

# 丝锥选型基准表 TAP SELECTION CHART



通孔 Through Hole

| SELECTION CHART<br>选定表                                     | 名称<br>Type   | 丝锥记号<br>Symbol             | 登记页码<br>Page No. | 表面处理<br>Surface Treatment | 切削锥(牙数)<br>Chamber Length<br>(Number of Threads) | 攻丝深度<br>(D:丝锥大径)<br>Effective Tapping length<br>(D:Thread dia.) |       |       | 加工材料 Work Material                     |                                |                              |                    |   |
|--|--|----------------------------|------------------|---------------------------|--|---|-------|-------|--|--------------------------------|------------------------------|--------------------|---|
|  |  |                            |                  |                           |  | <1.5D   | <2.5D | >2.5D | 低碳素钢<br>Low Carbon Steel<br>Mild Steel | 中碳素钢<br>Medium Carbon<br>Steel | 高碳素钢<br>High Carbon<br>Steel | 合金钢<br>Alloy Steel |   |
|  |  |                            |                  |                           |  |   |       |       | C<br>~0.25%                            | C0.25%<br>~0.45%               | C<br>0.45%~                  | SCM                |   |
| 挤压丝锥<br>Fluteless Taps                                     | TiN 涂层长柄型<br>TiN coated-Long Shank                   | TIN-LT-NRT                 | 550              | TiN                       | 4  | ○   | ○     | ○     | ○                                      | ○                              | ○                            | ○                  | ○ |
|  | 钢用<br>For Steels                                     | NRT                        | 551~553          | 氧化<br>OX                  | 4  | ○   | ○     | ○     | ○                                      | ○                              | ○                            | ○                  | ○ |
|  | 钢用长柄型<br>Long Shank-for Steel                        | LT-NRT                     | 554              | 氧化<br>OX                  | 2  | ○   | ○     | ○     | ○                                      | ○                              | ○                            | ○                  | ○ |
|  | NRT 型丝锥<br>Carbide Fluteless (Nu-Roll)               | OT-NRT                     | 555              |                           | 4  | ○   | ○     | ○     | ○                                      | ○                              | ○                            | ○                  | ○ |
|  | NRT 型丝锥长柄型<br>Carbide Long Shank-Fluteless (Nu-Roll) | OT-LT-NRT                  | 556              |                           | 4  | ○   | ○     | ○     | ○                                      | ○                              | ○                            | ○                  | ○ |
|  | 非铁合金用<br>For Non-Ferrous Metals                      | B-NRT                      | 557~560          | 氮化<br>N                   | 4  | ○   | ○     | ○     |  |                                |                              |                    |   |
|  | 非铁合金用长柄型<br>Long Shank-for Non-Ferrous Metals        | LT-B-NRT                   | 561              | 氮化<br>N                   | 2  | ○   | ○     | ○     |  |                                |                              |                    |   |
|  | 铜用<br>For Copper                                     | CU-NRT                     | 562              | CrN                       | 2  | ○   | ○     | ○     |  |                                |                              |                    |   |
|  | 铝用高速同步型<br>Synchro Taps for Aluminum                 | HS-AL-NRT                  | 563              |                           | 4  | ○   | ○     | ○     |  |                                |                              |                    |   |
|  | 超高速同步进给 NRT 型<br>Ultra Synchro Taps for Aluminum     | US-AL-NRT                  | 564              | V                         | 2  | ○   | ○     | ○     |  |                                |                              |                    |   |
|  | 钢用<br>For Steels                                     | HRT                        | 566              | 氧化<br>OX                  | 4  | ○   | ○     | ○     | ○                                      | ○                              | ○                            | ○                  | ○ |
|  | 非铁合金用<br>For Non-Ferrous Metals                      | B-HRT                      | 567~568          |                           | 4  | ○   | ○     | ○     |  |                                |                              |                    |   |
|  | 直槽丝锥<br>Straight Fluted Taps                         | 一般用<br>General Application | HT               | 687~719                   |  | 5   | ○     | ○     |  |                                | ○                            |                    |   |
| 一般用(4槽)<br>General Application (4F)                        |  | HT-4F                      | 720              |                           | 5  | ○   | ○     |       |  | ○                              |                              |                    |   |
| 一般用(3槽)<br>General Application (3F)                        |  | HT-3F                      | 721              |                           | 5  | ○   | ○     |       |  | ○                              |                              |                    |   |
| 中径加大型<br>Oversize  |  | EX-OST                     | 722              |                           | 5  | ○   | ○     |       |  | ○                              |                              | ○                  |   |
