



▼  
螺纹加工  
Thread machining



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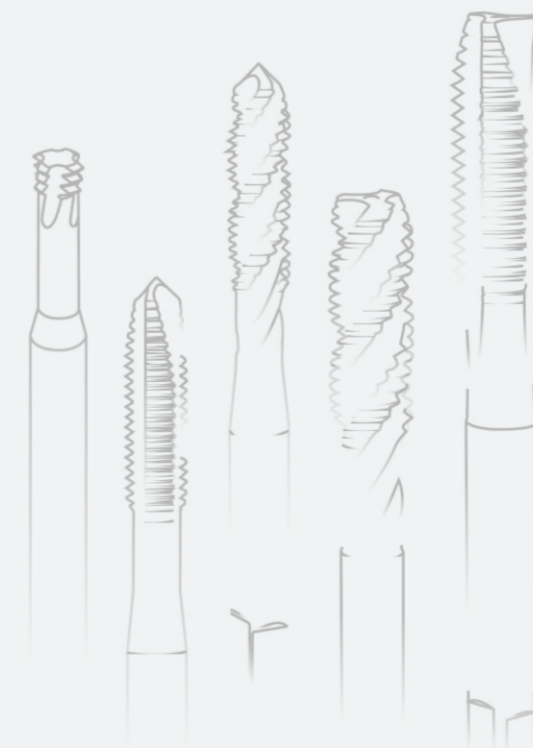
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**XUZHOU  
KEREN**

**CUTTING TOOLS CO., LTD.**

**徐州科刃切削工具有限公司**





## About US 關於我們

徐州科刃切削工具有限公司, 专注数控刀具生产及销售。公司刀具产品种类齐全, 应用广泛, 主要用于模具加工, 汽车零部件加工, IT行业、石墨、船舶、军工及通用机械等行业的加工应用。

公司多年来始终以客户利益最大化为己任, 与客户保持密切合作及畅通交流。并以此为依据不断优化创新产品类别, 持续为合作伙伴提供稳定、高品质兼具市场竞争力的刀具产品。

**Xuzhou Keren Cutting Tools Co., Ltd.** focuses on the production and sales of CNC cutting tools. The company has a wide range of cutting tools, which are mainly used in mold processing, auto parts processing, IT industry, graphite processing, shipbuilding, military industry, general machinery and other industries.

For many years, the company has always taken maximizing customer interests as its responsibility, maintaining close cooperation and smooth communication with customers. Based on this, we continuously optimize and innovate product categories, and provide stable, high-quality, and market competitive tool products to our partners.



## 螺纹铣刀系列 Thread milling cutter series

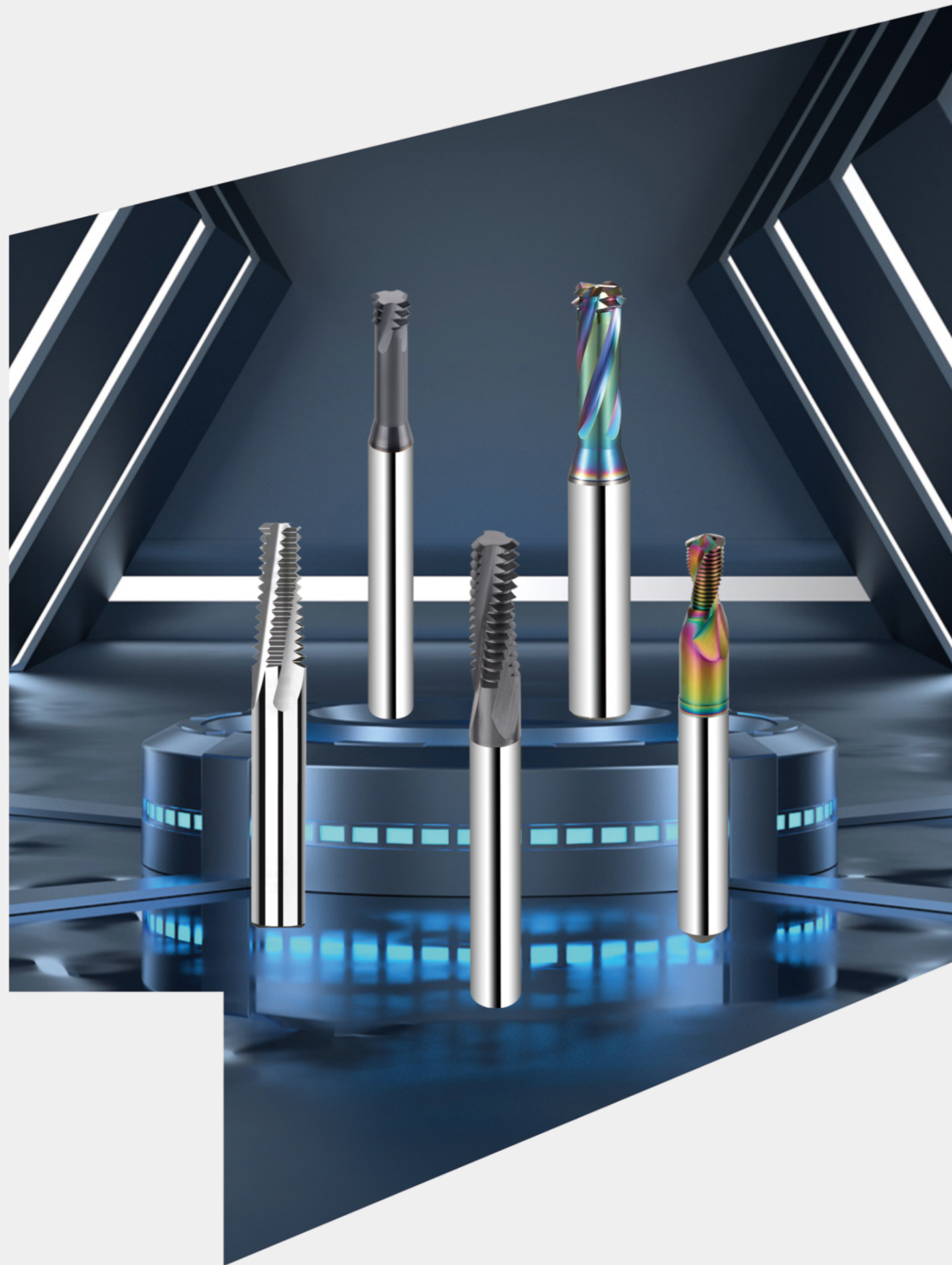
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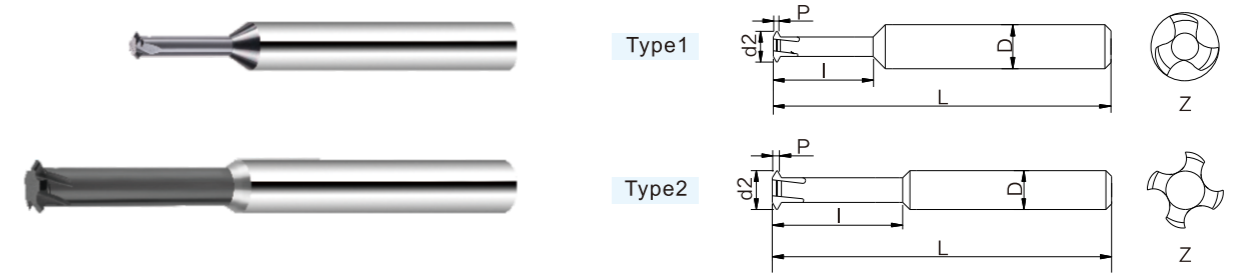
# 螺纹铣刀系列

## Thread Milling Cutter series



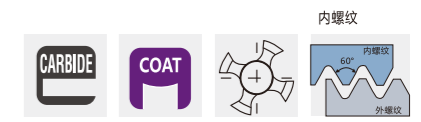
# ISO 单牙螺纹铣刀

ISO single thread milling cutter



## 使用范围牙型60°

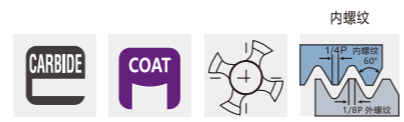
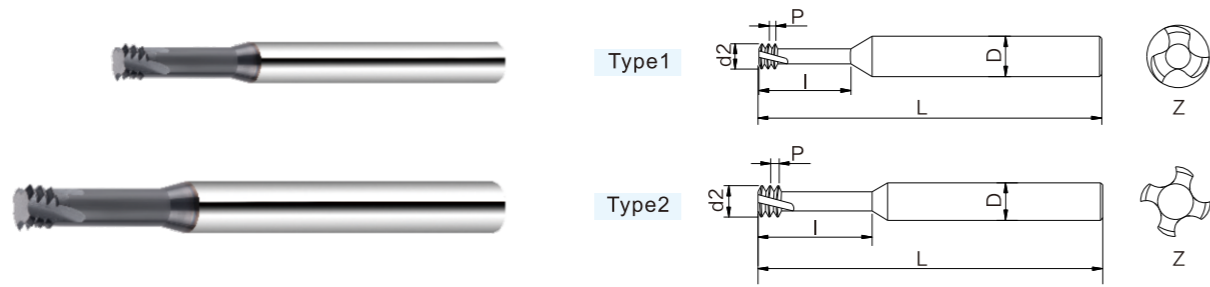
## 商品参数/PRODUCT PARAMETERS



铝用商品号	钢用商品号	螺纹 Thread			螺距 Pitch		尺寸 Dimensions mm				槽数 Z
		ISO标准牙	ISO细牙	美制UN、UNS、UNF、UNEF	mm	tpi	柄径 D	刃径 d2	刃长 l	总长 L	
M1T0731L	M1T0731	M1*0.25	M1.4*0.25		0.2-0.35		4	0.7	3.1	50	3
M1T0938L	M1T0938	M1.2*0.25	M1.4*0.25		0.2-0.35		4	0.9	3.8	50	3
M1T10544L	M1T10544	M1.4*0.3		NO 0-80UNF	0.25-0.4	80	4	1.05	4.4	50	3
M1T1250L	M1T1250	M1.6*0.35	M1.7-M1.8*0.35	NO1-72UNF	0.3-0.4	72-80	4	1.2	5	50	3
M1T1562L	M1T1562	M2*0.4		NO2-64UNF,2-56UNC	0.4-0.5	56-64	4	1.5	6.2	50	3
M1T19577L	M1T19577	M2.5*0.45		NO3-56UNF,NO3-48UNC,4-48UNF	0.45-0.5	48-56	4	1.95	7.7	50	3
M1T2492L	M1T2492	M3*0.5	M4-M5*0.5		0.5-0.6	48-56	4	2.4	9.2	50	3
M1T27512L	M1T27512	M3.5*0.6		NO6-40UNF	0.5-0.7	40	4	2.75	12	50	3
M1T31513L	M1T31513	M4*0.7		NO8-32UNC	0.5-0.8		4	3.15	13	50	3
M1T3916L	M1T3916	M5*0.8	M5*0.5,M5*0.75"	"NO10-56UNS,NO10-48UNS, NO10-40SNS,NO10-36UNS, NO10-32UNS"	0.5-0.8	32-56	3.9	4	16	50	3
M1T48520L	M1T48520	M6*1.0	"M6*0.5,M6*0.75"	"NO12-56UNS,NO12-48UNS, 1/4-40UNS1/4-36UNS,1/4-32UNEF, 1/4-28UNF,1/4-27UNS,1/4-24UNS,"	0.5-1.0	24-56	4.85	6	20	57	4
M1T5925L	M1T5925	M8*1.25	"M7*0.5M7*0.75M7.5*1"	"5/16-48UNS,5/16-40UNS,5/16-36UNS, 5/16-32UNEF,5/16-28UN,5/16-27UNS, 5/16-24UNS,5/16-20UN,"	0.5-1.25	20-48	5.9	6	25	57	4
M1T9935L	M1T9935		"M10.5*0.5M11*0.75M11*1"	"7/16-32UN,7/16-28UNEF, 7/16-27UNS7/16-24UNS"	0.5-1.0	24-56	9.9	10	38	70	5
M1T7932L	M1T7932	M10*1.5	M10*1.0 M10*1.25"	"3/8-24UNF,3/8-20UN, 7/16-18UNS7/16-24UNS"	1.0-1.50	16-24	7.9	8	32	65	5
M1T9938L	M1T9938	M12*1.75	"M12*1.0M12*1.25M12*1.5"	"1/2-24UNS,1/2-20UNS, 1/2-18UNS1/2-26UNS,1/2-14UNS"	1.0-1.75	14-24	9.9	10	38	70	5
M1T11945L	M1T11945		"M13.5*1M14*1.25M14*1.5"	9/16-24UNEF/1/2-13UNC	1.0-1.75	14-24	9.9	10	38	70	5
M1T11645L	M1T11645	M14*2		9/16-12UNC-5/8-11UNC	1.25-2.0	12-20	12	11.6	45	80	5
M1T11646L	M1T11646	M16*2			1.25-2.0	12-20	12	11.6	45	80	5
M1T13950L	M1T13950	M18*2.5		3/4-10UNC	1.5-3	10-18	14	13.9	50	90	6
M1T13951L	M1T13951	M20*2.5			1.5-3	10-18	14	13.9	50	90	6
M1T15965L	M1T15965	M24*3		7/8-9UNC,1"-8UNC	2.0-3.5	10-18	16	15.9	50	100	6

# ISO 三牙螺纹铣刀

ISO three-thread milling cutter



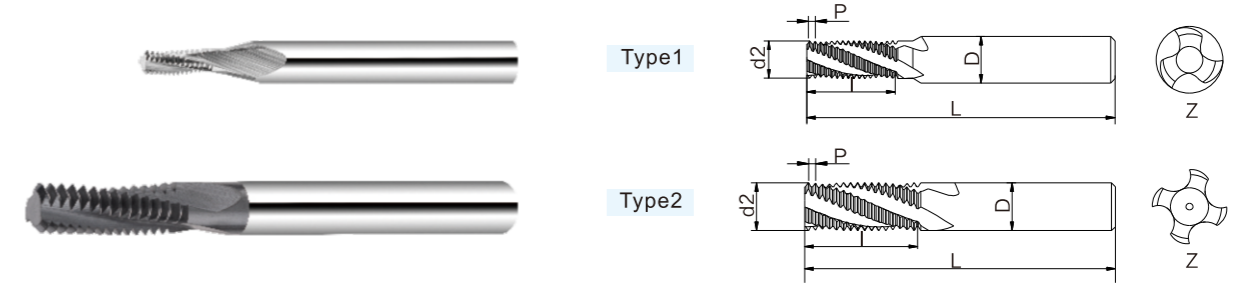
## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread		螺距 Pitch mm	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		ISO标准牙	ISO细牙		柄径 D	刃径 d2	刃长 l	总长 L		
M3T0728L	M3T0728	M1*0.25		0.25	4	0.7	2.8	50	3	0.75
M3T0932L	M3T0932	M1.2*0.25		0.25	4	0.9	3.2	50	3	0.95
M3T10534L	M3T10534	M1.4*0.3		0.3	4	1.05	3.4	50	3	1.1
M3T1235L	M3T1235	M1.6*0.35		0.35	4	1.2	3.5	50	3	1.25
M3T1438L	M3T1438	M1.8*0.35		0.35	4	1.4	3.8	50	3	1.45
M3T15543L	M3T15543	M2*0.4		0.4	4	1.55	4.3	50	3	1.6
M3T19553L	M3T19553	M2.5*0.45	M2.6*0.45	0.45	4	1.95	5.3	50	3	2.05
M3T2466L	M3T2466	M3*0.5	M3.5-M16*0.5	0.5	4	2.4	6.6	50	3	2.5
M3T27576L	M3T27576	M3.5*0.6		0.6	4	2.75	7.6	50	3	2.9
M3T31586L	M3T31586	M4*0.7		0.7	4	3.15	8.6	50	3	3.3
M3T39105L	M3T39105	M5*0.8		0.8	4	3.9	10.5	50	3	4.2
M3T4814L	M3T4814	M6*1.0	M8-M40*1.0	1	6	4.8	14	57	3	5
M3T595166L	M3T595166		M8*0.75	0.75	6	5.95	16.6	50	3	7.25
M3T5951661L	M3T5951661		M8*1	1	6	5.95	16.6	50	3	7
M3T595165L	M3T595165	M8*1.25		1.25	6	5.95	16.5	57	3	6.8
M3T6518L	M3T6518	M8*1.25粗柄		1.25	8	6.5	18	65	3	6.8
M3T79522L	M3T79522	M10*1.5		1.5	8	7.95	22	60	4	8.5
M3T8222L	M3T8222	M10*1.5粗柄	M12-M48*1.5	1.5	10	8.2	22	70	4	8.5
M3T9927L	M3T9927	M12*1.75		1.75	10	9.9	27	70	4	10.3
M3T11930L	M3T11930		M14*1.5-M16*1.5	1.5	12	11.9	30	75	4	12.5-14.5
M3T11633L	M3T11633	M14*2-M16*2		2	12	11.6	33	75	4	12-14
M3T13941L	M3T13941	M20*2.5		2.5	14	13.9	41.3	90	5	17.5
M3T15950L	M3T15950	M24*3.0		3	16	15.9	50	100	5	21

P03

# ISO 全牙螺纹铣刀

ISO full thread milling cutter



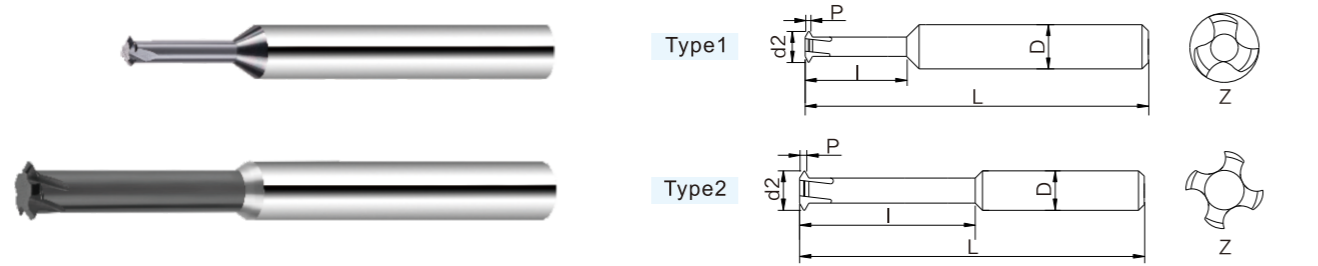
## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread		螺距 Pitch mm	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		ISO标准牙	ISO细牙		柄径 D	刃径 d2	刃长 l	总长 L		
M30524L	M30524	M3*0.5	M3.5-M16*0.5	0.5	4	2.4	6	50	3	2.5
M40532L	M40532		M4*0.5	0.5	4	3.2	8	50	3	3.5
M50532L	M50532		M5*0.5	0.5	4	3.2	8	50	3	4.5
M350628L	M350628	M3.5*0.6		0.6	4	2.8	7	50	3	2.9
M407315L	M407315	M4*0.7		0.7	4	3.15	8.4	50	3	3.3
M607539L	M607539		M6*0.75	0.75	4	3.9	12	50	3	5.3
M807559L	M807559		M8*0.75	0.75	6	5.9	16	57	3	7.3
M50839L	M50839	M5*0.8		0.8	4	3.9	10.4	50	3	4.2
M61048L	M61048	M6*1.0	M8-M40*1.0	1	6	4.8	12	57	3	5
M81059L	M81059		M8*1.0	1	6	5.9	16	57	3	7
M101079L	M101079		M10*1.0	1	8	7.9	20	65	3	9
M121099L	M121099		M12*1.0	1	10	9.9	24	70	4	11
M812559L	M812559	M8*1.25		1.25	6	5.9	16.2	57	3	6.8
M1012579L	M1012579		M10*1.25	1.25	8	7.9	20	65	3	8.8
M101579L	M101579	M10*1.5	M12-M48*1.5	1.5	8	7.9	19.5	65	3	8.5
M1212599L	M1212599		M12*1.25	1.25	10	9.9	24	70	3	10.8
M121599L	M121599		M12*1.5	1.5	10	9.9	24	70	4	10.5
M1415119L	M1415119		M14*1.5	1.5	12	11.9	30	75	4	12.5
M1615119L	M1615119		M16*1.5	1.5	12	11.9	30	75	4	14.5
M1217599L	M1217599	M12*1.75		1.75	10	9.9	25	70	4	10.2
M1420116L	M1420116	M14*2.0	M17-M80*2	2	12	11.6	30	75	4	12
M1620116L	M1620116	M16*2.0	M17-M80*2	2	12	11.6	30	75	4	14
M1825139L	M1825139	M18*2.5-M22*2.5		2.5	14	13.9	40	90	4	15.5
M2015159L	M2015159		M20-M80*1.5	1.5	16	15.9	40	100	4	18.5
M2025139L	M2025139	M20*2.5		2.5	14	13.9	40	90	4	17.5
M2430159L	M2430159	M24*3.0		3	16	15.9	42	100	4	21

P04

# ISO 加长单牙螺纹铣刀

ISO extended single-thread milling cutter



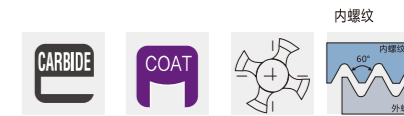
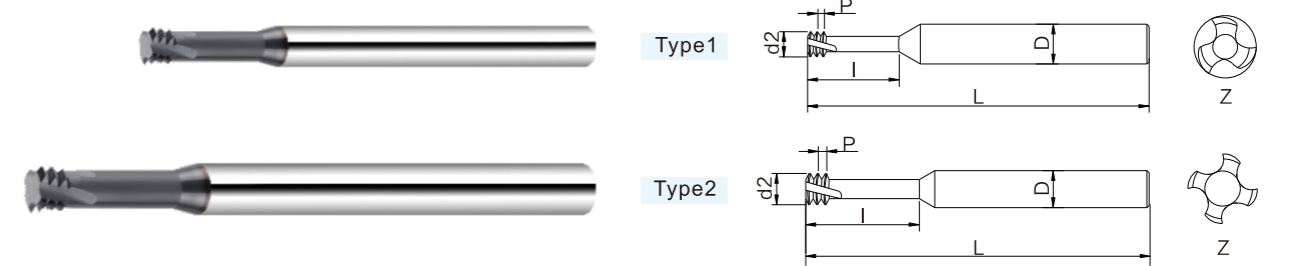
## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread		螺距 Pitch		尺寸 Dimensions mm				槽数 Z	
		ISO标准牙	细牙	美制UN、UNS、UNF、UNEF	mm	tpi	柄径 D	刃径 d2	刃长 l		总长 L
M1T105441BL	M1T105441B	M1.4*0.3		NO 0-80UNF	0.3	80	4	1.05	4.4	100	3
M1T12051BL	M1T12051B	M1.6*0.35	M1.7- M1.8*0.35	NO1-72UNF	0.35	72-80	4	1.2	5	100	3
M1T15621BL	M1T15621B	M2*0.4		NO2-64UNF,2-56UNC	0.4	56-64	4	1.5	6.2	100	3
M1T195771BL	M1T195771B	M2.5*0.45		NO3-56UNF, NO3-48UNC,4-48UNF	0.45	48-56	4	1.95	7.7	100	3
M1T24121BL	M1T24121B	M3*0.5	M4-M5*0.5		0.5	48-56	4	2.4	9.2	100	3
M1T315131BL	M1T315131B	M4*0.7		NO8-32UNC	0.7		4	3.15	13	100	3
M1T39161BL	M1T39161B	M5*0.8	M5*0.5 M5*0.75"	"NO10-56UNS,NO10- 48UNS,NO10-40SNS, NO10-36UNS, NO10-32UNS"	0.5-0.8	32-56	4	3.9	16	100	3
M1T485201BL	M1T485201B	M6*1.0	M6*0.5 M6*0.75"	"5/16-48UNS,5/16-40UNS, 5/16-36UNS,5/16-32UNEF, 5/16-28UN,5/16-27UNS, 5/16-24UNS,5/16-20UN,"	0.5-1.0	24-56	6	4.85	20	100	4
M1T59251BL	M1T59251B	M8*1.25	M7*0.5 M7*0.75 M7.5*1"	NO12-56UNS, NO12-48UNS, 1/4-40UNS,1/4-36UNS, 1/4-32UNEF,1/4-28UNF, 1/4-27UNS,1/4-24UNS,	0.5-1.25	20-48	6	5.9	25	100	4
M1T99351BL	M1T99351B		M10.5*0.5 M11*0.75 M11*1"	"7/16-32UN,7/ 16-28UNEF, 7/16-27UNS7/ 16-24UNS"	0.5-1.0	24-56	10	9.9	38	100	5
M1T79321BL	M1T79321B	M10*1.5	M10*1.0 M10*1.25"	"3/8-24UNF, 3/8-20UN, 7/16-18UNS 7/16-24UNS"	1.0-1.50	16-24	8	7.9	32	100	5
M1T99381BL	M1T99381B	M12*1.75	M12*1.0 M12*1.25 M12*1.5"	"1/2-24UNS, 1/2-20UNS, 1/2-18UNS,1/2-26 UNS,1/2-14UNS"	1.0-1.75	14-24	10	9.9	38	100	5
M1T116451BL	M1T116451B		M13.5*1 M14*1.25 M14*1.5"	9/16-12UNC-5/8-11UNC	1.0-1.75	14-24	12	11.6	45	100	5
M1T116461BL	M1T116461B	M14*2		9/16-12UNC-5/8-11UNC	1.25-2.0	12-20	12	11.6	45	100	5
M1T116471BL	M1T116471B	M16*2			1.25-2.0	12-20	12	11.6	45	100	5

P05

# ISO 加长三牙螺纹铣刀

ISO extended three-thread milling cutter



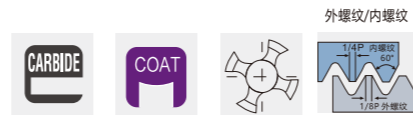
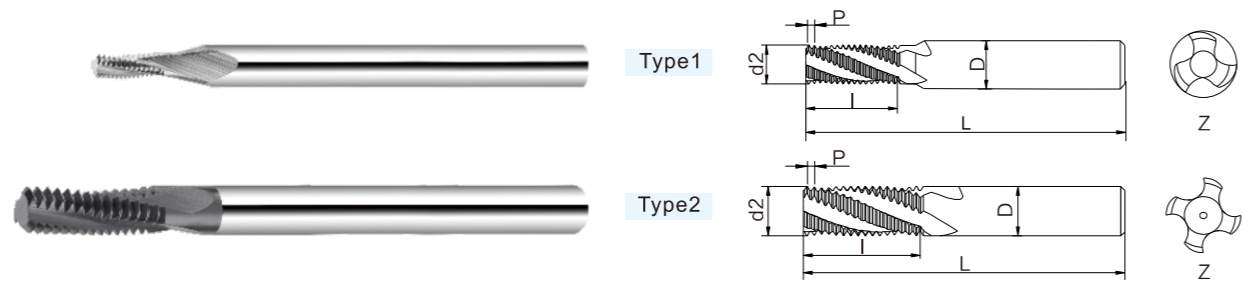
## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
				柄径 D	刃径 d2	刃长 l	总长 L		
M3T105341BL	M3T105341B	M1.4*0.3	0.3	4	1.05	3.4	100	3	1.1
M3T12351BL	M3T12351B	M1.6*0.35	0.35	4	1.2	3.5	100	3	1.25
M3T155431BL	M3T155431B	M2*0.4	0.4	4	1.55	4.3	100	3	1.6
M3T195531BL	M3T195531B	M2.5*0.45	0.45	4	1.95	5.3	100	3	2.05
M3T24661BL	M3T24661B	M3*0.5	0.5	4	2.4	6.6	100	3	2.5
M3T275761BL	M3T275761B	M3.5*0.6	0.6	4	2.75	7.6	100	3	2.9
M3T315861BL	M3T315861B	M4*0.7	0.7	4	3.15	8.6	100	3	3.3
M3T391051BL	M3T391051B	M5*0.8	0.8	4	3.9	10.5	100	3	4.2
M3T48141BL	M3T48141B	M6*1.0	1	6	4.8	14	100	3	5
M3T5951651BL	M3T5951651B	M8*1.25	1.25	6	5.95	16.5	100	3	6.8
M3T795221BL	M3T795221B	M10*1.5	1.5	8	7.95	22	100	4	8.5
M3T99271BL	M3T99271B	M12*1.75	1.75	10	9.9	27	100	4	10.3
M3T119301BL	M3T119301B	M14*1.5-M16*1.5	1.5	12	11.9	30	100	4	12.5-14.5
M3T116331BL	M3T116331B	M14*2-M16*2	2	12	11.6	33	100	4	12-14

P06

# ISO 加长全牙螺纹铣刀

ISO extended full thread milling cutter



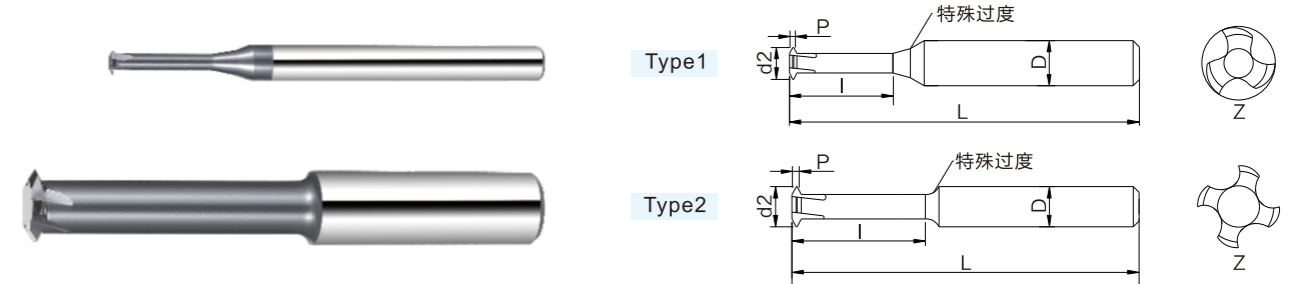
## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread		螺距 Pitch mm	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		ISO标准牙	ISO细牙		柄径 D	刃径 d2	刃长 l	总长 L		
M305241BL	M305241B	M3*0.5	M3.5-M16*0.5	0.5	4	2.4	6	100	3	2.5
M3506281BL	M3506281B	M3.5*0.6		0.6	4	2.8	7	100	3	2.9
M4073151BL	M4073151B	M4*0.7		0.7	4	3.15	8.4	100	3	3.3
M508391BL	M508391B	M5*0.8		0.8	4	3.9	10.4	100	3	4.2
M610481BL	M610481B	M6*1.0	M8-M40*1.0	1	6	4.8	12	100	3	5
M810591BL	M810591B	M8*1	M8*1.0	1	6	5.9	16	100	3	7
M8125591BL	M8125591B	M8*1.25		1.25	6	5.9	16.2	100	3	6.8
M1015791BL	M1015791B	M10*1.5	M12-M48*1.5	1.5	8	7.9	19.5	100	3	8.5
M12175991BL	M12175991B	M12*1.75		1.75	10	9.9	25	100	4	10.2
M14201161BL	M14201161B	M14*2.0	M17-M80*2	2	12	11.6	30	100	4	12
M16201161BL	M16201161B	M16*2.0	M17-M80*2	2	12	11.6	30	100	4	14

