

PM-SP PM-PO

PM SERIES

Reliable and high performance tapping for the mould&die industry



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Product features

PM-SP



HSS-P



PM-PO



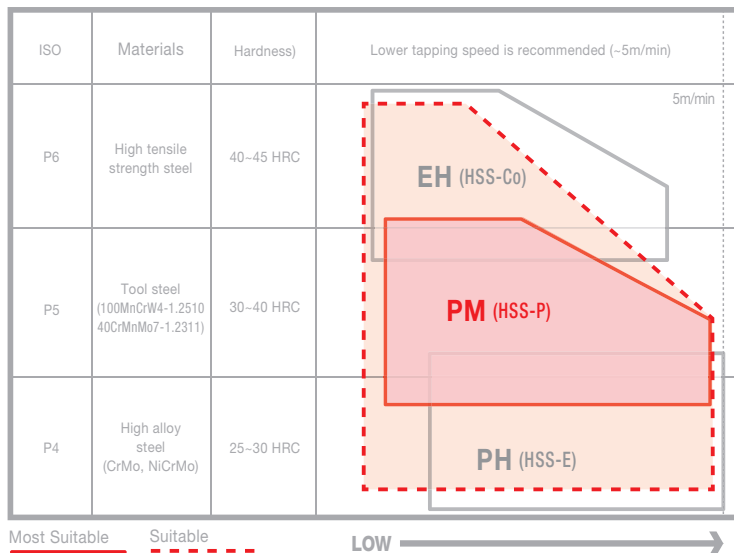
HSS-P



PM series can cover a wide range of materials from high carbon steels to a high tensile strength steel up to 45HRC.

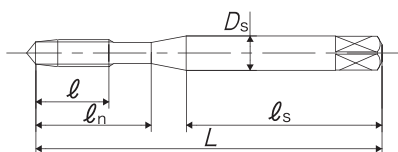
Thanks to toughness and wear resistance (as combination of HSSP material + suitable geometry), PM shows best performance in the application area of 30-40 HRC steel.

PM combined with already existing red ring taps (PH and EH) improves the Yamawa product range for tough materials widely used in the mould&die industry.

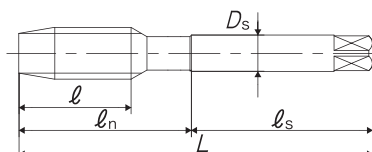


Dimensions and Sizes

[M6 and smaller]



[M8 and larger]



Unit:mm

Size	Class	L (mm)	ℓ (mm)	ℓn (mm)	ℓs (mm)	Ds (mm)	K (mm)	ℓk (mm)	PM-SP blind hole use			PM-PO through hole use		
									No. of flutes	Chamfer	Code	No. of flutes	Chamfer	Code
M														
M3X0.5	ISO2X (6HX)	56	9	18	34	3.5	2.7	6	3	2.75P	SD3.0GBDPB	3	5.5P	PD3.0GBDPB
M4X0.7		63	13	21	38	4.5	3.4	6	3	2.75P	SD4.0IBDPB	3	5.5P	PD4.0IBDPB
M5X0.8		70	14	25	39	6	4.9	8	3	2.75P	SD5.0KBDPB	3	5.5P	PD5.0KBDPB
M6X1		80	15	30	45	6	4.9	8	3	2.75P	SD6.0MBDPB	3	5.5P	PD6.0MBDPB
M8X1.25		90	19	35	47	8	6.2	9	3	2.75P	SD8.0NBDPB	3	5.5P	PD8.0NBDPB
M10X1.5		100	23	39	52	10	8	11	3	2.75P	SD10.0OBDPB	3	5.5P	PD10.0OBDPB
M12X1.75		110	26	-	56	9	7	10	3	2.75P	SG012PBDPB	3	5.5P	PG012PBDPB
M14X2		110	26	-	56	11	9	12	3	2.75P	SG014QBDPB	3	5.5P	PG014QBDPB
M16X2		110	26	-	56	12	9	12	3	2.75P	SG016QBDPB	3	5.5P	PG016QBDPB
M18X2.5		125	33	-	64	14	11	14	4	2.75P	SG018RBDPB	3	5.5P	PG018RBDPB
M20X2.5		140	33	-	71	16	12	15	4	2.75P	SG020RBDPB	3	5.5P	PG020RBDPB
M22X2.5		140	33	-	71	18	14.5	17	4	2.75P	SG022RBDPB	3	5.5P	PG022RBDPB
M24X3		160	37	-	82	18	14.5	17	4	2.75P	SG024SBDPB	3	5.5P	PG024SBDPB
M27X3		160	37	-	82	20	16	19	4	2.75P	SG027SBDPB	4	5.5P	PG027SBDPB
M30X3.5		180	44	-	92	22	18	21	4	2.75P	SG030TBDPB	4	5.5P	PG030TBDPB
MF														
MF8X1	ISO2X (6HX)	100	12	-	51	7	5.5	8	3	2.75P	SM8.0MBDPB	-	5.5P	-
MF10X1.25		100	23	-	51	7	5.5	8	3	2.75P	SM010NBDPB	3	5.5P	PM010NBDPB
MF10X1		100	13	-	51	7	5.5	8	3	2.75P	SM010MBDPB	-	5.5P	-
MF12X1.5		100	21	-	51	9	7	10	3	2.75P	SM012OBDPB	3	5.5P	PM012OBDPB
MF12X1.25		100	21	-	51	9	7	10	3	2.75P	SM012NBDPB	3	5.5P	PM012NBDPB
MF14X1.5		100	21	-	51	11	9	12	3	2.75P	SM014OBDPB	3	5.5P	PM014OBDPB
MF16X1.5		100	21	-	51	12	9	12	3	2.75P	SM016OBDPB	3	5.5P	PM016OBDPB
MF18X1.5		110	24	-	56	14	11	14	4	2.75P	SM018OBDPB	3	5.5P	PM018OBDPB
MF20X1.5		125	24	-	64	16	12	15	4	2.75P	SM020OBDPB	3	5.5P	PM020OBDPB
MF22X1.5		125	24	-	64	18	14.5	17	4	2.75P	SM022OBDPB	3	5.5P	PM022OBDPB
MF24X2		140	27	-	71	18	14.5	17	4	2.75P	SM024QBDPB	-	5.5P	-
MF24X1.5		140	27	-	71	18	14.5	17	4	2.75P	SM024OBDPB	3	5.5P	PM024OBDPB
MF27X2		140	20	-	71	20	16	19	4	2.75P	SM027QBDPB	-	5.5P	-
MF27X1.5		140	27	-	71	20	16	19	4	2.75P	SM027OBDPB	4	5.5P	PM027OBDPB
MF30X2		150	20	-	77	22	18	21	4	2.75P	SM030QBDPB	-	5.5P	-
MF30X1.5		150	27	-	77	22	18	21	4	2.75P	SM030OBDPB	4	5.5P	PM030OBDPB

WARNING

- Tools may shatter. Wear cover or eye glass to avoid injury during tapping.
- Tools may be shatter. Use tools under the proper tapping condition.
- Never wear gloves during turning operations as the gloves may get caught with the tools.
- Wear safety shoes to avoid injuring yourself by the falling tools.
- On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- Fasten the workpieces firmly so that they never move during operation.
- Never use worn tools or damaged tools with chipping.
- Take a special care to fire trouble. High temperature during machining may cause fire.



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