

丝锥选型基准表 TAP SELECTION CHART



盲孔 Blind Hole

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	中碳钢 Medium Carbon Steel	高碳钢 High Carbon Steel	合金钢 Alloy Steel	
								C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	
A 丝锥·A 丝锥(立铣刀柄) A-TAP·A-TAP (Endmill Shank)	A-SFT	569~576	V	2.5	○	○		○	○	○	○	
A 丝锥 A-TAP	A-SFT	576	V	1.5	○	○		○	○	○	○	
A 丝锥长柄型丝锥·A 丝锥长柄型(立铣刀柄) A-TAP Long Shank·A-TAP Long Shank (Endmill Shank)	A-LT-SFT	577~580	V	2.5	○	○		○	○	○	○	
一般用 General Application	EX-SFT	581~591		2.5	○	○		○	○	○	○	
一般用长柄型 Long Shank-General Application	EX-LT-SFT	592~598		2.5	○	○		○	○	○	○	
一般用氧化处理 General Application (with OX)	EX-H-SFT	599~600	氧化 OX	2.5	○	○		○	○	○	○	
一般用氧化处理长柄型 Long Shank-General Application (with OX)	EX-LT-H-SFT	601~602	氧化 OX	2.5	○	○		○	○	○	○	
短切削锥型 Short Chamfer type	EX-SC-SFT	603~605		1.5	○	○		○	○	○	○	
长柄短切削锥型 Short Chamfer type·Long Shank	LT-SC-SFT	606		1.5	○	○		○	○	○	○	
高强度钢用 For High Strength Steels	VP-SFT	607	V	2.5	○	○	○		○	○	○	
V 涂层 V coated	V-SFT	608	V	2.5	○	○		○	○	○	○	
V 涂层长柄型 V coated·Long Shank	V-LT-SFT	609	V	2.5	○	○		○	○	○	○	
大型部件加工用(卧式加工机用) For Machining Large Parts (For Horizontal Machines)	HXL-SFT	610	氧化 OX	2.5	○			○	○	○	○	
大型部件加工用(立式加工机用) For Machining Large Parts (For Vertical Machines)	VXL-SFT	611	氧化 OX	2.5	○	○		○	○	○	○	
TiN 涂层 TiN coated	TIN-SFT	612	TiN	2.5	○	○		○	○	○	○	
TiN 涂层长柄型 TiN coated·Long Shank	TIN-LT-SFT	613	TiN	2.5	○	○		○	○	○	○	
难加工材料 For Difficult to Machine Materials	CPM-SFT	614		3	○	○		○	○	○	○	
难加工材料用长柄型 Long Shank-for Difficult to Machine Materials	CPM-LT-SFT	615		3	○	○		○	○	○	○	
不锈钢加工用(适用水溶性切削油剂) For Stainless Steels (with water-soluble)	CC-SUS-SFT	616	CrN	2.5	○	○		○	○	○	○	
不锈钢 For Stainless Steels	EX-SUS-SFT	617~620	氧化 OX	2.5	○	○		○	○	○	○	
不锈钢用长柄型 Long Shank-for Stainless Steels	EX-LT-SUS-SFT	621~622	氧化 OX	2.5	○	○		○	○	○	○	
不锈钢·深孔用 For Stainless Steels·Deep Holes	SUS-DH-SFT	623	氧化 OX	2.5	○	○	○		○	○	○	
不锈钢·深孔用长柄 Long Shank·for Stainless Steels·Deep Holes	LT-SUS-DH-SFT	624	氧化 OX	2.5	○	○	○		○	○	○	
软钢·深孔用 For Mild Steels and Deep Holes	MS-DH-SFT	625~626	氧化 OX	2.5	○	○	○	○		○	○	
软钢·深孔用长柄 Long Shank-for Mild Steels and Deep Holes	LT-MS-DH-SFT	627	氧化 OX	2.5	○	○	○	○		○	○	
非铁合金·深孔用 For Non-Ferrous Metals and Deep Holes	EX-B-DH-SFT	628		2.5	○	○	○					
小螺旋角 Low Spiral	LW-SFT	629		2.5	○	○		○	○	○	○	
带内冷油孔 With Internal Coolant Supply	OIL-SFT	630	氧化 OX	2.5	○	○		○	○	○	○	
铝用 For Aluminium	EX-AL-SFT	631		2.5	○	○						
平行管螺纹丝锥 Carbide Spiral Fluted	OT-SFT	632		1.5	○	○	○					
				2.5	○	○	○					
A-TAP 硬质合金 A-TAP Carbide	A-CSF	633	FX	1.5	○	○	○					
高碳钢用 For High Carbon Steels	EX-HC-SFT	634		3	○	○				○	○	
铜用 For Copper	CU-SFT	635	CrN	2.5	○	○						
钛合金用 For Titanium Alloys	V-TI-SFT	636	V	2.5	○	○						
镍基超耐热合金用 HR 涂层 HR coated for Nickel Alloys	WHR-NI-SFT	637	HR	2.5	○	○						
镍基超耐热合金用 For Nickel Alloys	NI-SFT	638		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。

