GESAC

2023
丝锥 Tap



厦门金鹭 GESAC

公司简介
About GESAC

厦门金鹭硬质合金有限公司，成立于1989年，是一家中外合资的国家高新技术企业，隶属于中国六大稀土集团之一的厦门钨业股份有限公司。公司致力于高品质钨粉末材料、硬质合金、精密切削工具等钨系列产品的研发、生产，以及行业专业解决方案的提供，是世界知名的钨粉末、硬质合金及切削工具供应商。

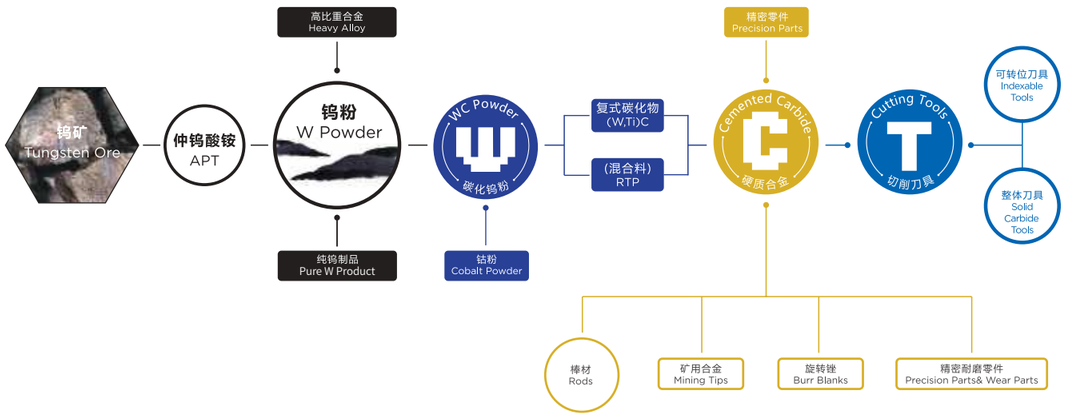
凭借完整钨产业链的产品集成技术研发，以及务实、创新的管理理念，厦门金鹭始终保持着强劲的发展势头，为全球用户提供最高性价比的钨粉末产品和服务，为现代工业领域解决高硬度、耐高温、耐磨损问题，提供了优良的产品和完善的解决方案，客户遍布全球四十多个工业发达国家和地区，享誉海内外。

公司拥有5个生产基地，4个境外销售公司和1个企业技术中心，独立承担并完成多项“国家科技支撑计划项目”，“国家科技重大专项”，“国家火炬计划项目”，“国家重点新产品”开发项目及省市重点研究课题，被评为“战略性新兴产业骨干企业”、“创新型企业”、“先进技术企业”。

Xiamen Golden Egret Cemented Carbides Co.,Ltd., founded in 1989, is a Sino-foreign joint venture with national high-tech, affiliated with XTC, which is one of six major rare earth groups in China. GESAC is committed to research & development, production and professional solutions providing of high-quality tungsten powder materials, cemented carbide, precision cutting tools and other tungsten products. Up to now, GESAC has become world-famous manufacturer and supplier of tungsten powder, cemented carbide and precision cutting tools products.

With the Integrated Product Development of complete tungsten industry chain, as well as a pragmatic and innovative management concept, GESAC has always maintained a strong momentum of development, providing the cost effective tungsten powder products and services for global users, offering the excellent products and perfect solutions for solving high hardness, high temperature resistance and wear resistance topics. Our brand "Golden Egret" has become one of the leading brand in the market, enjoying famous reputation in more than 40 countries and regions.

GESAC owns five production bases, four sales branches and one R&D center. We undertook and completed several development programs independently, including the “National Science and Technology Support Programs”, the “National Torch Program Projects”, and the “National Key Projects” and so on. GESAC was awarded as "Key Enterprise for Strategic Emerging Industry ", “Innovative Enterprise" and "Enterprise with Advanced Technology ".



GESAC



丝锥选用指南
Taps Selection Guide



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丝锥系列目录
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														P			M	K		N				S		H	
														1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
														碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
														(<35HRC)	(35-48HRC)			(<32HRC)	(<43HRC)	(Si<12%)	(Si>12%)	(<HB200)		(<HB450)	(<HB400)	(45-55HRC)	(55-60HRC)
T118	T118-FDN	高性能 通用加工挤压丝锥 High performance fluteless tap		D371/ D376	TiAl-C		≤2.5D		M4-M30	6HX	P14-17	P27		◎	○		○			◎		◎					
	T118-FDC	高性能 内冷通用加工挤压丝锥 High-performance internal coolant fluteless tap		D371/ D376	TiAl-C		≤2.5D		M4-M30	6HX	P18-19	P27		◎	○		◎			◎		◎					
	T118-FDR	高性能 内冷通用加工挤压丝锥 High-performance internal coolant fluteless tap		D371/ D376	TiAl-C		≤2.5D		M4-M30	6HX	P20-21	P27		◎	○		◎			◎		◎					
	T118-SDN	高性能 通用加工螺旋丝锥 High-performance spiral fluted tap		D371/ D376	TiAl-C		≤2.5D		M4-M16	6HX	P22	P27		◎	○		○	○	○	○	○	○					
	T118-PDN	高性能 通用加工刃倾角丝锥 High-performance spiral pointed tap		D371/ D376	TiAl-C		≤2.5D		M4-M16	6HX	P23	P27		◎	○		○	○	○	○	○	○					
T128	T128-HDN	高性能 铸铁加工直槽丝锥 High-performance cast iron machining straight fluted tap		D371/ D376	TiAl-Si		≤2.5D		M5-M16	6HX	P24	P27						◎	○								
	T128-HDC	高性能 内冷铸铁加工直槽丝锥 High-performance internal coolant cast iron machining straight fluted tap		D371/ D376	TiAl-Si		≤2.5D		M5-M16	6HX	P25	P27						◎	○								
	T128-HDR	高性能 内冷铸铁加工直槽丝锥 High-performance internal coolant cast iron machining straight fluted tap		D371/ D376	TiAl-Si		≤2.5D		M5-M16	6HX	P26	P27						◎	○								
ET138	ET138-FJN	经济型 钢用加工挤压丝锥 Economy steel machining fluteless tap		JIS	AlCrN		≤2.5D		M1-M16	RH4-10	P29-32	P62		◎			○										
	ET138-SJN	经济型 钢用加工螺旋丝锥 Economy steel machining spiral fluted tap		JIS	AlCrN		≤2.5D		M1-M16	P1-5	P33-35	P62		◎			○										
	ET138-PJN	经济型 钢用加工刃倾角丝锥 Economy steel machining spiral pointed tap		JIS	AlCrN		≤2.5D		M1-M16	P1-5	P36-38	P62		◎			○										
ET168	ET168-FJN	经济型 不锈钢加工挤压丝锥 Economy stainless steel machining fluteless tap		JIS	TiAlN		≤2.5D		M1-M16	RH4-10	P39-42	P62		○			◎										
	ET168-SJN	经济型 不锈钢加工螺旋丝锥 Economy stainless steel machining spiral fluted tap		JIS	TiAlN		≤2.5D		M1-M16	P1-5	P43-45	P62		○			◎										
	ET168-PJN	经济型 不锈钢加工刃倾角丝锥 Economy stainless steel machining spiral pointed tap		JIS	TiAlN		≤2.5D		M1-M16	P1-5	P46-48	P62		○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

丝锥系列目录
Contents of Tap Series

产品系列 Tap Series	内部型号 Tool Type	刀具名称及外形 Description and Profile		尺寸标准 Dimension Standard	涂层/牌号 Coating/Grade	适合加工孔类型 Suitable Hole Types	推荐加工深度 Drilling Depth L/D	冷却形式 Coolant Type	尺寸范围 Dimension Range	丝锥精度等级 Accuracy Class	尺寸表页码 Dimension Table Page	切削参数 Cutting Parameters		工件材料 WorkPiece Material												
														P			M	K		N				S		H	
														1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
														碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
														(<35HRC)	(35-48HRC)			(<32HRC)	(<43HRC)	(Si<12%)	(Si>12%)	(<HB200)		(<HB450)	(<HB400)	(45-55HRC)	(55-60HRC)
ET166	ET166-FJN	经济型 铜铝加工挤压丝锥 Economy copper & aluminum machining fluteless tap		JIS	DLC		≤2.5D		M1-M16	RH4-10	P49-52	P62								◎		◎						
	ET166-SJN	经济型 铜铝加工螺旋丝锥 Economy copper & aluminum machining spiral fluted tap		JIS	DLC		≤2.5D		M1-M16	P1-5	P53-55	P62								◎	◎	◎						
	ET166-PJN	经济型 铜铝加工刃倾角丝锥 Economy copper & aluminum machining spiral pointed tap		JIS	DLC		≤2.5D		M1-M16	P1-5	P56-58	P62								◎	◎	◎						
	ET128-HJN	经济型 铸铁加工直槽丝锥 Economy cast iron machining straight fluted tap		JIS	TiAl-Si		≤2.5D		M5-M16	P3-6	P59	P62					◎	○										
ET128	ET128-HJC	经济型 内冷铸铁加工直槽丝锥 Economy internal coolant cast iron machining straight fluted tap		JIS	TiAl-Si		≤2.5D		M5-M16	P3-6	P60	P62					◎	○										
	ET128-HJR	经济型 内冷铸铁加工直槽丝锥 Economy internal coolant cast iron machining hand straight fluted tap		JIS	TiAl-Si		≤2.5D		M5-M16	P3-6	P61	P62					◎	○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