P07

# ISO 高硬单牙螺纹铣刀

ISO high hardness single thread milling cutter



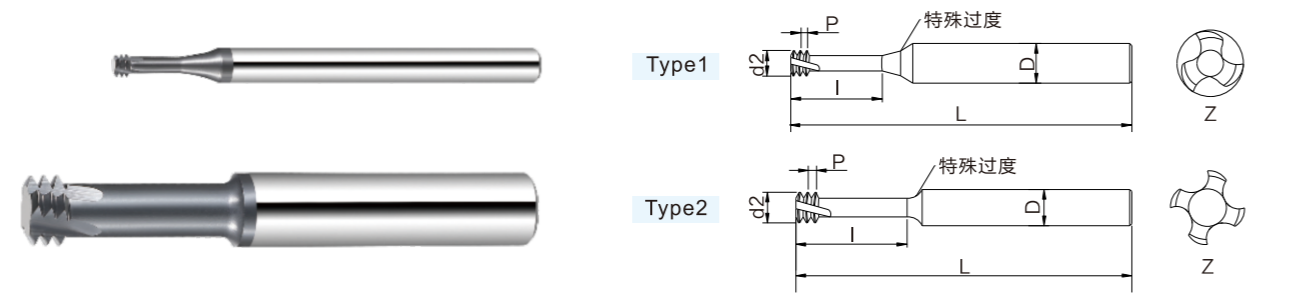
## 商品参数/PRODUCT PARAMETERS

钢用商品号	螺纹 Thread		螺距 Pitch	加工范围	tpi	尺寸 Dimensions mm				槽数 Z
	ISO标准牙	细牙				柄径 D	刃径 d2	刃长 l	总长 L	
M1T0731D	M1*0.25	M1.4*0.25	0.2-0.35			4	0.7	3.1	50	3
M1T0938D	M1.2*0.25	M1.4*0.25	0.2-0.35			4	0.9	3.8	50	3
M1T10544D	M1.4*0.3		0.25-0.4	80		4	1.05	4.4	50	3
M1T1250D	M1.6*0.35	M1.7-M1.8*0.35	0.3-0.4	72-80		4	1.2	5	50	3
M1T1562D	M2*0.4		0.4-0.5	56-64		4	1.5	6.2	50	3
M1T19577D	M2.5*0.45		0.45-0.5	48-56		4	1.95	7.7	50	3
M1T2492D	M3*0.5	M4-M5*0.5	0.5-0.6	48-56		4	2.4	9.2	50	3
M1T27512D	M3.5*0.6		0.5-0.7	40		4	2.75	12	50	3
M1T31513D	M4*0.7		0.5-0.8			4	3.15	13	50	3
M1T3916D	M5*0.8	"M5*0.5 M5*0.75"	0.5-0.8	32-56		4	3.9	16	50	3
M1T48520D	M6*1.0	"M6*0.5 M6*0.75"	0.5-1.0	24-56		6	4.85	20	57	4
M1T5925D	M8*1.25	"M7*0.5 M7*0.75M7.5*1"	0.5-1.25	20-48		6	5.9	25	57	4
M1T7932D	M10*1.5	"M10*1.0 M10*1.25"	1.0-1.50	16-24		8	7.9	32	65	5
M1T9938D	M12*1.75	"M12*1.0 M12*1.25M12*1.5"	1.0-1.75	14-24		10	9.9	38	70	5
M1T11645D	M14*2		1.25-2.0	12-20		12	11.6	45	75	5
M1T11646D	M16*2		1.25-2.0	12-20		12	11.6	45	75	5
M1T13950D	M18*2.5		1.5-3	10-18		14	13.9	50	90	6
M1T13951D	M20*2.5		1.5-3	10-18		14	13.9	50	90	6
M1T15965D	M24*3		2.0-3.5	10-18		16	15.9	50	100	6

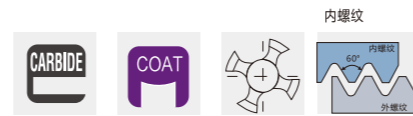
P08

# ISO 高硬三牙螺纹铣刀

ISO high hardness three-thread milling cutter



## 商品参数/PRODUCT PARAMETERS

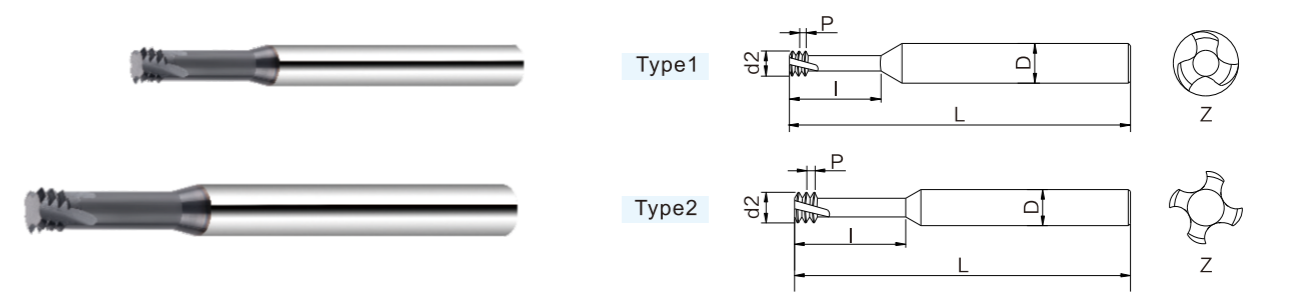


钢用商品号	螺纹 Thread		螺距 Pitch mm	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
	ISO标准牙	细牙		柄径 D	刃径 d2	刃长 l	总长 L		
M3T0728D	M1*0.25		0.25	4	0.7	2.8	50	3	0.75
M3T0932D	M1.2*0.25		0.25	4	0.9	3.2	50	3	0.95
M3T10534D	M1.4*0.3		0.3	4	1.05	3.4	50	3	1.1
M3T1235D	M1.6*0.35		0.35	4	1.2	3.5	50	3	1.25
M3T1438D	M1.8*0.35		0.35	4	1.4	3.8	50	3	1.45
M3T15543D	M2*0.4		0.4	4	1.55	4.3	50	3	1.6
M3T19553D	M2.5*0.45	M2.6*0.45	0.45	4	1.95	5.3	50	3	2.05
M3T2466D	M3*0.5	M3.5-M16*0.5	0.5	4	2.4	6.6	50	3	2.5
M3T27576D	M3.5*0.6		0.6	4	2.75	7.6	50	3	2.9
M3T31586D	M4*0.7		0.7	4	3.15	8.6	50	3	3.3
M3T39105D	M5*0.8		0.8	4	3.9	10.5	50	3	4.2
M3T4814D	M6*1.0	M8-M40*1.0	1	6	4.8	14	57	3	5
M3T595166D		M8*0.75	0.75	6	5.95	16.6	57	3	7.25
M3T5951661D		M8*1	1	6	5.95	16.6	57	3	7
M3T595165D	M8*1.25		1.25	6	5.95	16.5	57	3	6.8
M3T79522D	M10*1.5		1.5	8	7.95	22	65	4	8.5
M3T9927D	M12*1.75		1.75	10	9.9	27	70	4	10.3
M3T11930D	M14-/M16*1.5	M14*1.5-M16*1.5	1.5	12	11.9	30	75	4	12.5-14.5
M3T11633D	M14-/M16*2		2	12	11.6	33	75	4	12-14
M3T13941D	M18-/M20*2.5		2.5	14	13.9	41.3	90	5	17.5
M3T15950D	M24*3.0		3	16	15.9	50	100	5	21

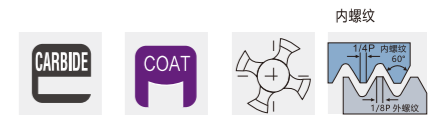
P09

# 美制三牙螺纹铣刀

American three-thread milling cutter



## 商品参数/PRODUCT PARAMETERS

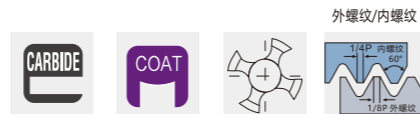
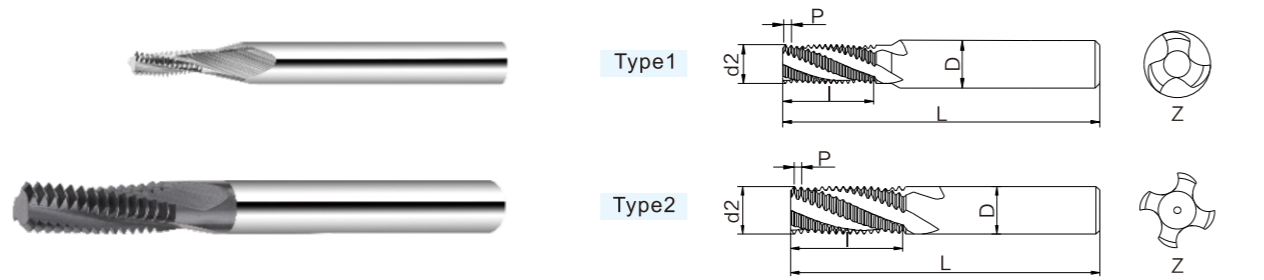


铝用商品号	钢用商品号	螺纹 Thread		螺距 Pitch tpi	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		UNC	UNF		柄径 D	刃径 d2	刃长 l	总长 L		
UN3T080L	UN3T080		NO.0-80 UNF	80	4	1.15	3.5	50	3	1.2
UN3T172L	UN3T172		NO.1-72 UNF	72	4	1.45	3.9	50	3	1.6
UN3T164L	UN3T164	NO.1-64 UNC	NO.2-64 UNF	64	4	1.4	4.2	50	3	1.5
UN3T256L	UN3T256	NO.2-56 UNC	NO.3-56 UNF	56	4	1.65	5	50	3	1.8
UN3T348L	UN3T348	NO.3-48 UNC	NO.4-48 UNF	48	4	1.9	6	50	3	2.1
UN3T440L	UN3T440	NO.4-40 UNC NO.5-40 UNC	NO.6-40 UNF	40	4	2.1	6	50	3	2.3
UN3T540L	UN3T540	NO.5-40 UNC	NO.6-40 UNF	40	4	2.45	7.2	50	3	2.6
UN3T836L	UN3T836		NO.8-36 UNF	36	4	3.3	8.7	50	3	3.5
UN3T632L	UN3T632	NO.6-32 UNC NO.8-32 UNC	NO.10-32 UNF	32	4	2.55	7.4	50	3	2.8
UN3T832L	UN3T832	NO.8-32 UNC	NO.10-32 UNF	32	4	3.2	10	50	3	3.5
UN3T1428L	UN3T1428		1/4"-28 UNF	28	6	5.25	13.2	57	3	5.5
UN3T1024L	UN3T1024	NO.10-24 UNC	5/16"-24 UNF	24	6	3.58	10.2	57	3	3.9
UN3T51624L	UN3T51624		5/16"-24 UNF	24	8	6.68	16.5	65	3	6.9
UN3T1420L	UN3T1420	1/4"-20 UNC	7/16"-20 UNF	20	6	4.88	13.4	57	3	5.2
UN3T71620L	UN3T71620		7/16"-20 UNF	20	10	9.55	23	70	3	9.9
UN3T1220L	UN3T1220		1/2"-20 UNF	20	10	9.55	25	70	3	11.4
UN3T51618L	UN3T51618	5/16"*18		18	6	5.95	17	57	3	6.5
UN3T3816L	UN3T3816	3/8"*16		16	8	6.7	19.1	65	3	8
UN3T71614L	UN3T71614	7/16"-14		14	10	9	23.3	70	3	9.4

P10

# 美制全牙螺纹铣刀

American full thread milling cutter

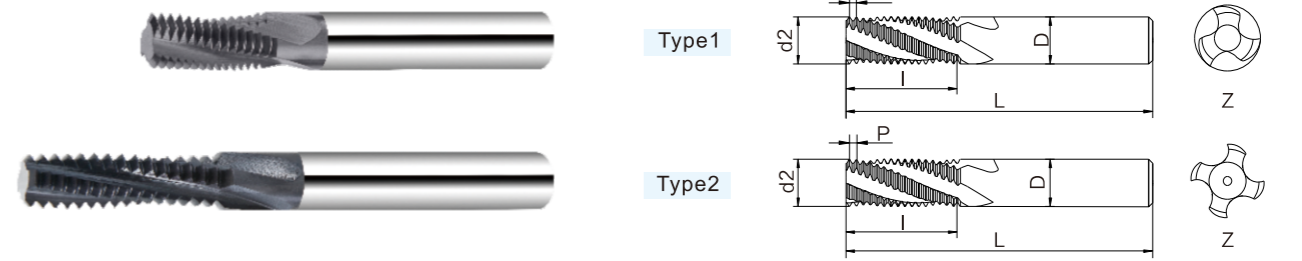


## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread			螺距 Pitch	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		UNC 粗牙	UNF 细牙	UNEF 超细牙		tpi	柄径 D	刃径 d2	刃长 l		
UN83600L	UN83600		NO.8-36		36	4	3	8.5	50	3	3.5
UN10320L	UN10320		NO.10-32	NO.12,-3/8**32	32	4	3.3	11.1	50	3	4
UN12280L	UN12280		NO.12-28,1/4**28	7/16",-1/2**28	28	4	3.8	11.8	50	3	4.6
UN14280L	UN14280		1/4**28	7/16",-1/2**28	28	6	4.6	12.7	57	3	5.5
UN71628L	UN71628			7/16",-1/2**28	28	10	9.2	22.7	70	4	10.2
UN10240L	UN10240	NO.10-24	5/16",3/8*24	9/16",-11/16**24	24	4	2.9	10.6	50	3	3.8
UN12240L	UN12240	NO.12-24	5/16",3/8*24	9/16",-11/16**24	24	4	3.5	11.6	50	3	4.5
UN51624L	UN51624		5/16",3/8*24	9/16",-11/16**24	24	6	5.7	15.9	57	3	6.8
UN38240L	UN38240		3/8**24	9/16",-11/16**24	24	8	7.4	19.1	65	3	8.5
UN91624L	UN91624			9/16",-11/16**24	24	12	11.9	28.6	75	4	13.2
UN14200L	UN14200	1/4**20	7/16",1/2**20	3/4",-1**20	20	4	3.9	12.7	50	3	5.2
UN71620L	UN71620		7/16",1/2**20	3/4",-1**20	20	10	8.5	22.9	70	4	9.8
UN12200L	UN12200		1/2**20	3/4",-1**20	20	10	9.9	25.4	70	4	11.5
UN34200L	UN34200			3/4",-1**20	20	16	15.9	38.1	100	5	17.8
UN51618L	UN51618	5/16**18	9/16",5/8**18	11/16",-1 11/16**18	18	6	5.2	16.9	57	3	6.5
UN91618L	UN91618		9/16",5/8**18	11/16",-1 11/16**18	18	12	11.3	29.6	75	4	12.8
UN58180L	UN58180		5/8**18	11/16",-1 11/16**18	18	12	11.9	32.5	75	4	14.5
UN38160L	UN38160	3/8**16	3/4**16		16	8	6.7	19.1	65	3	8
UN34160L	UN34160		3/4**16		16	16	15.9	38.1	100	4	17.5
UN71614L	UN71614	7/16**14	7/8**14		14	8	7.6	23.6	65	3	9.3
UN78140L	UN78140		7/8**14		14	20	18.7	44.4	105	4	20.5
UN12130L	UN12130	1/2**13			13	10	8.9	25.4	70	4	10.8
UN91612L	UN91612	9/16**12	1"-1 1/2**12		12	12	10.3	29.6	75	4	12.3
UN11212L	UN11212		1"-1 1/2**12		12	20	19.9	50.8	105	5	23.5
UN58110L	UN58110	5/8**11			11	12	11	32.3	75	4	13.5
UN34100L	UN34100	3/4**10			10	16	13.5	38.1	100	5	16.5
UN78900L	UN78900	7/8**9			9	16	15.2	45.2	100	4	19.5
UN18000L	UN18000	1"-8			8	20	17	50.8	105	4	22

# BSP(G)圆柱螺纹铣刀

BSP (G) cylindrical thread milling cutter

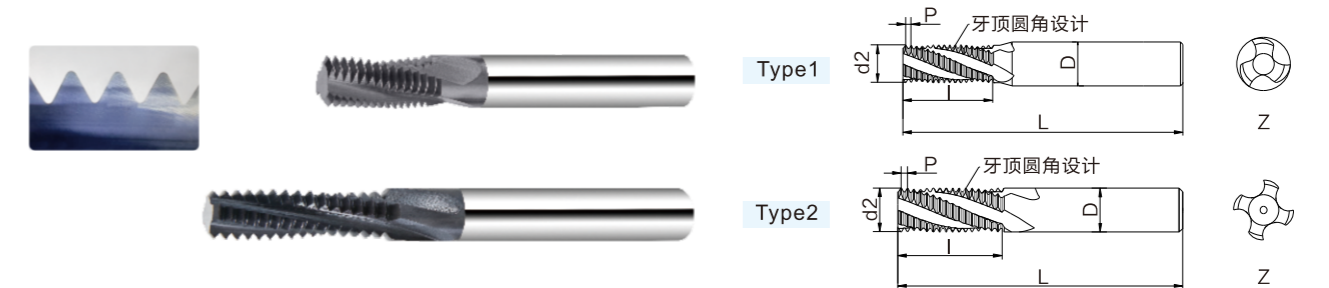


## 使用范围牙型55° 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
				BSP(G) 55° 牙型角	柄径 D	刃径 d2	刃长 l		
G11628L	G11628	G1/16-28	28	6	5.8	16.3	57	3	6.7
G18280L	G18280	G1/8-28	28	8	7.7	20	65	3	8.7
G14190L	G14190	G1/4-19/ G3/8-19	19	10	9.9	26.7	70	4	11.8
G38190L	G38190	G3/8-19	19	10	9.9	26.7	70	4	15.2
G12140L	G12140	G1/2-14	14	12	11.9	32	75	4	19
G58140L	G58140	G5/8-14/G3/4-14	14	14	13.9	40	90	4	20.5
G34140L	G34140	G3/4-14	14	14	13.9	40	90	4	24.2
G78140L	G78140	G7/8-14	14	16	15.9	45	100	4	28
G10110L	G10110	G1.1"1/2.G2".G2"1/2-11	11	18	17.9	41.6	100	5	30.7

## 牙顶圆角设计/BSP(G)圆柱螺纹铣刀

Crest fillet design/BSP (G) cylindrical thread milling cutter

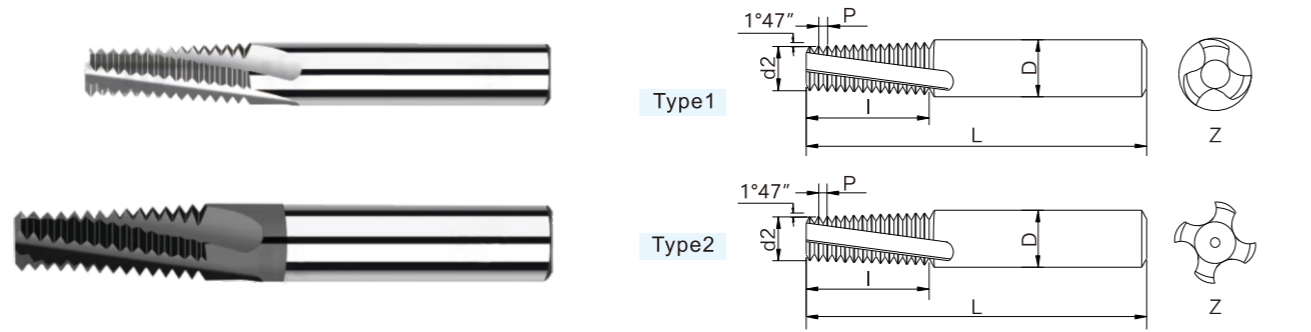


## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
				BSP(G)55° 牙型角	柄径 D	刃径 d2	刃长 l		
RG11628L	RG11628	G1/16-28	28	6	5.8	16.3	57	3	6.7
RG18280L	RG18280	G1/8-28	28	8	7.7	20	65	3	8.7
RG14190L	RG14190	G1/4-19/ G3/8-19	19	10	9.9	26.7	70	4	11.8
RG38190L	RG38190	G3/8-19	19	10	9.9	26.7	70	4	15.2
RG12140L	RG12140	G1/2-14	14	12	11.9	32	75	4	19
RG58140L	RG58140	G5/8-14/G3/4-14	14	14	13.9	40	90	4	20.5
RG34140L	RG34140	G3/4-14	14	14	13.9	40	90	4	24.2
RG78140L	RG78140	G7/8-14	14	16	15.9	45	100	4	28
RG10110L	RG10110	G1.1"1/2.G2".G2"1/2-11	11	18	17.9	41.6	100	5	30.7

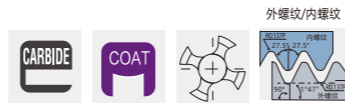
## BSPT(PT.RC)圆锥螺纹铣刀

BSPT (PT. RC) taper thread milling cutter



使用范围牙型55°

### 商品参数/PRODUCT PARAMETERS

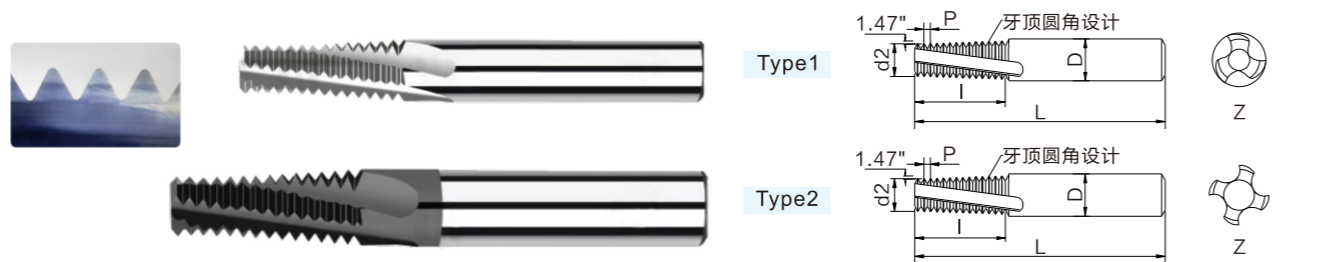


铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		BSPT(PT.RC)、55° 牙型角	tpi	柄径 D	小头刃径 d2	刃长 l	总长 L	Z	mm
PT11628L	PT11628	1/16-28	28	6	4.9	16.3	57	3	6.7
PT18280L	PT18280	1/8-28	28	8	6.7	20	65	3	8.7
PT14190L	PT14190	1/4-19 / 3/8-19	19	10	8.3	26.7	70	4	11.8
PT38190L	PT38190	3/8-19	19	10	8.3	26.7	70	4	15.2
PT12140L	PT12140	1/2-14	14	12	10	32	75	4	19
PT34140L	PT34140	3/4-14	14	14	11.9	33	90	4	23
PT10110L	PT10110	1"-1 1/2"-2"-2 1/2"-11	11	18	15.4	41.6	100	5	30.7

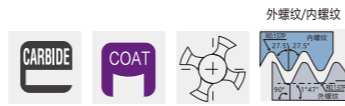
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## 牙顶圆角设计/英制BSPT(PT.RC)圆锥螺纹铣刀

Crest fillet design/BSPT (PT.RC) taper thread milling cutter



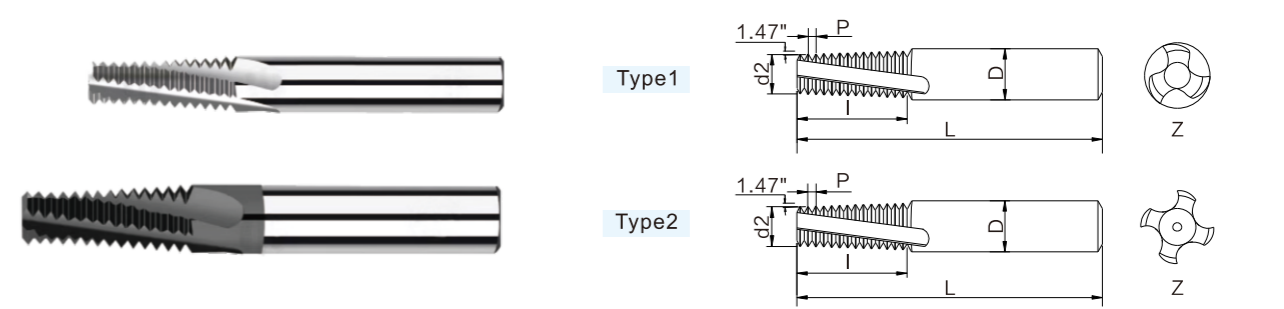
### 商品参数/PRODUCT PARAMETERS



铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		55° 牙型角BSPT(PT.RC)	tpi	柄径 D	小头刃径 d2	刃长 l	总长 L	Z	mm
RPT11628L	RPT11628	1/16-28	28	6	4.9	16.3	57	3	6.7
RPT18280L	RPT18280	1/8-28	28	8	6.7	20	65	3	8.7
RPT14190L	RPT14190	1/4-19 / 3/8-19	19	10	8.3	26.7	70	4	11.8
RPT38190L	RPT38190	3/8-19	19	10	8.3	26.7	70	4	15.2
RPT12140L	RPT12140	1/2-14	14	12	10	32	75	4	19
RPT34140L	RPT34140	3/4-14	14	14	11.9	33	90	4	23
RPT10110L	RPT10110	1"-1 1/2"-2"-2 1/2"-11	11	18	15.4	41.6	100	5	30.7

## 美制NPT/NPTF圆锥螺纹铣刀

NPT/NPT taper thread milling cutter



使用范围牙型60°

### 商品参数/PRODUCT PARAMETERS

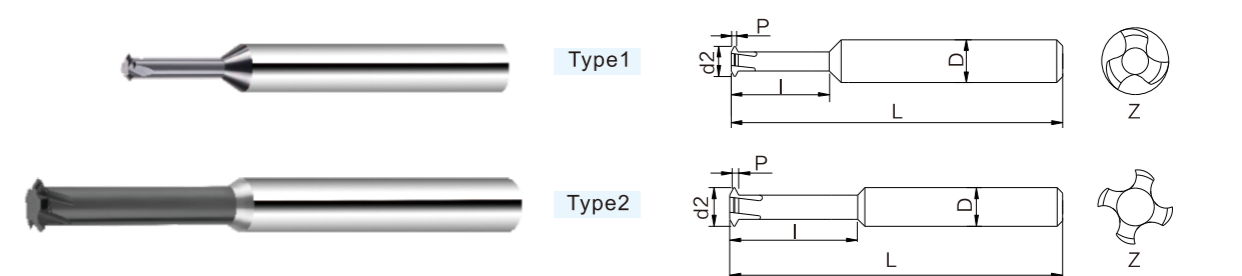


铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z	底孔直径 mm
		NPT 牙形角60°	tpi	柄径 D	小头刃径 d2	刃长 l	总长 L	Z	mm
NPT11627L	NPT11627	1/16-27	27	6	5.3	11.5	57	3	6.3
NPT18270L	NPT18270	1/8/27.0	27	8	7.3	11.5	65	3	8.5
NPT14180L	NPT14180	1/4-18.0	18	10	9.1	14.1	70	4	11.1
NPT38180L	NPT38180	3/8/18.0	18	10	9.1	14.1	70	4	14.5
NPT12140L	NPT12140	1/2 3/4-14	14	12	10.5	25.4	75	4	17.7-23
NPT34140L	NPT34140	3/4-14.0	14	14	11.9	33.1	90	4	23
NPT10115L	NPT10115	1"-2" 11.5	11.5	18	15.6	38.1	100	5	29-56

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## 惠氏螺纹W/G RC PT 单牙螺纹铣刀

Whitworth thread W/G RC PT single thread milling cutter



使用范围牙型55°

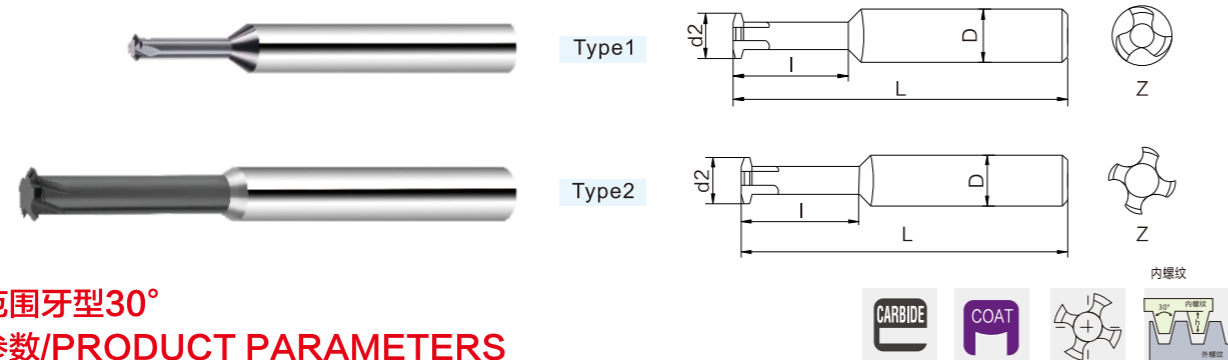
### 商品参数/PRODUCT PARAMETERS



铝用商品号	钢用商品号	螺纹 Thread	英寸、螺距 Pitch	尺寸 Dimensions mm				槽数 Z	适用范围
		惠氏螺纹/G RC PT/ 55° 范围	tpi	柄径 D	刃径 d2	刃长 l	总长 L	Z	P
W1T31624L	W1T31624	W3/16-24	24	4	3.5	11	50	3	1.058
W1T1420L	W1T1420	W1/4-20	20	6	4.6	16	57	4	1.27
W1T51618L	W1T51618	W5/16-18G1/16-28 G1/8-28	18/ 28	6	5.9	18	57	4	0.907-1.411
W1T3816L	W1T3816	W3/8-16G1/4-19 G3/8-19	16/14/19	8	7.5	22	65	4	1.337-1.587
W1T71614L	W1T71614	W7/16-14 G1/4-19 G3/8-19 G1/2-14	14/19	10	9	26	70	4	1.337-1.814
W1T5811L	W1T5811	W5/8-11 W3/4-10G3/4-14 G1"-11	11/10/14	12	11.9	35	75	4	1.814-2.54

## 单牙米制30° 梯形螺纹铣刀

Single thread metric 30° trapezoidal thread milling cutter



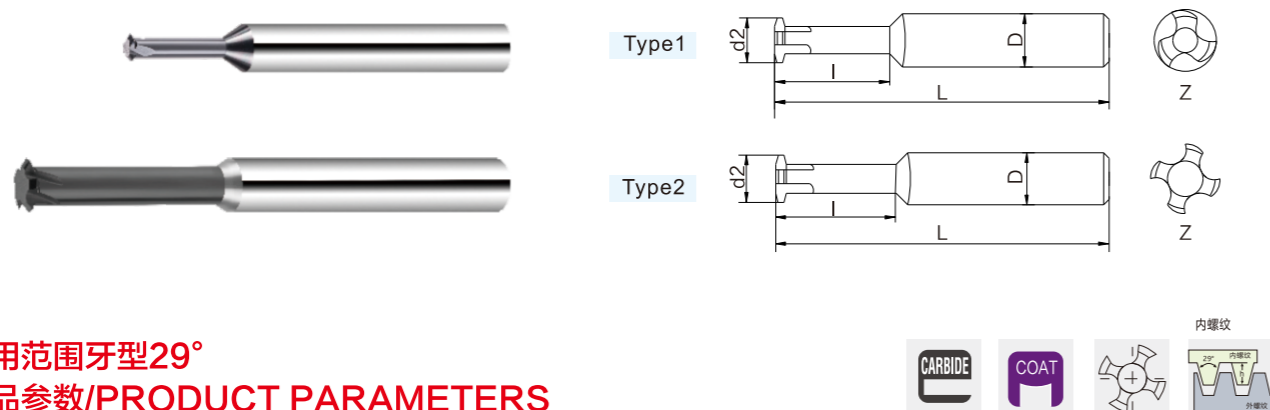
### 使用范围牙型30° 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	牙型角	尺寸 Dimensions mm				槽数 Z
					柄径 D	刃径 d2	刃长 l	总长 L	
		TR /30°	tpi	30°					
TR1T815L	TR1T815	TR8*1.5 - TR9*1.5	P1.5	30°	6	5.95	20	57	3
TR1T920L	TR1T920	TR9*2 - TR11*2	P2	30°	8	6.4	20	65	3
TR1T122L	TR1T122	TR12*2 - TR20*2	P2	30°	10	9.4	35	75	4
TR1T113L	TR1T113	TR11*3 - TR14*3	P3	30°	8	7.4	25	65	3
TR1T143L	TR1T143	TR14*3 - TR30*3	P3	30°	10	9.95	35	75	4
TR1T164L	TR1T164	TR16*4 - TR20*4	P4	30°	12	11	38	75	4
TR1T225L	TR1T225	TR22*5 - TR28*5	P5	30°	14	13.95	50	100	4