- 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

钻头
DRILLS

丝锥
TAPS

SELECTION CHART
选定表

量规
GAGES

板牙
ROUND Dies

滚造工具
ROLLING Dies

各种产品
OTHER PRODUCTS

索引
INDEX

THREAD MILL
螺纹铣刀

FLUTELESS TAP
挤压丝锥

SPRAL FLUTED TAP
螺旋槽丝锥

SPRAL 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

NUT TAP
螺母丝锥

MACHINING CENTER TAP
加工中心用丝锥

DRILL TAP
钻攻一体丝锥



盲孔 Blind Hole

◎最适合丝锥 ○Excellent ○适用的丝锥 ○Good

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 物 Casting	青 铜 Bronze	铝 形 插 合 金 Aluminum Interlocks	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 塑 性 热 固 性 塑 料 Thermoplastic Thermosetting Plastic	热 固 性 塑 料 Thermoplastic	聚 氨 酯 Vinyl Chloride 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			(酚醛树脂类) Bakelite Phenol		聚氨酯 Vinyl Chloride Nylon
◎				○	○	○		○	○	○	○	○	○	◎	○	○					
◎				○	○	○		○	○	○	○	○	○	◎	○	○					
◎				○	○	○		○	○	○	○	○	○	◎	○	○					
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						○		○	○	○	○	○	○	○	○	○					○
								○	○	○	○	○	○	○	○	○					○
								○	○	○	○	○	○	○	○	○					○
○	◎				◎			○	○	○	○	○	○	○	○	○					○
○				○	○	○		○	○	○	○	○	○	◎	○	○					○
○				○	○	○	○	○	○	○	○	○	○	◎	○	○					○
○				○	○	○		○	○	○	○	○	○	○	○	○					○
○				○	○	○		○	○	○	○	○	○	○	○	○					○
	○			○	○	○		○	○	○	○	○	○	○	○	○			○		○
	○			○	○	○		○	○	○	○	○	○	○	○	○			○		○
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									◎	◎	○	○	◎	○	○	○				◎	○
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	○								◎	○	○										○
	○																				○
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3. 经常检查加工的内螺纹的精度。
 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。

3. Always check the required thread limit for the internal thread.
 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.

一般用

GENERAL APPLICATION

EX-SFT



HSSE

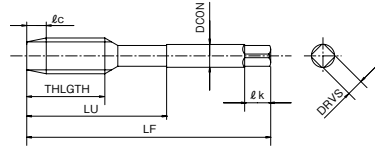
35°

< M52

15°

M52 ≤

用于碳素钢, 合金钢、非铁金属等切屑呈连续卷曲状的材料上的盲孔加工。
This tap is made for cutting materials whose chips are produced in continuous coil form, such as Carbon Steels, Alloy Steels, and nonferrous metals.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ϕc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18008	M 1 × 0.25	STD	OH1	2.5P	30	7	-	3	2	-	●	3
18009	M 1.1 × 0.25				32	8	-	3		-		2
18010	M 1.2 × 0.25				32	8	-	3		-		3
18012	M 1.4 × 0.3				34	9	-	3		-		3
18014	M 1.6 × 0.35				36	10	-	3		-		3
18016	M 1.7 × 0.35				36	11	-	3		-		3
18017	M 1.8 × 0.35	STD+1	OH2		36	11	-	3		-		3
18018	M 1.8 × 0.35	STD	OH1		36	11	-	3		-		3
18021	M 2 × 0.4	STD+1	OH2		40	12	-	3		-		3
18022	M 2 × 0.4	STD+2	OH3		40	12	-	3		-		3
18023	M 2 × 0.4	STD	OH1		40	12	-	3		-		3
18024	M 2 × 0.25	STD	OH1		42	13	-	3		-		4
18025	M 2.2 × 0.45	STD	OH1		42	13	-	3		-		4
18026	M 2.3 × 0.4	STD+1	OH2		42	13	-	3		-		4
18027	M 2.3 × 0.4	STD+2	OH3		42	13	-	3		-		4
18028	M 2.3 × 0.4	STD	OH1		42	13	-	3		-		4
18030	M 2.5 × 0.45	STD+1	OH2		44	14	-	3		-		4
18031	M 2.5 × 0.45	STD+2	OH3		44	14	-	3		-		4
18032	M 2.5 × 0.45	STD	OH1	44	14	-	3	-	4			
18033	M 2.5 × 0.35	STD+1	OH2	44	14	-	3	-	4			
18034	M 2.5 × 0.35	STD+2	OH3	44	14	-	3	-	4			
18035	M 2.6 × 0.45	STD+3	OH4	44	14	-	3	-	4			
18036	M 2.6 × 0.45	STD	OH1	44	14	-	3	-	4			
18037	M 2.6 × 0.45	STD	OH1	44	14	-	3	-	4			
18038	M 2.6 × 0.35	STD	OH1	44	14	-	3	-	4			

- 突顶尖长·柄部四部尺寸 ϕk , DRVS请参考P.963.
1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照P817)
 2. 2002年7月前产品中M3以下为突顶尖。
 3. 丝锥精度不能够保证内螺纹的精度。
 4. 切削油剂请参考P.958.

- Please see p.963 for length of external center and shank square length ϕk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.817)
 2. Taps of M3 or less produced before July 2002 have external center.
 3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
 4. Cutting fluid and Paste : Please refer to p.958.

尺寸 Size M3 ~ M8 下一页 NEXT

钻头
DRILL

丝锥
TAP

SPECIFICATION CHARTS
形状尺寸表

量规
GAGE

板牙
ROUND DIE

滚丝工具
ROLLING DIE

各种产品
OTHER PRODUCTS

素丝
ANSI

螺纹铣刀
THREAD MILL

无屑丝锥
FLUTELESS TAP

螺旋丝锥
SPRAL FLUTED TAP

刃倾角丝锥
SPRAL 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

●=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.

