

丝锥选型基准表 TAP SELECTION CHART



通孔 Through Hole

加工材料 Work Material	攻丝深度 (D: 丝锥大径) Effective Tapping length (D: Thread dia.)			表面处理 Surface Treatment	登记页码 Page No.	丝锥记号 Symbol	名称 Type	切削锥(牙数) Chamber Length (Number of Threads)	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	
	C ~0.25%	C 0.25% ~0.45%	C 0.45%~						SCM	
	<1.5D	<2.5D	>2.5D							
直槽丝锥 Straight Fluted Taps	铸件用零前角 V coated for Die castings	VP-DC-HT	748	V	1.5	○	○	○		
	铸件用零前角带内冷 V Coated · For Die Castings · With Internal Coolant Supply	VO-DC-HT	748	V	1.5	○	○	○		
	高硬度钢用 For High Strength Steels	EX-SH-HT	749		5	○	○		○	○
	高硬度钢用 For Hardened Steels (42-52 HRC)	V-XPM-HT	750	V	5	○				
	高硬度钢用 Carbide Straight Fluted-for Hardened Steels (50HRC~)	VX-OT	752	V	3	○				
	高硬度钢 (~55HRC)用 Carbide Straight Fluted-for Hardened Steels (55HRC~)	WH55-OT	751	WXS	5	○				
	螺纹修补用 Spatter Remove Hand Tap	SR-HT	812		5	○	○		○	○
行星铣刀 PLANET CUTTER	One Revolution 螺纹铣刀 One Pass Thread Mill	AT-1	495	EgiAs		○	*2		○	○
	小径螺纹铣刀 Carbide Small Diameter PLANET CUTTER	WH-VM-PNC	498	WXS		○			○	○
	钢用 NC 螺纹铣刀 Carbide PLANET CUTTER for Steels	WX-ST-PNC	499~500	WX		○			○	○
	内冷油孔钢用螺纹铣刀 Carbide PLANET CUTTER for Steels with Internal Coolant Supply	WXO-ST-PNC	501	WX		○			○	○
	NC 螺纹铣刀 Carbide PLANET CUTTER for Nonferrous Metal and Heat-Resistant Alloy	WX-PNC	502~505	WX		○				
	螺纹铣刀 HSS PLANET CUTTER	PNGT	506~507	TiN		○			○	○
	内冷油孔超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling with Internal Coolant Supply	DR-O-PNAC	509	FX		○	*3			
	超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling	DR-PNAC	508	FX		○	*3			
A-TAP 锥管螺纹用 A-TAP Taper Pipe Threads	A-TPT	753, 791	V	2.5	○	○	○	○	○	○
A-TAP 锥管螺纹用短螺纹型 A-TAP Taper Pipe Threads (Short Thread)	A-S-TPT	754	V	2.5	○	○		○	○	○
一般用 General Application	TPT	756, 793~794		2.5	○	○			○	○
一般用短螺纹 General Application (Short Thread)	S-TPT	756, 793~794		2.5	○	○			○	○
一般用氧化处理 General Application (with OX)	H-TPT	757	氧化 OX	2.5	○	○			○	○
一般用短螺纹氧化处理 General Application (with OX, Short Thread)	H-S-TPT	757	氧化 OX	2.5	○	○			○	○
一般用长柄型 Long Shank-General Application	LT-TPT	758		2.5	○	○			○	○
一般用短螺纹长柄型 Long Shank-General Application (Short Thread)	LT-S-TPT	758		2.5	○	○			○	○
高硬度钢用 For High Strength Steels	V-XPM-TPT	761	V	3	○					
高硬度钢用硬质合金锥管丝锥 Taper pipe thread tap for hardened steel	VX-TPT	762	V	3	○					
TiN 涂层 TiN coated	TiN-TPT	763	TiN	2.5	○	○			○	○
TiN 涂层短螺纹 TiN coated (Short Thread)	TiN-S-TPT	763	TiN	2.5	○	○			○	○
TiN 涂层长柄型 TiN coated-Long Shank	TiN-LT-TPT	764	TiN	2.5	○	○			○	○
TiN 涂层短螺纹长柄型 TiN coated-Long Shank (Short Thread)	TiN-LT-S-TPT	764	TiN	2.5	○	○			○	○
难加工材料用 For Difficult to Machine Materials	CPM-TPT	765		2.5	○	○				○
难加工材料短螺纹型 For Difficult to Machine Materials(Short Thread)	CPM-S-TPT	766		2.5	○	○				○
难加工材料短螺纹长柄型 Long Shank: For Difficult to Machine Materials(Short Thread)	CPM-LT-S-TPT	766		2.5	○	○				○
软钢用 For Mild Steels	STL-TPT	767	氧化 OX	2.5	○	○			○	○
软钢用短螺纹 For Mild Steels (Short Thread)	STL-S-TPT	767	氧化 OX	2.5	○	○			○	○
带内冷油孔 With Internal Coolant Supply	OIL-TPT	768	氧化 OX	2.5	○	○			○	○
V 涂层铝用 For Aluminum Alloy	V-AL-TPT	768	V	2.5	○	○				