| 一般用长柄型<br>Long Shank-General Application                   |  | EX-LT                      | 723~727          |                           | 5  | ○   | ○     |       |  | ○                              |                              | ○                  |   |
| 中径加大长柄型<br>Long Shank-Oversize                             |  | EX-LT-OST                  | 728              |                           | 5  | ○   | ○     |       |  | ○                              |                              | ○                  |   |
| 一般用氧化处理<br>General Application (with OX)                   |  | H-HT                       | 729              | 氧化<br>OX                  | 5  | ○   | ○     |       | ○                                      | ○                              | ○                            | ○                  |   |
| 一般用氧化处理长柄型<br>Long Shank-General Application (with OX)     |  | EX-H-LT                    | 730              | 氧化<br>OX                  | 5  | ○   | ○     |       | ○                                      | ○                              | ○                            | ○                  |   |
| 深孔用(细柄型)<br>For Deep Holes (Slim Shank)                    |  | EX-SST                     | 731              |                           | 5  | ○   | ○     |       |  | ○                              |                              | ○                  |   |
| V 涂层长柄型<br>V coated-Long Shank                             |  | V-LT                       | 732              | V                         | 5  | ○   | ○     |       | ○                                      | ○                              | ○                            | ○                  |   |
| TiN 涂层<br>TiN coated                                       |  | TIN-HT                     | 733              | TiN                       | 5  | ○   | ○     |       | ○                                      | ○                              | ○                            | ○                  |   |
| TiN 涂层长柄型<br>TiN coated-Long Shank                         |  | TIN-LT                     | 734              | TiN                       | 5  | ○   | ○     |       | ○                                      | ○                              | ○                            | ○                  |   |
| 难加工材料用<br>For Difficult to Machine Materials               |  | CPM-HT                     | 735              |                           | 5  | ○   | ○     |       |  |                                | ○                            |                    |   |
| 难加工材料用长柄型<br>Long Shank-for Difficult to Machine Materials |  | CPM-LT                     | 736              |                           | 5  | ○   | ○     |       |  |                                | ○                            |                    |   |
| 带内冷油孔<br>With Internal Coolant Supply                      |  | OIL-HT                     | 737              | 氧化<br>OX                  | 5  | ○   | ○     | ○     | ○                                      | ○                              | ○                            | ○                  |   |
| 不锈钢用<br>For Stainless Steels                               |  | EX-SUS-HT                  | 738              | 氧化<br>OX                  | 5  | ○   | ○     |       |  |                                |                              |                    |   |
| 铸铁用<br>For Cast Iron                                       |  | EX-FC-HT                   | 739              | 氮化<br>N                   | 3  | ○   | ○     | ○     |  |                                |                              |                    |   |
| 铸铁用长柄型<br>Long Shank-for Cast Iron                         |  | EX-FC-LT                   | 740              | 氮化<br>N                   | 3  | ○   | ○     | ○     |  |                                |                              |                    |   |
| 直槽丝锥<br>Straight Fluted                                    |  | OTT                        | 741              |                           | 3  | ○   | ○     | ○     |  |                                |                              |                    |   |
| 直槽丝锥长柄型<br>Long Shank-Straight Fluted                      |  | LT-OTT                     | 742              |                           | 3  | ○   | ○     | ○     |  |                                |                              |                    |   |
| 铝用<br>For Aluminium  | AL-HT  | 743                        |                  | 3                         | ○  | ○   | ○     |       |  |                                |                              |                    |   |
| 树脂用<br>For Plastic / Resin                                 | EX-PLA-HT  | 743                        | 氮化<br>N          | 3                         | ○  | ○   | ○     |       |  |                                |                              |                    |   |
| 铸件用<br>For Die Castings                                    | EX-DC-HT   | 744                        | 氮化<br>N          | 3                         | ○  | ○   | ○     |       |  |                                |                              |                    |   |
| 硬质合金铸件用<br>Straight Fluted-for Die Castings                | OT-DC-HT   | 747                        |                  | 3                         | ○  | ○   | ○     |       |  |                                |                              |                    |   |