加工材料 Work Material	低碳钢 Low Carbon Steel	中碳钢 Medium Carbon Steel	高碳钢 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	热硬性塑料 Thermo Setting Plastic	热塑性塑料 Thermo Plastic
	商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	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				
EX-SFT		○		○										○	○	○	○	○	○	○	○	○				

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FROM 尺寸 Size M1 ~ M2.6

商品号 EDP NO.	螺纹尺寸 Thread Size	切削锥长 &c	精度标记 Grade	精度 TAP Limit	新形状 New Dimension				旧形状 Old Dimension				槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
					全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU				
18040	M 3 × 0.6		STD	OH1	46	6	19	4	OH1	46	11	19	4	—		4
18041			STD+1	OH2					OH2					—		4
11544	M 3 × 0.5		STD	OH2	46	6	19	4	OH2	46	11	19	4	—		4
18045			STD+1	OH3					OH3					—		4
19942			STD+2	OH4					OH4					—		4
18046			STD	OH1					OH1					—		5
18048	M 3.5 × 0.6		STD+1	OH2	48	7.2	20	4	OH2	48	13	20	4	有		4
18049			STD	OH1					OH1					—		5
18050	M 3.5 × 0.35		STD	OH1	48	7.2	20	4	OH1	48	13	20	4	有		5
18053	M 4 × 0.75		STD	OH2	52	8.4	21	5	OH2	52	13	21	5	有		7
18054			STD+1	OH3					OH3					—		7
11556	M 4 × 0.7		STD	OH2	52	8.4	21	5	OH2	52	13	21	5	有		7
18057			STD+1	OH3					OH3					—		7
19946			STD+2	OH4					OH4					—		7
18059			STD	OH2					OH2					—		7
18062	M 4.5 × 0.75		STD	OH2	52	8.4	21	5	OH2	52	13	21	5	有		7
18066			STD+1	OH3	OH3	—	7									
18069	M 5 × 0.9		STD	OH2	55	9	21	5	OH2	55	13	21	5	有		9
18071			STD+1	OH3	OH3	—	9									
11571			STD	OH2	OH2	—	9									
18072			STD+1	OH3	OH3	—	9									
19950	M 5 × 0.8		STD+2	OH4	60	9.6	24	5.5	OH4	60	16	24	5.5	有		10
18073			STD	OH2	60	9.6	24	5.5	OH2	60	16	24	5.5	有		10
18074			STD	OH2	60	9.6	24	5.5	OH2	60	16	24	5.5	有		10
18077			STD	OH2	60	10.8	25	5.5	OH2	60	17	25	5.5	有		11
18079	M 5.5 × 0.5		STD	OH2	60	10.8	25	5.5	OH2	60	17	25	5.5	有		11
11583			STD+1	OH3	OH3	—	11									
18084			STD+2	OH4	OH4	—	11									
19954			STD	OH2	OH2	—	11									
18086	M 6 × 0.75		STD+1	OH3	62	12	29	6	OH3	62	19	29	6	有		12
18087			STD	OH2	62	12	29	6	OH2	62	19	29	6	有		12
18088			STD+1	OH3	OH3	—	12									
18092			STD	OH2	OH2	—	12									
18094	M 6 × 0.5		STD	OH2	62	12	29	6	OH2	62	19	29	6	有		12
18096			STD	OH2	65	12	33	6.2	OH2	65	19	33	6.2	—		15
11601			STD	OH2	65	12	33	6.2	OH2	65	19	33	6.2	—		15
18099			STD	OH2	65	12	33	6.2	OH2	65	19	33	6.2	—		15
18102	M 7 × 0.75		STD	OH2	65	12	33	6.2	OH2	65	19	33	6.2	—		15
18104			STD	OH2	65	12	33	6.2	OH2	65	19	33	6.2	—		15
18105			STD+1	OH3	OH3	—	17									
18107			STD	OH2	OH2	—	17									
18109	M 7 × 0.5		STD	OH2	65	12	33	6.2	OH2	65	19	33	6.2	—		15
11601			STD	OH2	65	12	33	6.2	OH2	65	19	33	6.2	—		15
18102			STD+1	OH3	OH3	—	17									
19958			STD+2	OH5	OH5	—	17									
18104	M 8 × 1		STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2	—		17
18105			STD+1	OH3	OH3	—	17									
18107	STD	OH2	OH2	—	17											
18109	M 8 × 0.75		STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2	—		17
11601			STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2	—		17
18102			STD+1	OH3	OH3	—	17									
19958			STD+2	OH5	OH5	—	17									

- 突顶尖长·柄部四方部尺寸fk, DRVS请参考 P.963.
- 1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P817)
- 2. 2002年7月前生产品中M3以下为突顶尖。
- 3. 丝锥精度不能够保证内螺纹的精度。
- 4. 切削油剂请参考 P.958.
- 5. 新形状逐步取代旧形状。

- Please see p.963 for length of external center and shank square length &k and width DRVS.
- 1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.817)
- 2. Taps of M3 or less produced before July 2002 have external center.
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- 4. Cutting fluid and Paste : Please refer to p.958.
- 5. Conventional dimension is replaced with new one accordingly.

尺寸 Size M8 ~ M12 NEXT

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●=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.