丝锥选用指南 Taps Selection Guide

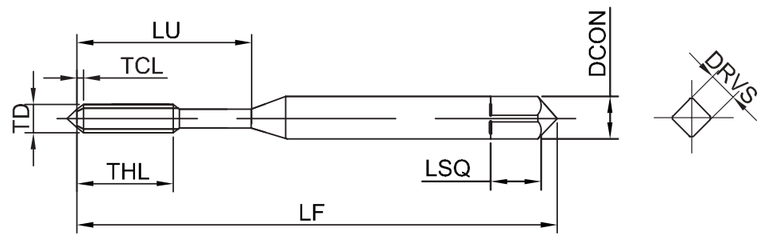
名词解释
Glossary

	图标 Sign	含义 Note
丝锥材料 Tap Material	HSS-PM	粉末冶金高速钢 Powder Metallurgy High Speed Steel
	HSSE	含钴高速钢 Cobalt-containing High Speed Steel
尺寸标准 Size Standard	DIN371/DIN376	DIN371/DIN376尺寸标准 Dimension Standard
	JIS	JIS尺寸标准 Dimension Standard
冷却方式 Cooling Method		侧向内冷 Coolant Directed Sideways
		轴向内冷 Coolant Directed Axially
		外冷 External Coolant
牙型 Tooth Type	M	ISO公制粗牙螺纹 ISO Metric Coarse Thread (DIN13)
	MF	ISO公制细牙螺纹 ISO Metric Fine Thread (DIN13)
	UNC	统一粗牙螺纹 Unified Coarse Thread (ASME B1.1)
	UNF	统一细牙螺纹 Unified Fine Thread (ASME B1.1)
孔类型 Hole Type		通孔 Through Hole
		盲孔 Blind Hole

	图标 Sign	含义 Note
涂层类型 Coating	AlCrN	铬铝涂层 Chrome Aluminum
	DLC	DLC涂层 Diamond-Like Carbon (DLC)
	TiAlN	钛铝涂层 Titanium Aluminum
	TiAl-C	钛铝碳涂层 Titanium Aluminum Carbon
	TiAl-Si	钛铝硅 Titanium Aluminum Silicon
螺纹公差等级 Thread tolerance class	ISO 6HX	丝锥公差等级 ISO 6HX Precision Grade ISO 6HX
	ISO 6H	丝锥公差等级 ISO 6H Precision Grade ISO 6H
	ISO 6H/2B	丝锥公差等级 ISO 6H/2B Precision Grade ISO 6H/2B

名词解释
Glossary

	标示 Sign	含义 Note
尺寸参数 Dimensional Parameters	TD	螺纹直径 Thread Diameter
	TP	螺纹导程 Thread pitch
	TPI	每英寸螺牙数 Threads per inch
	TCL	切削锥长度 Threading chamfer length
	THCHT	切削锥类型 Threading chamfer type
	LF	全长 Overall Length
	THL	螺纹长度 Thread Length
	LU	有效长度 Usable length
	DCON	柄径 Shank Diameter
	DRVS	方头宽度 Square Head Width
	LSQ	方头长度 Square Head Length
	CZCMS	机床连接尺寸 Square Head Length
	TDRM	推荐最大攻牙深度 Recommended Maximum Thread Depth
	NOF	槽数 Number of Flutes
	PHD	预钻孔尺寸/底孔尺寸 Premachined hole diameter
	TCTR	丝锥精度等级 Thread tolerance class
标准：采用ISO 13399 Standard: ISO 13399		



丝锥选用指南 Taps Selection Guide

金鹭丝锥内部型号
Tap Identification System

T 118 — S D C

030 050 C — 6HX

①

①丝锥大类 Tap Positioning	
T	高性能丝锥 High Performance tap
ET	经济型丝锥Economy tap

②

②丝锥系列号 Tap Series	
118	通用加工系列，主要加工PKM Universal machining, mainly machining PKM
128	铸铁加工系列 Cast Iron Machining
138	钢用加工系列 Steel Machining
166	铜铝合金加工系列 Copper & Aluminum Alloy Machining
168	不锈钢加工系列 Stainless Steel Machining

③

③丝锥类型 Tap Type	
S	螺旋丝锥 Spiral Fluted Tap
P	刃倾角丝锥 Spiral Pointed Tap
H	直槽丝锥 Straight fluted tap
F	挤压丝锥 Fluteless Tap

④

④丝锥尺寸标准 Tap Dimension Standard	
D	德标DIN标准 German standard DIN
J	日标JIS标准 Japanese standard JIS

⑤

⑤冷却方式 Cooling Method	
N	外冷 External Cooling
C	中心出水内冷 Internal Cooling with Center Outlet
R	侧边出水内冷Internal Cooling with Side Outlet

⑥

⑥螺纹直径 Thread Diameter	
030	公制丝锥直径M3 mm Metric Thread Dia.M3 mm
U0	美制No.0 Unified Thread No.0
U916	美制9/16英寸 Unified Thread 9/16 Inch

⑦

⑦螺距（公制）Pitch (metric)/ 每英寸牙数（英制）Threads per Inch (Unified)	
030	公制丝锥螺距0.5 mm Metric Pitch 0.5mm
U0	美制螺纹每英寸12个牙 Unified 12 Threads per Inch

⑧

⑧切削锥长	
A	直槽丝锥切削锥长6-8P（螺距） Hand Tap with Threading chamfer Length of 6-8P (Pitch)
B	刃倾角丝锥切削锥长3.5-5.5P（螺距） Spiral Pointed Tap with Threading chamfer Length of 3.5-5.5P (Pitch)
C	直槽丝锥或螺旋丝锥的切削锥长2-3P（螺距），或挤压丝锥挤压锥长2-3P（螺距） Hand/Spiral Fluted Tap with Threading chamfer Length of 2-3P (Pitch), Fluteless Tap with Threading chamfer Length of 2-3P (Pitch)
D	直槽丝锥或螺旋丝锥的切削锥长3.5-5P（螺距），或挤压丝锥挤压锥长3.5-5.5P（螺距） Hand/Spiral Fluted Tap with Threading chamfer Length of 3.5-5.5P (Pitch), Fluteless Tap with Threading chamfer Length of 3.5-5.5P (Pitch)
E	直槽丝锥或螺旋丝锥的切削锥长1.5-2P（螺距），或挤压丝锥挤压锥长1.5-2P（螺距） Hand/Spiral Fluted Tap with Threading chamfer Length of 1.5-2P (Pitch), Fluteless Tap with Threading chamfer Length of 1.5-2P (Pitch)
F	直槽丝锥或螺旋丝锥的切削锥长1-1.5P（螺距），或挤压丝锥挤压锥长1-1.5P（螺距） Hand/Spiral Fluted Tap with Threading chamfer Length of 1-1.5P (Pitch), Fluteless Tap with Threading chamfer Length of 1-1.5P (Pitch)

⑨

⑨丝锥精度等级 Thread Tolerance class	
6HX	丝锥精度等级 Thread Tolerance class 6HX
P2	丝锥精度等级 Thread Tolerance class P2
RH10	丝锥精度等级 Thread Tolerance class RH10

丝锥产品应用一览表
Overview of tap applications

系列定位 Series Positioning	尺寸标准 Dimensional Standard	螺纹刀具类型 Tap Type	冷却方式 Cooling Method	丝锥直径范围 Tap Diameter Range	P	M	N	K
高性能 High Performance	DIN	挤压丝锥 Fluteless Tap	外冷 External Cooling	M4-M30	T118-FDN			—
	DIN	挤压丝锥 Fluteless Tap	内冷 Internal Coolant	M4-M30	T118-FDC T118-FDR			—
	DIN	螺旋丝锥 Spiral Fluted Tap	外冷 External Cooling	M4-M16	T118-SDN			—
	DIN	刃倾角丝锥 Spiral Pointed Tap	外冷 External Cooling	M4-M16	T118-PDN			—
	DIN	直槽丝锥 Straight fluted tap	外冷 External Cooling	M5-M16	—	—	—	T128-HDN
	DIN	直槽丝锥 Straight fluted tap	内冷 Internal Coolant	M5-M16	—	—	—	T128-HDC T128-HDR
经济型 Economy	JIS	挤压丝锥 Fluteless Tap	外冷 External Cooling	M1-M16	ET138-FJN	ET168-FJN	ET166-FJN	—
	JIS	螺旋丝锥 Spiral Fluted Tap	外冷 External Cooling	M1-M16	ET138-SJN	ET168-SJN	ET166-SJN	—
	JIS	刃倾角丝锥 Spiral Pointed Tap	外冷 External Cooling	M1-M16	ET138-PJN	ET168-PJN	ET166-PJN	—
	JIS	直槽丝锥 Straight fluted tap	外冷 External Cooling	M5-M16	—	—	—	ET128-HJN
	JIS	直槽丝锥 Straight fluted tap	内冷 Internal Coolant	M5-M16	—	—	—	ET128-HJC ET128-HJR