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## 单牙ACME美制29° 梯形螺纹刀

Single thread ACME American 29° trapezoidal thread cutter

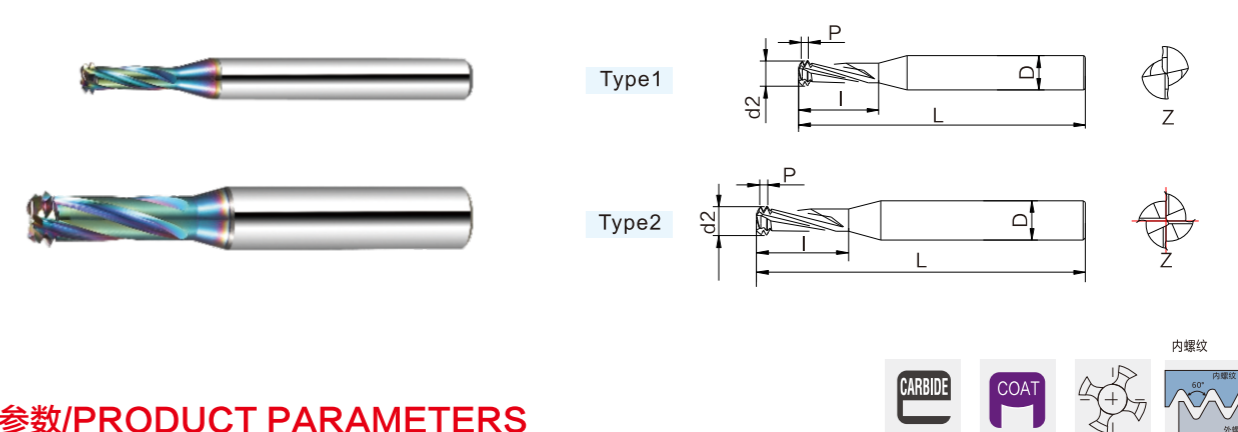


### 使用范围牙型29° 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹 Thread	螺距 Pitch	牙型角	尺寸 Dimension mm				槽数 Z
					柄径 D	刃径 d2	刃长 l	总长 L	
		ACME /29°	tpi	29°					
A1T1416L	A1T1416	ACME1/4-16	1.587	29°	6	4.7	15	57	4
A1T51614L	A1T51614	ACME5/16-14	1.814	29°	6	6	20	57	4
A1T3812L	A1T3812	ACME3/8-12	2.116	29°	8	7.2	25	65	4
A1T71612L	A1T71612	ACME7/16-12	2.116	29°	8	7.2	25	65	4
A1T1210L	A1T1210	ACME1/2-10	2.54	29°	10	10	35	75	4
A1T5808L	A1T5808	ACME5/8-8	3.175	29°	12	12	35	75	4
A1T3406L	A1T3406	ACME3/4-6	4.233	29°	12	12	35	75	4
A1T7806L	A1T7806	ACME7/8-6	4.233	29°	12	12	35	75	4

## 铝用免打孔螺纹铣刀

Nonpunching thread milling cutter for aluminum



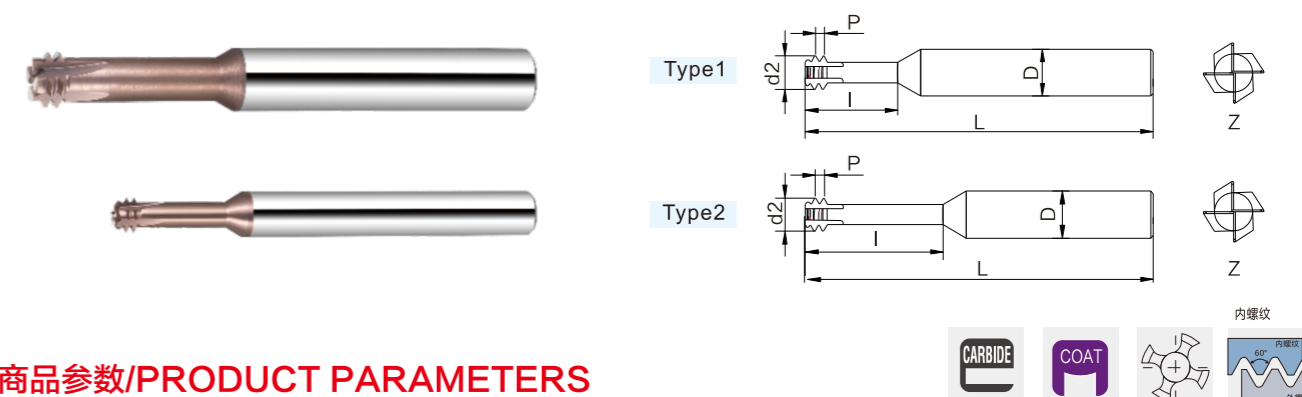
### 商品参数/PRODUCT PARAMETERS

商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z
			柄径 D	刃径 d2	刃长 l	总长 L	
		mm					
FH1150450L	M1.6*0.35	0.35	4	1.15	5	50	2
FH150450L	M2*0.4	0.4	4	1.5	6.5	50	2
FH190450L	M2.5*0.45	0.45	4	1.9	7	50	2
FH240650L	M3*0.5	0.5	6	2.4	9	50	4
FH320650L	M4*0.7	0.7	6	3.2	11	50	4
FH390650L	M5*0.8	0.8	6	3.9	12	50	4
FH470657L	M6*1	1	6	4.7	14	57	4
FH650865L	M8*1.25	1.25	8	6.5	18	65	4
FH780865L	M10*1.5	1.5	8	7.8	23	65	4
FH961070L	M12*1.75	1.75	10	9.6	26	70	4

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## 高硬免打孔螺纹铣刀

High hardness nonpunching thread milling cutter

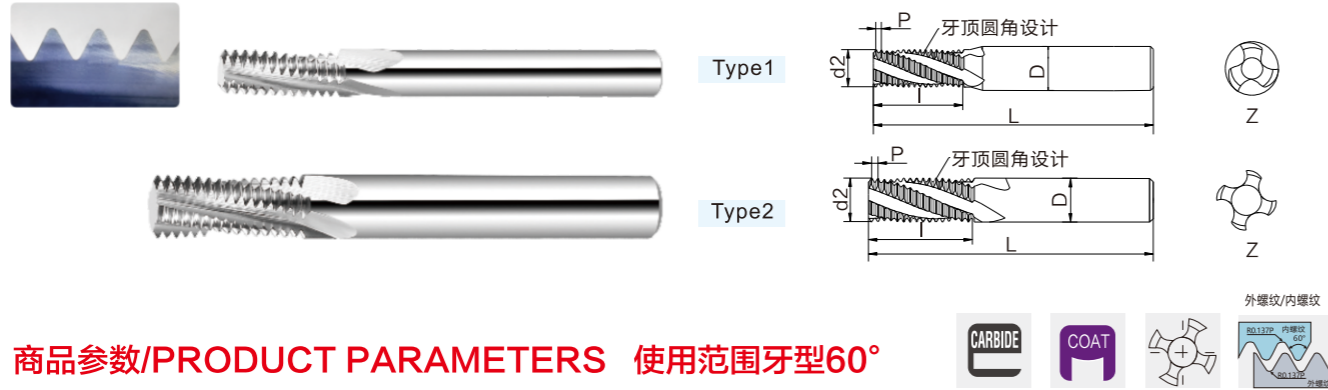


### 商品参数/PRODUCT PARAMETERS

商品号	螺纹 Thread	螺距 Pitch	尺寸 Dimensions mm				槽数 Z
			柄径 D	刃径 d2	刃长 l	总长 L	
		mm					
FH3052457D	M3*0.5	0.5	6	2.4	7.5	57	4
FH4073157D	M4*0.7	0.7	6	3.1	10	57	4
FH5083857D	M5*0.8	0.8	6	3.8	12.5	57	4
FH6104657D	M6*1	1	6	4.6	15	57	4
FH81256270D	M8*1.25	1.25	10	6.2	20	70	4
FH10157570D	M10*1.5	1.5	10	7.5	25	70	4
FH12175980D	M12*1.75	1.75	10	9	30	75	4

## MJ 航空全牙螺纹铣刀/牙顶圆角设计

MJ Aviation Full Thread Milling Cutter/Crest Fillet Design



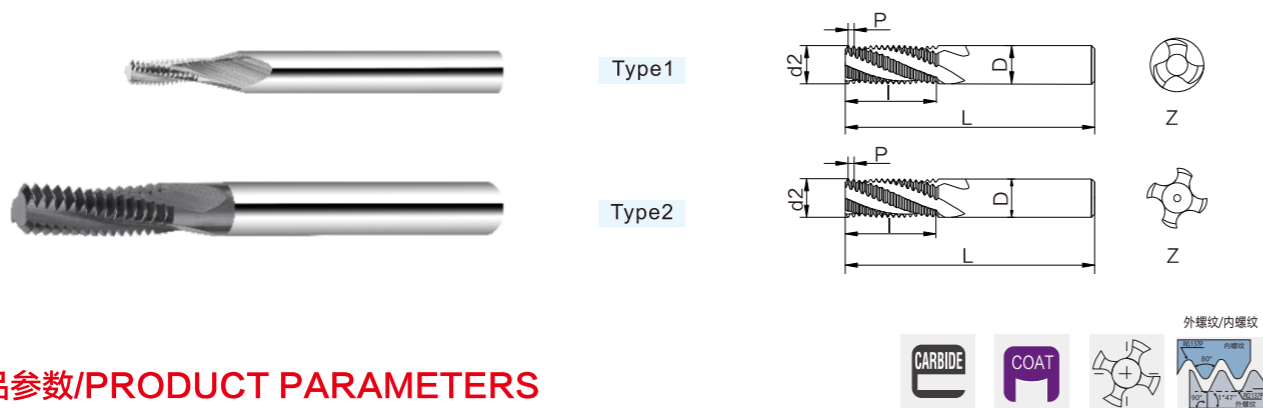
### 商品参数/PRODUCT PARAMETERS 使用范围牙型60°

铝用商品号	钢用商品号	螺纹	螺距	尺寸				槽数
		Thread	Pitch	Dimensions mm				
		标准牙	mm	柄径 D	刃径 d2	刃长 l	总长 L	Z
MJ61048L	MJ61048	MJ6*1.0	1	6	4.8	11	50	3
MJ8125595L	MJ8125595	MJ8*1.25	1.25	6	5.95	14.5	50	3
MJ1010795L	MJ1010795	MJ10*1.0	1	8	7.95	17	65	3
MJ10125795L	MJ10125795	MJ10*1.25	1.25	8	7.95	17.5	65	3
MJ1015795L	MJ1015795	MJ10*1.5	1.5	8	7.95	18	65	3
MJ1210995L	MJ1210995	MJ12*1.0	1	10	9.9	20	65	4
MJ1215995L	MJ1215995	MJ12*1.5	1.5	10	9.9	21	65	4
MJ12175995L	MJ12175995	MJ12*1.75	1.75	10	9.6	21.5	70	4
MJ14151195L	MJ14151195	MJ14-M39*1.5	1.5	12	11.95	24	75	4
MJ14201195L	MJ14201195	MJ14-M50*2	2	12	11.6	25	75	4

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## 德标PG螺纹铣刀

German standard PG thread milling cutter

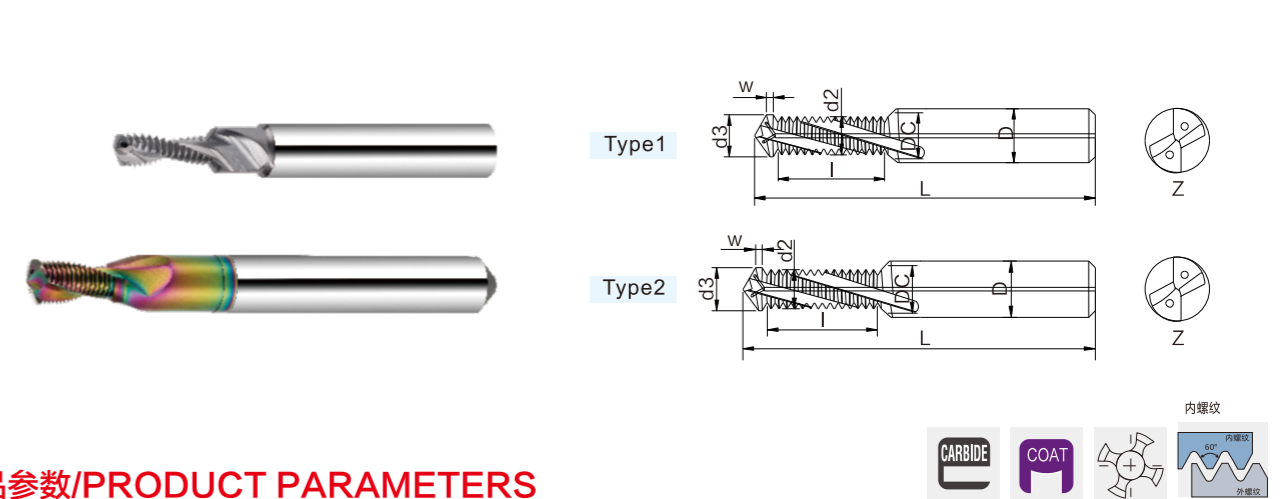


### 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹	螺距	尺寸				槽数	底孔直径
		Thread	Pitch	Dimensions mm					
		PG 牙形角80°	tpi	柄径 D	刃径 d2	刃长 l	总长 L	Z	mm
PG7020L	PG7020	PG7	20	8	7.9	19	65	3	11.5
PG9018L	PG9018	PG9	18	10	9.9	24	70	4	14
PG1118L	PG1118	PG11	18	10	9.9	24	70	4	17.25
PG13518L	PG13518	PG13.5	18	10	9.9	24	70	4	19
PG1618L	PG1618	PG16	18	10	9.9	24	70	4	21.25
PG2116L	PG2116	PG21	16	12	11.9	29	75	4	27
PG2916L	PG2916	PG29 PG36 PG42 PG48	16	12	11.9	29	75	4	35.5

## 内冷（钻铣倒一体）螺纹刀

Internal cooling (drilling, milling and chamfering) screw driver



### 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	螺纹	螺距	尺寸							槽数
		Thread	Pitch	Dimension mm							
		复合一体螺纹刀	mm	柄径 D	刃径 d2	刃长 l	钻头径 d3	W钻头刃长	倒角径 DC	总长 L	Z
FH610485EL	FH610485E	M6*1.0	1	8	4.85	12.1	5	1	6.3	65	2
FH81067EL	FH81067E	M8*1	1	10	6.7	15.1	7	1	8.3	75	2
FH812565EL	FH812565E	M8*1.25	1.25	10	6.5	15.1	6.8	1.3	8.3	75	2
FH10187EL	FH10187E	M10*1	1	12	8.7	20.1	9	1.3	10.3	83	2
FH101582EL	FH101582E	M10*1.5	1.5	12	8.2	19.6	8.5	1.5	10.3	83	2
FH1215102EL	FH1215102E	M12*1.5	1.5	14	10.2	24.1	10.5	1.5	12.3	89	2
FH1217599EL	FH1217599E	M12*1.75	1.75	14	9.9	22.9	10.3	1.5	12.3	89	2

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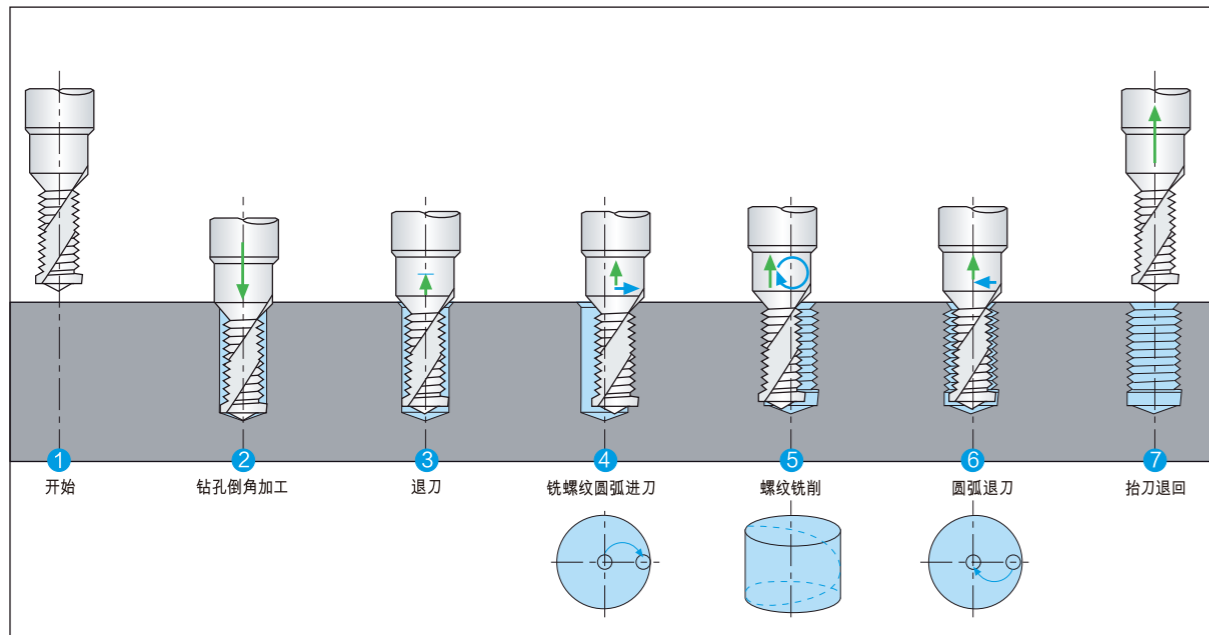
# 复合一体螺纹加工参数表

Processing parameters of composite one-piece thread

■ 整体合金螺纹铣刀切削速度Vc (m/min) 和进给量f (mm/tooth) 推荐表

材料类别	材料	布氏硬度 HB	强度 (N/mm <sup>2</sup> )	Vc [m/min]		fb [mm/rev]		fz [mm/tooth]	
				白刃	涂层 coat	≤6mm	≤12mm	≤6mm	≤12mm
K 铸铁	灰铸铁	≤150	≤500	50-80	80-120	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
	灰铸铁, 热处理过	150-300	500-1000	50-80	80-120	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
	球墨铸铁	≤200	≤700	50-80	80-120	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
N(k) Non-非铁金属	铜	≤200	≤700	100-300	—	0.10-0.30	0.06-0.10	0.03-0.06	0.06-0.10
	铝, 纯镁	≤100	≤350	100-400	100-400	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
	锻造铝合金, 延伸率(A5) < 14%	≤180	≤600	100-400	100-400	0.03-0.06	0.25-0.30	0.03-0.06	0.06-0.10
	锻造铝合金, 延伸率(A5) ≥ 14%	≤180	≤600	100-400	100-400	0.10-0.25	0.06-0.12	0.03-0.06	0.06-0.10
	铸造铝合金, 硅含量 < 10%	≤180	≤600	100-300	100-400	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
K	热塑性塑料	—	—	60-120	60-120	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
	热硬性塑料	—	—	60-100	60-100	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
	纤维塑料	—	—	40-60	40-60	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10

## 复合一体螺纹铣刀加工过程



# 螺纹刀加工参数表

Table of Threading Cutter Processing Parameters

■ 整体合金螺纹铣刀切削速度Vc (m/min) 和进给量f (mm/tooth) 推荐表

材料类别	材料	布氏硬度 HB	切削速度 Vc (mm/min)			进给量 (mm/tooth)		
			螺旋	直槽	微小径	螺旋	直槽	
P 钢	非合金钢	低碳(C=0.1-0.25%)	125	80-250	50-180	60-120	0.03-0.15	0.01-0.1
		中碳(C=0.25-0.55%)	150	80-230	50-140	60-120	0.03-0.1	0.01-0.08
		高碳(C=0.55-0.85%)	170	80-200	50-120	60-90	0.03-0.08	0.01-0.06
	低合金钢(合金含量 ≤ 5%)	非硬化	180	60-180	60-170	60-90	0.03-0.1	0.03-0.07
		淬硬	275	60-170	60-160	50-80	0.03-0.07	0.03-0.07
		淬硬	350	60-160	60-150	50-80	0.01-0.03	0.005-0.01
	高合金钢(合金含量 > 5%)	退火	200	40-100	40-90	50-80	0.03-0.05	0.01-0.03
		淬硬	325	30-80	30-70	50-80	0.01-0.03	0.005-0.01
	铸钢	低合金(合金含量 < 5%)	200	80-250	70-200	70-90	0.03-0.1	0.01-0.03
		高合金(合金含量 > 5%)	225	60-170	60-150	60-80	0.01-0.03	0.005-0.01
M 不锈钢	不锈钢铁素体	非硬化	200	60-150	50-140	60-90	0.04-0.1	0.01-0.05
		淬硬	330	60-120	50-110	50-80	0.01-0.05	0.005-0.01
	不锈钢奥氏体	奥氏体	180	60-140	60-130	60-90	0.04-0.1	0.007-0.02
		超级奥氏体	200	60-130	60-120	50-90	0.04-0.1	0.007-0.02
	不锈钢铁素体铸件	非硬化	200	60-160	50-150	60-90	0.04-0.1	0.01-0.03
		硬化	330	60-110	50-100	50-80	0.03-0.05	0.005-0.01
不锈钢奥氏体铸件	奥氏体	200	60-150	50-140	60-90	0.04-0.1	0.01-0.03	
淬硬	330	60-100	50-90	50-80	0.03-0.05	0.005-0.01		
K 铸铁	可锻铸铁	铁素体(短屑)	130	60-70	60-150	50-80	0.01-0.03	0.007-0.02
		珠光体(长屑)	230	60-150	80-100	60-90	0.03-0.05	0.005-0.01
	灰铸铁	低拉伸强度	180	70-160	50-140	70-100	0.025-0.1	0.007-0.02
		高拉伸强度	260	40-120	40-110	60-90	0.03-0.05	0.005-0.01
球墨铸铁	铁素体	160	40-110	40-100	70-100	0.05-0.1	0.007-0.02	
	珠光体	260	40-100	40-90	60-90	0.03-0.05	0.005-0.01	
N(k) Non-非铁金属	铝合金-锻造件	未时效	60	200-300	150-250	60-250	0.1-0.25	0.05-0.15
		时效	100	150-250	100-220	60-150	0.1-0.2	0.03-0.1
	铝合金	铸件	75	100-200	80-150	60-250	0.1-0.2	0.05-0.15
		铸件和时效的	90	120-220	90-160	60-150	0.1-0.15	0.03-0.1
	铝合金	铸件 硅含量 13-22%	130	200-300	150-250	250	0.1-0.2	0.05-0.15
铜和铜合金	黄铜	90	200-300	150-250	60-250	0.1-0.25	0.05-0.15	
	青铜和不含铅铜	100	150-250	100-220	60-150	0.1-0.2	0.03-0.1	
S(M) 抗热, 耐热材料	高温合金	退火的(铁基)	200	30-60	30-50	60	0.4-0.1	0.007-0.02
		时效(铁基)	280	20-50	20-40	50	0.01-0.03	0.005-0.01
		退火的(镍或钴基)	250	15-35	15-30	35	0.01-0.03	0.005-0.01
		时效(镍或钴基)	350	15-30	15-25	30	0.01-0.03	0.005-0.01
	钛合金	纯度99.5钛99.5Ti	400Rm	40-80	30-70	30-50	0.03-0.05	0.007-0.02
a+β合金		1050Rm	20-50	20-45	25-35	0.03-0.05	0.007-0.02	
H(k) 淬硬材料	高硬钢	淬硬和退火	45-50HRc	15-45	15-35	45	0.005-0.01	0.003-0.006
		51-55HRc	15-40	15-30	30	0.005-0.01	0.003-0.006	

建议:

刀具刚切入时的进给量f (mm/tooth) 比正常螺纹切削时的进给量低70%

例如:

螺纹切削进给量: 0.3 [mm/tooth]

刀具切入进给量: 0.09 [mm/tooth]

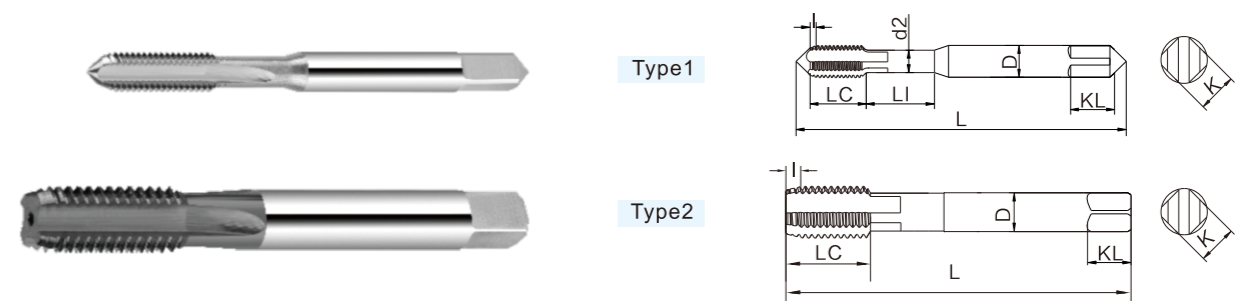
# 丝锥系列

## Screw Tap series



# 公制硬质合金直槽丝锥

Metric carbide straight groove screw tap

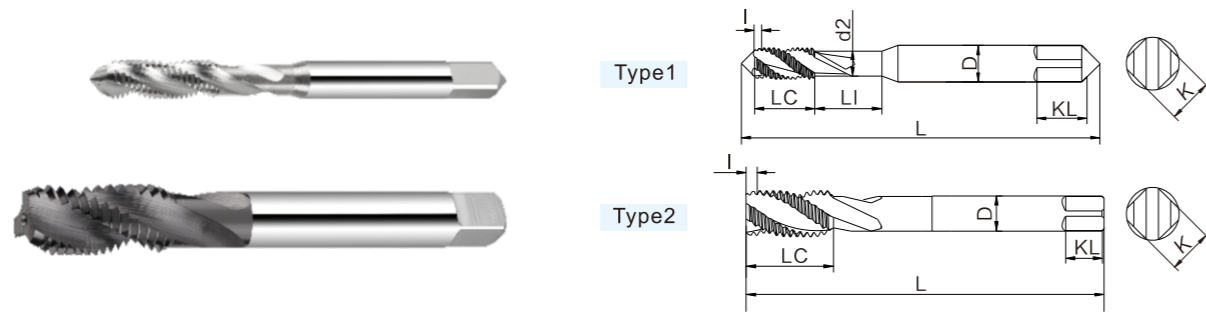


## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	方长	方宽	颈长	颈径
				I	L	LC	D	Z	LK	K	LI	d2
H14304203L	H14304203	M1.4*0.3	6H	2P	42	6	3	3	5	2.5		
H16354203L	H16354203	M1.6*0.35	6H	2P	42	8	3	3	5	2.5		
H17354203L	H17354203	M1.7*0.35	6H	2P	42	8	3	3	5	2.5		
H18354203L	H18354203	M1.8*0.35	6H	2P	42	9	3	3	5	2.5		
H20044203L	H20044203	M2.0*0.4	6H	2P	42	10	3	3	5	2.5		
H25454203L	H25454203	M2.5*0.45	6H	2P	42	11	3	3	5	2.5		
H30055204L	H30055204	M3.0*0.5	6H	2P	52	11	4	3	6	3.2	6	2.4
H35065204L	H35065204	M3.5*0.6	6H	2P	52	12	4	3	6	3.2	7	2.8
H40075505L	H40075505	M4.0*0.7	6H	2P	55	13	5	3	7	4	7	3.1
H50086005L	H50086005	M5.0*0.8	6H	2P	60	15	5	3	7	4	10	4
H60106506L	H60106506	M6.0*1	6H	2P	65	16	6	3	7	4.5	10	4.8
H80107362L	H80107362	M8.0*1	6H	2.5P	73	18	6.2	4	8	5		
H81257362L	H81257362	M8.0*1.25	6H	2.5P	73	18	6.2	4	8	5		
H10107508L	H10107508	M10*1	6H	2.5P	75	21	8	4	9	6		
H101257508L	H101257508	M10*1.25	6H	2.5P	75	21	8	4	9	6		
H10157508L	H10157508	M10*1.5	6H	2.5P	75	21	8	4	9	6		
H12108309L	H12108309	M12*1.0	6H	2.5P	83	25	9	4	9	7		
H121258309L	H121258309	M12*1.25	6H	2.5P	83	25	9	4	9	7		
H12158309L	H12158309	M12*1.5	6H	2.5P	83	25	9	4	9	7		
H121758309L	H121758309	M12*1.75	6H	2.5P	83	25	9	4	9	7		
H141590105L	H141590105	M14*1.5	6H	2.5P	90	26	10.5	4	11	8		
H142090105L	H142090105	M14*2	6H	2.5P	90	26	10.5	4	11	8		
H161598125L	H161598125	M16*1.5	6H	2.5P	98	29	12.5	4	13	10		
H162098125L	H162098125	M16*2	6H	2.5P	98	29	12.5	4	13	10		
H181510014L	H181510014	M18*1.5	6H	2.5P	100	33	14	4	14	11		
H182510014L	H182510014	M18*2.5	6H	2.5P	100	33	14	4	14	11		
H201510515L	H201510515	M20*1.5	6H	2.5P	105	33	15	4	15	12		
H202510515L	H202510515	M20*2.5	6H	2.5P	105	33	15	4	15	12		

# 公制硬质合金螺旋丝锥

Metric Carbide Screw Taps



## 商品参数/PRODUCT PARAMETERS

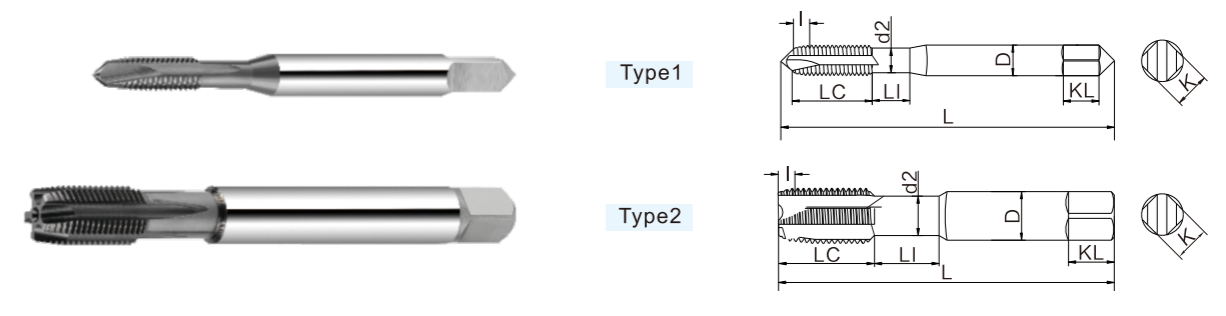


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	螺旋角	方长	方宽	颈长	颈径
				I	L	LC	D	Z	∠	LK	K	LI	d2
S14304203L	S14304203	M1.4*0.3	6H	1.5P	42	6	3	2	35	5	2.5		
S16354203L	S16354203	M1.6*0.35	6H	1.5P	42	8	3	2	35	5	2.5		
S17354203L	S17354203	M1.7*0.35	6H	1.5P	42	8	3	2	35	5	2.5		
S18354203L	S18354203	M1.8*0.35	6H	1.5P	42	9	3	2	35	5	2.5		
S20044203L	S20044203	M2.0*0.4	6H	1.5P	42	10	3	2	35	5	2.5		
S25454203L	S25454203	M2.5*0.45	6H	1.5P	42	11	3	2	35	5	2.5		
S30055204L	S30055204	M3.0*0.5	6H	2P	52	11	4	3	30	6	3.2	6	2.4
S35065204L	S35065204	M3.5*0.6	6H	2P	52	12	4	3	30	6	3.2	7	2.8
S40075505L	S40075505	M4.0*0.7	6H	2P	55	13	5	3	30	7	4	7	3.1
S50086005L	S50086005	M5.0*0.8	6H	2P	60	15	5	3	30	7	4	10	4
S60106506L	S60106506	M6.0*1	6H	2.5P	65	16	6	3	30	7	4.5	10	4.8
S80107362L	S80107362	M8.0*1	6H	2.5P	73	18	6.2	3	30	8	5		
S81257362L	S81257362	M8.0*1.25	6H	2.5P	73	18	6.2	3	30	8	5		
S10107508L	S10107508	M10*1	6H	2.5P	75	21	8	3	30	9	6		
S101257508L	S101257508	M10*1.25	6H	2.5P	75	21	8	3	30	9	6		
S10157508L	S10157508	M10*1.5	6H	2.5P	75	21	8	3	30	9	6		
S12108309L	S12108309	M12*1.0	6H	2.5P	83	25	9	4	15	9	7		
S121258309L	S121258309	M12*1.25	6H	2.5P	83	25	9	4	15	9	7		
S12158309L	S12158309	M12*1.5	6H	2.5P	83	25	9	4	15	9	7		
S121758309L	S121758309	M12*1.75	6H	2.5P	83	25	9	4	15	9	7		
S141590105L	S141590105	M14*1.5	6H	2.5P	90	26	10.5	4	15	11	8		
S142090105L	S142090105	M14*2	6H	2.5P	90	26	10.5	4	15	11	8		
S161598125L	S161598125	M16*1.5	6H	2.5P	98	29	12.5	4	15	13	10		
S162098125L	S162098125	M16*2	6H	2.5P	98	29	12.5	4	15	13	10		
S181510014L	S181510014	M18*1.5	6H	2.5P	100	33	14	4	15	14	11		
S182510014L	S182510014	M18*2.5	6H	2.5P	100	33	14	4	15	14	11		
S201510515L	S201510515	M20*1.5	6H	2.5P	105	33	15	4	15	15	12		
S202510515L	S202510515	M20*2.5	6H	2.5P	105	33	15	4	15	15	12		