一般用

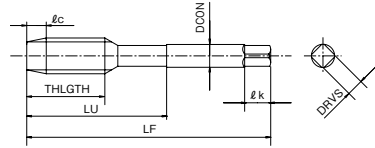
GENERAL APPLICATION

EX-SFT



FROM 尺寸 Size M3 ~ M8

用于碳素钢, 合金钢, 非铁金属等切屑呈连续卷曲状的材料上的盲孔加工。
This tap is made for cutting materials whose chips are produced in continuous coil form, such as Carbon Steels, Alloy Steels, and nonferrous metals.



螺纹种类: M

商品号 EDP NO.	螺纹尺寸 Thread Size	切削锥长 ϕc	精度标记 Grade	精度 TAP Limit	新形状 New Dimension				精度 TAP Limit	旧形状 Old Dimension				槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)									
					全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON		全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON													
18110	M 8 × 0.5	2.5P	STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2	3	●		18									
18113	M 9 × 1.25			OH3	72	15	38	7		72	22	38	7				24									
18115	M 9 × 1			OH2	72	15	38	7		72	22	38	7				24									
18119	M 9 × 0.5			OH3	72	15	38	7		72	22	38	7				24									
11621	M 10 × 1.5		STD+1	OH4	75	18	41	7	OH3 OH4	75	24	41	7				—	26								
18122			STD+2	OH5	—	—	—	—									—	—	—	—	—	25				
19962			—	—	—	—	—	—									—	—	—	—	—	25				
11624	M 10 × 1.25		STD	OH3	75	18	41	7	OH2 OH3	75	24	41	7				—	26								
18125			STD+1	OH4													—	—	—	—	—	—	—	—	—	26
18127			STD	OH2													—	—	—	—	—	—	—	—	—	26
18128	M 10 × 1		STD+1	OH3	75	18	41	7	OH2 OH3	75	24	41	7				—	26								
18131			OH2	75													18	41	7	75	24	41	7	27		
18135			M 11 × 1.5	OH3													80	18	48	8	80	25	48	8	34	
18138	M 11 × 1.25		STD	OH2	80	18	48	8	OH2	80	25	48	8				—	35								
18141	M 11 × 1			OH3	80	18	48	8		80	25	48	8				—	35								
18144	M 11 × 0.75			OH2	80	18	48	8		80	25	48	8				—	36								
11650	M 12 × 1.75	OH3		82	21	48	8.5	OH3 OH4		82	29	48	8.5	—	40											
18151		STD+1	OH4	—	—	—	—		—					—	—	—	—	40								
19968		STD+2	OH5	—	—	—	—		—					—	—	—	—	40								
11653	M 12 × 1.5	STD	OH3	82	21	48	8.5	OH2 OH3	82	29	48	8.5	—	41												
18154		STD+1	OH4										—	—	—	—	—	—	—	—	—	40				
11656		STD	OH3										82	21	48	8.5	OH2	82	29	48	8.5	—	41			
18157	M 12 × 1.25	STD+1	OH4	82	21	48	8.5	OH3	82	29	48	8.5	—	40												
18159	M 12 × 1	STD	OH2	82	21	48	8.5	OH2 OH3	82	29	48	8.5	—	40												
18160		STD+1	OH3										—	—	—	—	—	—	—	—	—	41				
18163		M 12 × 0.75	STD										OH2	82	21	48	8.5	OH2	82	29	48	8.5	—	42		
18166	M 12 × 0.5	STD	OH2	82	21	48	8.5	OH2	82	29	48	8.5	—	42												

■ 突顶尖长·柄部四方部尺寸 ϕk, DRVS 请参考 P.963.

1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P817)
2. 2002年7月前生产产品中 M3以下 为突顶尖。
3. 丝锥精度不能够保证内螺纹的精度。
4. 切削油剂请参考 P.958.
5. 新形状逐步取代旧形状。

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5. Conventional dimension is replaced with new one accordingly.

尺寸 Size M13 ~ M23 NEXT

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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	热塑性塑料 Thermo Plastic
	商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	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			
EX-SFT		○		○									○	○	○	○	○	○	○	○	○				○

