



再见了，烂牙！ 追加锥管螺纹

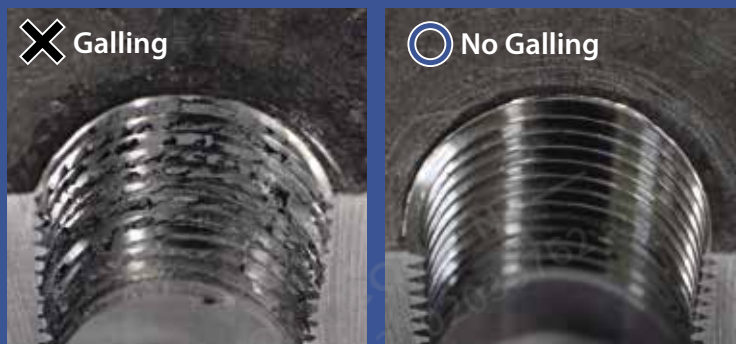
Newly expanded taper pipe tap lineup to help you achieve the perfect thread with no galling!

“即使是锥管螺纹，有没有一把丝锥能够加工出无烂牙的螺纹？”
为了回应客户的需求，我们追加了 A 丝锥管用型丝锥。

封面的内螺纹照片，是分别使用以往型与 A 丝锥在加工 SS400 时的对比图。

Manufacturers have demanded for “a reliable tap for taper pipe threads free of galling.”
We have answered such a calling with the new A-Tap series taper pipe tap lineup.

The images below features a comparison of hole quality between a conventional taper pipe tap and the A-Tap series taper pipe tap in SS400.



加工 SS400 的照片
Image to process taper pipe thread in SS400 material

刃倾角丝锥 通孔用 Spiral Pointed Tap for Through Holes

公制螺纹 Metric Screw Thread

A-POT 39

铣刀柄型 51
End Mill Shank

A-LT-POT 长柄型 47
Long Shank

铣刀柄型 52
End Mill Shank

美制螺纹 Unified Screw Thread

A-POT 46

DIN 规格

DIN Standard

A-SFT 53

A-LT-SFT 58

A-OIL-SFT 59

A-POT 61

A-LT-POT 65

A-TPT 66

A-SFT (A-SPT) 67

A-POT (A-SPT) 68

攻丝刀柄

Tap Holder

SynchroMaster 61

标记种类 Guide for Icons

1 材质 Tool Materials

CPM 粉末高速钢
Powder Metallurgy HSS (CPM)

HSSE 高钒高速钢
High Vanadium HSS

2 表面处理 Surface Treatment

V 涂层
(复合多层涂层)
V (Composite multi-layered) Coating

3 柄部 Shank

SHANK
h7 表示柄部精度
Tolerance for Shank Diameter

4 螺旋角 Helix Angle

45° 表示丝锥螺旋角
Helix angle of flute for taps

5 切削条件 Cutting Conditions

SPEED FEED 表示切削条件表所在页码
Indicates page number for cutting conditions

■ A-SFT・A-LT-SFT・A-OIL-SFT (～ M24、2.5P)

| 切削速度 (m/min) Cutting Speed | | 0 | 10 | 20 | 30 | 40 | 50 | 60 | 70 |
|----------------------------------------------------|------------------|---|---------------------|-------|-------|----|-------|----|----|
| 中・高碳素钢 Medium Carbon Steel High Carbon Steel | S45C | | 5-15 | 15-50 | | | 50-75 | | |
| 合金钢 Alloy Steel | SCM | | 5-10 | 10-15 | 15-30 | | | | |
| 一般构造用钢 Mild Steel | SS400 | | 5-20 ^(*) | | | | | | |
| 不锈钢 Stainless Steel | SUS304 SUS420 | | 5-10 | 10-15 | | | | | |
| 铝 Aluminum | AC ADC | | 5-50 | | | | | | |
| 球墨铸铁 Ductile Cast Iron | FCD | | 5-50 | | | | | | |

■ A-SFT (～ M24、短切削锥型1.5P・1P Short Chamfer) ・A-SFT HL・A-LT-SFT HL

| 切削速度 (m/min) Cutting Speed | | 0 | 10 | 20 | 30 | 40 | 50 | 60 | 70 |
|----------------------------------------------------|------------------|---|---------------------|----|-------|----|----|----|----|
| 中・高碳素钢 Medium Carbon Steel High Carbon Steel | S45C | | 3-15 | | 15-30 | | | | |
| 合金钢 Alloy Steel | SCM | | 3-8 ^(*) | | | | | | |
| 一般构造用钢 Mild Steel | SS400 | | 3-20 ^(*) | | | | | | |
| 不锈钢 Stainless Steel | SUS304 SUS420 | | 3-8 ^(*) | | | | | | |
| 铝 Aluminum | AC ADC | | 3-30 | | | | | | |
| 球墨铸铁 Ductile Cast Iron | FCD | | 3-15 | | | | | | |

■ A-SFT (M27 ～、2.5P) ・A-SFT(U) ・A-SPT(G)

| 切削速度 (m/min) Cutting Speed | | 0 | 10 | 20 | 30 | 40 | 50 | 60 | 70 |
|----------------------------------------------------|------------------|---|---------------------|------|----|----|----|----|----|
| 中・高碳素钢 Medium Carbon Steel High Carbon Steel | S45C | | 3-8 | 8-15 | | | | | |
| 合金钢 Alloy Steel | SCM | | 3-8 | 8-15 | | | | | |
| 一般构造用钢 Mild Steel | SS400 | | 3-15 ^(*) | | | | | | |
| 不锈钢 Stainless Steel | SUS304 SUS420 | | 3-8 | | | | | | |
| 铝 Aluminum | AC ADC | | 3-20 | | | | | | |
| 球墨铸铁 Ductile Cast Iron | FCD | | 3-15 | | | | | | |