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。

- 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.



# 丝锥选型基准表 TAP SELECTION CHART



盲孔 Blind Hole

| 名称<br>Type  | 丝锥记号<br>Symbol  | 登记页码<br>Page No. | 表面处理<br>Surface Treatment | 切削锥(牙数)<br>Chamber Length<br>(Number of Threads) | 攻丝深度<br>(D:丝锥大径)<br>Effective Tapping length<br>(D:Thread dia.) |       |       | 加工材料 Work Material                     |                                |                              |                    |            |
|---|---|------------------|---------------------------|--|---|-------|-------|--|--------------------------------|------------------------------|--------------------|------------|
|   |   |                  |                           |  | <1.5D   | <2.5D | >2.5D | 低碳素钢<br>Low Carbon Steel<br>Mild Steel | 中碳素钢<br>Medium Carbon<br>Steel | 高碳素钢<br>High Carbon<br>Steel | 合金钢<br>Alloy Steel | 合金钢<br>SCM |
|   |   |                  |                           |  |   |       |       | C<br>~0.25%                            | C0.25%<br>~0.45%               | C<br>0.45%~                  |                    |            |
| 中径加大型用<br>Oversize  | EX-OST  | 722              |                           | 1.5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| 一般用长柄型<br>Long Shank-General Application                              | EX-LT   | 723~727          |                           | 1.5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| 中径加大长柄型<br>Long Shank-Oversize  | EX-LT-OST   | 728              |                           | 1.5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| 一般用氧化处理<br>General Application (with OX)                              | H-HT  | 729              | 氧化<br>OX                  | 1.5  | ○   | ○     | ○     |  |                                |                              | ○                  |            |
| 一般用氧化处理长柄型<br>Long Shank-General Application (with OX)                | EX-H-LT   | 730              | 氧化<br>OX                  | 1.5  | ○   | ○     | ○     |  |                                |                              | ○                  |            |
| 深孔用(细柄型)<br>For Deep Holes (Slim Shank)                               | EX-SST  | 731              |                           | 1.5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| V涂层长柄型<br>V coated-Long Shank   | V-LT  | 732              | V                         | 1.5  | ○   | ○     | ○     |  | ○                              |                              | ○                  |            |
| TiN涂层<br>TiN coated   | TIN-HT  | 733              | TiN                       | 1.5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| TiN涂层长柄型<br>TiN coated-Long Shank                                     | TIN-LT  | 734              | TiN                       | 1.5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| 难加工材料用<br>For Difficult to Machine Materials                          | CPM-HT  | 735              |                           | 2  | ○   | ○     |       |  |                                |                              | ○                  |            |
| 难加工材料用长柄型<br>Long Shank-for Difficult to Machine Materials            | CPM-LT  | 736              |                           | 2  | ○   | ○     |       |  |                                |                              | ○                  |            |
| 带内冷油孔<br>With Internal Coolant Supply                                 | OIL-HT  | 737              | 氧化<br>OX                  | 1.5  | ○   | ○     | ○     |  | ○                              |                              | ○                  |            |
| 不锈钢用<br>For Stainless Steels  | EX-SUS-HT   | 738              | 氧化<br>OX                  | 1.5  | ○   | ○     |       |  |                                |                              | ○                  |            |
| 铸铁用<br>For Cast Iron  | EX-FC-HT  | 739              | 氮化<br>N                   | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
|   |   |                  |                           | 3  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 铸铁用长柄型<br>Long Shank-for Cast Iron                                    | EX-FC-LT  | 740              | 氮化<br>N                   | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
|   |   |                  |                           | 3  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 直槽丝锥<br>Carbide Straight Fluted                                       | OTT   | 741              |                           | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 直槽丝锥长柄型<br>Carbide Long Shank-Straight Fluted                         | LT-OTT  | 742              |                           | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 铝用<br>For Aluminium   | AL-HT   | 743              |                           | 1.5  | ○   | ○     |       |  |                                |                              |                    |            |
| 树脂用<br>For Plastic / Resin  | EX-PLA-HT   | 743              | 氮化<br>N                   | 3  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 铸件用<br>For Die Castings   | EX-DC-HT  | 744              | 氮化<br>N                   | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
|   |   |                  |                           | 3  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 硬质合金铸件用<br>Carbide Straight Fluted-for Die Castings                   | OT-DC-HT  | 747              |                           | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
| A-TAP 硬质合金<br>A-TAP Carbide   | A-CHT   | 745~746          | FX                        | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 铸件用零前角<br>V coated for Die Castings                                   | VP-DC-HT  | 748              | V                         | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 铸件用零前角带内冷<br>V Coated-for Die Castings-With Internal Coolant Supply   | VO-DC-HT  | 748              | V                         | 1.5  | ○   | ○     | ○     |  |                                |                              |                    |            |
| 高硬度钢用<br>For High Strength Steels                                     | EX-SH-HT  | 749              |                           | 2.5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| 高硬度钢用<br>For Hardened Steels (42-52 HRC)                              | V-XPM-HT  | 750              | V                         | 2.5  | ○   | ○     |       |  |                                |                              |                    |            |
| 高硬度钢用<br>Carbide Straight Fluted-for Hardened Steels (50HRC~)         | VX-OT   | 752              | V                         | 3  | ○   | ○     |       |  |                                |                              |                    |            |
| 高硬度钢(~55HRC)用<br>Carbide Straight Fluted-for Hardened Steels (55HRC~) | WH55-OT   | 751              | WXS                       | 2.5  | ○   | ○     |       |  |                                |                              |                    |            |
| 螺纹修补用<br>Spatter Remove Hand Tap                                      | SR-HT   | 812              |                           | 5  | ○   | ○     |       |  | ○                              |                              | ○                  |            |
| PLANET CUTTER<br>行星铣刀   | One Revolution 螺纹铣刀<br>One Pass Thread Mill                                 | AT-1             | EgiAs                     |  | ○*2   |       |       |  | ○                              |                              | ○                  |            |
|   | 小径螺纹铣刀<br>Carbide Small Diameter PLANET CUTTER                              | WH-VM-PNC        | 498                       | WXS  |   | ○     |       |  | ○                              |                              | ○                  |            |
|   | 钢用NC螺纹铣刀<br>Carbide PLANET CUTTER for Steels                                | WX-ST-PNC        | 499~500                   | WX   |   | ○     |       |  | ○                              |                              | ○                  |            |
|   | 内冷油孔钢用螺纹铣刀<br>Carbide PLANET CUTTER for Steels with Internal Coolant Supply | WXO-ST-PNC       | 501                       | WX   |   | ○     |       |  | ○                              |                              | ○                  |            |