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FROM 尺寸 Size M8 ~ M12

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)	
18168	M 13 × 1.75	STD	OH2	2.5P	88	30	48	9.5	3	—	●	56	
18171	M 13 × 1.5				88	30	48	9.5		—		57	
18175	M 13 × 1				88	30	48	9.5		—		58	
11680	M 14 × 2	—	—		88	30	48	10.5		—		—	64
18181		STD+1	OH3		—	—	—	—		64			
11683	M 14 × 1.5	STD	OH2		88	30	48	10.5		—		—	65
18184		STD+1	OH3		—	—	—	—		65			
18186	M 14 × 1.25	STD	OH2		88	30	48	10.5		—		—	66
18187	M 14 × 1				88	30	48	10.5		—		66	
18193	M 15 × 2				95	32	52	10.5		—		72	
18196	M 15 × 1.5				95	32	52	10.5		—		74	
18199	M 15 × 1				95	32	52	10.5		—		74	
11705	M 16 × 2	—	—		95	32	52	12.5		—		—	91
18206		STD+1	OH3		—	—	—	—		92			
11708	M 16 × 1.5	STD	OH2		95	32	52	12.5		—		—	92
18209		STD+1	OH3	—	—	—	—	93					
18211	M 16 × 1	STD	OH2	95	32	52	12.5	—	—	93			
18221	M 17 × 2		OH3	100	37	55	13	—	—	97			
18224	M 17 × 1.5		OH2	100	37	55	13	—	—	100			
18227	M 17 × 1		OH2	100	37	55	13	—	—	100			
11730	M 18 × 2.5		OH3	—	100	37	55	14	—	—	109		
18231		STD+1	OH4	—	—	—	—	110					
18233	M 18 × 2	STD	OH3	100	37	55	14	—	—	110			
11735	M 18 × 1.5		OH2	100	37	55	14	—	—	110			
18236		STD+1	OH3	—	—	—	—	112					
18238	M 18 × 1	STD	OH2	100	37	55	14	—	—	111			
18248	M 19 × 2.5		OH3	105	37	58	14	—	—	120			
18252	M 19 × 1.5		OH2	105	37	58	14	—	—	122			
18254	M 19 × 1		OH2	105	37	58	14	—	—	123			
11757	M 20 × 2.5		OH3	—	105	37	58	15	—	—	135		
18258		STD+1	OH4	—	—	—	—	136					
18260	M 20 × 2	STD	OH3	105	37	58	15	—	—	137			
11762	M 20 × 1.5		OH2	105	37	58	15	—	—	138			
18263		STD+1	OH3	—	—	—	—	138					
18266	M 20 × 1	STD	OH2	105	37	58	15	—	—	139			
11772	M 22 × 2.5		OH3	—	115	38	63	17	—	—	183		
18273		STD+1	OH4	—	—	—	—	183					
18275	M 22 × 2	STD	OH3	115	38	63	17	—	—	185			
11777	M 22 × 1.5		OH2	—	115	38	63	17	—	—	185		
18278		STD+1	OH3	—	—	—	—	186					
18282	M 22 × 1	STD	OH2	115	38	63	17	—	—	187			
18287	M 23 × 2.5		—	—	120	45	66	18	—	—	216		
18290	M 23 × 2		OH3	—	—	—	—	—	—	—	217		

- 突顶尖长·柄部四方部尺寸ℓk, DRVS请参考 P.963.
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- 3. 丝锥精度不能够保证内螺纹的精度。
- 4. 切削油剂请参考 P.958.

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尺寸 Size M24 ~ M56 NEXT

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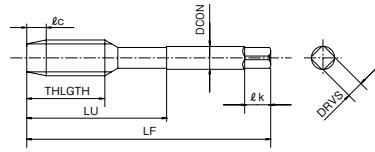
一般用

GENERAL APPLICATION

EX-SFT



用于碳素钢, 合金钢、非铁金属等切屑呈连续卷曲状的材料上的盲孔加工。
This tap is made for cutting materials whose chips are produced in continuous coil form, such as Carbon Steels, Alloy Steels, and nonferrous metals.



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FROM 尺寸 Size M13 ~ M23

螺纹种类 : M

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 $\varnothing c$	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11799	M 24 × 3	STD	OH3	2.5P	120	45	66	19	4	—	A	235
18300	M 24 × 3	STD+1	OH4							—	D	241
18302	M 24 × 2	STD	OH3	120	45	66	19	4	—	A	239	
11804	M 24 × 1.5		OH2						—		242	
18305	M 24 × 1.5	STD+1	OH3	120	45	66	19	4	—	A	242	
18308	M 24 × 1	STD	OH2						120		45	66
18311	M 25 × 3		STD	OH3	130	45	71	19	—	268		
18314	M 25 × 2	OH2		130	45	71	19	—	272			
18316	M 25 × 1.5	STD	OH2	130	45	71	19	—	274			
18323	M 26 × 3		OH3	130	45	71	20	—	300			
18325	M 26 × 2	STD	OH3	130	45	71	20	—	303			
18328	M 26 × 1.5		OH2	130	45	71	20	—	306			
18338	M 27 × 3	STD	OH3	130	45	71	20	4	—	A	317	
18339			OH4						—		316	
18341	M 27 × 2	STD+1	OH4	130	45	71	20	4	—	A	323	
18343	M 27 × 1.5	STD	OH3						—		323	
18344	M 27 × 1.5	STD+1	OH2	130	45	71	20	4	—	A	321	
18346	M 27 × 1	OH3	—						322			
18350	M 28 × 3	STD	OH2	135	48	74	21	4	—	A	368	
18353	M 28 × 2		OH3						—		368	
18355	M 28 × 1.5	STD	OH3	135	48	74	21	4	—	A	367	
18362	M 28 × 1.5		OH2						—		414	
18363	M 30 × 3.5	STD+1	OH3	135	48	74	23	4	—	A	415	
18365	M 30 × 3	OH4	—						417			
18368	M 30 × 2	STD	OH3	135	48	74	23	4	—	A	429	
18370	M 30 × 1.5	OH2	—						429			
18371	M 30 × 1.5	STD+1	OH3	135	48	74	23	4	—	A	429	
18383	M 32 × 1.5	OH3	—						387			
18389	M 33 × 3.5	STD	OH3	110	37	47	24	—	●	532		
18395	M 33 × 2		OH3	—	413							
18401	M 33 × 1.5	STD	OH3	110	37	47	25	—	—	409		
18413	M 35 × 1.5		OH3	—	453							
18420	M 36 × 4	STD	OH3	110	39	49	26	—	—	662		
18424	M 36 × 3		OH4	—	660							
18426	M 36 × 2	STD	OH4	155	57	82	28	—	—	660		
18431	M 36 × 1.5		OH3	—	475							
18443	M 39 × 4	STD	OH3	110	39	49	28	—	—	482		
18459	M 42 × 4.5		OH3	—	819							
18463	M 42 × 3	STD	OH4	165	60	87	30	—	—	819		
18467	M 42 × 2		OH4	—	987							
18470	M 42 × 1.5	STD	OH4	175	60	93	32	—	—	989		
18479	M 45 × 4.5		OH4	—	989							
18482	M 45 × 3	STD	OH3	120	39	49	32	—	—	715		
18470	M 42 × 1.5		OH3	—	715							
18479	M 45 × 4.5	STD	OH4	180	67	95	35	—	—	1190		
18482	M 45 × 3		OH4	—	1190							
18485	M 45 × 2	STD	OH4	180	67	95	35	—	—	1196		
18488	M 45 × 1.5		OH3	—	822							
18499	M 48 × 5	STD	OH3	120	45	55	35	—	—	822		
18502	M 48 × 3		OH3	—	822							
18504	M 48 × 2	STD	OH4	185	67	98	38	—	—	1429		
18506	M 48 × 1.5		OH4	—	1415							
19750	M 52 × 5	STD	OH3	185	67	98	38	—	—	1415		
19763	M 56 × 5.5		OH3	—	1005							
18506	M 48 × 1.5	STD	OH4	125	45	55	38	—	—	1006		
19750	M 52 × 5		OH4	—	1006							
19763	M 56 × 5.5	OH4	—	1762								
19763	M 56 × 5.5	OH4	—	2750								