A

高性能丝锥
High Performance Taps

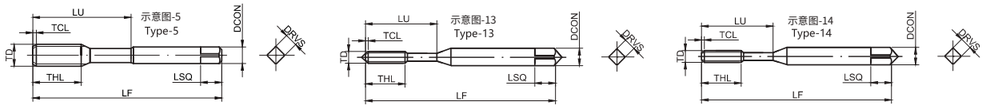


T118-FDN

M | MF | HSS-PM | DIN371/DIN376 | ISO 6HX | TiAl-C

高性能 通用加工挤压丝锥
High-performance general machining fluteless tap





订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDN-040070D-6HX	M4×0.7	4	0.7	6HX	4P	D	13	63	9	21	4.5	3.4	6	4.5×3.4	10.0	4	3.70	○
T118-FDN-040070C-6HX	M4×0.7	4	0.7	6HX	2.5P	C	14	63	9	21	4.5	3.4	6	4.5×3.4	10.0	4	3.70	●
T118-FDN-050080D-6HX	M5×0.8	5	0.8	6HX	4P	D	13	70	10	25	6	4.9	8	6×4.9	12.5	4	4.64	○
T118-FDN-050080C-6HX	M5×0.8	5	0.8	6HX	2.5P	C	14	70	10	25	6	4.9	8	6×4.9	12.5	4	4.64	●
T118-FDN-060100D-6HX	M6×1	6	1	6HX	4P	D	13	80	10	30	6	4.9	8	6×4.9	15.0	4	5.53	○
T118-FDN-060100C-6HX	M6×1	6	1	6HX	2.5P	C	14	80	10	30	6	4.9	8	6×4.9	15.0	4	5.53	●
T118-FDN-070100D-6HX	M7×1	7	1	6HX	4P	D	5	80	10	30	7	5.5	8	7×5.5	17.5	4	6.53	○
T118-FDN-070100C-6HX	M7×1	7	1	6HX	2.5P	C	5	80	10	30	7	5.5	8	7×5.5	17.5	4	6.53	○
T118-FDN-080125D-6HX	M8×1.25	8	1.25	6HX	4P	D	5	90	13	35	8	6.2	9	8×6.2	20.0	8	7.40	○
T118-FDN-080125C-6HX	M8×1.25	8	1.25	6HX	2.5P	C	5	90	13	35	8	6.2	9	8×6.2	20.0	8	7.40	●
T118-FDN-080100D-6HX	M8×1	8	1	6HX	4P	D	5	90	13	35	8	6.2	9	8×6.2	20.0	8	7.53	○
T118-FDN-080100C-6HX	M8×1	8	1	6HX	2.5P	C	5	90	13	35	8	6.2	9	8×6.2	20.0	8	7.53	○
T118-FDN-100150D-6HX	M10×1.5	10	1.5	6HX	4P	D	5	100	15	39	10	8	11	10×8	25.0	10	9.26	○
T118-FDN-100150C-6HX	M10×1.5	10	1.5	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	10	9.26	●
T118-FDN-100125D-6HX	M10×1.25	10	1.25	6HX	4P	D	5	100	15	39	10	8	11	10×8	25.0	10	9.40	○
T118-FDN-100125C-6HX	M10×1.25	10	1.25	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	10	9.40	●
T118-FDN-100100D-6HX	M10×1	10	1	6HX	4P	D	5	100	15	39	10	8	11	10×8	25.0	10	9.53	○
T118-FDN-100100C-6HX	M10×1	10	1	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	10	9.53	○
T118-FDN-120175D-6HX	M12×1.75	12	1.75	6HX	4P	D	5	110	17	49	9	7	10	9×7	30.0	10	11.13	○
T118-FDN-120175C-6HX	M12×1.75	12	1.75	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	10	11.13	●
T118-FDN-120150D-6HX	M12×1.5	12	1.5	6HX	4P	D	5	110	17	49	9	7	10	9×7	30.0	10	11.26	○
T118-FDN-120150C-6HX	M12×1.5	12	1.5	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	10	11.26	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		○			◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

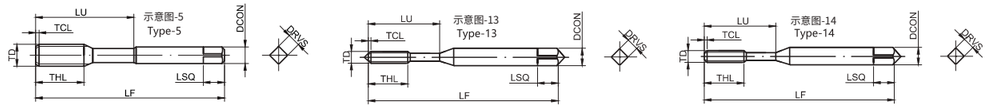
推荐切削参数 ※P27
Recommended Cutting Data ※P27

T118-FDN

M | MF | HSS-PM | DIN371/DIN376 | ISO 6HX | TiAl-C

高性能 通用加工挤压丝锥
High-performance general machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDN-120125D-6HX	M12×1.25	12	1.25	6HX	4P	D	5	110	17	49	9	7	10	9×7	30.0	10	11.40	○
T118-FDN-120125C-6HX	M12×1.25	12	1.25	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	10	11.40	●
T118-FDN-120100D-6HX	M12×1	12	1	6HX	4P	D	5	110	17	49	9	7	10	9×7	30.0	10	11.53	○
T118-FDN-120100C-6HX	M12×1	12	1	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	10	11.53	○
T118-FDN-140200D-6HX	M14×2	14	2	6HX	4P	D	5	110	20	53	11	9	12	11×9	35.0	10	12.99	○
T118-FDN-140200C-6HX	M14×2	14	2	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	10	12.99	●
T118-FDN-140150D-6HX	M14×1.5	14	1.5	6HX	4P	D	5	110	20	53	11	9	12	11×9	35.0	10	13.26	○
T118-FDN-140150C-6HX	M14×1.5	14	1.5	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	10	13.26	●
T118-FDN-140125D-6HX	M14×1.25	14	1.25	6HX	4P	D	5	110	20	53	11	9	12	11×9	35.0	10	13.40	○
T118-FDN-140125C-6HX	M14×1.25	14	1.25	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	10	13.40	○
T118-FDN-140100D-6HX	M14×1	14	1	6HX	4P	D	5	110	20	53	11	9	12	11×9	35.0	10	13.53	○
T118-FDN-140100C-6HX	M14×1	14	1	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	10	13.53	○
T118-FDN-160200D-6HX	M16×2	16	2	6HX	4P	D	5	110	20	54	12	9	12	12×9	40.0	12	14.99	○
T118-FDN-160200C-6HX	M16×2	16	2	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	12	14.99	●
T118-FDN-160150D-6HX	M16×1.5	16	1.5	6HX	4P	D	5	110	20	54	12	9	12	12×9	40.0	12	15.26	○
T118-FDN-160150C-6HX	M16×1.5	16	1.5	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	12	15.26	●
T118-FDN-160125D-6HX	M16×1.25	16	1.25	6HX	4P	D	5	110	20	54	12	9	12	12×9	40.0	12	15.40	○
T118-FDN-160125C-6HX	M16×1.25	16	1.25	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	12	15.40	○
T118-FDN-160100D-6HX	M16×1	16	1	6HX	4P	D	5	110	20	54	12	9	12	12×9	40.0	12	15.53	○
T118-FDN-160100C-6HX	M16×1	16	1	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	12	15.53	○
T118-FDN-180250D-6HX	M18×2.5	18	2.5	6HX	4P	D	5	125	25	61	14	11	14	14×11	45.0	12	16.72	○
T118-FDN-180250C-6HX	M18×2.5	18	2.5	6HX	2.5P	C	5	125	25	61	14	11	14	14×11	45.0	12	16.72	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		○			◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P27
Recommended Cutting Data ※P27