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

- 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。
- 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。
- 经常检查加工的内螺纹的精度。
- 丝锥的精度不能保证内螺纹的精度。

- These recommendations are general, and may be altered depending on tapping conditions.
- Oversized taps are appropriate when a standard tap produces a thread that is too small, or when tapping before plating.
- Always check the required thread limit for the internal thread.
- TAP LIMIT does not guarantee thread limit for the internal thread after tapping.

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ○Excellent ○适用的丝锥 ○Good

通孔 Through Hole



加工材料 Work Material				不锈钢	工具钢	铸钢	铸铁	球墨铸铁	铜	黄铜	黄铜铸件	青铜	铝	铝合金	镁合金	锌合金	钛合金	镍合金	热塑性塑料	热固性塑料	热塑性塑料
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			酚醛树脂类 Bakelite Phenol	聚四氟乙烯 Teflon	聚氯乙烯 Vinyl Chloride Nylon
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							◎	◎					○	◎	◎	◎					
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	○*1	◎																			
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													◎	◎							○

5. 攻丝深度，减去丝锥的切削锥部长度为有效螺纹长度。
 6. 此表以外的丝锥请联系OSG代理店。
 ※1 对应40HRC以上加工材料。
 ※2 M·U螺纹用丝锥仅可加工至2D。详细请确认尺寸表。
 ※3 可加工至2D。

5. Tapping depth minus chamfer length is an effective tapped thread length.
 6. For other special-purpose taps, contact your nearest agent or distributor.
 ※1 We recommend 40HRC and over for the tapping process by WH55-OT.
 ※2 Only taps for M·U threads are suitable for up to 2D. Please refer to the dimension table for details.
 ※3 Suitable for up to 2D.

DRILLS 钻头

TAPS 丝锥

SELECTION CHART 选定表

GAUGES 量规

ROUND Dies 板牙

ROLLING Dies 滚造工具

OTHER PRODUCTS 各种产品

INDEX 索引

THREAD MILL 螺纹铣刀

FLUTELESS TAP 挤压丝锥

SPIRAL FLUTED TAP 螺旋槽丝锥

SPIRAL POINTED TAP 刃倾角丝锥

HAND TAP 直槽丝锥

TAPER PIPE THREADS (UK) 锥管螺纹用丝锥 (英式)

PARALLEL PIPE THREADS (UK) 平行管螺纹用丝锥 (英式)

TAPER PIPE THREADS (ANSI) 锥管螺纹用丝锥 (美式)

PARALLEL PIPE THREADS (ANSI) 平行管螺纹用丝锥 (美式)