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

◎最适合丝锥 ○Excellent ○适用的丝锥 ○Good

## 盲孔 Blind Hole



| 加工材料 Work Material |           |           |           |                     |                |               |              |                        |          |          |                    |           |                             |                              |                               |                          |                    |                  |  |   |  |  |
|--------------------|-----------|-----------|-----------|---------------------|----------------|---------------|--------------|------------------------|----------|----------|--------------------|-----------|-----------------------------|------------------------------|-------------------------------|--------------------------|--------------------|------------------|--|---|--|--|
| 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 | 铝形铝合金 Aluminum Alloy Casted | 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 | 镍合金 Nickel Alloy | 热硬化塑料 Thermosetting Plastic (酚醛树脂 Bakelite Phenol) | 热塑性塑料 Thermoplastic (聚氯乙烯 Vinyl Chloride, 尼龙 Nylon) |  |  |
| 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                      |                    |                  |  |   |  |  |
|                    |           |           |           |                     | ○              | ○             | ○            | ○                      |          | ◎        | ◎                  | ◎         | ○                           | ○                            | ◎                             | ◎                        |                    |                  | ○  |   |  |  |
|                    |           |           |           |                     | ○              | ○             | ○            | ○                      |          | ○        | ○                  | ○         | ○                           | ○                            | ○                             | ○                        |                    |                  |  |   |  |  |
|                    |           |           |           |                     | ○              | ○             | ○            | ○                      |          | ○        | ○                  | ○         | ○                           | ○                            | ○                             | ○                        |                    |                  | ○  |   |  |  |
|                    |           |           |           |                     |                | ○             |              | ○                      |          |          |                    |           |                             |                              |                               | ○                        |                    |                  |  |   |  |  |
|                    |           |           |           |                     | ○              | ○             |              |                        |          | ○        | ○                  | ○         | ○                           | ○                            | ○                             | ○                        |                    |                  |  |   |  |  |
|                    |           |           |           |                     | ○              | ○             |              |                        |          | ○        | ○                  | ○         | ○                           | ○                            | ○                             | ○                        |                    |                  |  |   |  |  |
|                    |           |           |           |                     | ○              |               | ◎            | ◎                      |          |          |                    |           |                             |                              |                               |                          |                    | ○                |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
|                    |           |           |           |                     |                |               | ◎            | ◎                      |          | ○        | ○                  | ○         |                             |                              |                               |                          |                    |                  |  | ○   |  |  |
| ◎                  | ◎         | ◎         | ○         | ○                   | ○              | ○             | ○            | ○                      | ○        | ○        | ○                  | ○         | ◎                           | ◎                            | ◎                             | ◎                        | ◎                  | ◎                | ◎  | ◎   |  |  |
| ◎                  | ◎         | ◎         | ○         | ○                   | ○              | ○             | ○            | ○                      | ○        | ○        | ○                  | ○         | ◎                           | ◎                            | ◎                             | ◎                        | ◎                  | ◎                | ◎  | ◎   |  |  |
| ○                  | ○         |           |           | ◎                   |                | ◎             | ◎            | ◎                      | ○        | ○        | ○                  | ○         | ◎                           | ◎                            | ◎                             | ◎                        |                    | ○                | ○  | ○   |  |  |
| ○                  | ○         |           |           | ◎                   |                | ◎             | ◎            | ◎                      | ○        | ○        | ○                  | ○         | ◎                           | ◎                            | ◎                             | ◎                        |                    | ○                | ○  | ○   |  |  |
| ○                  | ○         |           |           | ◎                   |                | ◎             | ◎            | ◎                      | ○        | ○        | ○                  | ○         | ◎                           | ◎                            | ◎                             | ◎                        |                    | ○                | ○  | ○   |  |  |
| ○                  | ○         |           |           | ◎                   |                | ◎             | ◎            | ◎                      | ○        | ○        | ○                  | ○         | ◎                           | ◎                            | ◎                             | ◎                        |                    | ○                | ○  | ○   |  |  |