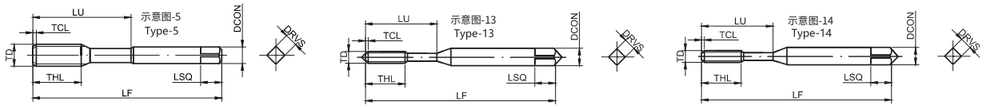
A 高性能丝锥 High Performance Taps

T118-FDN

M | MF | HSS-PM | DIN371/DIN376 | ISO 6HX | TiAl-C

高性能 通用加工挤压丝锥
High-performance general machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDN-180200D-6HX	M18×2	18	2	6HX	4P	D	5	125	25	61	14	11	14	14×11	45.0	12	16.99	○
T118-FDN-180200C-6HX	M18×2	18	2	6HX	2.5P	C	5	125	25	61	14	11	14	14×11	45.0	12	16.99	○
T118-FDN-180150D-6HX	M18×1.5	18	1.5	6HX	4P	D	5	125	25	61	14	11	14	14×11	45.0	12	17.26	○
T118-FDN-180150C-6HX	M18×1.5	18	1.5	6HX	2.5P	C	5	125	25	61	14	11	14	14×11	45.0	12	17.26	○
T118-FDN-200250D-6HX	M20×2.5	20	2.5	6HX	4P	D	5	140	25	69	16	12	15	16×12	50.0	12	18.72	○
T118-FDN-200250C-6HX	M20×2.5	20	2.5	6HX	2.5P	C	5	140	25	69	16	12	15	16×12	50.0	12	18.72	○
T118-FDN-200200D-6HX	M20×2	20	2	6HX	4P	D	5	140	25	69	16	12	15	16×12	50.0	12	18.99	○
T118-FDN-200200C-6HX	M20×2	20	2	6HX	2.5P	C	5	140	25	69	16	12	15	16×12	50.0	12	18.99	○
T118-FDN-200150D-6HX	M20×1.5	20	1.5	6HX	4P	D	5	140	25	69	16	12	15	16×12	50.0	12	19.26	○
T118-FDN-200150C-6HX	M20×1.5	20	1.5	6HX	2.5P	C	5	140	25	69	16	12	15	16×12	50.0	12	19.26	○
T118-FDN-220250D-6HX	M22×2.5	22	2.5	6HX	4P	D	5	140	25	69	18	14.5	17	18×14.5	55.0	12	20.72	○
T118-FDN-220250C-6HX	M22×2.5	22	2.5	6HX	2.5P	C	5	140	25	69	18	14.5	17	18×14.5	55.0	12	20.72	○
T118-FDN-220200D-6HX	M22×2	22	2	6HX	4P	D	5	140	25	69	18	14.5	17	18×14.5	55.0	12	20.99	○
T118-FDN-220200C-6HX	M22×2	22	2	6HX	2.5P	C	5	140	25	69	18	14.5	17	18×14.5	55.0	12	20.99	○
T118-FDN-220150D-6HX	M22×1.5	22	1.5	6HX	4P	D	5	140	25	69	18	14.5	17	18×14.5	55.0	12	21.26	○
T118-FDN-220150C-6HX	M22×1.5	22	1.5	6HX	2.5P	C	5	140	25	69	18	14.5	17	18×14.5	55.0	12	21.26	○
T118-FDN-240300D-6HX	M24×3	24	3	6HX	4P	D	5	160	30	78	18	14.5	17	18×14.5	60.0	12	22.45	○
T118-FDN-240300C-6HX	M24×3	24	3	6HX	2.5P	C	5	160	30	78	18	14.5	17	18×14.5	60.0	12	22.45	○
T118-FDN-240250D-6HX	M24×2.5	24	2.5	6HX	4P	D	5	160	30	78	18	14.5	17	18×14.5	60.0	12	22.72	○
T118-FDN-240250C-6HX	M24×2.5	24	2.5	6HX	2.5P	C	5	160	30	78	18	14.5	17	18×14.5	60.0	12	22.72	○
T118-FDN-240200D-6HX	M24×2	24	2	6HX	4P	D	5	160	30	78	18	14.5	17	18×14.5	60.0	12	22.99	○
T118-FDN-240200C-6HX	M24×2	24	2	6HX	2.5P	C	5	160	30	78	18	14.5	17	18×14.5	60.0	12	22.99	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		○			◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

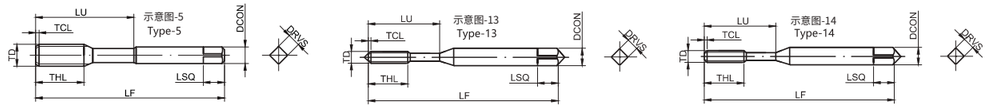
推荐切削参数 ※P27
Recommended Cutting Data ※P27

T118-FDN

M | MF | HSS-PM | DIN371/DIN376 | ISO 6HX | TiAl-C

高性能 通用加工挤压丝锥
High-performance general machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDN-270300D-6HX	M27×3	27	3	6HX	4P	D	5	160	30	78	20	16	19	20×16	67.5	12	25.45	○
T118-FDN-270300C-6HX	M27×3	27	3	6HX	2.5P	C	5	160	30	78	20	16	19	20×16	67.5	12	25.45	○
T118-FDN-270250D-6HX	M27×2.5	27	2.5	6HX	4P	D	5	160	30	78	20	16	19	20×16	67.5	12	25.72	○
T118-FDN-270250C-6HX	M27×2.5	27	2.5	6HX	2.5P	C	5	160	30	78	20	16	19	20×16	67.5	12	25.72	○
T118-FDN-270200D-6HX	M27×2	27	2	6HX	4P	D	5	160	30	78	20	16	19	20×16	67.5	12	25.99	○
T118-FDN-270200C-6HX	M27×2	27	2	6HX	2.5P	C	5	160	30	78	20	16	19	20×16	67.5	12	25.99	○
T118-FDN-300350D-6HX	M30×3.5	30	3.5	6HX	4P	D	5	180	35	88	22	18	21	22×18	75.0	12	28.18	○
T118-FDN-300350C-6HX	M30×3.5	30	3.5	6HX	2.5P	C	5	180	35	88	22	18	21	22×18	75.0	12	28.18	○
T118-FDN-300300D-6HX	M30×3	30	3	6HX	4P	D	5	180	35	88	22	18	21	22×18	75.0	12	28.45	○
T118-FDN-300300C-6HX	M30×3	30	3	6HX	2.5P	C	5	180	35	88	22	18	21	22×18	75.0	12	28.45	○
T118-FDN-300250D-6HX	M30×2.5	30	2.5	6HX	4P	D	5	180	35	88	22	18	21	22×18	75.0	12	28.72	○
T118-FDN-300250C-6HX	M30×2.5	30	2.5	6HX	2.5P	C	5	180	35	88	22	18	21	22×18	75.0	12	28.72	○
T118-FDN-300200D-6HX	M30×2	30	2	6HX	4P	D	5	180	35	88	22	18	21	22×18	75.0	12	28.99	○
T118-FDN-300200C-6HX	M30×2	30	2	6HX	2.5P	C	5	180	35	88	22	18	21	22×18	75.0	12	28.99	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		○			◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

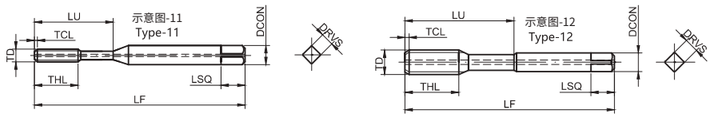
推荐切削参数 ※P27
Recommended Cutting Data ※P27

A 高性能丝锥 High Performance Taps

T118-FDC

高性能内冷通用加工挤压丝锥
High-performance internal coolant general machining fluteless tap





订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDC-040070C-6HX	M4×0.7	4	0.7	6HX	2.5P	C	11	63	9	21	4.5	3.4	6	4.5×3.4	10.0	4	3.70	○
T118-FDC-050080C-6HX	M5×0.8	5	0.8	6HX	2.5P	C	11	70	10	25	6	4.9	8	6×4.9	12.5	4	4.64	○
T118-FDC-060100C-6HX	M6×1	6	1	6HX	2.5P	C	11	80	10	30	6	4.9	8	6×4.9	15.0	4	5.53	●
T118-FDC-070100C-6HX	M7×1	7	1	6HX	2.5P	C	12	80	10	30	7	5.5	8	7×5.5	17.5	4	6.53	○
T118-FDC-080125C-6HX	M8×1.25	8	1.25	6HX	2.5P	C	12	90	13	35	8	6.2	9	8×6.2	20.0	8	7.40	●
T118-FDC-080100C-6HX	M8×1	8	1	6HX	2.5P	C	12	90	13	35	8	6.2	9	8×6.2	20.0	8	7.53	○
T118-FDC-100150C-6HX	M10×1.5	10	1.5	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25.0	10	9.26	●
T118-FDC-100125C-6HX	M10×1.25	10	1.25	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25.0	10	9.40	○
T118-FDC-100100C-6HX	M10×1	10	1	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25.0	10	9.53	○
T118-FDC-120175C-6HX	M12×1.75	12	1.75	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	10	11.13	●
T118-FDC-120150C-6HX	M12×1.5	12	1.5	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	10	11.26	○
T118-FDC-120125C-6HX	M12×1.25	12	1.25	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	10	11.40	○
T118-FDC-120100C-6HX	M12×1	12	1	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	10	11.53	○
T118-FDC-140200C-6HX	M14×2	14	2	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	10	12.99	○
T118-FDC-140150C-6HX	M14×1.5	14	1.5	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	10	13.26	○
T118-FDC-140125C-6HX	M14×1.25	14	1.25	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	10	13.40	○
T118-FDC-140100C-6HX	M14×1	14	1	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	10	13.53	○
T118-FDC-160200C-6HX	M16×2	16	2	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	12	14.99	○
T118-FDC-160150C-6HX	M16×1.5	16	1.5	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	12	15.26	○
T118-FDC-160125C-6HX	M16×1.25	16	1.25	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	12	15.40	○
T118-FDC-160100C-6HX	M16×1	16	1	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	12	15.53	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		◎			◎		◎					

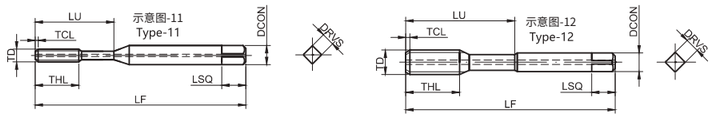
◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P27
Recommended Cutting Data ※P27