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加工材料 Work Material	低碳钢 Low Carbon Steel	中碳钢 Medium Carbon Steel	高碳钢 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
	商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	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			
EX-SFT		○		○									○	○	○	○	○	○	○	○	○				○



螺紋种类 : U

商品号 EDP NO.	螺紋尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	精度 TAP Limit	新形状 New Dimension				旧形状 Old Dimension				槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)	
					全长 LF	螺紋长 THLGTH	颈长 LU	柄径 DCON	精度 TAP Limit	全长 LF	螺紋长 THLGTH	颈长 LU					柄径 DCON
18821	NO. 4 - 40UNC	2.5P	STD	OH1	44	7.7	17	3	OH1	44	15	-	3	2	-	4	
18824	NO. 4 - 48UNF				44	7.7	17	3		44	15	-	3		-	4	
18827	NO. 5 - 40UNC				46	7.7	19	4		46	11	19	4		有	5	
18830	NO. 5 - 44UNF				46	7.7	19	4		46	11	19	4		有	5	
18833	NO. 6 - 32UNC				48	9.6	21	4		OH2	48	13	21		4	有	5
18836	NO. 6 - 40UNF				48	9.6	21	4		OH1	48	13	21		4	有	5
18840	NO. 8 - 32UNC				52	9.6	21	5		OH2	52	13	21		5	有	8
18842	NO. 8 - 36UNF				52	9.6	21	5			52	13	21		5	有	8
18846	NO. 10 - 24UNC				60	12.7	24	5.5			60	16	24		5.5	有	10
18849	NO. 10 - 32UNF				60	12.7	24	5.5			60	16	24		5.5	有	10
18852	NO. 12 - 24UNC			60	12.7	25	5.5	60	17		25	5.5	有	11			
18855	NO. 12 - 28UNF			60	12.7	25	5.5	60	17		25	5.5	有	11			
18858	1/4 - 20UNC			62	15.3	29	6	OH2	62		19	29	6	有	13		
18861	1/4 - 28UNF			62	15.3	29	6		62		19	29	6	有	13		
18867	5/16 - 18UNC			70	17	37	6.1		70		22	37	6.1	-	17		
18870	5/16 - 24UNF			70	17	37	6.1		70		22	37	6.1	-	17		
18876	3/8 - 16UNC			75	19	41	7		75	24	41	7	-	25			
18882	3/8 - 24UNF			75	19	41	7		75	24	41	7	-	26			
18891	7/16 - 14UNC			80	22	48	8		80	25	48	8	-	35			
18894	7/16 - 20UNF			80	22	48	8		80	25	48	8	-	42			
18900	1/2 - 13UNC	85	23	48	9	85	29		48	9	-	47					
18906	1/2 - 20UNF	85	23	48	9	85	29		48	9	-	44					

■ 突顶尖·柄部四方部尺寸ℓk, DRVS请参考 P.963.

1. 精度栏 是适合加工2级内螺紋的丝锥的推荐精度。(参照 P817)
2. 2002年7月前生产品中 NO.4以下为突顶尖。
3. 丝锥精度不能够保证内螺紋的精度。
4. 切削油剂请参考 P.958。
5. 新形状逐步取代旧形状。

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

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.817)
2. Taps of NO.4 or less produced before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.958.
5. Conventional dimension is replaced with new one accordingly.

尺寸 Size 9/16 ~ 1 3/4 下一页
NEXT

●=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.

■ 记号说明请参考 P.1页。 See p.1 for explanation of icons.

一般用

GENERAL APPLICATION

EX-SFT

用于碳素钢, 合金钢、非铁金属等切屑呈连续卷曲状的材料上的盲孔加工。
This tap is made for cutting materials whose chips are produced in continuous coil form, such as Carbon Steels, Alloy Steels, and nonferrous metals.