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# 公制硬质合金先端丝锥

Metric carbide tipped screw tap



## 商品参数/PRODUCT PARAMETERS

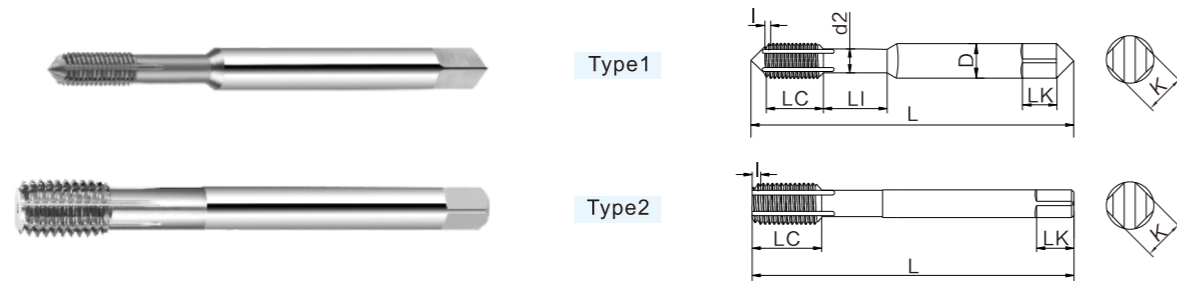


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	先端丝锥 槽数Z	方长	方宽	颈长	颈径
				I	L	LC	D	Z	LK	K	LI	d2
Y20044203L	Y20044203	M2.0*0.4	6H	5P	42	10	3	2	5	2.5		
Y25454203L	Y25454203	M2.5*0.45	6H	5P	42	11	3	2	5	2.5		
Y30055204L	Y30055204	M3.0*0.5	6H	5P	52	11	4	3	6	3.2	6	2.4
Y35065204L	Y35065204	M3.5*0.6	6H	5P	52	12	4	3	6	3.2	7	2.8
Y40075505L	Y40075505	M4.0*0.7	6H	5P	55	13	5	3	7	4	7	3.1
Y50086005L	Y50086005	M5.0*0.8	6H	5P	60	15	5	3	7	4	10	4
Y60106506L	Y60106506	M6.0*1	6H	5P	65	16	6	3	7	4.5	10	4.8
Y80107362L	Y80107362	M8.0*1	6H	5P	73	18	6.2	3	8	5		
Y81257362L	Y81257362	M8.0*1.25	6H	5P	73	18	6.2	3	8	5		
Y10107508L	Y10107508	M10*1	6H	5P	75	21	8	4	9	6		
Y101257508L	Y101257508	M10*1.25	6H	5P	75	21	8	4	9	6		
Y10157508L	Y10157508	M10*1.5	6H	5P	75	21	8	4	9	6		
Y12108309L	Y12108309	M12*1.0	6H	5P	83	25	9	4	9	7		
Y121258309L	Y121258309	M12*1.25	6H	5P	83	25	9	4	9	7		
Y12158309L	Y12158309	M12*1.5	6H	5P	83	25	9	4	9	7		
Y121758309L	Y121758309	M12*1.75	6H	5P	83	25	9	4	9	7		
Y141590105L	Y141590105	M14*1.5	6H	5P	90	26	10.5	4	11	8		
Y142090105L	Y142090105	M14*2	6H	5P	90	26	10.5	4	11	8		
Y161598125L	Y161598125	M16*1.5	6H	5P	98	29	12.5	4	13	10		
Y162098125L	Y162098125	M16*2	6H	5P	98	29	12.5	4	13	10		
Y181510014L	Y181510014	M18*1.5	6H	5P	100	33	14	4	14	11		
Y182510014L	Y182510014	M18*2.5	6H	5P	100	33	14	4	14	11		
Y201510515L	Y201510515	M20*1.5	6H	5P	105	33	15	4	15	12		
Y202510515L	Y202510515	M20*2.5	6H	5P	105	33	15	4	15	12		

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# 公制硬质合金挤压丝锥

Metric hard alloy extrusion screw tap



## 商品参数/PRODUCT PARAMETERS

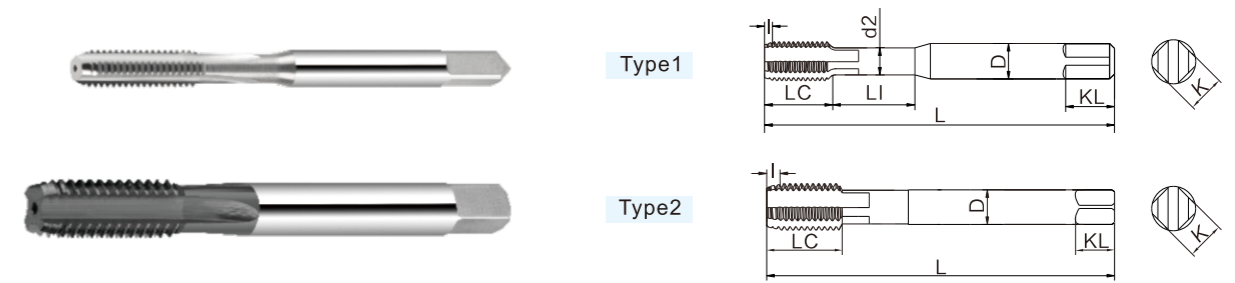


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	柄径	刃长	挤压丝锥 楞数/槽数Z	方长	方宽	颈长	颈径	
				I	L	D	LC	T	Z	LK	K	LI	d2
J12504203L	J12504203	M1.0*0.25	RH4	1P	42	3	5	4	/	5	2.5		
J12254203L	J12254203	M1.2*0.25	RH4	1P	42	3	5.5	4	/	5	2.5		
J14304203L	J14304203	M1.4*0.3	RH4	1P	42	3	6	4	/	5	2.5		
J16354203L	J16354203	M1.6*0.35	RH4	1P	42	3	8	4	/	5	2.5		
J17354203L	J17354203	M1.7*0.35	RH4	1P	42	3	8	4	/	5	2.5		
J18354203L	J18354203	M1.8*0.35	RH4	1P	42	3	9	4	/	5	2.5		
J20044203L	J20044203	M2.0*0.4	RH4	1.5P	42	3	10	4	/	5	2.5		
J25454203L	J25454203	M2.5*0.45	RH4	1.5P	42	3	11	4	/	5	2.5		
J30055204L	J30055204	M3.0*0.5	RH5	1.5P	52	4	11	4	/	6	3.2	6	2.4
J35065204L	J35065204	M3.5*0.6	RH6	1.5P	52	4	12	4	/	6	3.2	7	2.8
J40075505L	J40075505	M4.0*0.7	RH6	1.5P	55	5	12	4	2	7	4	7	3.1
J50086005L	J50086005	M5.0*0.8	RH6	1.5P	60	5	15	4	2	7	4	10	4
J60106506L	J60106506	M6.0*1	RH6	1.5P	65	6	16	4	4	7	4.5	10	4.8
J80107362L	J80107362	M8.0*1	RH6	1.5P	73	6.2	18	6	6	8	5		
J81257362L	J81257362	M8.0*1.25	RH6	1.5P	73	6.2	18	6	6	8	5		
J10107508L	J10107508	M10*1	RH7	2P	75	8	21	6	6	9	6		
J101257508L	J101257508	M10*1.25	RH7	2P	75	8	21	6	6	9	6		
J10157508L	J10157508	M10*1.5	RH7	2P	75	8	21	6	6	9	6		
J12108309L	J12108309	M12*1.0	RH7	2P	83	9	22	6	6	9	7		
J121258309L	J121258309	M12*1.25	RH7	2P	83	9	25	6	6	9	7		
J12158309L	J12158309	M12*1.5	RH7	2P	83	9	25	8	8	9	7		
J121758309L	J121758309	M12*1.75	RH8	2P	83	9	25	8	8	9	7		
J141590105L	J141590105	M14*1.5	RH9	2P	90	10.5	26	8	8	11	8		
J142090105L	J142090105	M14*2	RH10	2P	90	10.5	26	8	8	11	8		
J161598125L	J161598125	M16*1.5	RH9	2P	98	12.5	29	8	8	13	10		
J162098125L	J162098125	M16*2	RH10	2P	98	12.5	29	8	8	13	10		
J181510014L	J181510014	M18*1.5	RH9	2P	100	14	33	8	8	14	11		
J182510014L	J182510014	M18*2.5	RH10	2P	100	14	33	8	8	14	11		

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# 硬质合金加长直槽丝锥

Carbide long straight groove screw tap



## 商品参数/PRODUCT PARAMETERS

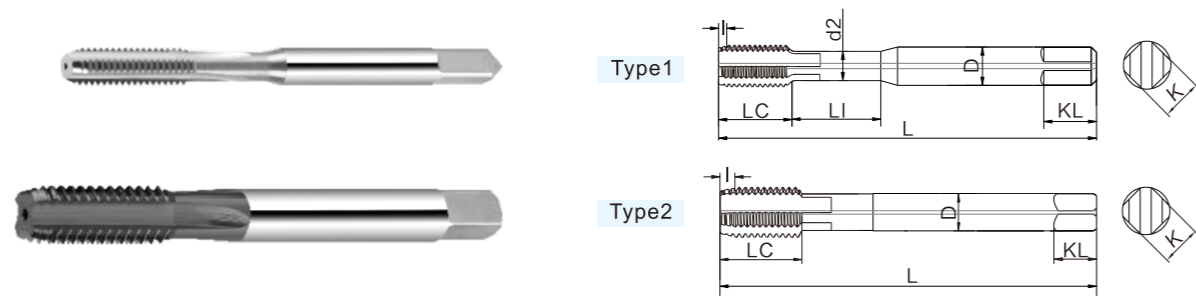


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	柄径	刃长	槽数	方长	方宽	颈长	颈径
				I	L	D	LC	z	LK	K	LI	d2
H30508004L	H30508004	M3*0.5	6HX	2.5P	80	4	9	3	5.5	3.2	8	2.4
H40708005L	H40708005	M4*0.7	6HX	2.5P	80	5	9	3	6	4	10	3.1
H50808006L	H50808006	M5*0.8	6HX	2.5P	80	6	12	3	8	4.5	12	4
H50801B06L	H50801B06	M5*0.8	6HX	2.5P	100	6	12	3	8	4.5	12	4
H60108006L	H60108006	M6*1	6HX	2.5P	80	6	13	3	8	4.9	12	4.8
H60101B06L	H60101B06	M6*1	6HX	2.5P	100	6	13	3	8	4.9	12	4.8
H80109008L	H80109008	M8*1	6HX	2.5P	90	8	16	4	9	6.2	24	6.3
H81259008L	H81259008	M8*1.25	6HX	2.5P	90	8	16	4	9	6.2	24	6.3
H81251B08L	H81251B08	M8*1.25	6HX	2.5P	100	8	16	4	9	6.2	24	6.3
H10101B10L	H10101B10	M10*1	6HX	2.5P	100	10	18	4	11	8	27	8.2
H101251B10L	H101251B10	M10*1.25	6HX	2.5P	100	10	18	4	11	8	27	8.2
H10151B10L	H10151B10	M10*1.5	6HX	2.5P	100	10	18	4	11	8	27	8.2
H12151B09L	H12151B09	M12*1.5	6HX	2.5P	100	9	22	4	10	7	20	8.8
H121751B09L	H121751B09	M12*1.75	6HX	2.5P	100	9	22	4	10	7	20	8.8
H141511B11L	H141511B11	M14*1.5	6HX	2.5P	110	11	22	4	12	9	20	10.8
H142011B11L	H142011B11	M14*2	6HX	2.5P	110	11	22	4	12	9	20	10.8
H161511B12L	H161511B12	M16*1.5	6HX	2.5P	110	12	22	4	13	9	20	11.8
H162011B12L	H162011B12	M16*2.0	6HX	2.5P	110	12	22	4	13	9	20	11.8
H181511B14L	H181511B14	M18*1.5	6HX	2.5P	110	14	24	4	14	11	20	13.8
H182511B14L	H182511B14	M18*2.5	6HX	2.5P	110	14	24	4	14	11	20	13.8

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## 硬质合金内冷加长直槽丝锥

Carbide internal cooling extended straight groove screw tap



### 商品参数/PRODUCT PARAMETERS

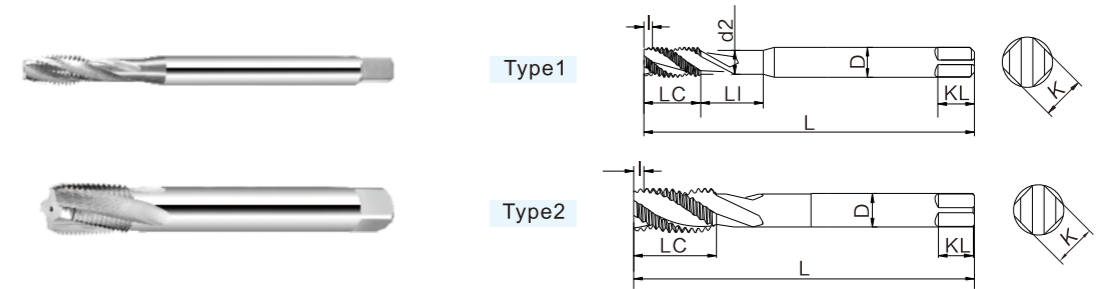


铝用商品号	钢用商品号	规格	精度	切削锥长	总长	柄径	刃长	槽数	方长	方宽	颈长	颈径
				I	L	D	LC	Z	Lk	K	LI	d2
H30508004EL	H30508004E	M3*0.5	6HX	2.5P	80	4	9	3	5.5	3.2	8	2.4
H40708005EL	H40708005E	M4*0.7	6HX	2.5P	80	5	9	3	6	4	10	3.1
H50808006EL	H50808006E	M5*0.8	6HX	2.5P	80	6	12	3	8	4.5	12	4
H50801B06EL	H50801B06E	M5*0.8	6HX	2.5P	100	6	12	3	8	4.5	12	4
H60108006EL	H60108006E	M6*1	6HX	2.5P	80	6	13	3	8	4.9	12	4.8
H60101B06EL	H60101B06E	M6*1	6HX	2.5P	100	6	13	3	8	4.9	12	4.8
H80109008EL	H80109008E	M8*1	6HX	2.5P	90	8	16	4	9	6.2	24	6.3
H81259008EL	H81259008E	M8*1.25	6HX	2.5P	90	8	16	4	9	6.2	24	6.3
H81251B08EL	H81251B08E	M8*1.25	6HX	2.5P	100	8	16	4	9	6.2	24	6.3
H10101B10EL	H10101B10E	M10*1	6HX	2.5P	100	10	18	4	11	8	27	8.2
H101251B10EL	H101251B10E	M10*1.25	6HX	2.5P	100	10	18	4	11	8	27	8.2
H10151B10EL	H10151B10E	M10*1.5	6HX	2.5P	100	10	18	4	11	8	27	8.2
H12151B09EL	H12151B09E	M12*1.5	6HX	2.5P	100	9	22	4	10	7	20	8.8
H121751B09EL	H121751B09E	M12*1.75	6HX	2.5P	100	9	22	4	10	7	20	8.8
H141511B11EL	H141511B11E	M14*1.5	6HX	2.5P	110	11	22	4	12	9	20	10.8
H142011B11EL	H142011B11E	M14*2	6HX	2.5P	110	11	22	4	12	9	20	10.8
H161511B12EL	H161511B12E	M16*1.5	6HX	2.5P	110	12	22	4	13	9	20	11.8
H162011B12EL	H162011B12E	M16*2.0	6HX	2.5P	110	12	22	4	13	9	20	11.8
H181511B14EL	H181511B14E	M18*1.5	6HX	2.5P	110	14	24	4	14	11	20	13.8
H182511B14EL	H182511B14E	M18*2.5	6HX	2.5P	110	14	24	4	14	11	20	13.8

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## 硬质合金加长螺旋丝锥

Carbide extended screw tap



### 商品参数/PRODUCT PARAMETERS

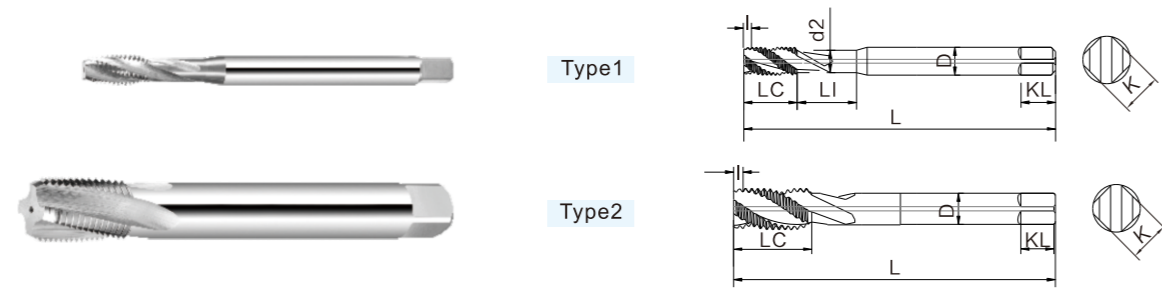


铝用商品号	钢用商品号	规格	精度	切削锥长	总长	刃长	柄径	槽数	螺旋角	方长	方宽	颈长	颈径
				I	L	LC	D	Z	∠	LK	K	LI	d2
S30508004L	S30508004	M3*0.5	6HX	1.5P	80	9	4	3	30	5.5	3.2	8	2.4
S40708005L	S40708005	M4*0.7	6HX	1.5P	80	9	5	3	30	6	4	10	3.1
S50808006L	S50808006	M5*0.8	6HX	1.5P	80	12	6	3	15	8	4.5	12	4
S50801B06L	S50801B06	M5*0.8	6HX	1.5P	100	12	6	3	15	8	4.5	12	4
S60108006L	S60108006	M6*1	6HX	1.5P	80	13	6	3	15	8	4.9	12	4.8
S60101B06L	S60101B06	M6*1	6HX	1.5P	100	13	6	3	15	8	4.9	12	4.8
S80109008L	S80109008	M8*1.0	6HX	1.5P	90	16	8	3	15	9	6.2	24	6.3
S81259008L	S81259008	M8*1.25	6HX	1.5P	90	16	8	3	15	9	6.2	24	6.3
S81251B08L	S81251B08	M8*1.25	6HX	1.5P	100	16	8	3	15	9	6.2	24	6.3
S10101B10L	S10101B10	M10*1	6HX	1.5P	100	18	10	3	15	11	8	27	8.2
S101251B10L	S101251B10	M10*1.25	6HX	1.5P	100	18	10	3	15	11	8	27	8.2
S10151B10L	S10151B10	M10*1.5	6HX	1.5P	100	18	10	3	15	11	8	27	8.2
S12151B09L	S12151B09	M12*1.5	6HX	1.5P	100	22	9	4	15	10	7	20	8.8
S121751B09L	S121751B09	M12*1.75	6HX	1.5P	100	22	9	4	15	10	7	20	8.8
S141511B11L	S141511B11	M14*1.5	6HX	1.5P	110	22	11	4	15	12	9	20	10.8
S142011B11L	S142011B11	M14*2	6HX	1.5P	110	22	11	4	15	12	9	20	10.8
S161511B12L	S161511B12	M16*1.5	6HX	1.5P	110	22	12	4	15	13	9	20	11.8
S162011B12L	S162011B12	M16*2.0	6HX	1.5P	110	22	12	4	15	13	9	20	11.8
S181511B14L	S181511B14	M18*1.5	6HX	1.5P	110	24	14	4	15	14	11	20	13.8
S182511B14L	S182511B14	M18*2.5	6HX	1.5P	110	24	14	4	15	14	11	20	13.8

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## 硬质合金内冷加长螺旋丝锥

Carbide internal cooling lengthened screw tap



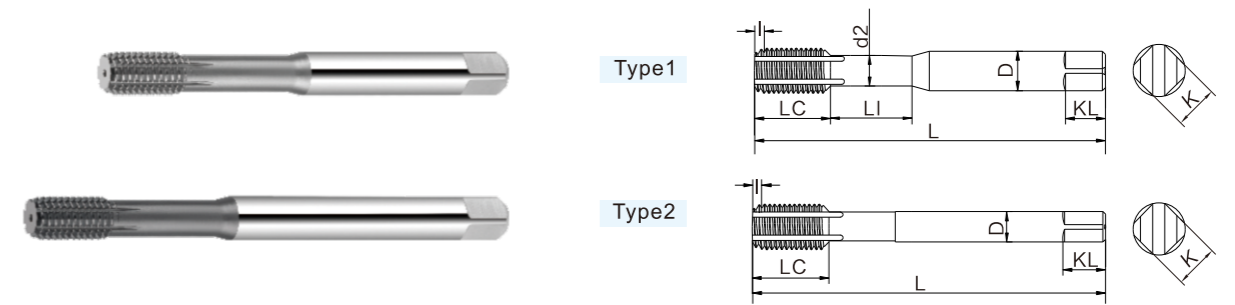
### 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	规格	精度	切削锥长	总长	柄径	刃长	槽数	螺旋角	方长	方宽	颈长	颈径
S30508004EL	S30508004E	M3*0.5	6HX	1.5P	80	4	9	3	30	5.5	3.2	8	2.4
S40708005EL	S40708005E	M4*0.7	6HX	1.5P	80	5	9	3	30	6	4	10	3.1
S50808006EL	S50808006E	M5*0.8	6HX	1.5P	80	6	12	3	15	8	4.5	12	4
S50801B06EL	S50801B06E	M5*0.8	6HX	1.5P	100	6	12	3	15	8	4.5	12	4
S60108006EL	S60108006E	M6*1	6HX	1.5P	80	6	13	3	15	8	4.9	12	4.8
S60101B06EL	S60101B06E	M6*1	6HX	1.5P	100	6	13	3	15	8	4.9	12	4.8
S80109008EL	S80109008E	M8*1.0	6HX	1.5P	90	8	16	3	15	9	6.2	24	6.3
S81259008EL	S81259008E	M8*1.25	6HX	1.5P	90	8	16	3	15	9	6.2	24	6.3
S81251B08EL	S81251B08E	M8*1.25	6HX	1.5P	100	8	16	3	15	9	6.2	24	6.3
S10101B10EL	S10101B10E	M10*1	6HX	1.5P	100	10	18	3	15	11	8	27	8.2
S101251B10EL	S101251B10E	M10*1.25	6HX	1.5P	100	10	18	3	15	11	8	27	8.2
S10151B10EL	S10151B10E	M10*1.5	6HX	1.5P	100	10	18	3	15	11	8	27	8.2
S12151B09EL	S12151B09E	M12*1.5	6HX	1.5P	100	9	22	4	15	10	7	20	8.8
S121751B09EL	S121751B09E	M12*1.75	6HX	1.5P	100	9	22	4	15	10	7	20	8.8
S141511B11EL	S141511B11E	M14*1.5	6HX	1.5P	110	11	22	4	15	12	9	20	10.8
S142011B11EL	S142011B11E	M14*2	6HX	1.5P	110	11	22	4	15	12	9	20	10.8
S161511B12EL	S161511B12E	M16*1.5	6HX	1.5P	110	12	22	4	15	13	9	20	11.8
S162011B12EL	S162011B12E	M16*2.0	6HX	1.5P	110	12	22	4	15	13	9	20	11.8
S181511B14EL	S181511B14E	M18*1.5	6HX	1.5P	110	14	24	4	15	14	11	20	13.8
S182511B14EL	S182511B14E	M18*2.5	6HX	1.5P	110	14	24	4	15	14	11	20	13.8

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## 硬质合金加长挤压丝锥

Carbide long extrusion screw tap



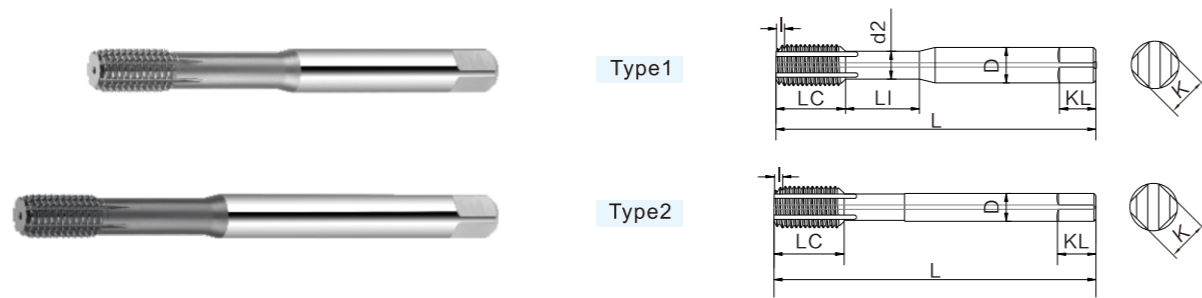
### 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	规格	精度	切削锥长	总长	柄径	刃长	挤压丝锥		方长	方宽	颈长	颈径
								楞数	槽数Z				
J30508004L	J30508004	M3*0.5	6HX	1.5P	80	4	9	4	2	5.5	3.2	8	2.4
J40708005L	J40708005	M4*0.7	6HX	1.5P	80	5	9	4	4	6	4	10	3.1
J50808006L	J50808006	M5*0.8	6HX	1.5P	80	6	11	4	4	8	4.5	12	4
J50801B06L	J50801B06	M5*0.8	6HX	1.5P	100	6	11	4	4	8	4.5	12	4
J60108006L	J60108006	M6*1	6HX	1.5P	80	6	12	4	4	8	4.9	12	4.8
J60101B06L	J60101B06	M6*1	6HX	1.5P	100	6	12	4	4	8	4.9	12	4.8
J80109008L	J80109008	M8*1.0	6HX	1.5P	90	8	16	6	6	9	6.2	24	6.3
J81259008L	J81259008	M8*1.25	6HX	1.5P	90	8	16	6	6	9	6.2	24	6.3
J81251B08L	J81251B08	M8*1.25	6HX	1.5P	100	8	16	6	6	9	6.2	24	6.3
J10101B10L	J10101B10	M10*1.0	6HX	1.5P	100	10	18	6	6	11	8	27	8.2
J101251B10L	J101251B10	M10*1.25	6HX	1.5P	100	10	18	6	6	11	8	27	8.2
J10151B10L	J10151B10	M10*1.5	6HX	1.5P	100	10	18	6	6	11	8	27	8.2
J12151B09L	J12151B09	M12*1.5	6HX	1.5P	100	9	19	6	6	10	7	20	8.8
J121751B09L	J121751B09	M12*1.75	6HX	1.5P	100	9	19	6	6	10	7	20	8.8
J141511B11L	J141511B11	M14*1.5	6HX	1.5P	110	11	19	6	6	12	9	20	10.8
J142011B11L	J142011B11	M14*2	6HX	1.5P	110	11	19	6	6	12	9	20	10.8
J161511B12L	J161511B12	M16*1.5	6HX	1.5P	110	12	19	8	8	13	9	20	11.8
J162011B12L	J162011B12	M16*2.0	6HX	1.5P	110	12	19	8	8	13	9	20	11.8
J181511B14L	J181511B14	M18*1.5	6HX	1.5P	110	14	22	8	8	14	11	20	13.8
J182511B14L	J182511B14	M18*2.5	6HX	1.5P	110	14	22	8	8	14	11	20	13.8

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## 硬质合金内冷加长挤压丝锥

Carbide internal cooling extended extrusion screw tap



### 商品参数/PRODUCT PARAMETERS

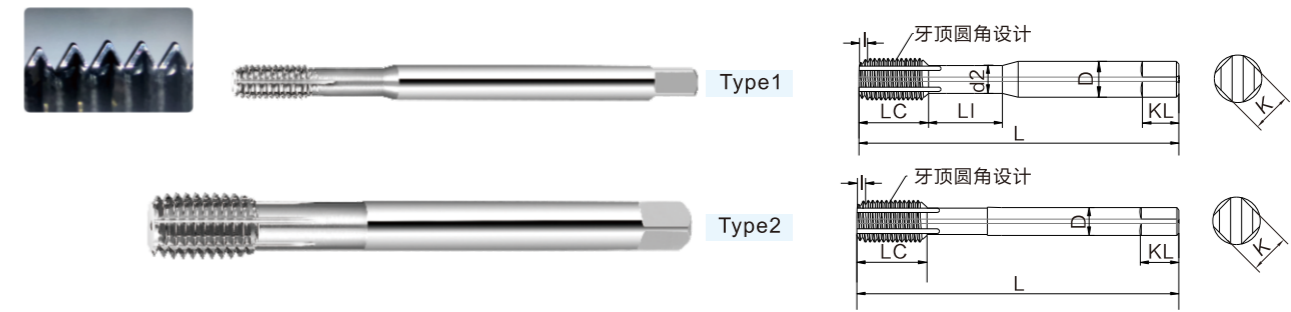


铝用商品号	钢用商品号	规格	精度	切削锥长	总长	柄径	刃长	挤压丝锥		方长	方宽	颈长	颈径
								楞数	槽数z				
				I	L	D	LC	楞数	槽数	LK	K	LI	d2
J30508004EL	J30508004E	M3*0.5	6HX	1.5P	80	4	9	4	2	5.5	3.2	8	2.4
J40708005EL	J40708005E	M4*0.7	6HX	1.5P	80	5	9	4	4	6	4	10	3.1
J50808006EL	J50808006E	M5*0.8	6HX	1.5P	80	6	11	4	4	8	4.5	12	4
J50801B06EL	J50801B06E	M5*0.8	6HX	1.5P	100	6	11	4	4	8	4.5	12	4
J60108006EL	J60108006E	M6*1	6HX	1.5P	80	6	12	4	4	8	4.9	12	4.8
J60101B06EL	J60101B06E	M6*1	6HX	1.5P	100	6	12	4	4	8	4.9	12	4.8
J80109008EL	J80109008E	M8*1.0	6HX	1.5P	90	8	16	6	6	9	6.2	24	6.3
J81259008EL	J81259008E	M8*1.25	6HX	1.5P	90	8	16	6	6	9	6.2	24	6.3
J81251B08EL	J81251B08E	M8*1.25	6HX	1.5P	100	8	16	6	6	9	6.2	24	6.3
J10101B10EL	J10101B10E	M10*1.0	6HX	1.5P	100	10	18	6	6	11	8	27	8.2
J101251B10EL	J101251B10E	M10*1.25	6HX	1.5P	100	10	18	6	6	11	8	27	8.2
J10151B10EL	J10151B10E	M10*1.5	6HX	1.5P	100	10	18	6	6	11	8	27	8.2
J12151B09EL	J12151B09E	M12*1.5	6HX	1.5P	100	9	19	6	6	10	7	20	8.8
J121751B09EL	J121751B09E	M12*1.75	6HX	1.5P	100	9	19	6	6	10	7	20	8.8
J141511B11EL	J141511B11E	M14*1.5	6HX	1.5P	110	11	19	6	6	12	9	20	10.8
J142011B11EL	J142011B11E	M14*2	6HX	1.5P	110	11	19	6	6	12	9	20	10.8
J161511B12EL	J161511B12E	M16*1.5	6HX	1.5P	110	12	19	8	8	13	9	20	11.8
J162011B12EL	J162011B12E	M16*2.0	6HX	1.5P	110	12	19	8	8	13	9	20	11.8
J181511B14EL	J181511B14E	M18*1.5	6HX	1.5P	110	14	22	8	8	14	11	20	13.8
J182511B14EL	J182511B14E	M18*2.5	6HX	1.5P	110	14	22	8	8	14	11	20	13.8