INSERT SCREW THREAD TAP 嵌套螺纹用丝锥

NUT TAP 螺母丝锥

MACHINING CENTER TAP 加工中心用丝锥

DRILL TAP 钻攻一体丝锥

丝锥选型基准表 TAP SELECTION CHART



盲孔 Blind Hole

钻头 DRILL BIT	丝锥 TAP	名称 Type	丝锥记号 Symbol	登记页码 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	低 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	合 金 钢 SCM	
															C ~0.25%
PLANET CUTTER 行星铣刀	行星铣刀 PLANET CUTTER	NC 螺纹铣刀 Carbide PLANET CUTTER for Nonferrous Metal and Heat-Resistant Alloy	WX-PNC	502 ~ 505	WX		○			○					
		螺纹铣刀 HSS PLANET CUTTER	PNGT	506 ~ 507	TiN		○			○	○	○	○		
		内冷油孔超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling with Internal Coolant Supply	DR-O-PNAC	509	FX		○*2								
PLANET CUTTER 行星铣刀	行星铣刀 PLANET CUTTER	超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling	DR-PNAC	508	FX		○*2								
		A-TAP 推管螺纹用 A-TAP	A-TPT	753, 791	V	2.5	○	○	○	○	○	○	○	○	○
		A-TAP 推管螺纹用短螺纹型 A-TAP (Short Thread)	A-S-TPT	754, 792	V	2.5	○	○	○	○	○	○	○	○	○
ROLLING DIE 滚压工具	滚压工具 ROLLING DIE	一般用 General Application	TPT	755 ~ 756, 793 ~ 794		2.5	○	○			○	○			
		一般用短螺纹 General Application (Short Thread)	S-TPT	756, 793 ~ 794		2.5	○	○			○	○			
		一般用氧化处理 General Application (with OX)	H-TPT	757	氧化 OX	2.5	○	○			○	○		○	
OTHER PRODUCTS 其他产品	其他产品 OTHER PRODUCTS	一般用短螺纹氧化处理 General Application (with OX, Short Thread)	H-S-TPT	757	氧化 OX	2.5	○	○			○	○		○	
		一般用长柄型 Long Shank-General Application	LT-TPT	758		2.5	○	○			○	○		○	
		一般用短螺纹长柄型 Long Shank-General Application (Short Thread)	LT-S-TPT	758		2.5	○	○			○	○		○	
ROCKET 火箭	火箭 ROCKET	螺旋槽型 Spiral Fluted	SFT-TPT	759, 795		2.5	○	○			○	○		○	
		螺旋槽型长柄型 Spiral Fluted (Long Thread)	SFT-S-TPT	759		2.5	○	○			○	○		○	
		螺旋槽型丝锥长柄型 Long Shank-Spiral	LT-SFT-TPT	760		2.5	○	○			○	○		○	
THREAD MILL 螺纹铣刀	螺纹铣刀 THREAD MILL	螺旋槽型丝锥短螺纹长柄型 Long Shank-Spiral(Short Thread)	LT-SFT-S-TPT	760		2.5	○	○			○	○		○	
		高硬度钢用 For High Strength Steels	V-XPM-TPT	761	V	3	○								
		高硬度钢用推管螺纹丝锥 Taper Pipe Thread Tap for Hardened Steel	VX-TPT	762	V	3	○								
FLUTELESS TAP 挤压丝锥	挤压丝锥 FLUTELESS TAP	TiN 涂层 TiN coated	TiN-TPT	763	TiN	2.5	○	○			○	○		○	
		TiN 涂层短螺纹 TiN coated (Short Thread)	TiN-S-TPT	763	TiN	2.5	○	○			○	○		○	
		TiN 涂层长柄型 TiN coated-Long Shank	TiN-LT-TPT	764	TiN	2.5	○	○			○	○		○	
SPIRAL POINTED TAP 刀倾角丝锥	刀倾角丝锥 SPIRAL POINTED TAP	TiN 涂层短螺纹长柄型 TiN coated-Long Shank (Short Thread)	TiN-LT-S-TPT	764	TiN	2.5	○	○			○	○		○	
		难加工材料用 For Difficult to Machine Materials	CPM-TPT	765		2.5	○	○						○	
		难加工材料用短螺纹 For Difficult to Machine Materials(Short thread)	CPM-S-TPT	766		2.5	○	○						○	
HAND TAP 直槽丝锥	直槽丝锥 HAND TAP	难加工材料用长柄短螺纹 Long Shank- for Difficult to Machine Materials(Short thread)	CPM-LT-S-TPT	766		2.5	○	○						○	
		软钢用 For Mild Steels	STL-TPT	767	氧化 OX	2.5	○	○			○	○		○	
		软钢用短螺纹 For Mild Steels (Short Thread)	STL-S-TPT	767	氧化 OX	2.5	○	○			○	○		○	
PARALLEL PIPE THREADS (UK) 平行管螺纹用丝锥(英式)	平行管螺纹用丝锥(英式) PARALLEL PIPE THREADS (UK)	带内冷油孔 With Internal Coolant Supply	OIL-TPT	768	氧化 OX	2.5	○	○			○	○		○	
		V 涂层铝用 For Aluminum Alloy	V-AL-TPT	768	V	2.5	○	○							
		铸铁用 For Cast Iron	EX-FC-TPT	769	氮化 N	2.5	○	○							
PARALLEL PIPE THREADS (ANSI) 平行管螺纹用丝锥(美式)	平行管螺纹用丝锥(美式) PARALLEL PIPE THREADS (ANSI)	锥管螺纹丝锥 Carbide For Taper Pipe Threads	OT-TPT	770		2.5	○	○							
		锥管螺纹丝锥短螺纹 Carbide For Taper Pipe Threads (Short Thread)	OT-S-TPT	770		2.5	○	○							
		锥管螺纹丝锥长柄型 Carbide Long Shank-for Taper Pipe Threads	OT-LT-TPT	771		2.5	○	○							
INSERT SCREW THREAD TAP 嵌套螺纹用丝锥	嵌套螺纹用丝锥 INSERT SCREW THREAD TAP	不锈钢用 For Stainless Steels	EX-SUS-TPT	772	氧化 OX	2.5	○	○							
		不锈钢用短螺纹 For Stainless Steels (Short Thread)	EX-SUS-S-TPT	772	氧化 OX	2.5	○	○							
		不锈钢用长柄型 Long Shank-for Stainless Steels	LT-SUS-TPT	773	氧化 OX	2.5	○	○							
NUT TAP 螺母丝锥	螺母丝锥 NUT TAP	不锈钢用短螺纹长柄 Long Shank-for Stainless Steels (Short Thread)	LT-SUS-S-TPT	773	氧化 OX	2.5	○	○							
		DRILL TAP 钻攻一体丝锥	DRILL TAP												