T118-FDC

高性能内冷通用加工挤压丝锥
High-performance internal coolant general machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDC-180250C-6HX	M18×2.5	18	2.5	6HX	2.5P	C	12	125	25	61	14	11	14	14×11	45.0	12	16.72	○
T118-FDC-180200C-6HX	M18×2	18	2	6HX	2.5P	C	12	125	25	61	14	11	14	14×11	45.0	12	16.99	○
T118-FDC-180150C-6HX	M18×1.5	18	1.5	6HX	2.5P	C	12	125	25	61	14	11	14	14×11	45.0	12	17.26	○
T118-FDC-200250C-6HX	M20×2.5	20	2.5	6HX	2.5P	C	12	140	25	69	16	12	15	16×12	50.0	12	18.72	○
T118-FDC-200200C-6HX	M20×2	20	2	6HX	2.5P	C	12	140	25	69	16	12	15	16×12	50.0	12	18.99	○
T118-FDC-200150C-6HX	M20×1.5	20	1.5	6HX	2.5P	C	12	140	25	69	16	12	15	16×12	50.0	12	19.26	○
T118-FDC-220250C-6HX	M22×2.5	22	2.5	6HX	2.5P	C	12	140	25	69	18	14.5	17	18×14.5	55.0	12	20.72	○
T118-FDC-220200C-6HX	M22×2	22	2	6HX	2.5P	C	12	140	25	69	18	14.5	17	18×14.5	55.0	12	20.99	○
T118-FDC-220150C-6HX	M22×1.5	22	1.5	6HX	2.5P	C	12	140	25	69	18	14.5	17	18×14.5	55.0	12	21.26	○
T118-FDC-240300C-6HX	M24×3	24	3	6HX	2.5P	C	12	160	30	78	18	14.5	17	18×14.5	60.0	12	22.45	○
T118-FDC-240250C-6HX	M24×2.5	24	2.5	6HX	2.5P	C	12	160	30	78	18	14.5	17	18×14.5	60.0	12	22.72	○
T118-FDC-240200C-6HX	M24×2	24	2	6HX	2.5P	C	12	160	30	78	18	14.5	17	18×14.5	60.0	12	22.99	○
T118-FDC-270300C-6HX	M27×3	27	3	6HX	2.5P	C	12	160	30	78	20	16	19	20×16	67.5	12	25.45	○
T118-FDC-270250C-6HX	M27×2.5	27	2.5	6HX	2.5P	C	12	160	30	78	20	16	19	20×16	67.5	12	25.72	○
T118-FDC-270200C-6HX	M27×2	27	2	6HX	2.5P	C	12	160	30	78	20	16	19	20×16	67.5	12	25.99	○
T118-FDC-300350C-6HX	M30×3.5	30	3.5	6HX	2.5P	C	12	180	35	88	22	18	21	22×18	75.0	12	28.18	○
T118-FDC-300300C-6HX	M30×3	30	3	6HX	2.5P	C	12	180	35	88	22	18	21	22×18	75.0	12	28.45	○
T118-FDC-300250C-6HX	M30×2.5	30	2.5	6HX	2.5P	C	12	180	35	88	22	18	21	22×18	75.0	12	28.72	○
T118-FDC-300200C-6HX	M30×2	30	2	6HX	2.5P	C	12	180	35	88	22	18	21	22×18	75.0	12	28.99	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		◎			◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

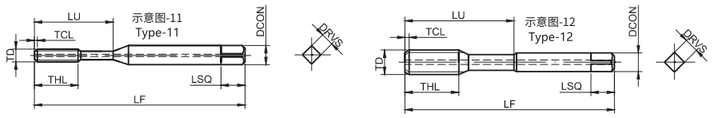
推荐切削参数 ※P27
Recommended Cutting Data ※P27

A 高性能丝锥 High Performance Taps

T118-FDR



高性能内冷通用加工挤压丝锥
High-performance internal coolant general machining fluteless tap



订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDR-040070D-6HX	M4×0.7	4	0.7	6HX	4P	D	11	63	9	21	4.5	3.4	6	4.5×3.4	10.0	4	3.70	○
T118-FDR-050080D-6HX	M5×0.8	5	0.8	6HX	4P	D	11	70	10	25	6	4.9	8	6×4.9	12.5	4	4.64	○
T118-FDR-060100D-6HX	M6×1	6	1	6HX	4P	D	11	80	10	30	6	4.9	8	6×4.9	15.0	4	5.53	○
T118-FDR-070100D-6HX	M7×1	7	1	6HX	4P	D	12	80	10	30	7	5.5	8	7×5.5	17.5	4	6.53	○
T118-FDR-080125D-6HX	M8×1.25	8	1.25	6HX	4P	D	12	90	13	35	8	6.2	9	8×6.2	20.0	8	7.40	○
T118-FDR-080100D-6HX	M8×1	8	1	6HX	4P	D	12	90	13	35	8	6.2	9	8×6.2	20.0	8	7.53	○
T118-FDR-100150D-6HX	M10×1.5	10	1.5	6HX	4P	D	12	100	15	39	10	8	11	10×8	25.0	10	9.26	○
T118-FDR-100125D-6HX	M10×1.25	10	1.25	6HX	4P	D	12	100	15	39	10	8	11	10×8	25.0	10	9.40	○
T118-FDR-100100D-6HX	M10×1	10	1	6HX	4P	D	12	100	15	39	10	8	11	10×8	25.0	10	9.53	○
T118-FDR-120175D-6HX	M12×1.75	12	1.75	6HX	4P	D	12	110	17	49	9	7	10	9×7	30.0	10	11.13	○
T118-FDR-120150D-6HX	M12×1.5	12	1.5	6HX	4P	D	12	110	17	49	9	7	10	9×7	30.0	10	11.26	○
T118-FDR-120125D-6HX	M12×1.25	12	1.25	6HX	4P	D	12	110	17	49	9	7	10	9×7	30.0	10	11.40	○
T118-FDR-120100D-6HX	M12×1	12	1	6HX	4P	D	12	110	17	49	9	7	10	9×7	30.0	10	11.53	○
T118-FDR-140200D-6HX	M14×2	14	2	6HX	4P	D	12	110	20	53	11	9	12	11×9	35.0	10	12.99	○
T118-FDR-140150D-6HX	M14×1.5	14	1.5	6HX	4P	D	12	110	20	53	11	9	12	11×9	35.0	10	13.26	○
T118-FDR-140125D-6HX	M14×1.25	14	1.25	6HX	4P	D	12	110	20	53	11	9	12	11×9	35.0	10	13.40	○
T118-FDR-140100D-6HX	M14×1	14	1	6HX	4P	D	12	110	20	53	11	9	12	11×9	35.0	10	13.53	○
T118-FDR-160200D-6HX	M16×2	16	2	6HX	4P	D	12	110	20	54	12	9	12	12×9	40.0	12	14.99	○
T118-FDR-160150D-6HX	M16×1.5	16	1.5	6HX	4P	D	12	110	20	54	12	9	12	12×9	40.0	12	15.26	○
T118-FDR-160125D-6HX	M16×1.25	16	1.25	6HX	4P	D	12	110	20	54	12	9	12	12×9	40.0	12	15.40	○
T118-FDR-160100D-6HX	M16×1	16	1	6HX	4P	D	12	110	20	54	12	9	12	12×9	40.0	12	15.53	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material														
P			M	K		N				S		H		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		◎			◎		◎					

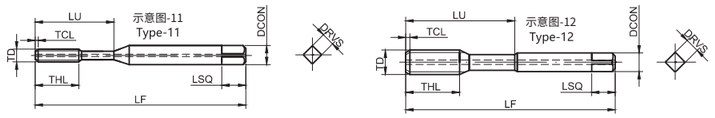
◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P27
Recommended Cutting Data ※P27

T118-FDR



高性能内冷通用加工挤压丝锥
High-performance internal coolant general machining fluteless tap



》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-FDR-180250D-6HX	M18×2.5	18	2.5	6HX	4P	D	12	125	25	61	14	11	14	14×11	45.0	12	16.72	○
T118-FDR-180200D-6HX	M18×2	18	2	6HX	4P	D	12	125	25	61	14	11	14	14×11	45.0	12	16.99	○
T118-FDR-180150D-6HX	M18×1.5	18	1.5	6HX	4P	D	12	125	25	61	14	11	14	14×11	45.0	12	17.26	○
T118-FDR-200250D-6HX	M20×2.5	20	2.5	6HX	4P	D	12	140	25	69	16	12	15	16×12	50.0	12	18.72	○
T118-FDR-200200D-6HX	M20×2	20	2	6HX	4P	D	12	140	25	69	16	12	15	16×12	50.0	12	18.99	○
T118-FDR-200150D-6HX	M20×1.5	20	1.5	6HX	4P	D	12	140	25	69	16	12	15	16×12	50.0	12	19.26	○
T118-FDR-220250D-6HX	M22×2.5	22	2.5	6HX	4P	D	12	140	25	69	18	14.5	17	18×14.5	55.0	12	20.72	○
T118-FDR-220200D-6HX	M22×2	22	2	6HX	4P	D	12	140	25	69	18	14.5	17	18×14.5	55.0	12	20.99	○
T118-FDR-220150D-6HX	M22×1.5	22	1.5	6HX	4P	D	12	140	25	69	18	14.5	17	18×14.5	55.0	12	21.26	○
T118-FDR-240300D-6HX	M24×3	24	3	6HX	4P	D	12	160	30	78	18	14.5	17	18×14.5	60.0	12	22.45	○
T118-FDR-240250D-6HX	M24×2.5	24	2.5	6HX	4P	D	12	160	30	78	18	14.5	17	18×14.5	60.0	12	22.72	○
T118-FDR-240200D-6HX	M24×2	24	2	6HX	4P	D	12	160	30	78	18	14.5	17	18×14.5	60.0	12	22.99	○
T118-FDR-270300D-6HX	M27×3	27	3	6HX	4P	D	12	160	30	78	20	16	19	20×16	67.5	12	25.45	○
T118-FDR-270250D-6HX	M27×2.5	27	2.5	6HX	4P	D	12	160	30	78	20	16	19	20×16	67.5	12	25.72	○
T118-FDR-270200D-6HX	M27×2	27	2	6HX	4P	D	12	160	30	78	20	16	19	20×16	67.5	12	25.99	○
T118-FDR-300350D-6HX	M30×3.5	30	3.5	6HX	4P	D	12	180	35	88	22	18	21	22×18	75.0	12	28.18	○
T118-FDR-300300D-6HX	M30×3	30	3	6HX	4P	D	12	180	35	88	22	18	21	22×18	75.0	12	28.45	○
T118-FDR-300250D-6HX	M30×2.5	30	2.5	6HX	4P	D	12	180	35	88	22	18	21	22×18	75.0	12	28.72	○
T118-FDR-300200D-6HX	M30×2	30	2	6HX	4P	D	12	180	35	88	22	18	21	22×18	75.0	12	28.99	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material														
P			M	K		N				S		H		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		◎			◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