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## 硬质合金圆弧顶内冷挤压丝锥

Carbide arc top internal cold extrusion screw tap



### 商品参数/PRODUCT PARAMETERS

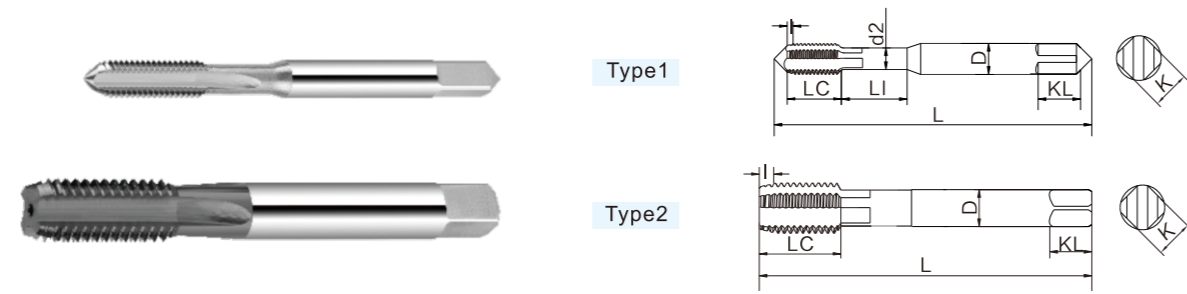


铝用商品号	钢用商品号	规格	精度	切削锥长	总长	柄径	刃长	挤压丝锥		方长	方宽	颈长	颈径
								楞数	槽数z				
				I	L	D	LC	楞数	槽数	LK	K	LI	d2
JR50808006EL	JR50808006E	M5*0.8	6HX	1.5P	80	6	11	4	4	8	4.5	12	4
JR50801B06EL	JR50801B06E	M5*0.8	6HX	1.5P	100	6	11	4	4	8	4.5	12	4
JR60108006EL	JR60108006E	M6*1.0	6HX	1.5P	80	6	12	4	4	8	4.9	12	4.8
JR60101B06EL	JR60101B06E	M6*1.0	6HX	1.5P	100	6	12	4	4	8	4.9	12	4.8
JR8109008EL	JR81059008E	M8*1.0	6HX	1.5P	90	8	15	6	6	9	6.2	24	6.3
JR81259008EL	JR81259008E	M8*1.25	6HX	1.5P	90	8	15	6	6	9	6.2	24	6.3
JR10101B10EL	JR10101B10E	M10*1	6HX	1.5P	100	10	17	6	6	11	8	27	8.2
JR101251B10EL	JR101251B10E	M10*1.25	6HX	1.5P	100	10	17	6	6	11	8	27	8.2
JR10151B10EL	JR10151B10E	M10*1.5	6HX	1.5P	100	10	17	6	6	11	8	27	8.2
JR12151B09EL	JR12151B09E	M12*1.5	6HX	1.5P	100	9	18	6	6	10	7	20	8.8
JR121751B09EL	JR121751B09E	M12*1.75	6HX	1.5P	100	9	18	6	6	10	7	20	8.8
JR121751B19EL	JR121751B09E	M12*1.75	6HX	1.5P	110	9	18	6	6	10	7	20	8.8
JR141511B11EL	JR141511B11E	M14*1.5	6HX	1.5P	110	11	18	6	6	12	9	20	10.8
JR142011B11EL	JR142011B11E	M14*2	6HX	1.5P	110	11	18	6	6	12	9	20	10.8
JR161511B12EL	JR161511B12E	M16*1.5	6HX	1.5P	110	12	18	6	6	13	9	20	11.8
JR162011B12EL	JR162011B12E	M16*2.0	6HX	1.5P	110	12	18	6	6	13	9	20	11.8
JR181511B14EL	JR181511B14E	M18*1.5	6HX	1.5P	110	14	20	8	8	14	11	20	13.8
JR182511B14EL	JR182511B14E	M18*2.5	6HX	1.5P	110	14	20	8	8	14	11	20	13.8

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## 硬质合金左旋直槽丝锥

Carbide left-hand straight groove screw tap



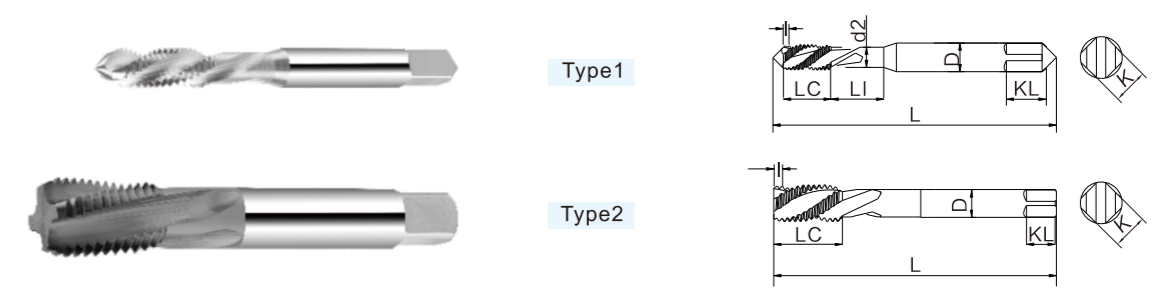
### 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	方长	方宽	颈长	颈径
				I	L	LC	D	Z	LK	K	LI	d2
LH20044203L	LH20044203	M2.0*0.4	6H	2.5P	42	10	3	3	5	2.5		
LH25454203L	LH25454203	M2.5*0.45	6H	2.5P	42	11	3	3	5	2.5		
LH30055204L	LH30055204	M3.0*0.5	6H	2.5P	52	11	4	3	6	3.2	6	2.4
LH40075505L	LH40075505	M4.0*0.7	6H	2.5P	55	13	5	3	7	4	7	3.1
LH50086005L	LH50086005	M5.0*0.8	6H	2.5P	60	15	5	3	7	4	10	4
LH60106506L	LH60106506	M6.0*1	6H	2.5P	65	16	6	3	7	4.5	10	4.8
LH81257362L	LH81257362	M8.0*1.25	6H	2.5P	73	18	6.2	4	8	5		
LH10157508L	LH10157508	M10*1.5	6H	2.5P	75	21	8	4	9	6		
LH121758309L	LH121758309	M12*1.75	6H	2.5P	83	25	9	4	9	7		
LH142090105L	LH142090105	M14*2	6H	2.5P	90	26	10.5	4	11	8		
LH162098125L	LH162098125	M16*2	6H	2.5P	98	29	12.5	4	13	10		
LH182510014L	LH182510014	M18*2.5	6H	2.5P	100	33	14	4	14	11		

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## 硬质合金左旋螺旋丝锥

Carbide left-hand screw tap



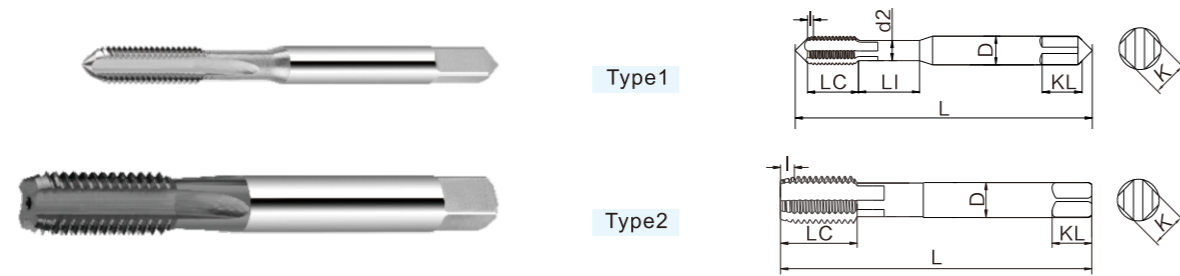
### 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	螺旋角	方长	方宽	颈长	颈径
				I	L	LC	D	Z	α	LK	K	LI	d2
LS20044203L	LS20044203	M2.0*0.4	6H	2.5P	42	10	3	2	30	5	2.5		
LS25454203L	LS25454203	M2.5*0.45	6H	2.5P	42	11	3	2	30	5	2.5		
LS30055204L	LS30055204	M3.0*0.5	6H	2.5P	52	11	4	3	30	6	3.2	6	2.4
LS40075505L	LS40075505	M4.0*0.7	6H	2.5P	55	13	5	3	30	7	4	7	3.1
LS50086005L	LS50086005	M5.0*0.8	6H	2.5P	60	15	5	3	30	7	4	10	4
LS60106506L	LS60106506	M6.0*1	6H	2.5P	65	16	6	3	30	7	4.5	10	4.8
LS81257362L	LS81257362	M8.0*1.25	6H	2.5P	73	18	6.2	3	30	8	5		
LS10157508L	LS10157508	M10*1.5	6H	2.5P	75	21	8	3	30	9	6		
LS121758309L	LS121758309	M12*1.75	6H	2.5P	83	25	9	4	15	9	7		
LS142090105L	LS142090105	M14*2	6H	2.5P	90	26	10.5	4	15	11	8		
LS162098125L	LS162098125	M16*2	6H	2.5P	98	29	12.5	4	15	13	10		
LS182510014L	LS182510014	M18*2.5	6H	2.5P	100	33	14	4	15	14	11		

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## 硬质合金公制直槽螺套丝锥

Carbide metric straight groove screw tap



### 商品参数/PRODUCT PARAMETERS

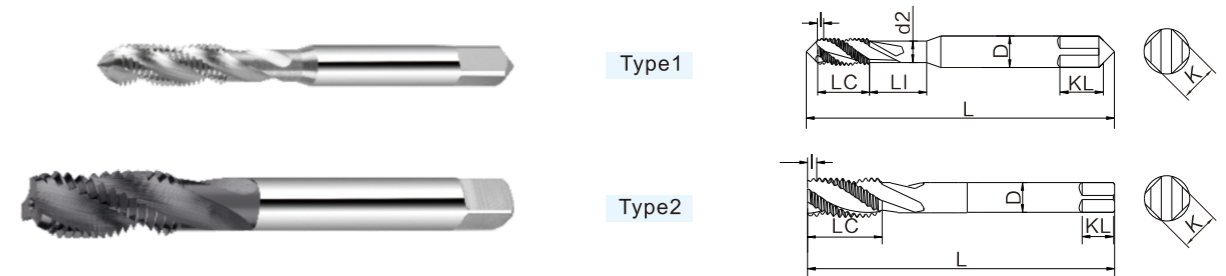


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	方长	方宽	颈长	颈径
				I	L	LC	D	Z	LK	K	LI	d2
TH20044203L	TH20044203	ST2*0.4	5H	2.5P	42	12	3	3	5	2.5		
TH25455204L	TH25455204	ST2.5*0.45	5H	2.5P	52	10	4	3	6	3.2	5.5	2.43
TH30055204L	TH30055204	ST3*0.5	5H	2.5P	52	11	4	3	6	3.2	7	3
TH35065505L	TH35065505	ST3.5*0.6	5H	2.5P	55	13	5	3	7	4	8	3.45
TH40076005L	TH40076005	ST4*0.7	5H	2.5P	60	14	5	3	7	4	10	3.95
TH50086506L	TH50086506	ST5*0.8	5H	2.5P	65	16	6	3	7	4.5	10	4.9
TH60107062L	TH60107062	ST6*1	5H	2.5P	70	17	6.2	3	8	5		
TH70107262L	TH70107262	ST7*1	5H	2.5P	72	18	6.2	3	8	5		
TH81257507L	TH81257507	ST8*1.25	5H	2.5P	75	21	7	3	8	5.5		
TH10158385L	TH10158385	ST10*1.5	5H	2.5P	83	24	8.5	3	9	6.5		
TH121590105L	TH121590105	ST12*1.5	6H	2.5P	90	25	10.5	4	11	8		
TH1217590105L	TH1217590105	ST12*1.75	5H	2.5P	90	27	10.5	4	11	8		
TH14159514L	TH14159514	ST14*1.5	6H	2.5P	95	25	13	4	14	11		
TH14209514L	TH14209514	ST14*2	5H	2.5P	95	29	13	4	14	11		
TH16151B14L	TH16151B14	ST16*1.5	6H	2.5P	100	25	14	4	14	11		
TH16201B14L	TH16201B14	ST16*2	5H	2.5P	100	30	14	4	14	11		

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## 硬质合金公制螺旋螺套丝锥

Carbide metric spiral screw tap



### 商品参数/PRODUCT PARAMETERS

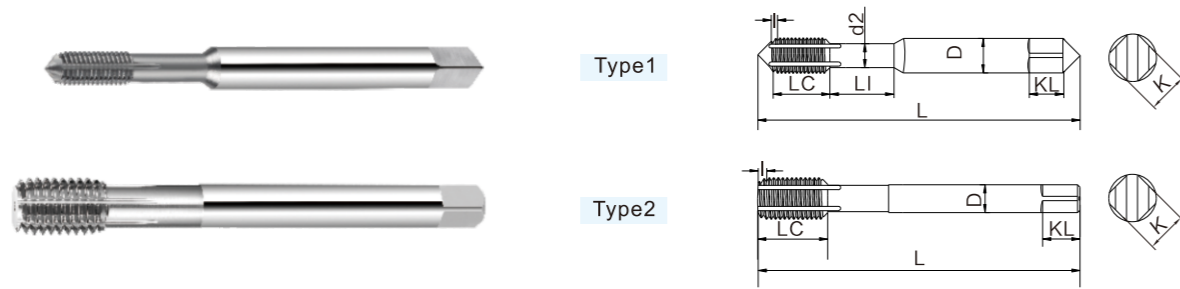


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	螺旋角	方长	方宽	颈长	颈径
				I	L	LC	D	Z	α	LK	K	LI	d2
TS20044203L	TS20044203	ST2*0.4	5H	1.5P	42	12	3	2	35	5	2.5		
TS25455204L	TS25455204	ST2.5*0.45	5H	1.5P	52	10	4	3	30	6	3.2	5.5	2.43
TS30055204L	TS30055204	ST3*0.5	5H	1.5P	52	11	4	3	30	6	3.2	7	3
TS35065505L	TS35065505	ST3.5*0.6	5H	1.5P	55	13	5	3	30	7	4	8	3.45
TS40076005L	TS40076005	ST4*0.7	5H	1.5P	60	14	5	3	30	7	4	10	3.95
TS50086506L	TS50086506	ST5*0.8	5H	1.5P	65	16	6	3	30	7	4.5	10	4.9
TS60107062L	TS60107062	ST6*1	5H	1.5P	70	17	6.2	3	30	8	5		
TS70107262L	TS70107262	ST7*1	5H	1.5P	72	18	6.2	3	30	8	5		
TS81257507L	TS81257507	ST8*1.25	5H	1.5P	75	21	7	3	30	8	5.5		
TS10158385L	TS10158385	ST10*1.5	5H	2.5P	83	24	8.5	3	30	9	6.5		
TS121590105L	TS121590105	ST12*1.5	6H	2.5P	90	25	10.5	4	30	11	8		
TS1217590105L	TS1217590105	ST12*1.75	5H	2.5P	90	27	10.5	4	30	11	8		
TS14159514L	TS14159514	ST14*1.5	6H	2.5P	95	25	13	4	30	14	11		
TS14209514L	TS14209514	ST14*2	5H	2.5P	95	29	13	4	30	14	11		
TS16151B14L	TS16151B14	ST16*1.5	6H	2.5P	100	25	14	4	30	14	11		
TS16201B14L	TS16201B14	ST16*2	5H	2.5P	100	30	14	4	30	14	11		

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## 硬质合金公制挤压螺套丝锥

Carbide metric extrusion screw tap



### 商品参数/PRODUCT PARAMETERS

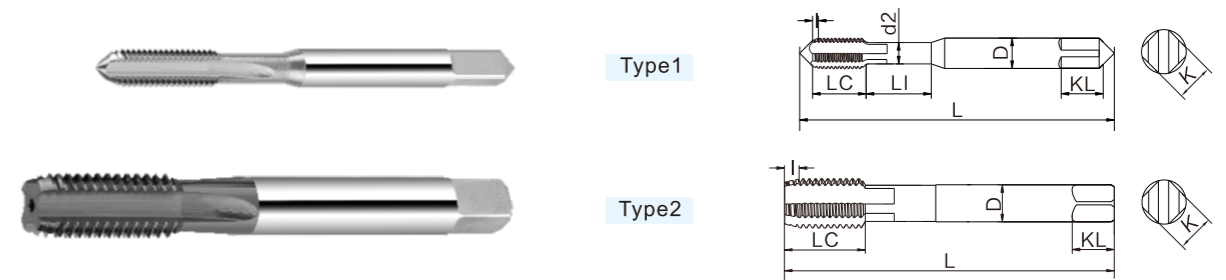


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	挤压丝锥 楞数T/槽数Z	方长	方宽	颈长	颈径	
				I	L	LC	D	T	Z	LK	K	LI	d2
TJ20044203L	TJ20044203	ST2*0.4	5H	1.5P	42	12	3	4		5	2.5		
TJ25455204L	TJ25455204	ST2.5*0.45	5H	1.5P	52	10	4	4		6	3.2	5.5	2.43
TJ30055204L	TJ30055204	ST3*0.5	5H	1.5P	52	10	4	4		6	3.2	7	3
TJ35065505L	TJ35065505	ST3.5*0.6	5H	1.5P	55	12	5	4		7	4	8	3.45
TJ40076005L	TJ40076005	ST4*0.7	5H	1.5P	60	12	5	4	2	7	4	10	3.95
TJ50086506L	TJ50086506	ST5*0.8	5H	1.5P	65	13	6	4	2	7	4.5	10	4.9
TJ60107062L	TJ60107062	ST6*1	5H	1.5P	70	14	6.2	4	2	8	5		
TJ70107262L	TJ70107262	ST7*1	5H	1.5P	72	17	6.2	6	3	8	5		
TJ80107507L	TJ80107507	ST8*1	6H	1.5P	75	19	7	6	6	8	5.5		
TJ81257507L	TJ81257507	ST8*1.25	5H	1.5P	75	19	7	6	6	8	5.5		
TJ10108385L	TJ10108385	ST10*1	6H	1.5P	83	23	8.5	6	6	9	6.5		
TJ101257585L	TJ101257585	ST10*1.25	6H	1.5P	83	23	8.5	6	6	9	6.5		
TJ10157585L	TJ10157585	ST10*1.5	5H	1.5P	83	23	8.5	6	6	9	6.5		
TJ121590105L	TJ121590105	ST12*1.5	6H	1.5P	90	25	10.5	8	8	11	8		
TJ1217590105L	TJ1217590105	ST12*1.75	5H	1.5P	90	25	10.5	8	8	11	8		
TJS14159514L	TJS14159514	ST14*1.5	6H	1.5P	95	25	13	8	8	14	11		
TJS14209514L	TJS14209514	ST14*2	5H	1.5P	95	29	13	8	8	14	11		
TJS16151B14L	TJS16151B14	ST16*1.5	6H	1.5P	100	25	14	8	8	14	11		
TJS16201B14L	TJS16201B14	ST16*2	5H	1.5P	100	30	14	8	8	14	11		

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## 硬质合金美制直槽丝锥

Carbide American straight groove screw tap



### 商品参数/PRODUCT PARAMETERS

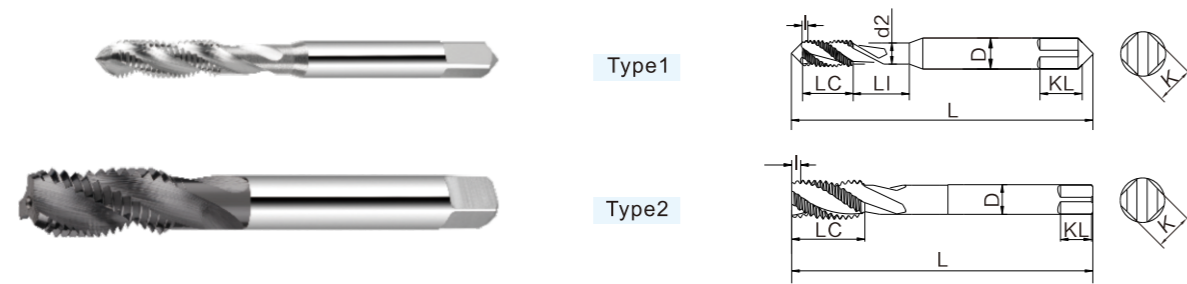


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	方长	方宽	颈长	颈径
				I	L	LC	D	Z	LK	K	LI	d2
UH2564203L	UH2564203	NO.2-56UNC	2B/3B	1.5P	42	11	3	3	5	2.5		
UH2644203L	UH2644203	NO.2-64UNF	2B/3B	1.5P	42	11	3	3	5	2.5		
UH3484203L	UH3484203	NO.3-48UNC	2B/3B	1.5P	42	12	3	3	5	2.5		
UH3564203L	UH3564203	NO.3-56UNF	2B/3B	1.5P	42	12	3	3	5	2.5		
UH4405203L	UH4405203	NO.4-40UNC	2B/3B	1.5P	52	12	3	3	5	2.5	7	2.1
UH4485203L	UH4485203	NO.4-48UNF	2B/3B	1.5P	52	12	3	3	5	2.5	7	2.1
UH5405204L	UH5405204	NO.5-40UNC	2B/3B	1.5P	52	12	4	3	6	3.2	7	2.4
UH5445204L	UH5445204	NO.5-44UNF	2B/3B	1.5P	52	12	4	3	6	3.2	7	2.4
UH6325204L	UH6325204	NO.6-32UNC	2B/3B	1.5P	52	13	4	3	6	3.2	8	2.55
UH6405204L	UH6405204	NO.6-40UNF	2B/3B	1.5P	52	13	4	3	6	3.2	8	2.55
UH8325505L	UH8325505	NO.8-32UNC	2B/3B	1.5P	55	13	5	3	6	4	8	3.2
UH8365505L	UH8365505	NO.8-36UNF	2B/3B	1.5P	55	13	5	3	6	4	8	3.2
UH10246005L	UH10246005	NO.10-24UNC	2B/3B	1.5P	60	15	5	3	6	4	8	3.55
UH10326005L	UH10326005	NO.10-32UNF	2B/3B	1.5P	60	15	5	3	6	4	8	3.55
UH12246506L	UH12246506	NO.12-24UNC	2B/3B	2.5P	65	15	6	3	7	4.5	10	4.25
UH12286506L	UH12286506	NO.12-28UNF	2B/3B	2.5P	65	15	6	3	7	4.5	10	4.25
UH14206506L	UH14206506	1/4-20UNC	2B/3B	2.5P	65	17	6	3	7	4.5	10	4.8
UH14286506L	UH14286506	1/4-28UNF	2B/3B	2.5P	65	17	6	3	7	4.5	10	4.8
UH516187261L	UH516187261	5/16-18UNC	2B/3B	2.5P	72	20	6.1	4	8	5		
UH516247261L	UH516247261	5/16-24UNF	2B/3B	2.5P	72	20	6.1	4	8	5		
UH38167507L	UH38167507	3/8-16UNC	2B/3B	2.5P	75	22	7	4	8	5.5		
UH38247507L	UH38247507	3/8-24UNF	2B/3B	2.5P	75	22	7	4	8	5.5		
UH716248308L	UH716248308	7/16-14UNC	2B/3B	2.5P	83	25	8	4	9	6		
UH716208308L	UH716208308	7/16-20UNF	2B/3B	2.5P	83	25	8	4	9	6		
UH12138509L	UH12138509	1/2-13UNC	2B/3B	2.5P	90	25	9	4	10	7		
UH12208509L	UH12208509	1/2-20UNF	2B/3B	2.5P	90	25	9	4	10	7		

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# 硬质合金美制螺旋丝锥

Carbide American screw tap



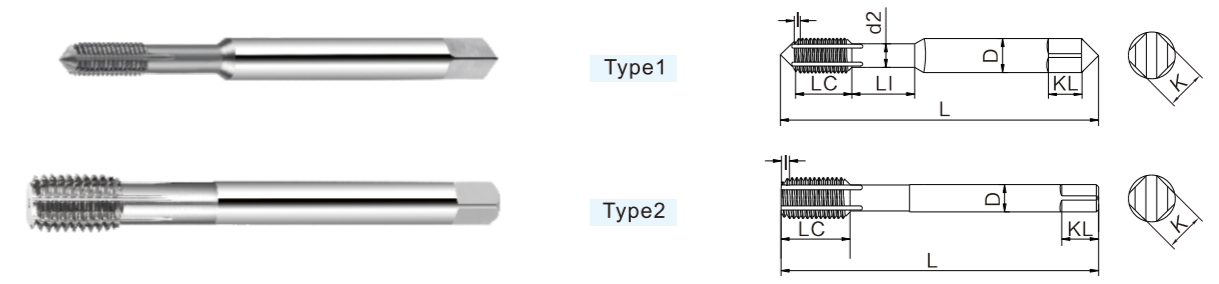
## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	规格	精度	切削 锥长 I	总长 L	刃长 LC	柄径 D	螺旋丝锥 槽数		方长 LK	方宽 K	颈长 LI	颈径 d2
								Z	∠				
US2564203L	US2564203	NO.2-56UNC	2B/3B	1.5P	42	11	3	2	30	5	2.5		
US2644203L	US2644203	NO.2-64UNF	2B/3B	1.5P	42	11	3	2	30	5	2.5		
US3484203L	US3484203	NO.3-48UNC	2B/3B	1.5P	42	12	3	2	30	5	2.5		
US3564203L	US3564203	NO.3-56UNF	2B/3B	1.5P	42	12	3	2	30	5	2.5		
US4405203L	US4405203	NO.4-40UNC	2B/3B	1.5P	52	12	3	3	30	5	2.5	7	2.1
US4485203L	US4485203	NO.4-48UNF	2B/3B	1.5P	52	12	3	3	30	5	2.5	7	2.1
US5405204L	US5405204	NO.5-40UNC	2B/3B	1.5P	52	12	4	3	30	6	3.2	7	2.4
US5445204L	US5445204	NO.5-44UNF	2B/3B	1.5P	52	12	4	3	30	6	3.2	7	2.4
US6325204L	US6325204	NO.6-32UNC	2B/3B	1.5P	52	13	4	3	30	6	3.2	8	2.55
US6405204L	US6405204	NO.6-40UNF	2B/3B	1.5P	52	13	4	3	30	6	3.2	8	2.55
US8325505L	US8325505	NO.8-32UNC	2B/3B	1.5P	55	13	5	3	30	6	4	8	3.2
US8365505L	US8365505	NO.8-36UNF	2B/3B	1.5P	55	13	5	3	30	6	4	8	3.2
US10246005L	US10246005	NO.10-24UNC	2B/3B	1.5P	60	15	5	3	30	6	4	8	3.55
US10326005L	US10326005	NO.10-32UNF	2B/3B	1.5P	60	15	5	3	30	6	4	8	3.55
US12246506L	US12246506	NO.12-24UNC	2B/3B	2.5P	65	15	6	3	30	7	4.5	10	4.25
US12286506L	US12286506	NO.12-28UNF	2B/3B	2.5P	65	15	6	3	30	7	4.5	10	4.25
US14206506L	US14206506	1/4-20UNC	2B/3B	2.5P	65	17	6	3	30	7	4.5	10	4.8
US14286506L	US14286506	1/4-28UNF	2B/3B	2.5P	65	17	6	3	30	7	4.5	10	4.8
US516187261L	US516187261	5/16-18UNC	2B/3B	2.5P	72	20	6.1	3	30	8	5		
US516247261L	US516247261	5/16-24UNF	2B/3B	2.5P	72	20	6.1	3	30	8	5		
US38167507L	US38167507	3/8-16UNC	2B/3B	2.5P	75	22	7	3	30	8	5.5		
US38247507L	US38247507	3/8-24UNF	2B/3B	2.5P	75	22	7	3	30	8	5.5		
US716248308L	US716248308	7/16-14UNC	2B/3B	2.5P	83	25	8	3	30	9	6		
US716208308L	US716208308	7/16-20UNF	2B/3B	2.5P	83	25	8	3	30	9	6		
US12138509L	US12138509	1/2-13UNC	2B/3B	2.5P	90	25	9	4	15	10	7		
US12208509L	US12208509	1/2-20UNF	2B/3B	2.5P	90	25	9	4	15	10	7		

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# 硬质合金美制挤压丝锥

Carbide American extrusion screw tap



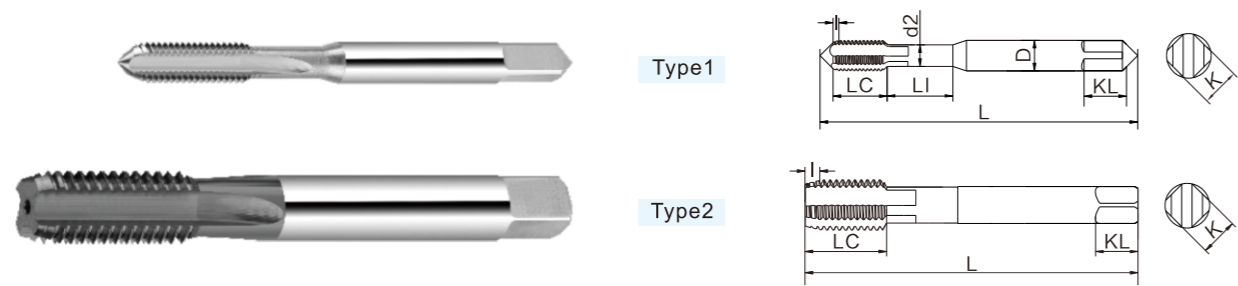
## 商品参数/PRODUCT PARAMETERS

铝用商品号	钢用商品号	规格	精度	切削 锥长 I	总长 L	刃长 LC	柄径 D	挤压丝锥 槽数T/槽数Z		方长 Lk	方宽 K	颈长 LI	颈径 d2
								T	Z				
UJ2564203L	UJ2564203	NO.2-56UNC	2B/3B	1.5P	42	11	3	4	-	5	2.5		
UJ2644203L	UJ2644203	NO.2-64UNF	2B/3B	1.5P	42	11	3	4	-	5	2.5		
UJ3484203L	UJ3484203	NO.3-48UNC	2B/3B	1.5P	42	12	3	4	-	5	2.5		
UJ3564203L	UJ3564203	NO.3-56UNF	2B/3B	1.5P	42	12	3	4	-	5	2.5		
UJ4405203L	UJ4405203	NO.4-40UNC	2B/3B	1.5P	52	12	3	4	-	5	2.5	7	2.1
UJ4485203L	UJ4485203	NO.4-48UNF	2B/3B	1.5P	52	12	3	4	-	5	2.5	7	2.1
UJ5405204L	UJ5405204	NO.5-40UNC	2B/3B	1.5P	52	12	4	4	-	6	3.2	7	2.4
UJ5445204L	UJ5445204	NO.5-44UNF	2B/3B	1.5P	52	12	4	4	-	6	3.2	7	2.4
UJ6325204L	UJ6325204	NO.6-32UNC	2B/3B	1.5P	52	13	4	4	-	6	3.2	8	2.55
UJ6405204L	UJ6405204	NO.6-40UNF	2B/3B	1.5P	52	13	4	4	-	6	3.2	8	2.55
UJ8325505L	UJ8325505	NO.8-32UNC	2B/3B	1.5P	55	13	5	4	2	6	4	8	3.2
UJ8365505L	UJ8365505	NO.8-36UNF	2B/3B	1.5P	55	13	5	4	2	6	4	8	3.2
UJ10246005L	UJ10246005	NO.10-24UNC	2B/3B	1.5P	60	15	5	4	2	6	4	8	3.55
UJ10326005L	UJ10326005	NO.10-32UNF	2B/3B	1.5P	60	15	5	4	2	6	4	8	3.55
UJ12246506L	UJ12246506	NO.12-24UNC	2B/3B	1.5P	65	15	6	4	2	7	4.5	10	4.25
UJ12286506L	UJ12286506	NO.12-28UNF	2B/3B	1.5P	65	15	6	4	2	7	4.5	10	4.25
UJ14206506L	UJ14206506	1/4-20UNC	2B/3B	1.5P	65	17	6	4	4	7	4.5	10	4.8
UJ14286506L	UJ14286506	1/4-28UNF	2B/3B	1.5P	65	17	6	4	4	7	4.5	10	4.8
UJ516187261L	UJ516187261	5/16-18UNC	2B/3B	1.5P	72	20	6.1	6	6	8	5		
UJ516247261L	UJ516247261	5/16-24UNF	2B/3B	1.5P	72	20	6.1	6	6	8	5		
UJ38167507L	UJ38167507	3/8-16UNC	2B/3B	1.5P	75	22	7	6	6	8	5.5		
UJ38247507L	UJ38247507	3/8-24UNF	2B/3B	1.5P	75	22	7	6	6	8	5.5		
UJ716248308L	UJ716248308	7/16-14UNC	2B/3B	1.5P	83	25	8	6	6	9	6		
UJ716208308L	UJ716208308	7/16-20UNF	2B/3B	1.5P	83	25	8	6	6	9	6		
UJ12138509L	UJ12138509	1/2-13UNC	2B/3B	1.5P	90	25	9	6	6	10	7		
UJ12208509L	UJ12208509	1/2-20UNF	2B/3B	1.5P	90	25	9	6	6	10	7		