钻头 DRILLS

丝锥 TAPS

SELECTION CHART 选定表

量规 GAUGES

板牙 ROUND Dies

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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 嵌套螺纹用丝锥

NUIT TAP 螺母丝锥

MACHINING CENTER TAP 加工中心用丝锥

DRILL TAP 钻攻一体丝锥

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 Only taps for M·U threads are suitable for up to 2D. Please refer to the dimension table for details.

# 铸铁用

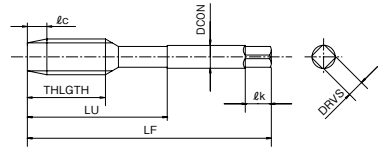
FOR CAST IRON

## EX-FC-HT



HSSE N

适用于灰口铸铁、球墨铸铁，可锻造铸铁等各种铸铁及黄铜铸件等。  
Suitable for tapping grey cast iron, nodular cast iron, malleable cast iron, brass castings, and other similar materials.



### 螺纹种类：M

| 商品号<br>EDP NO. | 螺纹尺寸<br>Thread Size | 精度<br>Grade | 精度<br>TAP Limit | 切削长<br>$\phi c$ | 全长<br>LF | 螺纹长<br>THLGTH | 颈长<br>LU | 柄径<br>DCON | 槽数<br>NOF | 突顶尖<br>External Center | 库存<br>Stock | 重量<br>(g) |
|----------------|---------------------|-------------|-----------------|-----------------|----------|---------------|----------|------------|-----------|------------------------|-------------|-----------|
| 24522          | M 3 x 0.5           | STD         | OH3             | 3P              | 46       | 11            | 19       | 4          | 3         | 有                      | —           | 4         |
| 24523          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24526          | M 3.5 x 0.6         | STD         | OH3             | 3P              | 48       | 11            | 19       | 4          | 3         | 有                      | —           | 5         |
| 24527          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24530          | M 4 x 0.7           | STD         | OH3             | 3P              | 52       | 13            | 21       | 5          | 3         | 有                      | —           | 7         |
| 24531          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24536          | M 5 x 0.8           | STD         | OH3             | 3P              | 60       | 16            | 24       | 5.5        | 4         | 有                      | —           | 10        |
| 24537          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24540          | M 6 x 1             | STD         | OH3             | 3P              | 62       | 19            | 29       | 6          | 4         | 有                      | —           | 12        |
| 24541          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24548          | M 8 x 1.25          | STD         | OH4             | 3P              | 70       | 22            | 37       | 6.2        | 4         | 有                      | ●           | 17        |
| 24549          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24552          | M 8 x 1             | STD         | OH3             | 3P              | 70       | 22            | 37       | 6.2        | 4         | 有                      | —           | 17        |
| 24553          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24556          | M10 x 1.5           | STD         | OH4             | 3P              | 75       | 24            | 41       | 7          | 4         | 有                      | —           | 26        |
| 24557          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24560          | M10 x 1.25          | STD         | OH4             | 3P              | 75       | 24            | 41       | 7          | 4         | 有                      | —           | 26        |
| 24561          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24564          | M10 x 1             | STD         | OH3             | 3P              | 75       | 24            | 41       | 7          | 4         | 有                      | —           | 26        |
| 24565          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24576          | M12 x 1.75          | STD         | OH5             | 3P              | 82       | 29            | 48       | 8.5        | 4         | 有                      | —           | 40        |
| 24577          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |