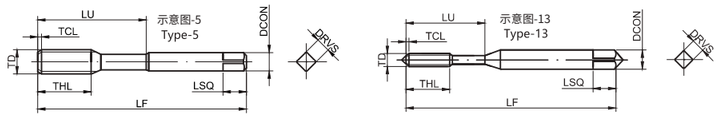
推荐切削参数 ※P27
Recommended Cutting Data ※P27

A 高性能丝锥 High Performance Taps

T118-SDN



高性能通用加工螺旋丝锥
High-performance general machining spiral fluted tap



订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-SDN-040070C-6HX	M4×0.7	4	0.7	6HX	2.5P	C	13	63	9	21	4.5	3.4	6	4.5×3.4	10.0	3	3.30	●
T118-SDN-050080C-6HX	M5×0.8	5	0.8	6HX	2.5P	C	13	70	10	25	6	4.9	8	6×4.9	12.5	3	4.20	●
T118-SDN-060100C-6HX	M6×1	6	1	6HX	2.5P	C	13	80	10	30	6	4.9	8	6×4.9	15.0	3	5.00	●
T118-SDN-070100C-6HX	M7×1	7	1	6HX	2.5P	C	5	80	10	30	7	5.5	8	7×5.5	17.5	3	6.00	○
T118-SDN-080125C-6HX	M8×1.25	8	1.25	6HX	2.5P	C	5	90	13	35	8	6.2	9	8×6.2	20.0	3	6.75	●
T118-SDN-080100C-6HX	M8×1	8	1	6HX	2.5P	C	5	90	13	35	8	6.2	9	8×6.2	20.0	3	7.00	●
T118-SDN-100150C-6HX	M10×1.5	10	1.5	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	3	8.50	●
T118-SDN-100125C-6HX	M10×1.25	10	1.25	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	3	8.75	●
T118-SDN-100100C-6HX	M10×1	10	1	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	3	9.00	○
T118-SDN-120175C-6HX	M12×1.75	12	1.75	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	3	10.25	●
T118-SDN-120150C-6HX	M12×1.5	12	1.5	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	3	10.50	●
T118-SDN-120125C-6HX	M12×1.25	12	1.25	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	3	10.75	●
T118-SDN-120100C-6HX	M12×1	12	1	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	3	11.00	○
T118-SDN-140200C-6HX	M14×2	14	2	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	12.00	●
T118-SDN-140150C-6HX	M14×1.5	14	1.5	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	12.50	●
T118-SDN-140125C-6HX	M14×1.25	14	1.25	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	12.75	○
T118-SDN-140100C-6HX	M14×1	14	1	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	13.00	○
T118-SDN-160200C-6HX	M16×2	16	2	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	14.00	●
T118-SDN-160150C-6HX	M16×1.5	16	1.5	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	14.50	●
T118-SDN-160125C-6HX	M16×1.25	16	1.25	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	14.75	○
T118-SDN-160100C-6HX	M16×1	16	1	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。 PHD for referance only.

工件材料 Workpiece Material														
P			M	K		N				S		H		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		○	○	○	○	○	○					

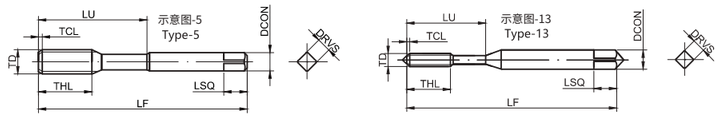
◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P27
Recommended Cutting Data ※P27

T118-PDN



高性能 通用加工刃倾角丝锥
High-performance general machining spiral pointed tap



订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T118-PDN-040070B-6HX	M4×0.7	4	0.7	6HX	5P	B	13	63	9	21	4.5	3.4	6	4.5×3.4	10.0	3	3.30	●
T118-PDN-050080B-6HX	M5×0.8	5	0.8	6HX	5P	B	13	70	10	25	6	4.9	8	6×4.9	12.5	3	4.20	●
T118-PDN-060100B-6HX	M6×1	6	1	6HX	5P	B	13	80	10	30	6	4.9	8	6×4.9	15.0	3	5.00	●
T118-PDN-070100B-6HX	M7×1	7	1	6HX	5P	B	5	80	10	30	7	5.5	8	7×5.5	17.5	3	6.00	○
T118-PDN-080125B-6HX	M8×1.25	8	1.25	6HX	5P	B	5	90	13	35	8	6.2	9	8×6.2	20.0	3	6.75	●
T118-PDN-080100B-6HX	M8×1	8	1	6HX	5P	B	5	90	13	35	8	6.2	9	8×6.2	20.0	3	7.00	●
T118-PDN-100150B-6HX	M10×1.5	10	1.5	6HX	5P	B	5	100	15	39	10	8	11	10×8	25.0	3	8.50	●
T118-PDN-100125B-6HX	M10×1.25	10	1.25	6HX	5P	B	5	100	15	39	10	8	11	10×8	25.0	3	8.75	●
T118-PDN-100100B-6HX	M10×1	10	1	6HX	5P	B	5	100	15	39	10	8	11	10×8	25.0	3	9.00	○
T118-PDN-120175B-6HX	M12×1.75	12	1.75	6HX	5P	B	5	110	17	49	9	7	10	9×7	30.0	4	10.25	●
T118-PDN-120150B-6HX	M12×1.5	12	1.5	6HX	5P	B	5	110	17	49	9	7	10	9×7	30.0	4	10.50	●
T118-PDN-120125B-6HX	M12×1.25	12	1.25	6HX	5P	B	5	110	17	49	9	7	10	9×7	30.0	4	10.75	●
T118-PDN-120100B-6HX	M12×1	12	1	6HX	5P	B	5	110	17	49	9	7	10	9×7	30.0	4	11.00	○
T118-PDN-140200B-6HX	M14×2	14	2	6HX	5P	B	5	110	20	53	11	9	12	11×9	35.0	4	12.00	●
T118-PDN-140150B-6HX	M14×1.5	14	1.5	6HX	5P	B	5	110	20	53	11	9	12	11×9	35.0	4	12.50	●
T118-PDN-140125B-6HX	M14×1.25	14	1.25	6HX	5P	B	5	110	20	53	11	9	12	11×9	35.0	4	12.75	○
T118-PDN-140100B-6HX	M14×1	14	1	6HX	5P	B	5	110	20	53	11	9	12	11×9	35.0	4	13.00	○
T118-PDN-160200B-6HX	M16×2	16	2	6HX	5P	B	5	110	20	54	12	9	12	12×9	40.0	4	14.00	●
T118-PDN-160150B-6HX	M16×1.5	16	1.5	6HX	5P	B	5	110	20	54	12	9	12	12×9	40.0	4	14.50	●
T118-PDN-160125B-6HX	M16×1.25	16	1.25	6HX	5P	B	5	110	20	54	12	9	12	12×9	40.0	4	14.75	○
T118-PDN-160100B-6HX	M16×1	16	1	6HX	5P	B	5	110	20	54	12	9	12	12×9	40.0	4	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。 PHD for referance only.