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# 硬质合金美制直槽螺套丝锥

Carbide American straight groove screw tap



## 商品参数/PRODUCT PARAMETERS

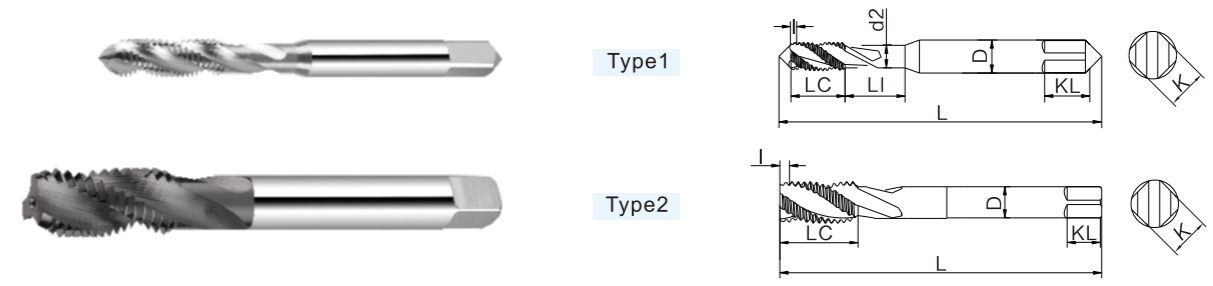


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	槽数	方长	方宽	颈长	颈径
				I	L	LC	D	Z	LK	K	LI	d2
STH2564203L	STH2564203	NO.2-56UNC	2B/3B	2.5P	42	12	3	3	5	2.5		
STH2644203L	STH2644203	NO.2-64UNF	2B/3B	2.5P	42	12	3	3	5	2.5		
STH3485204L	STH3485204	NO.3-48UNC	2B/3B	2.5P	52	12	4	3	6	3.15	8	2.5
STH3565204L	STH3565204	NO.3-56UNF	2B/3B	2.5P	52	12	4	3	6	3.15	8	2.5
STH4405204L	STH4405204	NO.4-40UNC	2B/3B	2.5P	52	12	4	3	6	3.15	8	2.8
STH4485204L	STH4485204	NO.4-48UNF	2B/3B	2.5P	52	12	4	3	6	3.15	8	2.8
STH5405505L	STH5405505	NO.5-40UNC	2B/3B	2.5P	55	14	5	3	6	4	10	3.2
STH5445505L	STH5445505	NO.5-44UNF	2B/3B	2.5P	55	14	5	3	6	4	10	3.2
STH6325505L	STH6325505	NO.6-32UNC	2B/3B	2.5P	55	14	5	3	6	4	10	3.5
STH6405505L	STH6405505	NO.6-40UNF	2B/3B	2.5P	55	14	5	3	6	4	10	3.5
STH8326506L	STH8326506	NO.8-32UNC	2B/3B	2.5P	65	16	6	3	7	4.5	10	4.2
STH8366506L	STH8366506	NO.8-36UNF	2B/3B	2.5P	65	16	6	3	7	4.5	10	4.1
STH10246506L	STH10246506	NO.10-24UNC	2B/3B	2.5P	65	16	6	3	7	4.5	10	4.85
STH10326506L	STH10326506	NO.10-32UNF	2B/3B	2.5P	65	16	6	3	7	4.5	10	4.85
STH12247006L	STH12247006	NO.12-24UNC	2B/3B	2.5P	70	16	6	3	8	4.5		
STH12287006L	STH12287006	NO.12-28UNF	2B/3B	2.5P	70	16	6	3	8	4.5		
STH14207062L	STH14207062	1/4-20UNC	2B/3B	2.5P	70	16	6.2	3	8	5		
STH14287062L	STH14287062	1/4-28UNF	2B/3B	2.5P	70	16	6.2	3	8	5		
STH516187507L	STH516187507	5/16-18UNC	2B/3B	2.5P	75	20	7	4	9	5.5		
STH516247507L	STH516247507	5/16-24UNF	2B/3B	2.5P	75	20	7	4	9	5.5		
STH38168385L	STH38168385	3/8-16UNC	2B/3B	2.5P	83	22	8.5	4	9	6.5		
STH38248308L	STH38248308	3/8-24UNF	2B/3B	2.5P	83	22	8	4	9	6		
STH7162483105L	STH7162483105	7/16-14UNC	2B/3B	2.5P	83	23	10.5	4	11	8		
STH716208309L	STH716208309	7/16-20UNF	2B/3B	2.5P	83	23	9	4	10	7		
STH12139012L	STH12139012	1/2-13UNC	2B/3B	2.5P	90	25	12	4	11	9		
STH122090105L	STH122090105	1/2-20UNF	2B/3B	2.5P	90	25	10.5	4	10	8		

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# 硬质合金美制螺旋螺套丝锥

Carbide American screw tap



## 商品参数/PRODUCT PARAMETERS

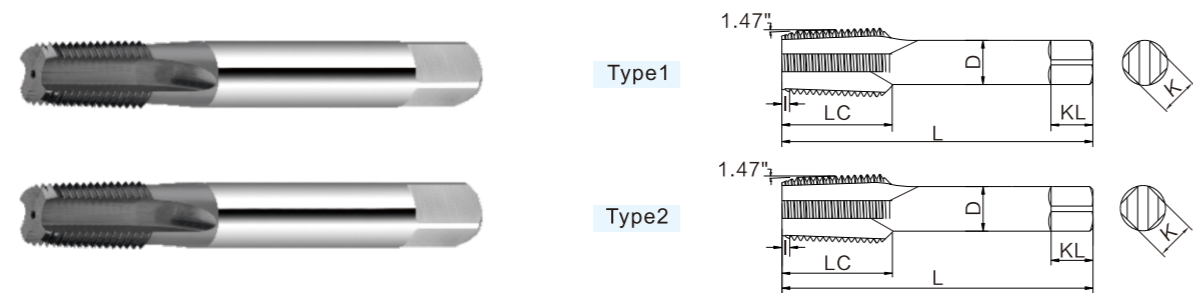


铝用商品号	钢用商品号	规格	精度	切削 锥长	总长	刃长	柄径	螺旋丝锥 槽数		方长	方宽	颈长	颈径
				I	L	LC	D	Z	α	LK	K	LI	d2
STS2564203L	STS2564203	NO.2-56UNC	2B/3B	1.5P	42	12	3	2	30	5	2.5		
STS2644203L	STS2644203	NO.2-64UNF	2B/3B	1.5P	42	12	3	2	30	5	2.5		
STS3485204L	STS3485204	NO.3-48UNC	2B/3B	1.5P	52	12	4	3	30	6	3.15	8	2.5
STS3565204L	STS3565204	NO.3-56UNF	2B/3B	1.5P	52	12	4	3	30	6	3.15	8	2.5
STS4405204L	STS4405204	NO.4-40UNC	2B/3B	1.5P	52	12	4	3	30	6	3.15	8	2.8
STS4485204L	STS4485204	NO.4-48UNF	2B/3B	1.5P	52	12	4	3	30	6	3.15	8	2.8
STS5405505L	STS5405505	NO.5-40UNC	2B/3B	1.5P	55	14	5	3	30	6	4	10	3.2
STS5445505L	STS5445505	NO.5-44UNF	2B/3B	1.5P	55	14	5	3	30	6	4	10	3.2
STS6325505L	STS6325505	NO.6-32UNC	2B/3B	1.5P	55	14	5	3	30	6	4	10	3.5
STS6405505L	STS6405505	NO.6-40UNF	2B/3B	1.5P	55	14	5	3	30	6	4	10	3.5
STS8326506L	STS8326506	NO.8-32UNC	2B/3B	1.5P	65	16	6	3	30	7	4.5	10	4.2
STS8366506L	STS8366506	NO.8-36UNF	2B/3B	1.5P	65	16	6	3	30	7	4.5	10	4.1
STS10246506L	STS10246506	NO.10-24UNC	2B/3B	1.5P	65	16	6	3	30	7	4.5	10	4.85
STS10326506L	STS10326506	NO.10-32UNF	2B/3B	1.5P	65	16	6	3	30	7	4.5	10	4.85
STS12247006L	STS12247006	NO.12-24UNC	2B/3B	1.5P	70	16	6	3	30	8	4.5		
STS12287006L	STS12287006	NO.12-28UNF	2B/3B	1.5P	70	16	6	3	30	8	4.5		
STS14207062L	STS14207062	1/4-20UNC	2B/3B	1.5P	70	16	6.2	3	30	8	5		
STS14287062L	STS14287062	1/4-28UNF	2B/3B	1.5P	70	16	6.2	3	30	8	5		
STS516187507L	STS516187507	5/16-18UNC	2B/3B	1.5P	75	20	7	3	30	9	5.5		
STS516247507L	STS516247507	5/16-24UNF	2B/3B	1.5P	75	20	7	3	30	9	5.5		
STS38168385L	STS38168385	3/8-16UNC	2B/3B	1.5P	83	22	8.5	3	30	9	6.5		
STS38248308L	STS38248308	3/8-24UNF	2B/3B	1.5P	83	22	8	3	30	9	6		
STS7162483105L	STS7162483105	7/16-14UNC	2B/3B	1.5P	83	23	10.5	3	15	11	8		
STS716208309L	STS716208309	7/16-20UNF	2B/3B	1.5P	83	23	9	3	15	10	7		
STS12139012L	STS12139012	1/2-13UNC	2B/3B	1.5P	90	25	12	4	15	11	9		
STS122090105L	STS122090105	1/2-20UNF	2B/3B	1.5P	90	25	10.5	4	15	10			

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## 硬质合金RC/PT/直槽圆锥管丝锥

Carbide RC/PT/straight groove taper pipe tap



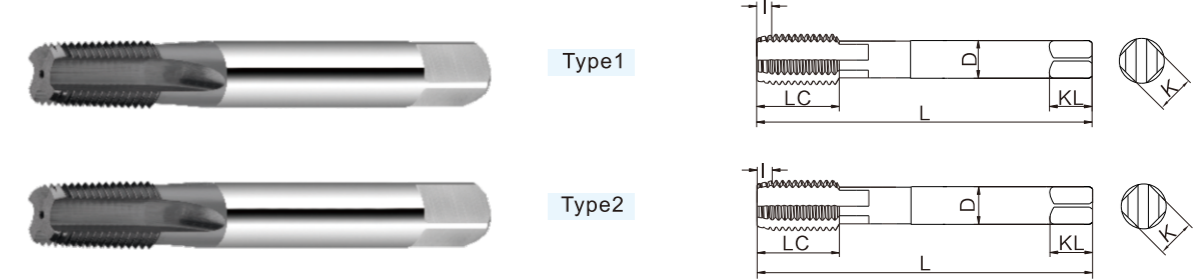
### 商品参数/PRODUCT PARAMETERS



铝用商品号	钢用商品号	规格	螺距	切削锥长	刃长	总长	柄径	槽数	方长	方宽
			P	I	LC	L	D	Z	LK	K
CP116286006L	CP116286006	PT1/16-28	0.907	2.5P	16	60	6	4	7	4.9
CP180286508L	CP180286508	PT1/8-28	0.907	2.5P	18	65	8	4	8	6
CP140197011L	CP140197011	PT1/4-19	1.337	2.5P	19.5	70	11	4	11	9
CP380197514L	CP380197514	PT3/8-19	1.337	2.5P	21	75	14	4	14	11
CP120147018L	CP120147018	PT1/2-14	1.814	2.5P	28	80	18	4	17	14

## 硬质合金PF/G/直槽圆柱管丝锥

Carbide PF/G/straight groove cylindrical pipe tap



### 商品参数/PRODUCT PARAMETERS

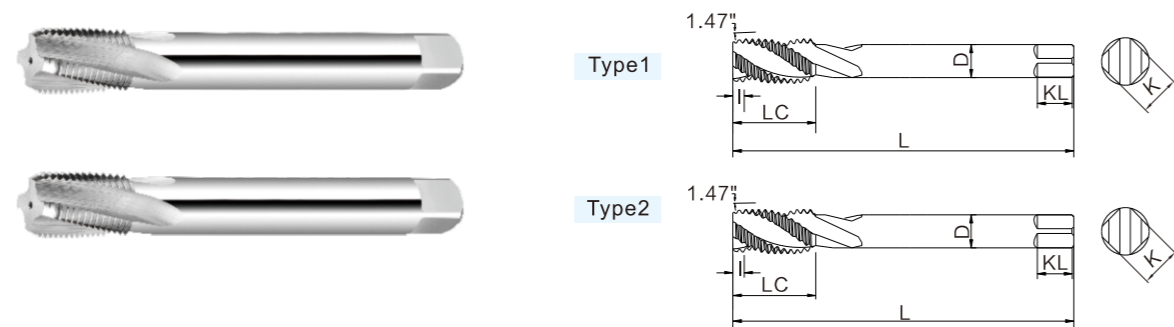


铝用商品号	钢用商品号	规格	螺距	切削锥长	刃长	总长	柄径	槽数	方长	方宽
			P	I	LC	L	D	Z	LK	K
CG116286106L	CG116286106	G1/16-28	0.907	2.5P	16	65	6	4	7	4.5
CG118286608L	CG118286608	G1/8-28	0.907	2.5P	18	65	8	4	8	6
CG140197111L	CG140197111	G1/4-19	1.337	2.5P	24	70	11	4	11	9
CG380197614L	CG380197614	G3/8-19	1.337	2.5P	25	75	14	4	14	11
CG120148118L	CG120148118	G1/2-14	1.814	2.5P	28	85	18	4	17	14

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## 硬质合金RC/PT/螺旋圆锥管丝锥

Carbide RC/PT/spiral taper pipe tap



### 商品参数/PRODUCT PARAMETERS

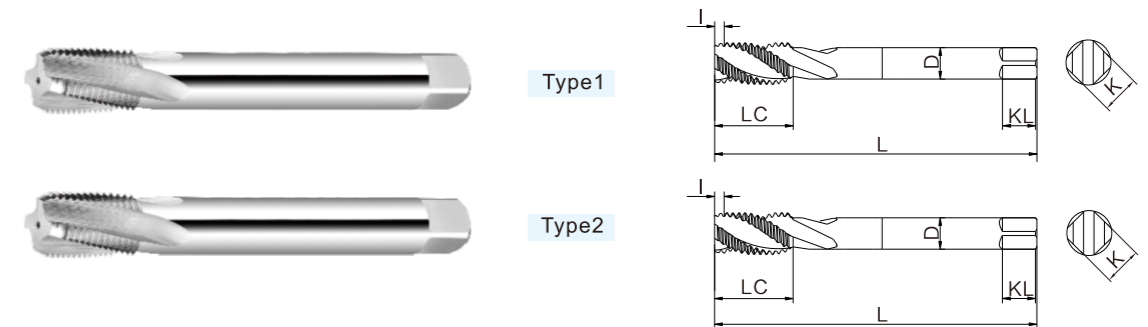


铝用商品号	钢用商品号	规格	螺距	切削锥长	刃长	总长	柄径	槽数	螺旋角	方长	方宽
			P	I	LC	L	D	Z	∠	LK	K
SP116286006L	SP116286006	PT1/16-28	0.907	2.5P	16	60	6	3	15	7	4.9
SP180286508L	SP180286508	PT1/8-28	0.907	2.5P	18	65	8	4	15	8	6
SP140197011L	SP140197011	PT1/4-19	1.337	2.5P	19.5	70	11	4	15	11	9
SP380197514L	SP380197514	PT3/8-19	1.337	2.5P	21	75	14	4	15	14	11
SP120147018L	SP120147018	PT1/2-14	1.814	2.5P	28	80	18	4	15	17	14

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## 硬质合金PF/G/螺旋圆柱管丝锥

Carbide PF/G/spiral cylindrical pipe tap



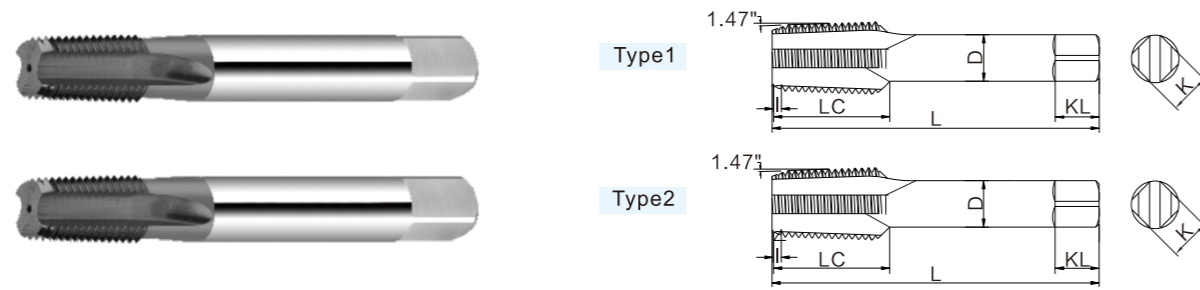
### 商品参数/PRODUCT PARAMETERS



铝用商品号	钢用商品号	规格	螺距	切削锥长	刃长	总长	柄径	槽数	螺旋角	方长	方宽
			P	I	LC	L	D	Z	∠	LK	K
SG116286106L	SG116286106	G1/16-28	0.907	2.5P	16	65	6	3	15	7	4.5
SG118286608L	SG118286608	G1/8-28	0.907	2.5P	18	65	8	3	15	8	6
SG140197111L	SG140197111	G1/4-19	1.337	2.5P	24	70	11	4	15	11	9
SG380197614L	SG380197614	G3/8-19	1.337	2.5P	25	75	14	4	15	14	11
SG120148118L	SG120148118	G1/2-14	1.814	2.5P	28	85	18	4	15	17	14

## 硬质合金NPT直槽圆锥管丝锥

Carbide NPT straight groove taper pipe tap



### 商品参数/PRODUCT PARAMETERS

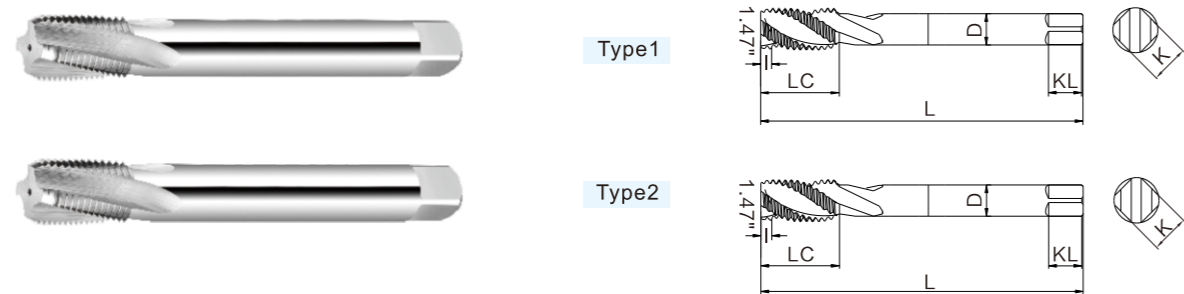


铝用商品号	钢用商品号	规格	螺距	切削锥长	刃长	总长	柄径	槽数	方长	方宽
			P	I	LC	L	D	Z	LK	K
CN116276006L	CN116276006	NPT1/16-27	0.9407	2.5P	16	60	6	4	7	4.5
CN118276508L	CN118276508	NPT1/8-27	0.9407	2.5P	18	65	8	4	8	6
CN140187011L	CN140187011	NPT1/4-18	1.411	2.5P	19.5	70	11	4	11	9
CN380187514L	CN380187514	NPT3/8-18	1.411	2.5P	21	75	14	4	14	11
CN120148018L	CN120148018	NPT1/2-14	1.814	2.5P	27	80	18	4	17	14

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## 硬质合金NPT/螺旋圆锥管丝锥

Carbide NPT/spiral taper pipe tap



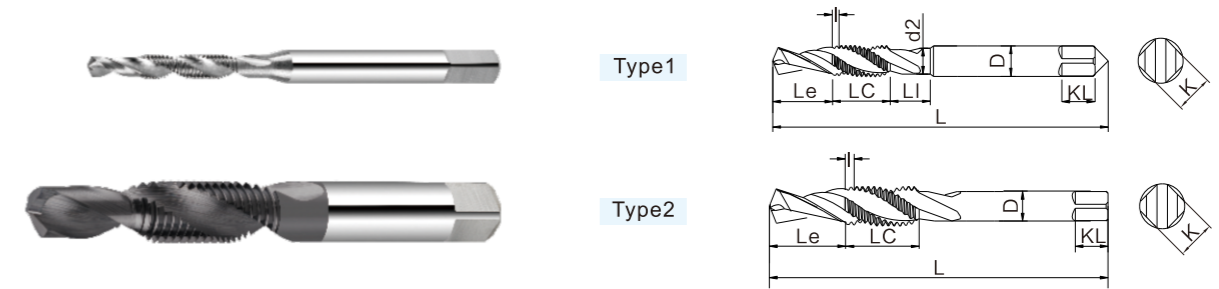
### 商品参数/PRODUCT PARAMETERS



铝用商品号	钢用商品号	规格	螺距	切削锥长	刃长	总长	柄径	槽数	螺旋角	方长	方宽
			P	I	LC	L	D	Z	∠	LK	K
SN116276006L	SN116276006	NPT1/16-27	0.9407	2.5P	16	60	6	3	15	7	4.5
SN118276508L	SN118276508	NPT1/8-27	0.9407	2.5P	16.5	65	8	4	15	8	6
SN140187011L	SN140187011	NPT1/4-18	1.411	2.5P	19.5	70	11	4	15	11	9
SN380187514L	SN380187514	NPT3/8-18	1.411	2.5P	21	75	14	4	15	14	11
SN120148018L	SN120148018	NPT1/2-14	1.814	2.5P	27	80	18	4	15	17	14

## 硬质合金复合钻攻一体螺旋丝锥

Carbide composite drilling and tapping one-piece screw tap



### 商品参数/PRODUCT PARAMETERS

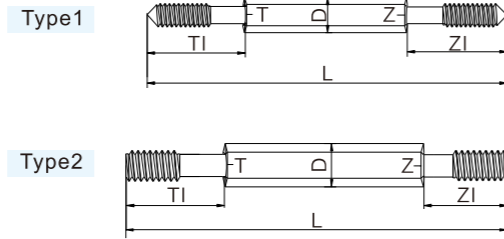
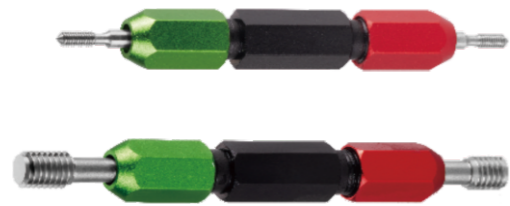


铝用商品号	钢用商品号	规格	精度	切削锥长	钻头刃长	螺纹刃长	总长	柄径	槽数	槽数	螺旋角	方长	方宽	颈长	颈径
					Le	Lc	L	D	Z	∠	LK	K	L1	d2	
CZ20405203L	CZ20405203	M2*0.4	6H	2.5P	6	10	52	3	2	30	5	2.5	5	1.9	
CZ25455503L	CZ25455503	M2.5*0.45	6H	2.5P	7	10	55	3	2	30	5	2.5	5	2.4	
CZ30505604L	CZ30505604	M3*0.5	6H	2.5P	7	12	56	4	2	30	6	3.2	5	2.8	
CZ40705604L	CZ40705604	M4*0.7	6H	2.5P	7	12	56	4	2	30	6	3.2	/	/	
CZ50806505L	CZ50806505	M5*0.8	6H	2.5P	9	15	65	5	2	30	7	4	/	/	
CZ60107006L	CZ60107006	M6*1	6H	2.5P	12	18	70	6	2	30	8	4.5	/	/	
CZ81257508L	CZ81257508	M8*1.25	6H	2.5P	15	20	75	8	2	30	9	6	/	/	
CZ10158710L	CZ10158710	M10*1.5	6H	2.5P	18	25	85	10	2	30	10	8	/	/	
CZ121759512L	CZ121759512	M12*1.75	6H	2.5P	20	25	92	12	2	30	13	10	/	/	

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# 硬质合金螺纹通止规

Carbide thread go/no-go gauge



## 商品参数/PRODUCT PARAMETERS



商品号	规格	精度	通端长	止端长	总长	6方柄径
			TI	ZI	L	D
TZ14306H	M1.4*0.3	6H	6	5	78	9
TZ16356H	M1.6*0.35	6H	6	5	78	9
TZ17356H	M1.7*0.35	6H	6	5	78	9
TZ18356H	M1.8*0.35	6H	7	6	78	9
TZ20406H	M2.0*0.4	6H	7	6	78	9
TZ25456H	M2.5*0.45	6H	9	8	82	9
TZ30506H	M3.0*0.5	6H	10	8	82	9
TZ35606H	M3.5*0.6	6H	10	8	82	9
TZ40706H	M4.0*0.7	6H	10	8	88	9
TZ50806H	M5.0*0.8	6H	13	11	90	9
TZ60106H	M6.0*1	6H	18	12	90	9
TZ80106H	M8.0*1	6H	20	15	120	12
TZ81256H	M8.0*1.25	6H	20	15	120	12
TZ10106H	M10*1	6H	21	15	120	12
TZ101256H	M10*1.25	6H	21	15	120	12
TZ101506H	M10*1.5	6H	21	15	120	12
TZ121006H	M12*1.0	6H	25	15	130	14
TZ121256H	M12*1.25	6H	25	15	130	14
TZ121506H	M12*1.5	6H	25	15	130	14
TZ121756H	M12*1.75	6H	25	15	130	14
TZ141506H	M14*1.5	6H	27	17	135	14
TZ142006H	M14*2	6H	27	17	135	14
TZ161506H	M16*1.5	6H	30	20	140	14
TZ162006H	M16*2	6H	30	20	140	14
TZ181506H	M18*1.5	6H	30	20	140	14
TZ182506H	M18*2.5	6H	30	20	140	14

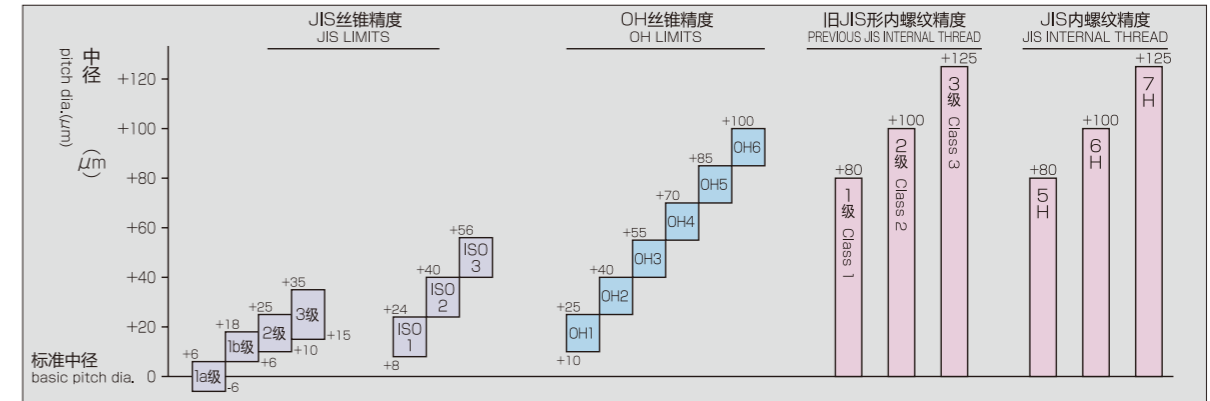
# 螺纹精度值

Thread accuracy value

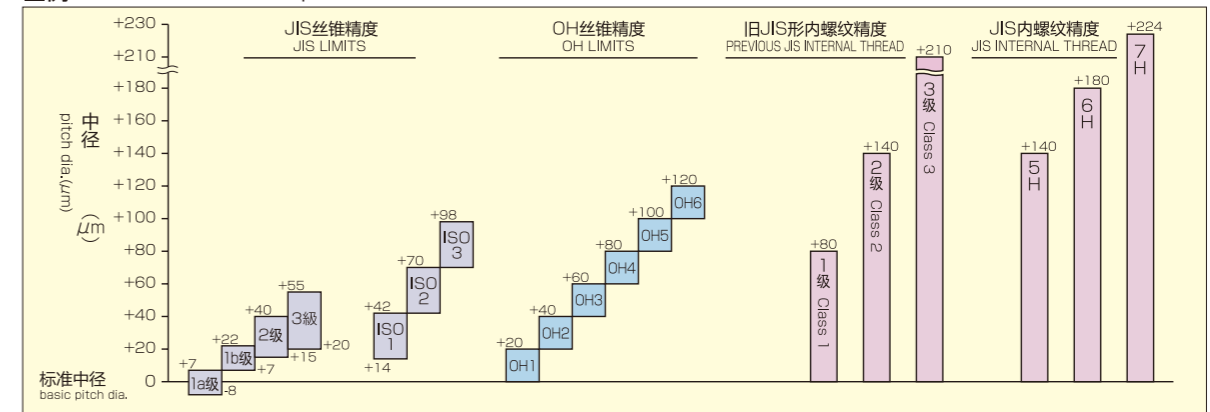
几乎所有研磨丝锥都适应此精度，该精度具有JIS2级等同或同等以上的精度，根据螺距将丝锥中径按下划分。Most of thread's ground finished taps use this limit system. The limits are calculated as follows.