- 突顶尖长·柄部四方部尺寸  $\phi k$ , DRVS 请参考 P.963.
- 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P817)
  - 丝锥精度不能够保证内螺纹的精度。
  - 切削油剂请参考 P.958。

单位:mm Unit:mm

| 商品号<br>EDP NO. | 螺纹尺寸<br>Thread Size | 精度<br>Grade | 精度<br>TAP Limit | 切削长<br>$\phi c$ | 全长<br>LF | 螺纹长<br>THLGTH | 颈长<br>LU | 柄径<br>DCON | 槽数<br>NOF | 突顶尖<br>External Center | 库存<br>Stock | 重量<br>(g) |
|----------------|---------------------|-------------|-----------------|-----------------|----------|---------------|----------|------------|-----------|------------------------|-------------|-----------|
| 24580          | M12 x 1.5           | STD         | OH4             | 3P              | 82       | 29            | 48       | 8.5        | 4         | 有                      | —           | 40        |
| 24581          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24584          | M12 x 1.25          | STD         | OH3             | 3P              | 82       | 29            | 48       | 8.5        | 4         | 有                      | —           | 40        |
| 24585          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24588          | M12 x 1             | STD         | OH3             | 3P              | 82       | 29            | 48       | 8.5        | 4         | 有                      | —           | 39        |
| 24589          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24598          | M14 x 2             | STD         | OH5             | 3P              | 88       | 30            | 48       | 10.5       | 4         | 有                      | —           | 65        |
| 24599          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24602          | M14 x 1.5           | STD         | OH4             | 3P              | 88       | 30            | 48       | 10.5       | 4         | 有                      | —           | 66        |
| 24603          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24612          | M16 x 2             | STD         | OH5             | 3P              | 95       | 32            | 52       | 12.5       | 4         | 有                      | —           | 93        |
| 24613          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24616          | M16 x 1.5           | STD         | OH4             | 3P              | 95       | 32            | 52       | 12.5       | 4         | 有                      | —           | 93        |
| 24617          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24626          | M18 x 2.5           | STD         | OH5             | 3P              | 100      | 37            | 55       | 14         | 4         | 有                      | —           | 113       |
| 24627          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24630          | M18 x 1.5           | STD         | OH4             | 3P              | 100      | 37            | 55       | 14         | 4         | 有                      | —           | 113       |
| 24631          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24638          | M20 x 2.5           | STD         | OH5             | 3P              | 105      | 37            | 58       | 15         | 4         | 有                      | —           | 139       |
| 24639          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |
| 24642          | M20 x 1.5           | STD         | OH4             | 3P              | 105      | 37            | 58       | 15         | 4         | 有                      | —           | 143       |
| 24643          |                     |             |                 | 1.5P            |          |               |          |            |           |                        |             | 有         |

- Please see p.963 for length of external center and shank square length  $\phi k$  and width DRVS.
- The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.817)
  - TAP Limit does not guarantee thread limit for the internal thread after tapping.
  - Cutting fluid and Paste : Please refer to p.958.

钻头  
DRILL

丝锥  
TAP

SPECIFICATION CHARTS  
形状尺寸表

量规  
GAGE

板牙  
ROUND DIE

滚压工具  
ROLLING DIE

其他产品  
OTHER PRODUCTS

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INDEX

螺纹铣刀  
THREAD MILL

无屑丝锥  
FLUTELESS TAP

挤压丝锥  
挤压丝锥

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)

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

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

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

●=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.