工件材料 Workpiece Material														
P			M	K		N				S		H		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎	○		○	○	○	○	○	○					

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P27
Recommended Cutting Data ※P27

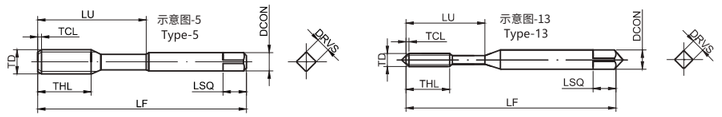
A 高性能丝锥 High Performance Taps

T128-HDN



高性能 铸铁加工直槽丝锥

High-performance cast iron machining hand tap



订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T128-HDN-050080C-6HX	M5×0.8	5	0.8	6HX	2.5P	C	13	70	10	25	6	4.9	8	6×4.9	12.5	3	4.20	●
T128-HDN-060100C-6HX	M6×1	6	1	6HX	2.5P	C	13	80	10	30	6	4.9	8	6×4.9	15.0	3	5.00	●
T128-HDN-070100C-6HX	M7×1	7	1	6HX	2.5P	C	13	80	10	30	7	5.5	8	7×5.5	17.5	3	6.00	○
T128-HDN-080125C-6HX	M8×1.25	8	1.25	6HX	2.5P	C	5	90	13	35	8	6.2	9	8×6.2	20.0	4	6.75	●
T128-HDN-080100C-6HX	M8×1	8	1	6HX	2.5P	C	5	90	13	35	8	6.2	9	8×6.2	20.0	4	7.00	○
T128-HDN-100150C-6HX	M10×1.5	10	1.5	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	4	8.50	●
T128-HDN-100125C-6HX	M10×1.25	10	1.25	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	4	8.75	●
T128-HDN-100100C-6HX	M10×1	10	1	6HX	2.5P	C	5	100	15	39	10	8	11	10×8	25.0	4	9.00	○
T128-HDN-120175C-6HX	M12×1.75	12	1.75	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	4	10.25	●
T128-HDN-120150C-6HX	M12×1.5	12	1.5	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	4	10.50	●
T128-HDN-120125C-6HX	M12×1.25	12	1.25	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	4	10.75	○
T128-HDN-120100C-6HX	M12×1	12	1	6HX	2.5P	C	5	110	17	49	9	7	10	9×7	30.0	4	11.00	○
T128-HDN-140200C-6HX	M14×2	14	2	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	12.00	●
T128-HDN-140150C-6HX	M14×1.5	14	1.5	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	12.50	●
T128-HDN-140125C-6HX	M14×1.25	14	1.25	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	12.75	○
T128-HDN-140100C-6HX	M14×1	14	1	6HX	2.5P	C	5	110	20	53	11	9	12	11×9	35.0	4	13.00	○
T128-HDN-160200C-6HX	M16×2	16	2	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	14.00	●
T128-HDN-160150C-6HX	M16×1.5	16	1.5	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	14.50	●
T128-HDN-160125C-6HX	M16×1.25	16	1.25	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	14.75	○
T128-HDN-160100C-6HX	M16×1	16	1	6HX	2.5P	C	5	110	20	54	12	9	12	12×9	40.0	4	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。 PHD for referance only.

工件材料 Workpiece Material																		
P			M	K		N				S		H						
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2					
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels					
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC					
				◎	○													

◎ 最适合 Most Suitable ○ 适合 Suitabel

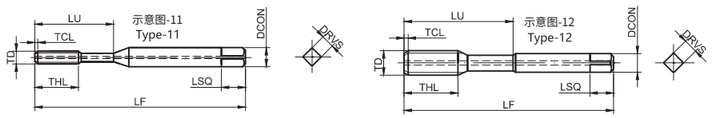
推荐切削参数 ※P27
Recommended Cutting Data ※P27

T128-HDC



高性能 内冷铸铁加工直槽丝锥

High-performance internal cooling cast iron machining hand tap



订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T128-HDC-050080C-6HX	M5×0.8	5	0.8	6HX	2.5P	C	11	70	10	25	6	4.9	8	6×4.9	12.5	3	4.20	○
T128-HDC-060100C-6HX	M6×1	6	1	6HX	2.5P	C	11	80	10	30	6	4.9	8	6×4.9	15	3	5.00	○
T128-HDC-070100C-6HX	M7×1	7	1	6HX	2.5P	C	11	80	10	30	7	5.5	8	7×5.5	17.5	3	6.00	○
T128-HDC-080125C-6HX	M8×1.25	8	1.25	6HX	2.5P	C	12	90	13	35	8	6.2	9	8×6.2	20	4	6.75	○
T128-HDC-080100C-6HX	M8×1	8	1	6HX	2.5P	C	12	90	13	35	8	6.2	9	8×6.2	20	4	7.00	○
T128-HDC-100150C-6HX	M10×1.5	10	1.5	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25	4	8.50	○
T128-HDC-100125C-6HX	M10×1.25	10	1.25	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25	4	8.75	○
T128-HDC-100100C-6HX	M10×1	10	1	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25	4	9.00	○
T128-HDC-120175C-6HX	M12×1.75	12	1.75	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30	4	10.25	○
T128-HDC-120150C-6HX	M12×1.5	12	1.5	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30	4	10.50	○
T128-HDC-120125C-6HX	M12×1.25	12	1.25	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30	4	10.75	○
T128-HDC-120100C-6HX	M12×1	12	1	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30	4	11.00	○
T128-HDC-140200C-6HX	M14×2	14	2	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35	4	12.00	○
T128-HDC-140150C-6HX	M14×1.5	14	1.5	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35	4	12.50	○
T128-HDC-140125C-6HX	M14×1.25	14	1.25	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35	4	12.75	○
T128-HDC-140100C-6HX	M14×1	14	1	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35	4	13.00	○
T128-HDC-160200C-6HX	M16×2	16	2	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40	4	14.00	○
T128-HDC-160150C-6HX	M16×1.5	16	1.5	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40	4	14.50	○
T128-HDC-160125C-6HX	M16×1.25	16	1.25	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40	4	14.75	○
T128-HDC-160100C-6HX	M16×1	16	1	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40	4	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。 PHD for referance only.

工件材料 Workpiece Material																		
P			M	K		N				S		H						
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2					
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels					
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC					
				◎	○													

◎ 最适合 Most Suitable ○ 适合 Suitabel

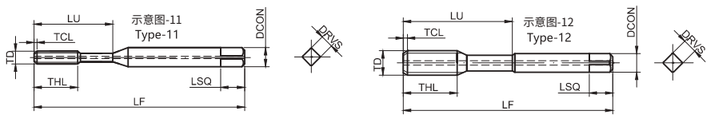
推荐切削参数 ※P27
Recommended Cutting Data ※P27

A 高性能丝锥 High Performance Taps

T128-HDR

高性能 内冷铸铁加工直槽丝锥
High-performance internal cooling cast iron machining hand tap





订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
T128-HDR-050080C-6HX	M5×0.8	5	0.8	6HX	2.5P	C	11	70	10	25	6	4.9	8	6×4.9	12.5	3	4.20	○
T128-HDR-060100C-6HX	M6×1	6	1	6HX	2.5P	C	11	80	10	30	6	4.9	8	6×4.9	15.0	3	5.00	○
T128-HDR-070100C-6HX	M7×1	7	1	6HX	2.5P	C	11	80	10	30	7	5.5	8	7×5.5	17.5	3	6.00	○
T128-HDR-080125C-6HX	M8×1.25	8	1.25	6HX	2.5P	C	12	90	13	35	8	6.2	9	8×6.2	20.0	4	6.75	○
T128-HDR-080100C-6HX	M8×1	8	1	6HX	2.5P	C	12	90	13	35	8	6.2	9	8×6.2	20.0	4	7.00	○
T128-HDR-100150C-6HX	M10×1.5	10	1.5	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25.0	4	8.50	○
T128-HDR-100125C-6HX	M10×1.25	10	1.25	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25.0	4	8.75	○
T128-HDR-100100C-6HX	M10×1	10	1	6HX	2.5P	C	12	100	15	39	10	8	11	10×8	25.0	4	9.00	○
T128-HDR-120175C-6HX	M12×1.75	12	1.75	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	4	10.25	○
T128-HDR-120150C-6HX	M12×1.5	12	1.5	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	4	10.50	○
T128-HDR-120125C-6HX	M12×1.25	12	1.25	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	4	10.75	○
T128-HDR-120100C-6HX	M12×1	12	1	6HX	2.5P	C	12	110	17	49	9	7	10	9×7	30.0	4	11.00	○
T128-HDR-140200C-6HX	M14×2	14	2	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	4	12.00	○
T128-HDR-140150C-6HX	M14×1.5	14	1.5	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	4	12.50	○
T128-HDR-140125C-6HX	M14×1.25	14	1.25	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	4	12.75	○
T128-HDR-140100C-6HX	M14×1	14	1	6HX	2.5P	C	12	110	20	53	11	9	12	11×9	35.0	4	13.00	○
T128-HDR-160200C-6HX	M16×2	16	2	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	4	14.00	○
T128-HDR-160150C-6HX	M16×1.5	16	1.5	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	4	14.50	○
T128-HDR-160125C-6HX	M16×1.25	16	1.25	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	4	14.75	○
T128-HDR-160100C-6HX	M16×1	16	1	6HX	2.5P	C	12	110	20	54	12	9	12	12×9	40.0	4	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。 PHD for referance only.