$1.P \leq 0.6$ (40牙以上) 上公差: $0.010 + 0.015 \times n$ 下公差: 上公差 - 0.015 单位: mm Unit: mm	$P \leq 0.6$ (T.P.I $\geq 40$ ) upper limit: $0.010 + 0.015 \times n$ lower limit: (upper limit) - 0.015 (n=OH号) (n=OH number)	$2.P \geq 0.7$ (3.6牙以上) 上公差: $0.020 \times n$ 下公差: 上公差 - 0.020 单位: mm Unit: mm	$P \geq 0.7$ (T.P.I $\geq 36$ ) upper limit: $0.020 \times n$ lower limit: (upper limit) - 0.020 (n=OH号) (n=OH number)
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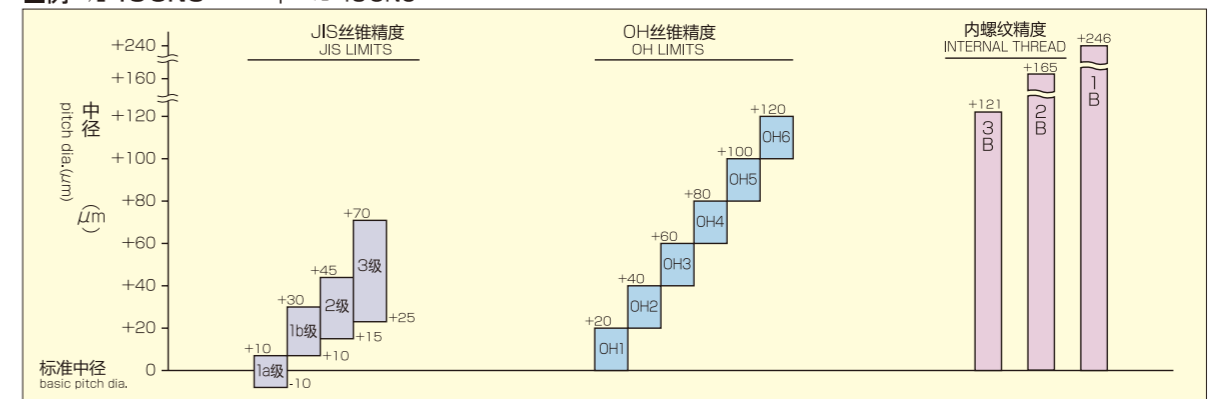
例 M3x0.5 Example M3x0.5



例 M10x1.5 Example M10x1.5



例 1/2-13UNC Example 1/2-13UNC



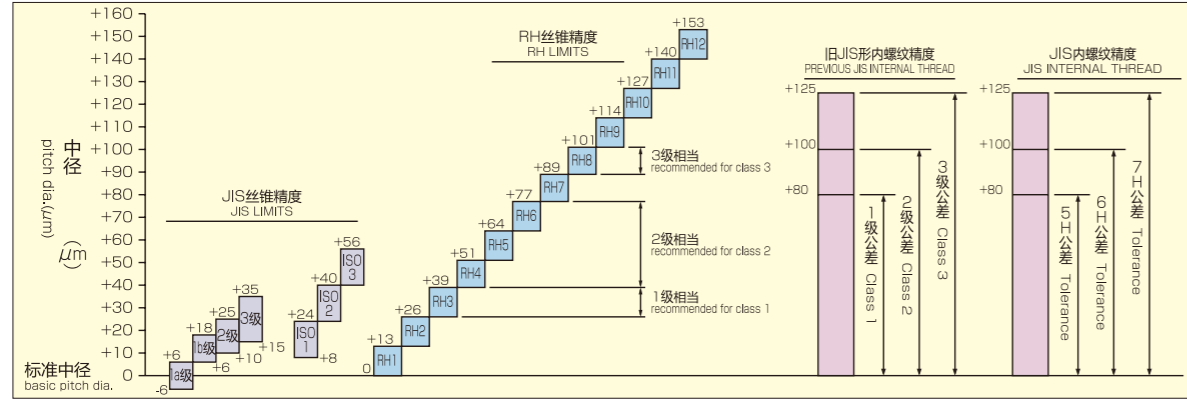
# 螺纹精度值

Thread accuracy value

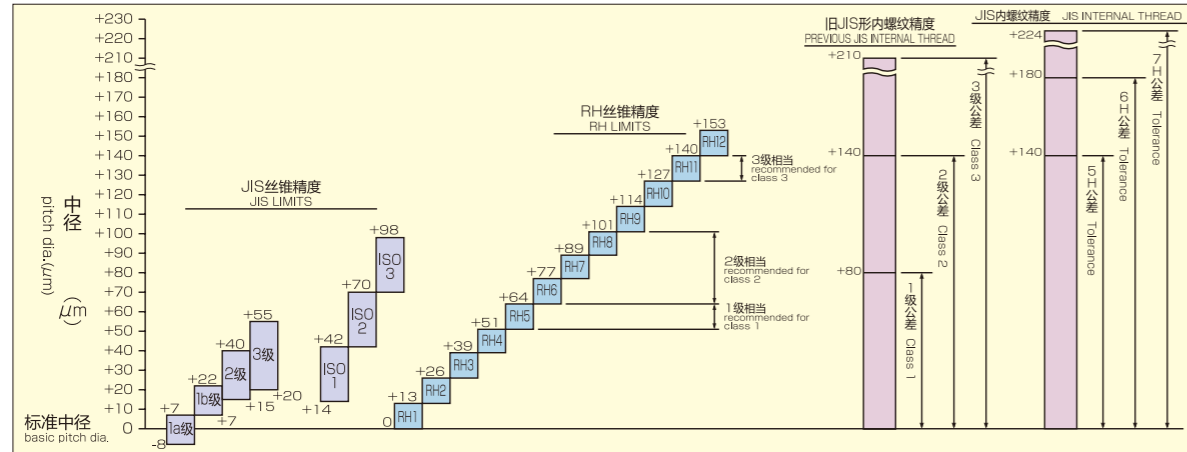
# 切削速度和切削液

Cutting speed and cutting fluid

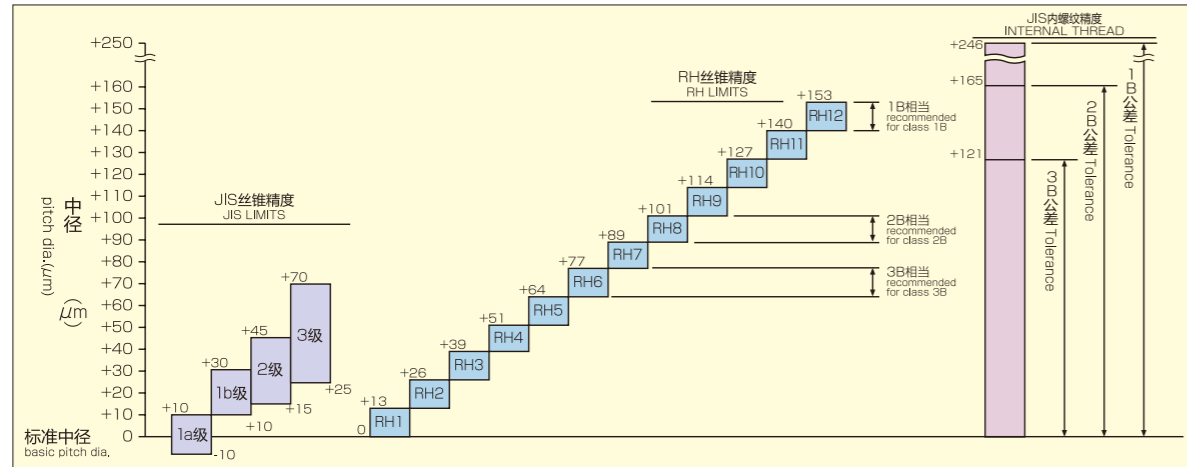
例 M3×0.5 Example M3×0.5



例 M10×1.5 Example M10×1.5



例 1/2-13UNC Example 1/2-13 UNC



## 切削速度和切削液

选定切削速度时必须考虑丝锥的材质、种类、牙数、底孔形状、加工材质及切削液等加工条件，另外切削液、具有润滑，冷却，抗粘刀3种作用，攻丝加工是一种复杂加工，必须选择适当的切削液。

### 标准切削速度与切削液

加工材料	切削速度 (m/min)							切削液				
	※直槽丝锥	螺旋槽丝锥	※刃倾角丝锥	※硬质合金丝锥	※挤压丝锥	高速同步丝锥	管用丝锥	油性	水溶性(乳化液)	半干式	干式	
低碳素钢	C0.25%以下	8~13	8~13	15~25	-	8~13	27~32	3~6	○	○	-	-
中碳素钢	C0.25~0.45%	7~12	7~12	10~15	-	7~10	27~32	3~6	○	○	-	-
高碳素钢	C0.45%以上	6~9	6~9	8~13	-	5~8	22~27	2~5	○	○	-	-
合金钢	SCM	7~12	7~12	10~15	-	5~8	22~27	2~5	○	△	-	-
调质钢	25~45HRC	3~5 (4~8)	3~5 (4~8)	4~6 (6~10)	-	-	-	2~5	○	△	-	-
不锈钢	SUS	4~7	5~8	8~13	-	5~10	-	3~6	○	○	-	-
析出硬质不锈钢	SUS630 SUS631	3~5	3~5	4~6	-	-	-	2~5	○	-	-	-
工具钢	SKD	6~9	6~9	7~10	-	-	-	2~5	○	-	-	-
铸钢	SC	6~11	6~11	10~15	-	-	17~22	2~5	○	○	-	-
铸铁	FC	10~15	-	-	10~20	-	-	2~5	○	○	○	○
球墨铸铁	FCD	7~12	7~12	10~20	10~20	-	-	4~8	○	○	○	-
铜	Cu	6~9	6~11	7~12	10~20	7~12	27~32	2~5	○	○	-	-
黄铜·黄铜铸件	Bs-BsC	10~15	10~20	15~25	15~25	7~12	27~32	5~10	○	○	○	○
青铜·青铜铸件	PB-PBC	6~11	6~11	10~20	10~20	7~12	-	5~10	○	○	-	-
变形铝合金	AL	10~20	10~20	15~25	-	10~20	100~300	6~11	○	○	-	-
铝合金铸件	AC-ADC	10~15	10~15	15~20	10~20	10~15	80~300	10~15	○	○	-	-
镁合金	MC	7~12	7~12	10~15	10~20	-	-	10~15	○	○	-	-
锌铸件	ZDC	7~12	7~12	10~15	10~20	7~12	27~100	10~15	○	○	-	-
热硬塑料	酚醛塑料 环氧树脂	10~20	-	-	15~25	-	-	5~10	-	○	○	○
热塑性塑料	聚乙烯、尼龙、共聚甲醛	10~20	10~15	10~20	10~20	-	27~32	5~10	-	○	-	-

1. 此表为一般性的选定基准，根据使用条件有所变更。

2. 选型时参照各用途丝锥选型基准表。

3. 调质钢的( )内为CPM系列丝锥的切削速度。

※DUR ACON系列的参数按照表值的30%~50%设定，但不包括氧化处理和氮化处理。

○ 最適 ○ 適用 △ 可使用 - 不可使用

# 关于螺纹底孔

ON THREADED BOTTOM HOLE

# 螺纹底孔参数表

Parameter Table of Threaded Bottom Hole

## 底孔径 DRILL HOLE SIZE

底孔径是影响攻丝加工的重要因素之一。  
外螺纹和内螺纹的有效嵌合高度与标准牙形高的比称为嵌合率。

The Drill Hole diameter (or Thread Overlap Ratio) substantially affects tapping operations.  
cf. Thread Overlap Ratio = percentage of thread overlap (a) to basic overlap (h)

### 嵌合率★Formula★

$$\text{嵌合率} = \frac{(\text{外螺纹大径的基准尺寸}) - (\text{底孔径})}{2 \times (\text{标准牙形高度})} \times 100$$

Percentage of thread engagement =  $\frac{(\text{basic major dia. of external thread}) - (\text{drill hole dia.})}{2 \times (\text{basic height of thread engagement})} \times 100$

在加工内螺纹底孔之前必须考虑到这个嵌合率。

内螺纹小径和底孔直径相等。如果定下了螺距P、外螺纹大径d、嵌合率，那么底孔径（公制螺纹、美制统一螺纹）可由外螺纹标准牙高0.541266P。

Because the minor dia. of the internal thread is equal to the Drill Hole diameter, the Drill diameter is calculated using the following formula (Metric and Unified Threads:)

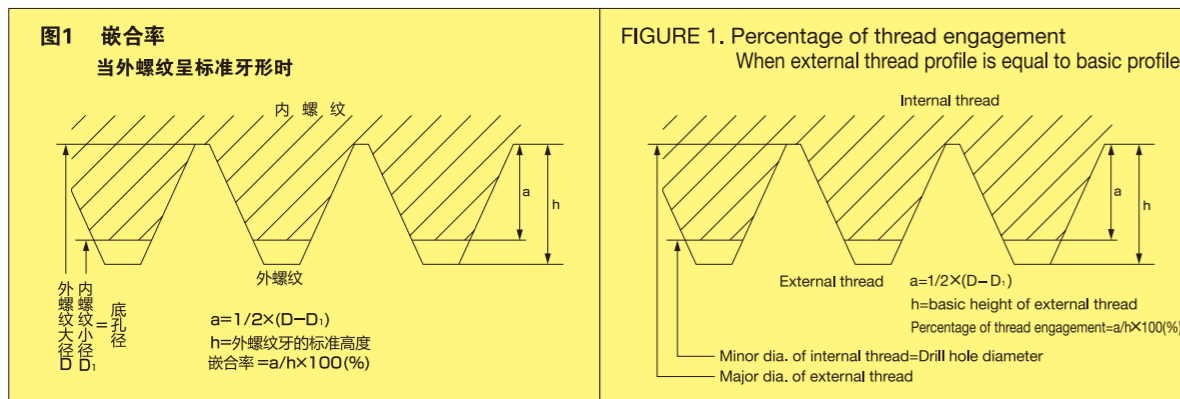
### 底孔径(公制螺纹、美制螺纹)★Formula★

$$\text{底孔径} = d - 2 \times (0.541266P) \times \left( \frac{\text{嵌合率}}{100} \right)$$

Drill Hole diameter =  $d - 2 \times (0.541266P) \times \left( \frac{\text{Percentage of thread engagement}}{100} \right)$

求出。

d: 外螺纹大径 d:M  
p: 螺距 P:Pitch (mm)



## 公制螺纹(切削丝锥)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小低孔径 Min. drill hole dia.				最大低孔径 Max. drill hole dia.		
		各精度通用	旧JIS2级用	4H用	5H用	6H用	6H用	6H用
M 1×0.25	0.75	0.73	0.78	0.77	0.78	0.8		
※1 × 0.2	0.8	0.79	—	0.82	0.83	0.84		
1.1 × 0.25	0.85	0.83	0.88	0.87	0.88	0.9		
※1.1 × 0.2	0.9	0.89	—	0.92	0.93	0.94		
1.2 × 0.25	0.95	0.93	0.98	0.97	0.98	1		
※1.2 × 0.2	1	0.99	—	1.02	1.03	1.04		
1.4 × 0.3	1.1	1.08	1.14	1.12	1.14	1.16		
※1.4 × 0.2	1.2	1.19	—	1.22	1.23	1.24		
1.6 × 0.35	1.25	1.23	1.32	1.28	1.3	1.32		
※1.6 × 0.2	1.4	1.39	—	1.42	1.43	1.44		
※1.7 × 0.35	1.35	—	—	1.38	1.4	1.42		
※1.7 × 0.3	1.4	—	—	1.42	1.44	1.46		
※1.7 × 0.25	1.45	—	—	1.47	1.48	1.5		
※1.7 × 0.2	1.5	—	—	1.52	1.53	1.54		
1.8 × 0.35	1.45	1.43	1.52	1.48	1.5	1.52		
※1.8 × 0.2	1.6	1.59	—	1.62	1.63	1.64		
2 × 0.4	1.6	1.57	1.67	1.63	1.65	1.67		
※2 × 0.25	1.75	1.73	—	1.77	1.78	1.8		
2.2 × 0.45	1.75	1.72	1.83	1.79	1.81	1.83		
※2.2 × 0.25	1.95	1.93	—	1.97	1.98	2		
※2.3 × 0.4	1.9	—	—	1.93	1.95	1.97		
※2.3 × 0.35	1.95	—	—	1.98	2	2.02		
※2.3 × 0.25	2.05	—	—	2.07	2.08	2.1		
2.5 × 0.45	2.05	2.02	2.13	2.09	2.11	2.13		
2.5 × 0.35	2.15	2.13	2.22	2.18	2.2	2.22		
※2.6 × 0.45	2.15	—	—	2.19	2.22	2.23		
※2.6 × 0.35	2.25	—	—	2.28	2.3	2.32		
※3 × 0.6	2.4	2.35	2.42	2.45	2.47	2.51		
3 × 0.5	2.5	2.46	2.59	2.54	2.57	2.59		
3 × 0.35	2.65	2.63	2.72	2.68	2.7	2.72		
3.5 × 0.6	2.9	2.85	3.01	2.95	2.97	3.01		
※3.5 × 0.5	3	2.96	—	3.04	3.07	3.09		
3.5 × 0.35	3.15	3.13	3.22	3.18	3.2	3.22		
4 × 0.75	3.25	3.19	3.32	3.3	3.33	3.37		
4 × 0.7	3.3	3.25	3.42	3.35	3.38	3.42		
4 × 0.5	3.5	3.46	3.59	3.54	3.57	3.59		
4.5 × 0.75	3.75	3.69	3.87	3.8	3.83	3.87		
4.5 × 0.5	4	3.96	4.09	4.04	4.07	4.09		
※5 × 0.9	4.1	—	—	4.15	4.19	4.23		
5 × 0.8	4.2	4.14	4.33	4.25	4.29	4.33		
※5 × 0.75	4.25	4.19	—	4.3	4.33	4.37		
5 × 0.5	4.5	4.46	4.59	4.54	4.57	4.59		
※5.5 × 0.9	4.6	—	—	4.65	4.69	4.73		
※5.5 × 0.75	4.75	—	—	4.8	4.83	4.87		
5.5 × 0.5	5	4.96	5.09	5.04	5.07	5.09		
6 × 1	5	4.92	5.15	5.06	5.1	5.15		
6 × 0.75	5.25	5.19	5.37	5.3	5.33	5.37		
※6 × 0.5	5.5	—	—	5.54	5.57	5.59		
7 × 1	6	5.92	6.15	6.06	6.1	6.15		
7 × 0.75	6.25	6.19	6.37	6.3	6.33	6.37		

## Metric screw threads

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小低孔径 Min. drill hole dia.			最大低孔径 Max. drill hole dia.			
		各精度通用	旧JIS2级用	4H用	5H用	6H用	6H用	
※7 × 0.5	6.5	—	—	6.54	6.57	6.59		
8 × 1.25	6.75	6.65	6.91	6.81	6.85	6.91		
8 × 1	7	6.92	7.15	7.06	7.1	7.15		
8 × 0.75	7.25	7.19	7.37	7.3	7.33	7.37		
※8 × 0.5	7.5	—	—	7.54	7.57	7.59		
9 × 1.25	7.75	7.65	7.91	7.81	7.85	7.91		
9 × 1	8	7.92	8.15	8.06	8.1	8.15		
9 × 0.75	8.25	8.19	8.37	8.3	8.33	8.37		
※9 × 0.5	8.5	—	—	8.54	8.57	8.59		
10 × 1.5	8.5	8.38	8.67	8.52	8.61	8.67		
10 × 1.25	8.75	8.65	8.91	8.81	8.85	8.91		
10 × 1	9	8.92	9.15	9.06	9.1	9.15		
10 × 0.75	9.25	9.19	9.37	9.3	9.33	9.37		
※10 × 0.5	9.5	—	—	9.54	9.57	9.59		
11 × 1.5	9.5	9.38	9.67	9.52	9.61	9.67		
11 × 1.25	9.75	9.65	9.8	9.81	9.85	9.91		
11 × 1	10	9.92	10.15	10.06	10.1	10.15		
11 × 0.75	10.25	10.19	10.37	10.3	10.33	10.37		
※11 × 0.5	10.5	—	—	10.54	10.57	10.59		
12 × 1.75	10.25	10.11	10.44	10.31	10.37	10.44		
12 × 1.5	10.5	10.38	10.67	10.56	10.61	10.67		
12 × 1.25	10.75	10.65	10.91	10.81	10.85	10.91		
12 × 1	11	10.92	11.15	11.06	11.1	11.15		
※12 × 0.75	11.25	—	—	11.3	11.33	11.37		
※12 × 0.5	11.5	—	—	11.54	11.57	11.59		
※13 × 1.75	11.25	—	—	11.31	11.37	11.44		
※13 × 1.5	11.5	—	—	11.56	11.61	11.67		
※13 × 1.25	11.75	—	—	11.81	11.85	11.91		
※13 × 1	12	—	—	12.06	12.1	12.15		
※13 × 0.75	12.3	—	—	12.3	12.33	12.37		
※13 × 0.5	12.5	—	—	12.54	12.57	12.59		
14 × 2	12	11.84	12.21	12.07	12.13	12.21		
14 × 1.5	12.5	12.38	12.67	12.56	12.61	12.67		
14 × 1.25	12.75	12.65	—	—	—	12.91		
14 × 1	13	12.92	13.15	13.06	13.1	13.15		
※14 × 0.75	13.3	—	—	13.3	13.33	13.37		
※14 × 0.5	13.5	—	—	13.54	13.57	13.59		
※15 × 2	13	—	—	13.07	13.13	13.21		
15 × 1.5	13.5	13.4	13.6	13.56	13.61	13.67		
15 × 1.25	13.8	13.7	13.9	13.81	13.85	13.91		
15 × 1	14	13.95	14.15	14.06	14.1	14.15		
※15 × 0.75	14.3	—	—	14.3	14.33	14.37		
※15 × 0.5	14.5	—	—	14.54	14.57	14.59		
16 × 2	14	13.9	14.2	14.07	14.13	14.21		
16 × 1.5	14.5	14.4	14.6	14.56	14.61	14.67		
※16 × 1.25	14.75	14.65	—	14.81	14.85	14.91		
16 × 1	15	14.95	15.15	15.06	15.1	15.15		
※16 × 0.75	15.25	15.19	—	15.3	15.33	15.37		
16 × 0.5	15.5	15.46	15.52	15.54	15.57	15.59		
※17 × 2	15	—	—	15.07	15.13	15.21		

# 螺纹底孔参数表

Parameter Table of Threaded Bottom Hole

# 螺纹底孔参数表

Parameter Table of Threaded Bottom Hole

## 公制螺纹(切削丝锥)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.				最大底孔径 Max. drill hole dia.			
		各精度通用	旧JIS2级用	4H用	5H用	6H用	4H用	5H用	6H用
17 × 1.5	15.5	15.4	15.68	15.56	15.61	15.67			
※ 17 × 1.25	15.8	—	—	15.81	15.85	15.91			
17 × 1	16	15.95	16.15	16.06	16.1	16.15			
※ 17 × 0.75	16.3	—	—	16.3	16.33	16.37			
※ 17 × 0.5	16.5	—	—	16.54	16.57	16.59			
18 × 2.5	15.5	15.3	15.7	15.57	15.64	15.74			
18 × 2	16	15.9	16.2	16.07	16.13	16.21			
18 × 1.5	16.5	16.4	16.6	16.56	16.61	16.67			
※ 18 × 1.25	16.75	16.65	—	16.81	16.85	16.91			
18 × 1	17	16.95	17.15	17.06	17.1	17.15			
※ 18 × 0.75	17.25	17.19	—	17.3	17.33	17.37			
18 × 0.5	17.5	17.46	17.52	17.54	17.57	17.59			
※ 19 × 2.5	16.5	—	—	16.57	16.64	16.74			
※ 19 × 2	17	—	—	17.07	17.13	17.21			
※ 19 × 1.5	17.5	—	—	17.56	17.61	17.67			
※ 19 × 1.25	17.8	—	—	17.81	17.85	17.91			
※ 19 × 1	18	—	—	18.06	18.1	18.15			
※ 19 × 0.75	18.3	—	—	18.3	18.33	18.37			
※ 19 × 0.5	18.5	—	—	18.54	18.57	18.59			
20 × 2.5	17.5	17.3	17.7	17.57	17.64	17.74			
20 × 2	18	17.9	18.2	18.07	18.13	18.21			
20 × 1.5	18.5	18.4	18.6	18.56	18.61	18.67			
※ 20 × 1.25	18.75	18.65	—	18.81	18.85	18.91			
20 × 1	19	18.95	19.15	19.06	19.1	19.15			
20 × 0.5	19.5	19.46	19.52	19.54	19.57	19.59			
※ 21 × 2.5	18.5	—	—	18.57	18.64	18.74			
※ 21 × 1.5	19.5	—	—	19.56	19.61	19.67			
※ 21 × 1	20	—	—	20.06	20.1	20.15			
22 × 2.5	19.5	19.3	19.7	19.57	19.64	19.74			
22 × 2	20	19.9	20.2	20.07	20.13	20.21			
22 × 1.5	20.5	20.4	20.6	20.56	20.61	20.67			
22 × 1	21	20.95	21.15	21.06	21.1	21.15			
22 × 0.5	21.5	21.46	21.52	21.54	21.57	21.59			
※ 23 × 2.5	20.5	—	—	20.57	20.64	20.74			
※ 23 × 2	21	—	—	21.07	21.13	21.21			
※ 23 × 1.5	21.5	—	—	21.56	21.61	21.67			
※ 23 × 1	22	—	—	22.06	22.1	22.15			
24 × 3	21	20.8	21.2	21.06	21.15	21.25			
※ 24 × 2.5	21.5	21.29	—	21.57	21.64	21.74			
24 × 2	22	21.9	22.2	22.07	22.13	22.21			
24 × 1.5	22.5	22.4	22.6	22.56	22.61	22.67			
※ 24 × 1.25	22.75	22.65	—	22.81	22.85	22.91			
24 × 1	23	22.95	23.15	23.06	23.1	23.15			
※ 25 × 3	22	—	—	22.06	22.15	22.25			
25 × 2	23	22.9	23.2	23.07	23.13	23.21			
25 × 1.5	23.5	23.4	23.6	23.56	23.61	23.67			
25 × 1	24	23.95	24.15	24.06	24.1	24.15			
※ 26 × 3	23	—	—	23.06	23.15	23.25			
※ 26 × 2	24	—	—	24.07	24.13	24.21			
26 × 1.5	24.5	24.4	24.6	24.56	24.61	24.67			

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.		最大底孔径 Max. drill hole dia.					
		各精度通用	旧JIS2级用	4H用	5H用	6H用			
26 × 1	25	24.95	25.15	25.06	25.1	25.15			
27 × 3	24	23.8	24.2	24.06	24.15	24.25			
※ 27 × 2.5	24.5	—	—	24.57	24.64	24.74			
27 × 2	25	24.9	25.2	25.07	25.13	25.21			
27 × 1.5	25.5	25.4	25.6	25.56	25.61	25.67			
27 × 1	26	25.95	26.15	26.06	26.1	26.15			
※ 28 × 3	25	—	—	25.06	25.15	25.25			
28 × 2	26	25.9	26.2	26.07	26.13	26.21			
28 × 1.5	26.5	26.4	26.6	26.56	26.61	26.67			
28 × 1	27	26.95	27.15	27.06	27.1	27.15			
30 × 3.5	26.5	26.3	26.7	26.56	26.66	26.77			
30 × 3	27	26.8	27.2	27.06	27.15	27.25			
30 × 2	28	27.9	28.2	28.07	28.13	28.21			
30 × 1.5	28.5	28.4	28.6	28.56	28.61	28.67			
30 × 1	29	28.95	29.15	29.06	29.1	29.15			
※ 32 × 3	29	—	—	29.06	29.15	29.25			
32 × 2	30	29.9	30.2	30.07	30.13	30.21			
32 × 1.5	30.5	30.4	30.6	30.56	30.61	30.67			
32 × 1	31	30.95	30.15	30.06	30.1	30.15			
33 × 3.5	29.5	29.3	29.7	29.56	29.66	29.77			
33 × 3	30	29.8	30.2	30.06	30.15	30.25			
33 × 2	31	30.9	31.2	31.07	31.13	31.21			
33 × 1.5	31.5	31.4	31.6	31.56	31.61	31.67			
※ 33 × 1	32	—	—	32.06	32.1	32.15			
※ 34 × 3	31	—	—	31.06	31.15	31.25			
※ 34 × 2	32	—	—	32.07	32.13	32.21			
※ 34 × 1.5	32.5	—	—	32.56	32.61	32.67			
※ 34 × 1	33	—	—	33.06	33.1	33.15			
※ 35 × 3	32	—	—	32.06	32.15	32.25			
※ 35 × 2	33	—	—	33.07	33.13	33.2			
35 × 1.5	33.5	33.4	33.6	33.56	33.61	33.67			
※ 35 × 1	34	—	—	34.06	34.1	34.15			
36 × 4	32	31.7	32.2	32.04	32.14	32.27			
36 × 3	33	32.8	33.2	33.06	33.15	33.25			
36 × 2	34	33.9	34.2	34.07	34.13	34.21			
36 × 1.5	34.5	34.4	34.6	34.56	34.61	34.67			
※ 36 × 1	35	—	—	35.06	35.1	35.15			
※ 37 × 1.5	35.5	—	—	35.56	35.61	35.67			
※ 37 × 1	36	—	—	36.06	36.1	36.15			
※ 38 × 4	34	—	—	34.04	34.14	34.27			
※ 38 × 3	35	—	—	35.06	35.15	35.25			
※ 38 × 2	36	—	—	36.07	36.13	36.21			
38 × 1.5	36.5	36.4	36.6	36.56	36.61	36.67			
38 × 1	37	36.95	36.62	37.06	37.1	37.15			
39 × 4	35	34.7	35.2	35.04	35.14	35.27			
39 × 3	36	35.8	36.2	36.06	36.15	36.25			
39 × 2	37	36.9	37.2	37.07	37.13	37.21			
39 × 1.5	37.5	37.4	37.6	37.56	37.61	37.67			
※ 39 × 1	38	—	—	38.06	38.1	38.15			
※ 40 × 4	36	—	—	36.04	36.14	36.27			

## 美制螺纹(切削丝锥)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	JIS2B级用 JIS class 2B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
No. 0 - 80UNF	1.25	1.19	1.3
1 - 64UNC	1.51	1.43	1.58
1 - 72UNF	1.55	1.48	1.61
2 - 56UNC	1.79	1.7	1.87
2 - 64UNF	1.84	1.76	1.91
3 - 48UNC	2.05	1.95	2.14
3 - 56UNF	2.11	2.03	2.19
4 - 40UNC	2.27	2.16	2.38
4 - 48UNF	2.37	2.28	2.45
5 - 40UNC	2.59	2.49	2.69
5 - 44UNF	2.65	2.56	2.74
6 - 32UNC	2.77	2.65	2.89
6 - 40UNF	2.92	2.82	3.02
8 - 32UNC	3.42	3.31	3.53
8 - 36UNF	3.51	3.41	3.6
10 - 24UNC	3.83	3.69	3.96
10 - 32UNF	4.07	3.97	4.16
12 - 24UNC	4.47	4.35	4.59
12 - 28UNF	4.61	4.5	4.72
1/4 - 20UNC	5.12	4.98	5.25
1/4 - 28UNF	5.47	5.36	5.58
1/4 - 32UNEF	5.59	5.49	5.68
5/16 - 18UNC	6.57	6.41	6.73
5/16 - 24UNF	6.91	6.79	7.03
5/16 - 32UNEF	7.18	7.09	7.26
3/8 - 16UNC	7.98	7.8	8.15
3/8 - 20UN	8.3	8.16	8.43
3/8 - 24UNF	8.51	8.39	8.63
3/8 - 32UNEF	8.77	8.67	8.86
7/16 - 14UNC	9.35	9.15	9.55
7/16 - 20UNF	9.88	9.73	10.03
1/2 - 13UNC	10.81	10.6	11.02
1/2 - 20UNF	11.47	11.33	11.6
5/16 - 12UNC	12.2	11.99	12.4
5/8 - 11UNC	13.6	13.4	13.8
5/8 - 18UNF	14.5	14.4	14.6
5/8 - 24UNEF	14.9	14.8	14.9
3/4 - 10UNC	16.6	16.4	16.8
3/4 - 16UNF	17.5	17.4	17.6
3/4 - 20UNEF	17.8	17.7	17.9
7/8 - 9UNC	19.5	19.2	19.7

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	JIS2B级用 JIS class 2B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
No. 7/8 - 14UNF	20.5	20.3	20.6
7/8 - 20UNEF	21	20.9	21.1
1 - 8UNC	22.3	22	22.6
1 - 12UNF	23.4	23.2	23.5
※ 1 - 14UNS	23.6	23.5	23.8
1 1/16 - 12UN	24.9	24.7	25.1
1 1/8 - 7UNC	25	24.7	25.3
1 1/8 - 8UN	25.4	25.2	25.7
1 1/8 - 12UNF	26.5	26.3	26.7
1 1/4 - 7UNC	28.2	27.9	28.5
1 1/4 - 8UN	28.7	28.4	28.9
1 1/4 - 12UNF	29.7	29.5	29.9
1 3/16 - 12UN	31.2	31.1	31.49
1 3/8 - 6UNC	30.8	30.4	31.1
1 3/8 - 8UN	31.8	31.5	32.1
1 3/8 - 12UNF	32.9	32.7	33
1 1/2 - 6UNC	33.9	33.6	34.2
1 1/2 - 8UN	35	34.7	35.3
1 1/2 - 12UNF	36	35.8	36.3
※ 1 5/8 - 5UNS	36.2	35.8	36.6
1 5/8 - 8UN	38.1	37.8	38.5
1 5/8 - 12UN	39.2	40	39.5
1 3/4 - 5UNC	39.4	39	39.8
1 3/4 - 8UN	41.4	41.1	41.6
1 3/4 - 12UN	42.4	42.2	42.6
1 7/8 - 8UN	44.5	44.2	44.8
2 - 4.5UNC	45.1	44.7	45.5
2 - 8UN	47.7	47.4	48
2 - 12UN	48.8	48.6	48.9

# 螺纹底孔参数表

Parameter Table of Threaded Bottom Hole

## 航天航空用UNJ螺纹规格

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	3B级用 3B drill hole dia.	
		最小直径 Min. drill hole dia.	最大直径 Max. drill hole dia.
No. -32UNJC	2.84	2.74	2.93
6 -40UNJF	2.97	2.89	3.05
8 -32UNJC	3.5	3.4	3.59
8 -36UNJF	3.57	3.48	3.66
10 -24UNJC	3.93	3.8	4.06
10 -32UNJF	4.16	4.06	4.25
1/4 -20UNJC	5.25	5.12	5.38
1/4 -28UNJF	5.57	5.47	5.66

UNJ thread for aircraft and aerospace industry

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	3B级用 3B drill hole dia.	
		最小直径 Min. drill hole dia.	最大直径 Max. drill hole dia.
5/16 - 18UNJC	6.7	6.57	6.83
5/16 - 24UNJF	7.01	6.91	7.1
3/8 - 16UNJC	8.12	7.98	8.25
3/8 - 24UNJF	8.59	8.5	8.67
7/16 - 14UNJC	9.49	9.35	9.63
7/16 - 20UNJF	9.98	9.88	10.08
1/2 - 13UNJC	10.95	10.8	11.09
1/2 - 20UNJF	11.57	11.47	11.66

## 缝纫机螺纹

螺纹尺寸 Thread size	钻头直径 Drill dia.	2级螺纹及 底孔直径 JIS class 2 drill hole dia.	2级内螺纹小径	
			最小直径 Min.	最大直径 Max.
SM 1/16 - 80	1.25	1.28(75%)	1.211	1.281
5/64 - 64	1.55	1.57(80%)	1.513	1.593
3/32 - 100	2.1	2.15(70%)	2.081	2.156
3/32 - 56	1.85	1.91(80%)	1.841	1.936
1/8 - 44	2.5	2.58(80%)	2.485	2.605
1/8 - 40	2.45	2.52(80%)	2.421	2.551
9/64 - 40	2.85	2.91(80%)	2.818	2.948
11/64 - 40	3.65	3.71(80%)	3.612	3.742
3/16 - 32	3.9	3.94(80%)	3.82	3.98
3/16 - 28	3.7	3.82(80%)	3.684	3.844
3/16 - 24	3.55	3.59(85%)	3.498	3.658
7/32 - 32	4.7	4.73(80%)	4.614	4.774
15/64 - 28	4.9	5.01(80%)	4.875	5.055
1/4 - 40	5.6	5.69(80%)	5.596	5.726
1/4 - 28	5.3	5.41(80%)	5.272	5.452

Screw threads for sewing machines

螺纹尺寸 Thread size	钻头直径 Drill dia.	2级螺纹及 底孔直径 JIS class 2 drill hole dia.	2级内螺纹小径	
			最小直径 Min.	最大直径 Max.
SM 1/4 - 24	5.1	5.25(80%)	5.086	5.266
5/32 - 28	6.1	6.2(80%)	6.066	6.256
5/32 - 20	5.7	5.82(80%)	5.634	5.824
5/16 - 28	6.9	6(80%)	6.86	7.05
5/16 - 24	6.7	6.84(80%)	6.674	6.864
5/16 - 18	6.3	6.38(85%)	6.254	6.444
11/32 - 28	7.6	7.79(80%)	7.653	7.843
3/8 - 28	8.5	8.58(80%)	8.447	8.637
3/8 - 18	7.9	7.97(85%)	7.843	8.053
7/16 - 28	10.1	10.17(80%)	10.034	10.224
7/16 - 16	9.3	9.36(85%)	9.22	9.44
1/2 - 28	11.7	11.76(80%)	11.622	11.812
1/2 - 20	11.3	11.38(80%)	11.19	11.41
1/2 - 12	10.3	10.36(85%)	10.18	10.42