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

- 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。
- 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。
- 经常检查加工的内螺纹的精度。

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

丝锥选型基准表 TAP SELECTION CHART

盲孔 Blind Hole



◎最适合丝锥 ○Excellent ○适用的丝锥 ○Good

加工材料 Work Material					不锈钢	工具钢	铸钢	铸铁	球墨铸铁	铜	黄铜	黄铜铸件	青铜	铝	铝合金铸件	镁合金铸件	锌合金铸件	钛合金	镍合金	热硬化塑料	热塑性塑料	热塑性塑料
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			(酚醛树脂类) Bakelite Phenol	聚乙烯 Vinyl Chloride	尼龙 Nylon	
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																					◎	

4. 丝锥的精度不能保证内螺纹的精度。
 5. 攻丝深度，减去丝锥的切削锥部长度为有效螺纹长。
 6. 此表以外的丝锥请联系OSG代理店。
 ※1 对应40HRC以上加工材料。
 ※2 M·U 螺纹用丝锥仅可加工至2D。详细请确认尺寸表。

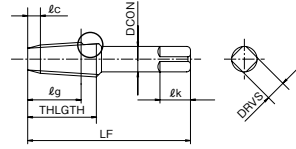
4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.
 5. Tapping depth minus chamfer length is an effective tapped thread length.
 6. For other special-purpose taps, contact your nearest agent or distributor.
 ※1 We recommend 40HRC and over for the tapping process by WH55-OT.
 ※2 Suitable for up to 2D.

