

螺纹加工工具选型基准表 THREADING TOOLS SELECTION CHART

钻头
DRILLS

螺纹加工工具
THREADING TOOLS

SELECTION CHART
选型表

量规
GAUGES

索引
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THREAD MILL
螺纹铣刀

TAP HOLDER
攻丝刀柄

通孔 Through Hole

名称 Type	商品记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamber Length (Number of Threads)	攻丝深度 (D: 丝锥大径) Effective Tapping length (D: Thread dia.)			加工材料 Work Material			
					<1.5D	<2.5D	>2.5D	软碳素钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel
One Revolution 螺纹铣刀 One Pass Thread Mill	AT-1	113	EgiAs		◎*1			◎	◎	◎	◎
高硬度钢用带底刃螺纹铣刀 2D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2D Type	AT-2	116	DUROREY	1	◎*2			○	○	○	
高硬度钢用带底刃螺纹铣刀 2.5D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2.5D Type	AT-2	117	DUROREY	1	◎	◎		○	○	○	

盲孔 Blind Hole

名称 Type	商品记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamber Length (Number of Threads)	攻丝深度 (D: 丝锥大径) Effective Tapping length (D: Thread dia.)			加工材料 Work Material			
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高硬度钢用带底刃螺纹铣刀 2.5D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2.5D Type	AT-2	117	DUROREY	1	◎	◎		○	○	○	

OX: with OX TIN: TIN coating V: V coating WX: WX (TiAlN) coating FX: FX (TiAlN) coating CrN: CrN coating N: with Nitride

1. 此表是丝锥在一般条件下的选择标准, 根据使用条件的不同而改变。
2. 使用标准精度的丝锥加工出的螺纹偏小, 或加工电镀前螺纹时, 可使用中径加大型丝锥。
3. 经常检查加工的内螺纹的精度。

1. These recommendations are general, and may be altered depending on tapping conditions.
2. Oversized taps are appropriate when a standard tap produces a thread that is too small, or when tapping before plating.
3. Always check the required thread limit for the internal thread.

NEW

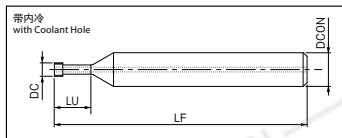
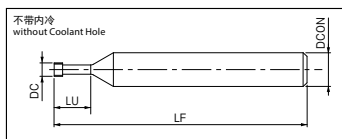
高硬度钢用带底刃螺纹铣刀 2.5D型

THREAD MILL WITH END-CUTTING EDGE FOR HIGH HARDNESS STEELS 2.5D TYPE



AT-2

切削条件 Cutting Conditions | P.124



因为是左刀，所以请主轴逆转使用。
Spindle will rotate counterclockwise due to the left-hand cut configuration.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	加工径 Cutting Bore Dia.	最大加工径 ^{※1} Max. Cutting Bore Dia.	外径 DC	全长 LF	最大螺纹长 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331207	M 3×0.5	4.2	2.4	50	7.5	8.7	6	4	—	●	—
8331208	M 4×0.7	5.3	3.1	50	10	11.7	6		—	●	—
8331209	M 5×0.8	7	4	50	12.5	14.5	6		—	●	—
8331210	M 6×1	8	4.6	50	15	17.5	6		—	●	—
8331211	M 8×1.25	10.9	6.2	70	20	23.1	10		—	●	—
8331212	M10×1.5	13.2	7.5	70	25	28.7	10		○	●	—
8331213	M12×1.75	15.9	9	80	30	34.3	10		○	●	—
	M16×2	21.1	11.7	100	40	45	12		○	●	—
	M18×2.5	25.1	14	135	45	51.2	16		○	※	—
	M20×2.5	28.5	15.7	135	50	56.2	16		○	※	—

※=受注生产品 ※=Special order item ○=Yes

AT-2为内螺纹加工专用。

1. ThreadPro的路径类型请选择“单刃进给”

※1. 螺旋铣孔和螺纹铣削同时加工时的最大值。

加工超过最大加工径的内螺纹尺寸时，请进行底孔加工。

AT-2 is only for milling internal threads.

1. Please select "Single-feed" for the path type in ThreadPro.

※1. This is the maximum value when helical drilling and threading take place at the same time. Please make a pilot hole when machining an internal thread size that exceeds the maximum bore diameter.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	加工径 Cutting Bore Dia.	最大加工径 ^{※1} Max. Cutting Bore Dia.	外径 DC	全长 LF	最大螺纹长 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
	No. 8 - 32UNC	4.7	3.1	50	10.42	12.4	6	4	—	※	—
	No.10 - 24UNC	6.1	3.7	70	12.07	14.7	6		—	※	—
	1/4 - 20UNC	7.6	4.55	70	15.88	19	6		—	※	—
	1/4 - 28UNF	8	4.55	70	15.88	18.1	6		—	※	—
	3/16 - 18UNC	9.7	5.7	80	19.85	23.3	10		—	※	—
	3/8 - 16UNC	11.6	6.7	80	23.81	27.7	10		—	※	—
	7/16 - 14UNC	13.3	7.7	80	27.78	32.3	10		○	※	—
	1/2 - 13UNC	16.2	9.2	80	31.75	36.6	10		○	※	—

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加工材料 Work Material	低碳素钢 Low Carbon Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel					不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝合金 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	软钢	中碳钢	高碳钢	合金钢	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM																						
AT-2	○	○	○		○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

库存记号 Inventory symbols

● = 标准库存品 Standard stock item
○ = 准标准库存品 (请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代 (请确认库存。) Scheduled to be replaced by new product or successor item

□ = 特定代理店库存品 Stocked by specific distributors. Contact us for price & availability.

△ = 停产产品 (请确认库存。) Discontinued item

■ 标识说明请参考P1页。 See p.1 for explanation of icons.