## 英制粗牙螺纹

螺纹尺寸 Thread size	牙数 Number of thread	内螺纹最大径 Internal thread max.minor dia.	内螺纹最小径 Internal thread min.minor dia.
W 1/8	40	2.602	2.452
5/32	32	3.073	3.253
3/16	24	3.807	3.567
1/4	20	5.204	4.914
5/16	18	6.67	6.34
3/8	16	8.113	7.733
7/16	14	9.508	9.048
1/2	12	10.83	10.31
5/8	12	12.418	11.898
3/4	11	13.817	13.257
7/8	9	16.778	16.178
1	8	19.691	19.031
1 1/8	8	22.514	21.814
1 1/4	7	25.229	24.469

Whitworth Coarse screw threads

螺纹尺寸 Thread size	牙数 Number of thread	内螺纹最大径 Internal thread max.minor dia.	内螺纹最小径 Internal thread min.minor dia.
1 1/4	7	28.404	27.644
1 3/8	6	30.923	30.123
1 1/2	6	34.098	33.298
1 5/8	5	36.409	35.529
1 3/4	5	39.584	38.704
1 7/8	4?	42.227	41.237
2	4?	45.402	44.412
2 1/8	4	47.893	46.783
2 1/4	4	51.068	49.958
2 3/8	4	54.243	53.133
2 1/2	4	57.418	56.308
2 3/4	3?	62.816	61.636
2 7/8	3?	65.99	64.81
3	3?	69.166	67.986

# 螺纹底孔参数表

Parameter Table of Threaded Bottom Hole

## 英式锥管螺纹 Taper pipe threads

管螺纹 尺寸 Thread size	JIS B 0203				JIS B 2301	
	锥管内螺纹Rc(PT) Taper internal threads(PT)		平行内螺纹Rp(PS) Parallel internal threads(PS)		锥管内螺纹 Taper internal threads	
	计算值 calculated value	底孔直径 Drill hole dia.	计算值 calculated value	底孔直径 Drill hole dia.	计算值 calculated value	底孔直径 Drill hole dia.
1/16	6.230	6.2	6.490	6.5	—	—
1/8	8.235	8.2	8.495	8.5	8.191	8.2
1/4	10.941	10.9	11.341	11.4	10.945	10.9
3/8	14.428	14.4	14.846	14.9	14.388	14.4
1/2	17.950	18	18.489	18.5	17.943	18
3/4	23.349	23	23.975	24	23.305	23
1	29.423	29	30.111	30	29.353	29
1 1/4	37.940	38	38.772	39	37.890	38
1 1/2	43.833	44	44.565	45	43.720	43
2	55.412	55	56.476	56	55.406	55
2 1/2	70.701	71	72.009	72	70.788	70
3	83.201	83	84.709	85	83.364	83
3 1/2	95.547	96	97.155	97	95.747	95
4	107.834	108	109.855	110	108.322	108
5	133.110	133	135.255	135	133.597	133
6	158.510	159	160.655	161	158.810	158
7	183.360	183	185.954	186	—	—
8	208.560	209	211.354	212	—	—
9	233.960	234	236.754	237	—	—
10	259.166	259	262.154	262	—	—
12	309.747	310	312.875	313	—	—

1982年由于ISO的导入，JIS管螺纹规格得到修订。螺纹代号有了变更，但螺纹精度没有改变。

种类 Type	旧记号 Previous Symbol	新记号 New Symbol
密封用锥管内螺纹 Taper pipe threads for	PT	Rc
Parallel pipe threads	PS	Rp
一般结合用 平行内螺纹 Parallel pipe threads for	PF	G

## 英式平行管螺纹 Parallel pipe threads

螺纹Thread		最小底孔径 Drill hole dia min.	最大底孔径 Drill hole dia max.
尺寸 Thread size	大径 Major dia.		
G 1/16	7.723	6.56 (100%)	6.79 (80%)
G(PF) 1/8	9.728	8.57 "	8.80 "
1/4	13.157	11.45 "	11.87 (75%)
3/8	16.662	14.95 "	15.38 "
1/2	20.955	18.6 "	19.1 (80%)
5/8	22.911	20.6 "	21.0 "
3/4	26.441	24.1 "	24.6 "
7/8	30.201	27.9 "	28.3 "
1	33.249	30.3 "	30.9 "
1 1/8	37.897	34.9 "	35.5 "
1 1/4	41.91	39.0 "	39.4 (85%)
1 3/8	44.323	41.4 "	42.0 (80%)
1 1/2	47.803	44.8 "	45.4 "
1 3/4	53.746	50.8 "	51.4 "
2	59.614	56.6 "	57.2 "
2 1/2	75.184	72.2 "	72.8 "
3	87.884	84.9 "	85.5 "
3 1/2	100.33	97.3 "	98 "
4	113.030	110.1 "	110.7 "

## 英式管用平行螺纹(挤压丝锥) Parallel pipe Parallel pipe threads (Nu-Roll tap)

螺纹尺寸 Thread size	RH精度 RH Limits	最小-最大(嵌合率%) Min.-Max.(thread Overlap Ratio:%)
1/8	6	9.24 ~ 9.35 (100 ~ 80)
1/4	7	12.41 ~ 12.62 (100 ~ 75)
3/8	7	15.92 ~ 16.12 (100 ~ 75)
1/2	8	19.93 ~ 20.15 (100 ~ 80)
3/4	8	25.41 ~ 25.64 (100 ~ 80)
1	10	31.919 ~ 32.205(100 ~ 80)



# 螺纹底孔参数表

Parameter Table of Threaded Bottom Hole

# 螺纹底孔径参数表(挤压丝锥用)

Parameter table of thread bottom hole diameter (for extrusion tap)

## 管螺纹推荐底孔

管用螺纹尺寸 Thread size	锥管螺纹 (NPT) Taper threads(NPT)				平行螺纹 (NPSC) Parallel threads(NPSC)	
	钻头直径 Drill dia.				钻头直径 Drill dia.	
	使用铰刀时 Where Reamer is used		不使用铰刀时 Where Reamer is not used			
1/16	—	5.94 (0.234)	—	6.15 (0.242)	1/4	6.35 (0.25)
1/8	2 1/64	8.33 (0.328)	—	8.43 (0.332)	1 1/32	8.74 (0.344)
1/4	2 7/64	10.72 (0.422)	7/16	11.13 (0.438)	7/16	11.13 (0.438)
3/8	9/16	14.27 (0.562)	9/16	14.27 (0.562)	3 7/64	14.68 (0.578)
1/2	1 1/16	17.48 (0.688)	4 5/64	17.86 (0.703)	2 3/32	18.26 (0.719)
3/4	5 7/64	22.63 (0.891)	2 9/32	23.01 (0.906)	5 9/64	23.42 (0.922)
1	1 1/8	28.58 (1.125)	1 9/64	28.98 (1.141)	1 5/32	29.36 (1.156)
1 1/4	1 15/32	37.31 (1.469)	1 3 1/64	37.69 (1.484)	1 1/2	38.10 (1.5)
1 1/2	1 4 5/64	43.26 (1.703)	1 2 3/32	43.66 (1.719)	1 3/4	44.45 (1.75)
2	2 1 1/64	55.17 (2.172)	2 3/16	55.58 (2.188)	2 7/32	56.36 (2.219)
2 1/2	2 3 3/64	65.48 (2.578)	2 3 3/64	66.27 (2.609)	2 2 1/32	67.46 (2.656)

管用螺纹尺寸 Thread size	锥管螺纹 (NPTF) Taper threads(NPTF)				平行螺纹 (NPSF) Parallel threads(NPSF)	
	钻头直径 Drill dia.				钻头直径 Drill dia.	
	使用铰刀时 Where Reamer is used		不使用铰刀时 Where Reamer is not used			
1/16	—	5.94 (0.234)	—	6.15 (0.242)	—	6.25 (0.246)
1/8	2 1/64	8.33 (0.328)	—	8.43 (0.332)	—	8.61 (0.339)
1/4	2 7/64	10.72 (0.422)	7/16	11.13 (0.438)	7/16	11.13 (0.438)
3/8	9/16	14.3 (0.563)	9/16	14.27 (0.562)	3 7/64	14.68 (0.578)
1/2	1 1/16	17.48 (0.688)	4 5/64	17.86 (0.703)	4 5/64	17.86 (0.703)
3/4	5 7/64	22.63 (0.891)	2 9/32	23.01 (0.906)	5 9/64	23.42 (0.922)
1	1 1/8	28.58 (1.125)	1 9/64	28.98 (1.141)	1 5/32	29.36 (1.156)
1 1/4	1 15/32	37.31 (1.469)	1 3 1/64	37.69 (1.484)	—	—
1 1/2	1 4 5/64	43.26 (1.703)	1 2 3/32	43.66 (1.719)	—	—
2	2 1 1/64	55.17 (2.172)	2 3/16	55.58 (2.188)	—	—
2 1/2	2 3 3/64	65.48 (2.578)	2 3 3/64	66.27 (2.609)	—	—

## 公制螺纹(挤压丝锥)

Metric screw threads (Nu-Roll tap)

螺纹尺寸 Thread size	1级螺纹用底孔直径 for JIS class 1 drill hole dia.		2级螺纹用底孔直径 for JIS class 2 drill hole dia.		4H		5H		6H	
	RH 精度 RH Limits	最小 ~ 最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)	RH 精度 RH Limits	最小 ~ 最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)	RH 精度 RH Limits	最小 ~ 最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)	RH 精度 RH Limits	最小 ~ 最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)	RH 精度 RH Limits	最小 ~ 最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)
M1 × 0.25	2	0.87 ~ 0.89 (100% ~ 85%)	4	0.90 ~ 0.92 (100% ~ 80%)	2	0.875 ~ 0.889 (100% ~ 85%)	4	0.901 ~ 0.920 (100% ~ 80%)	—	—
1.1 × 0.25	2	0.97 ~ 0.99 "	4	1.00 ~ 1.02 "	2	0.975 ~ 0.989 "	4	1.001 ~ 1.020 "	—	—
1.2 × 0.25	2	1.07 ~ 1.09 "	4	1.10 ~ 1.12 "	2	1.075 ~ 1.089 "	4	1.101 ~ 1.120 "	—	—
1.4 × 0.3	2	1.244 ~ 1.263 "	4	1.270 ~ 1.294 "	2	1.245 ~ 1.262 "	4	1.270 ~ 1.294 "	4	1.270 ~ 1.291 (100% ~ 82%)
1.6 × 0.35	2	1.41 ~ 1.44 (100% ~ 80%)	4	1.44 ~ 1.48 (100% ~ 75%)	2	1.415 ~ 1.442 (100% ~ 80%)	4	1.440 ~ 1.466 (100% ~ 81%)	4	1.440 ~ 1.475 (100% ~ 75%)
× 0.35	—	—	4	1.54 ~ 1.58 "	—	—	—	—	—	—
1.8 × 0.35	2	1.61 ~ 1.64 (100% ~ 80%)	4	1.64 ~ 1.68 "	2	1.615 ~ 1.634 (100% ~ 86%)	4	1.640 ~ 1.666 (100% ~ 81%)	4	1.640 ~ 1.675 (100% ~ 75%)
2 × 0.4	2	1.78 ~ 1.82 "	4	1.81 ~ 1.85 "	2	1.785 ~ 1.806 "	4	1.810 ~ 1.840 "	4	1.810 ~ 1.849 "
2 × 0.25	2	1.88 ~ 1.89 "	—	—	2	1.875 ~ 1.888 (100% ~ 87%)	4	1.901 ~ 1.918 (99% ~ 82%)	—	—
2.2 × 0.45	2	1.95 ~ 1.99 "	4	1.98 ~ 2.03 (100% ~ 75%)	2	1.955 ~ 1.979 (100% ~ 86%)	4	1.980 ~ 2.012 (100% ~ 82%)	4	1.980 ~ 2.024 (100% ~ 75%)
2.3 × 0.4	—	—	4	2.11 ~ 2.15 "	—	—	—	—	—	—
2.5 × 0.45	2	2.25 ~ 2.29 (100% ~ 80%)	4	2.28 ~ 2.33 "	2	2.255 ~ 2.279 (100% ~ 86%)	4	2.280 ~ 2.312 (100% ~ 82%)	4	2.280 ~ 2.324 (100% ~ 75%)
× 0.45	—	—	4	2.38 ~ 2.43 "	—	—	-3	—	—	—
× 0.6	3	2.68 ~ 2.70 (100% ~ 90%)	5	2.70 ~ 2.73 (100% ~ 90%)	—	—	—	—	—	—
3 × 0.5	3	2.74 ~ 2.78 (100% ~ 80%)	5	2.76 ~ 2.81 (100% ~ 75%)	3	2.737 ~ 2.764 (100% ~ 86%)	5	2.762 ~ 2.798 (100% ~ 82%)	5	2.762 ~ 2.812 (100% ~ 75%)
3.5 × 0.6	3	3.18 ~ 3.21 (100% ~ 85%)	5	3.20 ~ 3.26 "	3	3.177 ~ 3.210 "	5	3.202 ~ 3.242 (100% ~ 83%)	5	3.202 ~ 3.250 (100% ~ 80%)
× 0.75	4	3.60 ~ 3.64 "	6	3.62 ~ 3.67 (100% ~ 85%)	—	—	—	—	—	—
4 × 0.7	4	3.63 ~ 3.67 "	6	3.65 ~ 3.70 "	4	3.63 ~ 3.66 (100% ~ 88%)	4	3.63 ~ 3.67 (100% ~ 85%)	6	3.66 ~ 3.69 (100% ~ 85%)
4.5 × 0.75	4	4.10 ~ 4.14 "	6	4.12 ~ 4.18 (100% ~ 80%)	4	4.10 ~ 4.13 "	4	4.10 ~ 4.14 "	6	4.13 ~ 4.18 (100% ~ 85%)
5 × 0.8	4	4.51 ~ 4.56 "	6	4.53 ~ 4.59 (100% ~ 85%)	—	—	—	—	—	—
5 × 0.9	4	4.57 ~ 4.62 "	6	4.59 ~ 4.66 (100% ~ 80%)	4	4.57 ~ 4.60 (100% ~ 88%)	4	4.57 ~ 4.61 (100% ~ 85%)	6	4.60 ~ 4.65 (100% ~ 80%)
6 × 1	4	5.45 ~ 5.51 "	7	5.48 ~ 5.57 "	4	5.45 ~ 5.49 "	4	5.45 ~ 5.50 "	7	5.49 ~ 5.56 "
7 × 1	4	6.45 ~ 6.51 "	7	6.48 ~ 6.57 "	4	6.45 ~ 6.49 (100% ~ 89%)	4	6.45 ~ 6.50 "	7	6.49 ~ 6.56 "
8 × 1.25	5	7.31 ~ 7.38 "	7	7.34 ~ 7.41 (100% ~ 85%)	5	7.31 ~ 7.36 (100% ~ 90%)	7	7.34 ~ 7.40 (100% ~ 87%)	7	7.34 ~ 7.41 (100% ~ 85%)
8 × 1	4	7.45 ~ 7.51 "	7	7.48 ~ 7.57 (100% ~ 80%)	4	7.45 ~ 7.48 (100% ~ 91%)	4	7.45 ~ 7.50 (100% ~ 85%)	7	7.49 ~ 7.56 (100% ~ 80%)
10 × 1.5	5	9.16 ~ 9.22 (100% ~ 90%)	7	9.18 ~ 9.28 (100% ~ 85%)	5	9.16 ~ 9.21 "	7	9.19 ~ 9.24 (100% ~ 90%)	7	9.19 ~ 9.27 (100% ~ 85%)
10 × 1.25	5	9.31 ~ 9.38 (100% ~ 85%)	7	9.34 ~ 9.41 "	5	9.31 ~ 9.36 (100% ~ 90%)	7	9.34 ~ 9.40 (100% ~ 87%)	7	9.34 ~ 9.41 "
10 × 1	5	9.46 ~ 9.52 "	7	9.48 ~ 9.57 (100% ~ 80%)	5	9.47 ~ 9.50 "	5	9.47 ~ 9.52 (100% ~ 85%)	7	9.49 ~ 9.56 (100% ~ 80%)
12 × 1.75	5	11.01 ~ 11.08 (100% ~ 90%)	8	11.05 ~ 11.15 (100% ~ 85%)	5	11.01 ~ 11.07 (100% ~ 91%)	8	11.05 ~ 11.11 (100% ~ 90%)	8	11.05 ~ 11.15 (100% ~ 85%)
12 × 1.5	5	11.16 ~ 11.22 "	7	11.18 ~ 11.28 "	5	11.16 ~ 11.21 "	7	11.19 ~ 11.24 "	7	11.19 ~ 11.27 "
12 × 1.25	5	11.31 ~ 11.38 (100% ~ 85%)	7	11.34 ~ 11.41 "	5	11.31 ~ 11.36 (100% ~ 90%)	7	11.34 ~ 11.40 (100% ~ 87%)	7	11.34 ~ 11.41 "
12 × 1	5	11.46 ~ 11.52 "	7	11.48 ~ 11.57 (100% ~ 80%)	5	11.47 ~ 11.50 "	5	11.47 ~ 11.52 (100% ~ 85%)	7	11.49 ~ 11.56 (100% ~ 80%)
14 × 2	6	12.83 ~ 12.95 (100% ~ 90%)	10	12.92 ~ 13.04 (100% ~ 85%)	6	12.88 ~ 12.93 (100% ~ 92%)	10	12.93 ~ 13.00 (100% ~ 90%)	10	12.93 ~ 13.04 (100% ~ 85%)
14 × 1.5	5	13.16 ~ 13.22 "	9	13.21 ~ 13.30 "	5	13.16 ~ 13.21 (100% ~ 91%)	9	13.21 ~ 13.27 "	9	13.21 ~ 13.30 "
16 × 2	6	14.87 ~ 14.95 "	10	~ 15.04 "	6	14.88 ~ 14.93 (100% ~ 92%)	6	14.88 ~ 14.95 "	10	14.93 ~ 15.04 "
16 × 1.5	5	15.16 ~ 15.22 "	9	15.21 ~ 15.30 (100% ~ 80%)	5	15.16 ~ 15.21 (100% ~ 91%)	9	15.21 ~ 15.27 "	9	15.21 ~ 15.30 "
18 × 2.5	6	16.57 ~ 16.67 "	11	16.63 ~ 16.78 (100% ~ 85%)	6	16.57 ~ 16.64 (100% ~ 92%)	11	16.64 ~ 16.73 "	11	16.64 ~ 16.78 "
18 × 1.5	6	17.17 ~ 17.23 "	10	~ 17.31 "	6	17.18 ~ 17.22 (100% ~ 91%)	6	17.18 ~ 17.23 "	10	17.23 ~ 17.31 "
20 × 2.5	6	18.57 ~ 18.67 "	11	18.63 ~ 18.78 "	6	18.57 ~ 18.64 (100% ~ 92%)	11	18.64 ~ 18.73 "	11	18.64 ~ 18.78 "
20 × 1.5	6	19.17 ~ 19.23 "	10	~ 19.31 "	6	19.18 ~ 19.22 (100% ~ 91%)	6	19.18 ~ 19.23 "	10	19.23 ~ 19.31 "
22 × 2.5	—	—	11	20.63 ~ 20.78 (100% ~ 85%)	—	—	—	—	11	20.63 ~ 20.78 (100% ~ 85%)
22 × 1.5	—	—	10	21.22 ~ 21.31 "	—	21.22 ~ 21.31 "	—	—	10	21.22 ~ 21.31 "
24 × 3	—	—	13	22.36 ~ 22.53 "	—	22.36 ~ 22.53 "	—	—	13	22.36 ~ 22.53 "
24 × 1.5	—	—	10	23.22 ~ 23.31 "	—	23.22 ~ 23.31 "	—	—	10	23.22 ~ 23.31 "
27 × 3	—	—	13	25.36 ~ 25.53 "	—	25.36 ~ 25.53 "	—	—	13	25.36 ~ 25.53 "
30 × 3.5	—	—	14	28.07 ~ 28.25 "	—	28.07 ~ 28.25 "	—	—	10	28.07 ~ 28.25 "
33 × 3.5	—	—	14	31.07 ~ 31.25 "	—	31.07 ~ 31.25 "	—	—	—	31.07 ~ 31.25 "
36 × 4	—	—	15	33.78 ~ 33.99 "	—	33.78 ~ 33.99 "	—	—	15	33.78 ~ 33.99 "
42 × 4.5	—	—	16	39.49 ~ 39.71 "	—	39.49 ~ 39.71 "	—	—	16	39.49 ~ 39.71 "
45 × 4.5	—	—	16	42.49 ~ 42.71 "	—	42.49 ~ 42.71 "	—	—	16	42.49 ~ 42.71 "

## 美制粗牙挤压丝锥推荐底孔

螺纹尺寸 Thread size	2B级螺纹用底孔直径 for JIS class 2B drill hole dia.		3B级螺纹用底孔直径 for JIS class 3B drill hole dia.	
	RH 精度 RH Limits	最小 ~ 最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)	RH 精度 RH Limits	最小 ~ 最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)
No. 1 - 64UNC	3	1.66 ~ 1.7 (100~65)	2	1.65 ~ 1.69 (100~65)
No. 2 - 56	4	1.96 ~ 2.02 (100~65)	3	1.95 ~ 2.01 (100~65)
No. 3 - 48	4	2.25 ~ 2.32 (100~65)	3	2.23 ~ 2.31 (100~65)
No. 4 - 40	5	2.52 ~ 2.6 (100~70)	3	2.5 ~ 2.58 (100~70)
No. 5 - 40	5	2.86 ~ 2.93 (100~70)	3	2.83 ~ 2.91 (100~70)
No. 6 - 32	5	3.09 ~ 3.17 (100~75)	3	3.06 ~ 3.14 (100~75)
No. 8 - 32	5	3.75 ~ 3.83 (100~75)	4	3.74 ~ 3.82 (100~75)
No.10 - 24	6	4.26 ~ 4.35 (100~80)	4	4.24 ~ 4.32 (100~80)
No.12 - 24	6	4.92 ~ 5.01 (100~80)	4	4.9 ~ 4.96 (100~85)
1/4 - 20	6	5.66 ~ 5.76 (100~80)	4	5.64 ~ 5.74 (100~80)
5/16 - 18	7	7.18 ~ 7.29 (100~80)	5	7.15 ~ 7.24 (100~85)
3/8 - 16	7	8.66 ~ 8.78 (100~80)	5	8.63 ~ 8.73 (100~85)
7/16 - 14	7	10.11 ~ 10.25 (100~80)	5	10.08 ~ 10.19 (100~85)
1/2 - 13	8	11.62 ~ 11.78 (100~80)	6	11.6 ~ 11.68 (100~90)
9/16 - 12	10	13.14 ~ 13.27 (100~85)	8	13.11 ~ 13.24 (100~85)

# 螺纹底孔径参数表(嵌套螺纹)

Parameter table of thread bottom hole diameter(Nesting of threads)

# 柄部形状/悬长

SHANK SHAPE/SUSPENDED LENGTH

## 公制粗牙螺纹(切削丝锥)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
M 2 × 0.4 ( 2.520)	2.1	2.17	2.1
2.5 × 0.45 ( 3.085)	2.6	2.65	2.6
2.6 × 0.45 ( 3.185)	2.7	2.75	2.7
3 × 0.5 ( 3.650)	3.12	3.2	3.15
4 × 0.7 ( 4.909)	4.17	4.3	4.2
5 × 0.8 ( 6.039)	5.16	5.33	5.2
6 × 1 ( 7.300)	6.25	6.42	6.3
8 × 1.25 ( 9.624)	8.31	8.52	8.4
10 × 1.5 ( 11.948)	10.37	10.62	10.5
12 × 1.75 ( 14.274)	12.43	12.73	12.5
14 × 2 ( 16.598)	14.49	14.83	14.5
16 × 2 ( 18.598)	16.49	16.83	16.5
18 × 2.5 ( 21.248)	18.58	19.04	19
20 × 2.5 ( 23.248)	20.58	21.04	21
22 × 2.5 ( 25.248)	22.58	23.04	23
24 × 3 ( 27.898)	24.7	25.25	25
27 × 3 ( 30.898)	27.65	28.05	27.8
30 × 3.5 ( 34.547)	30.76	31.2	31

## 公制牙螺纹(切削丝锥)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
M 10 × 1 ( 11.300)	10.25	10.42	10.3
10 × 1.25 ( 11.624)	10.31	10.52	10.4
12 × 1.25 ( 13.624)	12.31	12.52	12.5
12 × 1.5 ( 13.948)	12.37	12.62	12.5
14 × 1.5 ( 15.948)	14.37	14.62	14.5
16 × 1.5 ( 17.948)	16.37	16.62	16.5
18 × 1.5 ( 19.948)	18.37	18.62	18.5
20 × 1.5 ( 21.948)	20.37	20.62	20.5
20 × 2 ( 22.598)	20.47	20.83	20.5
22 × 1.5 ( 23.948)	22.37	22.62	22.5
24 × 1.5 ( 25.948)	24.37	24.62	24.5
24 × 2 ( 26.598)	24.47	24.83	24.5
27 × 1.5 ( 28.948)	27.33	27.56	27.4
30 × 1.5 ( 31.948)	30.37	30.62	30.5

## 美制粗牙螺纹(切削丝锥)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
No 2-56UNC ( 2.773)	2.29	2.39	2.3
No 3-48 ( 3.202)	2.64	2.74	2.7
No 4-40 ( 3.670)	2.95	3.07	3
No 5-40 ( 4.000)	3.25	3.38	3.3
No 6-32 ( 4.536)	3.66	3.81	3.7
No 8-32 ( 5.197)	4.32	4.47	4.4
No 10-24 ( 6.201)	5.05	5.21	5.1
No 12-24 ( 6.861)	5.61	5.77	5.7
1/4-20 ( 8.000)	6.63	6.78	6.7
5/16-18 ( 9.771)	8.33	8.48	8.4
3/8-16 ( 11.587)	9.91	10.11	10
7/16-14 ( 13.469)	11.51	11.76	11.5
1/2-13 ( 15.238)	13.08	13.34	13.1
9/16-12 ( 17.038)	14.68	14.94	14.7
5/8-11 ( 18.875)	16.59	16.84	16.7
3/4-10 ( 22.350)	19.84	20.09	20
7/8-9 ( 25.891)	23.01	23.27	23.1
1-8 ( 29.524)	26.19	26.52	26.4

## 美制细牙螺纹(切削丝锥)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
No 4 - 48UNF ( 3.532)	2.97	3.05	3
No 6 - 40 ( 4.330)	3.66	3.78	3.7
No 8 - 36 ( 5.083)	4.32	4.44	4.4
No 10 - 32 ( 5.857)	4.98	5.13	5
No 12 - 28 ( 6.665)	5.7	5.86	5.8
1/4 - 28 ( 7.528)	6.53	6.71	6.6
5/16 - 24 ( 9.313)	8.2	8.38	8.2
3/8 - 24 ( 10.900)	9.78	9.96	9.8
7/16 - 20 ( 12.762)	11.43	11.63	11.5
1/2 - 20 ( 14.350)	13.03	13.26	13.1
9/16 - 18 ( 16.121)	14.66	14.88	14.7
5/8 - 18 ( 17.708)	16.26	16.48	16.3
3/4 - 16 ( 21.112)	19.43	19.68	19.5
7/8 - 14 ( 24.582)	22.61	22.86	22.7
1 - 12 ( 28.150)	25.76	26.04	26

## 公制螺纹(挤压丝锥)

螺纹尺寸 Thread size	RH精度 RH Limits	最小~最大(嵌合率%) Min.-Max.(Threads Overlap Ratio:%)	
		2	4
2 × 0.4 ( 2.520)	2	2.31 ~ 2.33(100 ~80)	
2.5 × 0.45 ( 3.085)	2	2.84 ~ 2.87(100 ~80)	
2.6 × 0.45 ( 3.185)	2	2.94 ~ 2.97(100 ~80)	
3 × 0.5 ( 3.650)	3	3.39 ~ 3.43(100 ~80)	
4 × 0.7 ( 4.909)	4	4.54 ~ 4.58(100 ~85)	
5 × 0.8 ( 6.039)	4	5.61 ~ 5.66(100 ~85)	
6 × 1 ( 7.300)	4	6.75 ~ 6.81(100 ~85)	

## 公制螺纹(挤压丝锥)

螺纹尺寸 Thread size	RH精度 RH Limits	最小~最大(嵌合率%) Min.-Max.(Threads Overlap Ratio:%)	
		5	5
M 8 × 1.25 ( 9.624)	5	8.93 ~ 9.01 ( 100~85)	
10 × 1.5 ( 11.948)	5	11.11 ~ 11.17 ( 100~90)	
10 × 1.25 ( 11.624)	5	10.93 ~ 11.01 ( 100~85)	
12 × 1.75 ( 14.274)	5	13.28 ~ 13.35 ( 100~90)	
12 × 1.5 ( 13.948)	5	13.11 ~ 13.17 ( 100~90)	
12 × 1.25 ( 13.624)	5	12.93 ~ 13.01 ( 100~85)	

## 柄部四角部形状 Straight shank with flat part

公制螺纹 Metric thread

柄径 DS	四角部分 ek	四角部宽 k
3	5	2.5
4	6	3.2
5	7	4
5.5		4.5
6	8	5
6.1		5.5
6.2		5.5
7	9	6
8		6.5
8.5	10	7
9		7
9.5	11	8
10		8
10.5	12	9
11		9
12	13	10
12.5		10
13	14	11
14		11
15	15	12
16		12
17	16	13
18	17	14
19	18	15

单位:mm Unit:mm

柄径 DS	四角部分 ek	四角部宽 k
20	18	15
21	20	17
22		17
23	22	19
24		19
25	24	21
26		21
28	24	21
30	26	23
32	30	26
35		26
38	32	29
40	35	32
42		32
44	38	35
46		35
48	42	38
50		38
52	44	41
55		41
58	50	46
60		46
65	52	50

美制螺纹 Unified thread

柄径 DS	四角部分 ek	四角部宽 k
3	5	2.5
4	6	3.2
5	7	4
5.5		4.5
6	8	5
6.1		5.5
7	9	6
8		6
8.5	10	6.5
9		7
10.5	11	8
12		9
14	14	11
17		13
20	18	15
22		17
24	22	19
26		21
30	26	23
32		26
35	30	26
38		29
42	35	32
44		32
46	38	35
48		35
50	42	38
52		38
55	44	41
58		41
60	50	46
65		50

管螺纹 Pipe thread

柄径 DS	四角部分 ek	四角部宽 k
8	9	6
11	12	9
14	14	11
18	17	14
19	18	15
23	20	17
24	22	19
26	24	21
28		21
32	30	26
35		26
38	32	29
42	35	32
46	38	35
55	44	41
65	52	50
70	58	54
75	62	58

## ■ 悬长 Length of external center

公制螺纹 Metric thread

尺寸 Size	e	长度 Length
M 1		(0.4)
M 1.1		(0.4)
M 1.2		(0.5)
M 1.4		(0.6)
M 1.6		(0.6)
M 1.7		(0.7)
M 1.8		(0.7)
M 2		(0.8)
M 2.2		(0.8)
M 2.3		(1)
M 2.5		

单位:mm Unit:mm

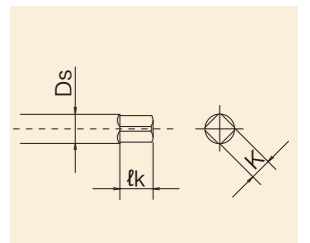
尺寸 Size	e	长度 Length
M 2.6		(1.1)
M 3		(1.2)
M 3.5		(1.5)
M 4		(1.7)
M 4.5		(1.9)
M 5		(2.2)
M 5.5		(2.4)
M 6		(2.6)
M 7		(3.1)
M 8		(3.5)

美制螺纹 Unified thread

尺寸 Size	e	长度 Length
0		(0.6)
No. 1		(0.8)
No. 2		(0.9)
No. 3		(1.1)
No. 4		(1.2)
No. 5		(1.3)
No. 6		(1.5)
No. 8		(1.8)
No. 10		(2.1)
No. 12		(2.4)
U 1/4		

■ 仅POTOnly for spiral pointed taps

※ 悬长是参考值。 ※ The Lengths above are for reference only.



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