钻头 DRILLS
 丝锥 TAPS
 SELECTION CHART
 选定表
 量规 GAUGES
 圆孔钻头 ROUND DRILLS
 滚压工具 ROLLING DRILLS
 各种产品 OTHER PRODUCTS
 索引 INDEX
 螺纹铣刀 THREAD MILL
 挤压丝锥 FLUTELESS TAP
 螺旋槽丝锥 SPIRAL FLUTED TAP
 刃倾角丝锥 SPIRAL POINTED TAP
 直槽丝锥 HAND TAP
 锥管螺纹用丝锥 TAPER PIPE THREADS (UK)
 平行管螺纹用丝锥 PARALLEL PIPE THREADS (UK)
 锥管螺纹用丝锥 TAPER PIPE THREADS (ANSI)
 平行管螺纹用丝锥 PARALLEL PIPE THREADS (ANSI)
 嵌套螺纹用丝锥 INSERT SCREW THREAD TAP
 螺母丝锥 NUT TAP
 加工中心用丝锥 MACHINING CENTER TAP
 钻攻一体丝锥 DRILL TAP

难加工材料用

FOR DIFFICULT TO MACHINE MATERIALS

CPM-TPT



CPM

螺纹种类：PT(Rc)

商品号 EDP NO.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309102	1/8 - 28			55	19	13	8			23
8309103	1/4 - 19	JIS2	2.5P	62	28	21	11	4	●	48
8309104	3/8 - 19			65	28	21	14			69

■ 突顶尖尖·柄部四方尺寸 ℓk , DRVS 请参考 P.963.

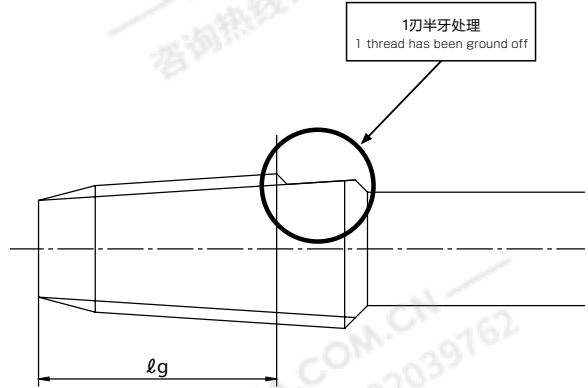
1. 基准位置 (ℓg) 后1刃进行半牙处理。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.958。

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309105	1/2 - 14			80	35	25	18			136
8309106	3/4 - 14	JIS2	2.5P	85	35	25	23	4	●	237
8309108	1 - 11			95	45	32	26			356

■ Please see p.963 for length of external center and shank square length ℓk and width DRVS.

1. Threads on one of cutting edges has been ground off from the ℓg .
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.958.



钻头
DRILL

量规
GAGE

圆孔
ROUND BORE

滚压工具
ROLLING TOOL

各种产品
OTHER PRODUCTS

索引
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螺纹铣刀
THREAD MILL

无屑挤压丝锥
FLUTELESS TAP

螺旋槽丝锥
SPIRAL FLUTED TAP

刀倾角丝锥
SPIRAL POINTED TAP

直槽丝锥
HAND TAP

锥管螺纹用丝锥(英式)
TAPER PIPE THREADS (UK)

平行管螺纹用丝锥(英式)
PARALLEL PIPE THREADS (UK)

锥管螺纹用丝锥(美式)
TAPER PIPE THREADS (ANSI)

平行管螺纹用丝锥(美式)
PARALLEL PIPE THREADS (ANSI)

嵌套螺纹用丝锥
INSERT SCREW THREAD TAP

螺母丝锥
NUT TAP

加工中心用丝锥
MACHINING CENTER TAP

钻攻一体丝锥
DRILL TAP

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	热塑性塑料 Thermo Plastic
	C	C0.25%~0.45%	C	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	ACADC	MC	ZDC				
商品代号 Abbreviation	C	C0.25%~0.45%	C	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	ACADC	MC	ZDC				
CPM-TPT			○									○	○									○	○		

●=标准库存品 ●=Standard stock item. □=特定代理店库存品 □=Stocked by specific distributors. Contact us for price & availability.