



Segment : 1C

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

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
For Metric Threads													
M2 × 0.4	P1	SPP2.0E--L	2.5P	42	7.2	12	27	3	2.5	5	2	1	△
M2.3 × 0.4	P1	SPP2.3E--L	2.5P	42	7.2	12	27	3	2.5	5	2	1	△
M2.5 × 0.45	P1	SPP2.5F--L	2.5P	46	8.1	14	29	3	2.5	5	2	1	△
M2.6 × 0.45	P1	SPP2.6F--L	2.5P	46	8.1	14	29	3	2.5	5	2	1	△
M3 × 0.5	P1	SPP3.0G--L	2.5P	46	9	14	26	4	3.2	6	3	1	○
M4 × 0.7	P2	SPQ4.0I--L	2.5P	52	11	17	29	5	4	7	3	1	○
M5 × 0.8	P2	SPQ5.0K--L	2.5P	60	13	22	33	5.5	4.5	7	3	1	○
M6 × 1	P2	SPQ6.0M--L	2.5P	62	15	26	33	6	4.5	7	3	1	○
M7 × 1	P2	SPQ7.0M--L	2.5P	70	19	-	36	6.2	5	8	3	2	△
M8 × 1.25	P2	SPQ8.0N--L	2.5P	70	19	-	36	6.2	5	8	3	2	○
M8 × 1	P2	SPQ8.0M--L	2.5P	70	19	-	36	6.2	5	8	3	2	△
M10 × 1.5	P2	SPQ0100--L	2.5P	75	23	-	38	7	5.5	8	3	2	○
M10 × 1.25	P2	SPQ010N--L	2.5P	75	23	-	38	7	5.5	8	3	2	○
M10 × 1	P2	SPQ010M--L	2.5P	75	23	-	38	7	5.5	8	3	2	△
M12 × 1.75	P2	SPQ012P--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	○
M12 × 1.5	P2	SPQ0120--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M12 × 1.25	P2	SPQ012N--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M12 × 1	P2	SPQ012M--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
M14 × 2	P2	SPQ014Q--L	2.5P	88	26	-	45	10.5	8	11	3	2	△
M14 × 1.5	P2	SPQ0140--L	2.5P	88	26	-	45	10.5	8	11	3	2	△
M16 × 2	P2	SPQ016Q--L	2.5P	95	26	-	48	12.5	10	13	3	2	○
M16 × 1.5	P2	SPQ0160--L	2.5P	95	26	-	48	12.5	10	13	3	2	△
M18 × 2.5	P3	SPR018R--L	2.5P	100	33	-	51	14	11	14	4	2	△

SP LH Spiral Fluted Taps for Left Hand Threads

Overall length	Chamfered thread	Thread length	Thread-tooth length	Shank length	Shank dia.	Size of square	Length of square
L	ℓt	ℓ	ℓn	ℓs	Ds	K	ℓk

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
M18 × 1.5	P2	SPQ0180--L	2.5P	100	33	-	51	14	11	14	4	2	△
M20 × 2.5	P3	SPR020R--L	2.5P	105	33	-	50	15	12	15	4	3	○
M20 × 1.5	P3	SPR0200--L	2.5P	105	33	-	50	15	12	15	4	3	△
M22 × 2.5	P3	SPR022R--L	2.5P	115	33	-	55	17	13	16	4	3	△
M22 × 1.5	P3	SPR0220--L	2.5P	115	33	-	55	17	13	16	4	3	△
M24 × 3	P3	SPR024S--L	2.5P	120	39	-	55	19	15	18	4	3	○
M24 × 1.5	P3	SPR0240--L	2.5P	120	39	-	55	19	15	18	4	3	△
M27 × 3	P3	SPR027S--L	2.5P	130	39	-	60	20	15	18	4	3	△
M30 × 3.5	P4	SPS030T--L	2.5P	135	46	-	62	23	17	20	4	3	△
M30 × 2	P3	SPR030Q--L	2.5P	135	46	-	62	23	17	20	4	3	△
M30 × 1.5	P3	SPR0300--L	2.5P	135	46	-	62	23	17	20	4	3	△

For Unified Threads

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
1/4-20UNC	P2	SPQU04N--L	2.5P	62	15	26	33	6	4.5	7	3	1	△
1/4-28UNF	P2	SPQU04K--L	2.5P	62	15	26	33	6	4.5	7	3	1	△
5/16-18UNC	P2	SPQU050--L	2.5P	70	19	-	36	6.2	5	8	3	2	△
5/16-24UNF	P2	SPQU05M--L	2.5P	70	19	-	36	6.2	5	8	3	2	△
3/8-16UNC	P2	SPQU06P--L	2.5P	75	23	-	38	7	5.5	8	3	2	△
3/8-24UNF	P2	SPQU06M--L	2.5P	75	23	-	38	7	5.5	8	3	2	△
7/16-14UNC	P3	SPRU07Q--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
7/16-20UNF	P2	SPQU07N--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
1/2-13UNC	P3	SPRU08R--L	2.5P	88	26	-	45	10.5	8	11	3	2	△
1/2-20UNF	P2	SPQU08N--L	2.5P	88	26	-	45	10.5	8	11	3	2	△

For Whitworth Threads

Size	Class	Code	Chamfer	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	No. of flutes	Type	Stock
1/4W20	P2	SPQW04N--L	2.5P	62	15	26	33	6	4.5	7	3	1	△
5/16W18	P2	SPQW050--L	2.5P	70	19	-	36	6.2	5	8	3	2	△
3/8W16	P2	SPQW06P--L	2.5P	75	23	-	38	7	5.5	8	3	2	△
7/16W14	P3	SPRW07Q--L	2.5P	82	26	-	42	8.5	6.5	9	3	2	△
1/2W12	P3	SPRW08S--L	2.5P	88	26	-	45	10.5	8	11	3	2	△
5/8W11	P3	SPRW10U--L	2.5P	95	26	-	48	12.5	10	13	3	2	△
3/4W10	P3	SPRW12V--L	2.5P	105	33	-	50	15	12	15	4	3	△