钻头
DRILL

丝锥
TAP

SPECIFICATION CHARTS
形状尺寸表



上一页

FROM 尺寸 Size NO.4 ~ 1/2

螺纹种类: U

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18912	9/16 - 12UNC	STD	OH2	2.5P	90	30	48	10.5	3	—	●	66
18915	9/16 - 18UNF				90	30	48	10.5		—		70
18919	5/8 - 11UNC				95	32	52	12		—		86
18921	5/8 - 18UNF		95		32	52	12	—	86			
18925	3/4 - 10UNC		105		37	58	14	—	119			
18927	3/4 - 16UNF		105		37	58	14	—	122			
18931	7/8 - 9UNC		115		38	63	17	—	186			
18933	7/8 - 14UNF		115		38	63	17	—	186			
18937	1 - 8UNC		125		45	68	20	—	281			
18940	1 - 12UNF		125		45	68	20	—	279			
18943	1 - 14UNS		125		45	68	20	—	282			
18945	1 1/8 - 7UNC		135		48	72	22	—	379			
18947	1 1/8 - 12UNF		105		37	47	22	—	300			
18952	1 1/4 - 7UNC		145		51	77	24	—	496			
18955	1 1/4 - 12UNF		105		37	47	24	—	368			
18958	1 3/8 - 6UNC		155		57	82	26	—	622			
18960	1 3/8 - 12UNF		110		39	49	26	—	447			
18964	1 1/2 - 6UNC		160		60	85	30	—	771			
18966	1 1/2 - 12UNF		115		39	49	30	—	577			
18970	1 3/4 - 5UNC	175	67	93	35	—	1141					
18972	1 3/4 - 12UN	120	45	55	35	—	825					

■ 突顶尖长·柄部四方面尺寸ℓk, DRVS请参考P.963。

1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照P817)
2. 2002年7月生产以前的产品No.4以下有突顶尖。
3. 丝锥精度不能够保证内螺纹的精度。
4. 切削油剂请参考P.958。

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

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.817)
2. Taps of NO.4 or less produced before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.958.

量规
GAUGE

圆头丝锥
ROUND TAP

滚道工具
ROLLING TAP

其他产品
OTHER PRODUCTS

丝锥
TAP

螺纹铣刀
THREAD MILL

无屑丝锥
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(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

●=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.

加工材料 Work Material	低碳钢 Low Carbon Steel	中碳钢 Medium Carbon Steel	高碳钢 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
	商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	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				
EX-SFT		○		○										○	○	○	○	○	○	○	○	○				○

HSSE

35°

螺纹种类：W

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size		精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18704	W	1/8 - 40	STD	OH1	2.5P	46	11	19	4	3	有	●	4
18707	W	3/16 - 24				60	16	24	5.5		有		10
18710	W	1/4 - 20				62	19	29	6		有		12
18714	W	5/16 - 18				70	22	37	6.1		-		17
18718	W	3/8 - 16				75	24	41	7		-		25
18722	W	7/16 - 14				80	25	48	8		-		34
18726	W	1/2 - 12		85		29	48	9	-	46			
18730	W	5/8 - 11		95		32	52	12	-	86			
18734	W	3/4 - 10		105		37	58	14	-	119			
18738	W	7/8 - 9		115		38	63	17	-	184			
18742	W	1 - 8		125		45	68	20	-	275			
18746	W	1 1/8 - 7		135		48	72	22	-	388			
18750	W	1 1/4 - 7		145		51	77	24	-	493			
18758	W	1 1/2 - 6		160		60	85	30	-	770			

■突顶尖长·柄部四方尺寸ℓk, DRVS请参考P.963.

1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照P817)
2. 丝锥精度不能够保证内螺纹的精度。
3. 切削油剂请参考P.958.

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

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.817)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.958.

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一般用

GENERAL APPLICATION

EX-SFT

用于碳素钢, 合金钢、非铁金属等切屑呈连续卷曲状的材料上的盲孔加工。
This tap is made for cutting materials whose chips are produced in continuous coil form, such as Carbon Steels, Alloy Steels, and nonferrous metals.

钻头
DRILL

丝锥
TAP

SPECIFICATION CHARTS
形状尺寸表

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GAGES

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滚压工具
ROLLING Dies

各种产品
OTHER PRODUCTS

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螺纹铣刀

FLUTELESS TAP
挤压丝锥

SPIRAL FLUTED TAP
螺旋槽丝锥

SPRICAL POINTED TAP
刀倾角丝锥

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)
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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



螺纹种类: SM

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓ c	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19901	SM 3/32 - 56	STD	OH1	2.5P	42	13	20	3	2	有	●	3
19903	SM 1/8 - 44				46	11	19	4	有	4		
19905	SM 9/64 - 40				48	13	21	4	有	5		
19907	SM 11/64 - 40				55	13	21	5	有	8		
19910	SM 3/16 - 28				60	16	24	5.5	有	10		
19911	SM 3/16 - 32		60		16	24	5.5	有	10			
19915	SM 15/64 - 28		62		19	29	6	有	12			
19917	SM 1/4 - 24		62		19	29	6	有	11			
19920	SM 1/4 - 40		62		19	29	6	有	13			
19921	SM 9/32 - 20		65		22	33	6.5	-	16			
19922	SM 9/32 - 28	65	22	33	6.5	-	16					

■ 突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.963.

1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P817)
2. 丝锥精度不能够保证内螺纹的精度。
3. 切削油剂请参考 P.958.

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

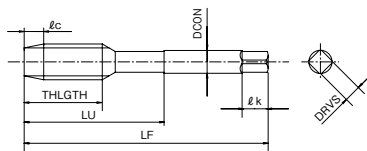
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.817)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.958.