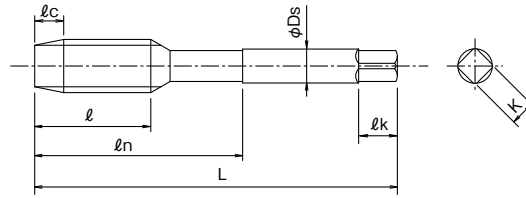
■ A-SFT・A-LT-SFT (铣刀柄型 End Mill Shank)

| 切削速度 (m/min) Cutting Speed | | 0 | 10 | 20 | 30 | 40 | 50 | 60 | 70 |
|----------------------------------------------------|------------------|---|---------------------|-------|-------|----|-------|----|----|
| 中・高碳素钢 Medium Carbon Steel High Carbon Steel | S45C | | 5-15 | 15-50 | | | 50-75 | | |
| 合金钢 Alloy Steel | SCM | | 5-10 | 10-15 | 15-30 | | | | |
| 一般构造用钢 Mild Steel | SS400 | | 5-20 ^(*) | | | | | | |
| 不锈钢 Stainless Steel | SUS304 SUS420 | | 5-10 | 10-15 | | | | | |
| 铝 Aluminum | AC ADC | | 5-50 | | | | | | |
| 球墨铸铁 Ductile Cast Iron | FCD | | 5-75 | | | | | | |

推荐范围 Advisable 可加工范围 Possible

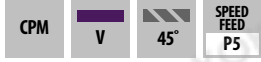


A-SFT HL



- 切削锥长 (l_c) 2.5P、1.5P
Chamfer Length

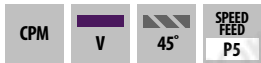
- A-SFT为全尺寸突顶尖去除品
The entire lineup of A-SFT is without external center on the screw side.



螺纹种类：M

单位:mm Unit:mm

| 商品号 EDP No. | 尺寸 Thread Size | 切削锥部 l_c | 精度 TAP Limit | 全长 L | 螺纹部长度 l | 颈长 l_n | 柄径 D_s | 槽数 Flutes | 推荐底孔径 Recommended drill hole dia. | 库存 Stock |
|----------------|-------------------|---------------|-----------------|---------|--------------|-------------|-------------|--------------|-----------------------------------------|-------------|
| 8327751 | M 2 × 0.4 | 2.5P | OH1 | 44 | 3.6 | 13 | 3 | 2 | * | ○ |
| 8327753 | M 2.5 × 0.45 | 2.5P | OH1.5 | 46 | 4 | 19 | 4 | 3 | * | |
| 8327755 | M 2.6 × 0.45 | 2.5P | OH1.5 | 46 | 4 | 19 | 4 | 3 | * | |
| 8327757 | M 3 × 0.5 | 2.5P | OH1.5 | 48 | 4.8 | 20 | 4 | 3 | * | |
| 8327759 | | 1.5P | | | | | | | * | |
| 8327761 | M 4 × 0.7 | 2.5P | OH2 | 60 | 6.4 | 24 | 5.5 | 3 | * | |
| 8327763 | | 1.5P | | | | | | | * | |
| 8327765 | M 5 × 0.8 | 2.5P | OH2 | 62 | 8 | 29 | 6 | 3 | * | |
| 8327767 | | 1.5P | | | | | | | * | |
| 8327769 | M 6 × 1 | 2.5P | OH2 | 65 | 12 | 33 | 6.2 | 3 | * | |
| 8327771 | | 1.5P | | | | | | | * | |
| 8327773 | M 8 × 1.25 | 2.5P | OH2 | 75 | 15 | 41 | 7 | 3 | * | |
| 8327775 | | 1.5P | | | | | | | * | |
| 8327777 | M 10 × 1.5 | 2.5P | OH2 | 82 | 18 | 48 | 8.5 | 3 | * | |
| 8327779 | | 1.5P | | | | | | | * | |
| 8327781 | M 12 × 1.75 | 2.5P | OH2 | 90 | 21 | 48 | 10.5 | 3 | * | |



螺纹种类：U

单位:mm Unit:mm

| 商品号 EDP No. | 尺寸 Thread Size | 切削锥部 l_c | 精度 TAP Limit | 全长 L | 螺纹部长度 l | 颈长 l_n | 柄径 D_s | 槽数 Flutes | 推荐底孔径 Recommended drill hole dia. | 库存 Stock |
|----------------|-------------------|---------------|-----------------|---------|--------------|-------------|-------------|--------------|-----------------------------------------|-------------|
| 8327785 | No.10 - 32UNF | 2.5P | GH2 | 62 | 8 | 29 | 6 | 3 | * | ○ |
| 8327787 | 1/4 - 28UNF | 2.5P | GH2.5 | 70 | 11 | 37 | 6.2 | 3 | * | |
| 8327789 | 5/16 - 24UNF | 2.5P | GH3 | 75 | 13 | 41 | 7 | 3 | * | |
| 8327791 | 3/8 - 24UNF | 2.5P | GH3 | 80 | 13 | 48 | 8 | 3 | * | |

■ 使用上的注意点请参照 p.38.

■ Please refer p.38 for notes/precaution of usage.

优势在这!
Key Point

GH精度 GH Limit

为了对应有高精度要求的航空零部件加工，采用相对于OH精度公差较小的GH精度。
Applied tighter tolerance GH limits to satisfy high precision demand from aerospace threading parts operation.

