pitch	EDP No.	Limit	Overall Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute
尺寸	牙距	型号	精度	全长	螺纹长	柄径	方块尺寸	方块长度	槽数
ØD1	P			L2	L1	ØD2	K	KI	
M3 × 0.5		T1204202	YH2	120	11	4	3.2	6	3
M4 × 0.7		T1204242	YH2	120	13	5	4	7	3
M5 × 0.8		T1204282	YH2	120	16	5.5	4.5	7	3
M6 × 1		T1204312	YH2	120	19	6	4.5	7	3
M8 × 1.25		T1204363	YH3	120	22	6.2	5	8	3
M10 × 1.5		T1204423	YH3	120	24	7	5.5	8	3
M10 × 1.25		T1204433	YH3	120	24	7	5.5	8	3
M12 × 1.75		T1204504	YH4	120	29	8.5	6.5	9	3
M12 × 1.5		T1204513	YH3	120	29	8.5	6.5	9	3
M12 × 1.25		T1204523	YH3	120	29	8.5	6.5	9	3
M14 × 2		T1204544	YH4	120	30	10.5	8	11	3
M14 × 1.5		T1204553	YH3	120	30	10.5	8	11	3
M16 × 2		T1204604	YH4	120	32	12.5	10	13	3
M16 × 1.5		T1204613	YH3	120	32	12.5	10	13	3

► Refer to p.B233-B238 for recommended tap drill sizes. 参考p.B233-B238 底孔尺寸.

◎ : Excellent (优秀) ○ : Good (良好)

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	○	○	○	○	○			○	○	○	○	○	○	○	○	○	○	○	

ISO Material Description	N					S					H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials			Heat Resistant Super Alloys			Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron			
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	○	○	○			○	○														