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一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

EX-SFT



螺纹种类：M(L)

商品号 EDP NO.	螺纹尺寸 Thread Size	切削推长 ϕc	精度标记 Grade	新形状 New Dimension				旧形状 Old Dimension				槽数 NOF	突顶点 External Center	库存 Stock	重量 (g)			
				精度 TAP Limit	全长 LF	螺纹长 THLGH	颈长 LU	柄径 DCON	精度 TAP Limit	全长 LF	螺纹长 THLGH					颈长 LU	柄径 DCON	
18510	M 3 × 0.5	2.5P	STD	OH2	46	6	19	4	OH2	46	11	19	4	3	—	5		
18514	M 4 × 0.7				52	8.4	21	5		52	13	21	5		有	8		
18518	M 5 × 0.8				60	9.6	24	5.5		60	16	24	5.5		有	10		
18522	M 6 × 1				62	12	29	6		62	19	29	6		有	13		
18526	M 8 × 1.25				70	15	37	6.2		70	22	37	6.2		—	17		
18530	M 10 × 1.5				75	18	41	7		75	24	41	7		—	26		
18532	M 10 × 1.25			OH3			75	18		41	7	75	24		41	7	—	26
18536	M 12 × 1.75						82	21		48	8.5	82	29		48	8.5	—	40
18538	M 12 × 1.5						82	21		48	8.5	82	29		48	8.5	—	41
18540	M 12 × 1.25						82	21		48	8.5	82	29		48	8.5	—	41

1. 新形状逐步取代旧形状。

1. Conventional dimension is replaced with new one accordingly.

商品号 EDP NO.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ϕc	全长 LF	螺纹长 THLGH	颈长 LU	柄径 DCON	槽数 NOF	突顶点 External Center	库存 Stock	重量 (g)				
													新形状 New Dimension	旧形状 Old Dimension		
18544	M 14 × 2	STD	OH2	2.5P	88	30	48	10.5	3	—	●	65				
18546	M 14 × 1.5				88	30	48	10.5		65						
18550	M 16 × 2				95	32	52	12.5		91						
18552	M 16 × 1.5				95	32	52	12.5		93						
18556	M 18 × 2.5				100	37	55	14		109						
18558	M 18 × 1.5				100	37	55	14		113						
18562	M 20 × 2.5				105	37	58	15		137						
18564	M 20 × 1.5				105	37	58	15		139						
18568	M 22 × 2.5				115	38	63	17		184						
18570	M 22 × 1.5				115	38	63	17		187						
18573	M 24 × 3				OH3			120		45		66	19	4	—	237
18576	M 24 × 1.5							120		45		66	19		243	
18580	M 27 × 3							130		45		71	20		315	
18582	M 27 × 1.5							130		45		71	20		324	
18586	M 30 × 3.5	135	48	74				23	414							
18588	M 30 × 1.5	135	48	74				23	427							

■ 突顶点长·柄部四方面尺寸 ϕk , DRVS 请参考 P963.

1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P817)
2. 2002年7月前生产品中M3以下为突顶点。
3. 丝锥精度不能够保证内螺纹的精度。
4. 切削油剂请参考 P.958.

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

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.817)
2. Taps of M3 or less produced before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste: Please refer to p.958.

加工材料 Work Material	低碳素钢	中碳素钢	高碳素钢	合金钢	调质钢				不锈钢	工具钢	铸钢	铸铁	球墨铸铁	铜	黄铜	黄铜铸件	青铜	变形铝合金	铝合金铸件	镁合金铸件	锌合金铸件	钛合金	镍基合金	热硬性塑料	热塑性塑料
	Low Carbon Steel Mild Steel	Medium Carbon Steel	High Carbon Steel	Alloy Steel	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	Titanium Alloy	Nickel Alloy	Thermo Setting Plastic	Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C ~0.45%~0.5%	SCM																					
EX-SFT	○	○	○	○																					○

●=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.

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

钻头

丝锥

SPECIFICATION CHARTS 形状尺寸表

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圆规

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SPIRAL FLUTED TAP 螺旋槽丝锥

SPIRAL POINTED TAP 刀倾角丝锥

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 钻头一体丝锥

G-LIST No. | TH1040

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

EX-SFT

HSSE

35°

螺纹种类: W(L)

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓ c	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)				
19703	W 1/4 - 20 - L	STD	OH2	2.5P	62	19	29	6	3	有	●	13				
19704	W 3/16 - 18 - L				70	22	37	6.1		-		17				
19705	W 3/8 - 16 - L				75	24	41	7		-		24				
19707	W 1/2 - 12 - L				85	29	48	9	-	47						
19709	W 5/8 - 11 - L				95	32	52	12	-	86						
19710	W 3/4 - 10 - L				105	37	58	14	-	121						
19711	W 7/8 - 9 - L				115	38	63	17	-	184						
19712	W 1 - 8 - L				125	45	68	20	-	286						
												4	-			

■ 突顶尖·柄部四方部尺寸ℓk, DRVS请参考 P.963.

1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P.817)
2. 丝锥精度不能够保证内螺纹的精度。
3. 切削油剂请参考 P.958.

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

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.817)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.958.

加工材料 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	黄铜铸件	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	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	Stainless Steel	Tool Steel	Cast Steel	Cast Iron	Ductile Cast Iron	Copper	Brass	Brass Casting	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 Abbreviation	C	C0.25%	C0.45%	C	SCM				SUS	SKD	SC	FC	FCD	Cu	BS	B5C	PB	AL	AC/ADC	MC	ZDC				
EX-SFT		○		○									○	○	○	○	○	○	○	○	○				○

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