工件材料 Workpiece Material																	
P			M	K		N				S			H				
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4		1	2			
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys		淬硬钢 Hardened Steels	淬硬钢 Hardened Steels			
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400		45-55HRC	55-60HRC			
				◎	○												

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P27
Recommended Cutting Data ※P27

高性能丝锥切削速度表
High Performance Tap Cutting Speed Table

工件材料 Workpiece Material		T118-FDN	T118-FDC T118-FDR	T118-SDN	T118-PDN	T128-HDN	T128-HDC T128-HDR
		外冷 External Cooling	内冷 Internal Coolant	外冷 External Cooling			内冷 Internal Coolant
P	低碳钢 Low carbon steel (＜125HB)	10-25	15-30	15-25	15-25		
P	高碳钢及合金钢 High carbon steel and alloy steel (＜35HRC)	8-20	15-25	10-20	10-20		
P	调质钢和工具钢 (35-48HRC) Quenched and tempered steel and tool steel	5-12	5-15	5-15	5-15		5-20
M	奥氏体不锈钢 (35-48HRC) Austenitic stainless steel (130-200HB) (130-200HB)	10-25	15-30	10-25	10-25		
M	高强度的奥氏体和铸造不锈钢 High-strength austenitic and cast stainless steel (＜25HRC)	8-20	15-25	10-25	10-25		
M	双相不锈钢 Duplex stainless steel (＜30HRC)	5-12	5-15	5-12	5-12		
K	灰铸铁和球墨铸铁 Gray cast iron and ductile iron (＜32HRC)			10-20	10-20	20-40	30-50
K	高合金铸铁 Gray cast iron and ductile iron (＜43HRC)			5-15	5-15	10-25	15-35
N	锻造铝合金和铸造铝合金 Forged aluminum alloy and cast aluminum alloy (Si＜12%)	20-50	30-60	20-50	20-50		
N	铸造铝合金 Cast aluminum alloy (Si＞12%)			10-35	10-35		
N	铜合金 Copper alloy (＜HB200)	20-50	30-60	20-50	20-50		

【注意Note】
1.建议使用刚性较高的机床加工。
It is recommended to use a machine with higher rigidity for machining.
2.推荐使用丝锥专用刀柄加工。
The use of a specialized tap handle for machining is also recommended.
3. 表中切削参数为推荐参数，加工时请根据实际加工情况适当调整切削参数。
During the machining process, please adjust the cutting parameters according to the actual conditions.

单位:m/min
unit:m/min

A 高性能丝锥 High Performance Taps

B

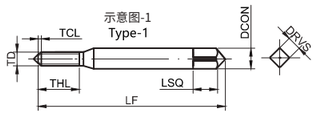
经济型丝锥
Economy Taps

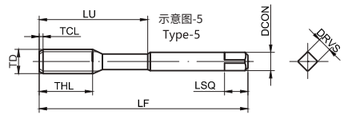


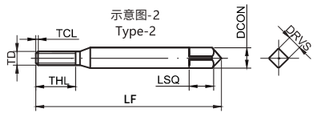
ET138-FJN

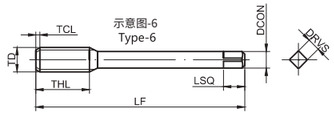
经济型 钢用加工挤压丝锥
Economical steel machining fluteless tap











订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-FJN-010025D-RH4	M1×0.25	1	0.25	RH4	4P	D	1	32	4.5	—	3	2.5	3	3×2.5	2.5	—	0.92	○
ET138-FJN-010025E-RH4	M1×0.25	1	0.25	RH4	2P	E	2	31	3.5	—	3	2.5	3	3×2.5	2.5	—	0.92	○
ET138-FJN-012025D-RH4	M1.2×0.25	1.2	0.25	RH4	4P	D	1	32	4.5	—	3	2.5	3	3×2.5	3.0	—	1.12	○
ET138-FJN-012025E-RH4	M1.2×0.25	1.2	0.25	RH4	2P	E	2	31	3.5	—	3	2.5	3	3×2.5	3.0	—	1.12	○
ET138-FJN-014030D-RH4	M1.4×0.3	1.4	0.3	RH4	4P	D	1	37	6.5	—	3	2.5	3	3×2.5	3.5	—	1.29	○
ET138-FJN-014030E-RH4	M1.4×0.3	1.4	0.3	RH4	2P	E	2	36	6.5	—	3	2.5	3	3×2.5	3.5	—	1.29	○
ET138-FJN-016035D-RH4	M1.6×0.35	1.6	0.35	RH4	4P	D	1	37	8	—	3	2.5	3	3×2.5	4.0	—	1.46	○
ET138-FJN-016035E-RH4	M1.6×0.35	1.6	0.35	RH4	2P	E	2	35.5	8	—	3	2.5	3	3×2.5	4.0	—	1.46	○
ET138-FJN-017035D-RH4	M1.7×0.35	1.7	0.35	RH4	4P	D	1	37	8	—	3	2.5	3	3×2.5	4.3	—	1.56	○
ET138-FJN-017035E-RH4	M1.7×0.35	1.7	0.35	RH4	2P	E	2	35.5	8	—	3	2.5	3	3×2.5	4.3	—	1.56	○
ET138-FJN-020040D-RH5	M2×0.4	2	0.4	RH5	4P	D	1	45	10	—	3	2.5	3	3×2.5	5.0	—	1.85	●
ET138-FJN-020040E-RH5	M2×0.4	2	0.4	RH5	2P	E	2	43.5	10	—	3	2.5	3	3×2.5	5.0	—	1.85	●
ET138-FJN-023040D-RH5	M2.3×0.4	2.3	0.4	RH5	4P	D	1	45	10	—	3	2.5	3	3×2.5	5.8	—	2.15	○
ET138-FJN-023040E-RH5	M2.3×0.4	2.3	0.4	RH5	2P	E	2	43.5	10	—	3	2.5	3	3×2.5	5.8	—	2.15	○
ET138-FJN-025045D-RH5	M2.5×0.45	2.5	0.45	RH5	4P	D	1	45	13	—	3	2.5	3	3×2.5	6.3	—	2.32	●
ET138-FJN-025045E-RH5	M2.5×0.45	2.5	0.45	RH5	2P	E	2	43.5	13	—	3	2.5	3	3×2.5	6.3	—	2.32	●
ET138-FJN-026045D-RH5	M2.6×0.45	2.6	0.45	RH5	4P	D	1	45	13	—	3	2.5	3	3×2.5	6.5	—	2.42	○
ET138-FJN-026045E-RH5	M2.6×0.45	2.6	0.45	RH5	2P	E	2	43.5	13	—	3	2.5	3	3×2.5	6.5	—	2.42	●
ET138-FJN-030050D-RH7	M3×0.5	3	0.5	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	7.5	—	2.82	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

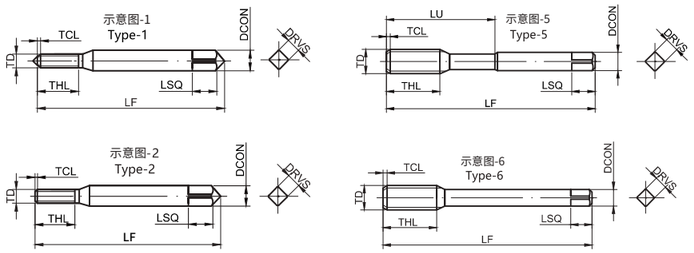
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET138-FJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | AlCrN

经济型 钢用加工挤压丝锥
Economical steel machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-FJN-030050E-RH7	M3×0.5	3	0.5	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	7.5	—	2.82	●
ET138-FJN-035060D-RH7	M3.5×0.6	3.5	0.6	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	8.8	—	3.26	●
ET138-FJN-035060E-RH7	M3.5×0.6	3.5	0.6	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	8.8	—	3.26	●
ET138-FJN-040070D-RH7	M4×0.7	4	0.7	RH7	4P	D	1	57	18	—	5	4	7	5×4	10.0	—	3.71	●
ET138-FJN-040070E-RH7	M4×0.7	4	0.7	RH7	2P	E	2	55	18	—	5	4	7	5×4	10.0	—	3.71	●
ET138-FJN-050080D-RH7	M5×0.8	5	0.8	RH7	4P	D	1	66	20	—	5.5	4.5	7	5.5×4.5	12.5	—	4.65	●
ET138-FJN-050080E-RH7	M5×0.8	5	0.8	RH7	2P	E	2	63.5	20	—	5.5	4.5	7	5.5×4.5	12.5	—	4.65	●
ET138-FJN-060100D-RH7	M6×1	6	1	RH7	4P	D	1	69	27	—	6	4.5	7	6×4.5	15.0	2	5.55	●
ET138-FJN-060100E-RH7	M6×1	6	1	RH7	2P	E	2	66.5	27	—	6	4.5	7	6×4.5	15.0	2	5.55	●
ET138-FJN-070100D-RH7	M7×1	7	1	RH7	4P	D	5	70	13	23	6.2	5	8	6.2×5	17.5	2	6.55	○
ET138-FJN-070100E-RH7	M7×1	7	1	RH7	2P	E	5	70	13	23	6.2	5	8	6.2×5	17.5	2	6.55	○
ET138-FJN-080125D-RH7	M8×1.25	8	1.25	RH7	4P	D	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.41	●
ET138-FJN-080125E-RH7	M8×1.25	8	1.25	RH7	2P	E	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.41	●
ET138-FJN-100150D-RH8	M10×1.5	10	1.5	RH8	4P	D	5	75	15	43	7	5.5	8	7×5.5	25.0	6	9.29	○
ET138-FJN-100150E-RH8	M10×1.5	10	1.5	RH8	2P	E	5	75	15	43	7	5.5	8	7×5.5	25.0	6	9.29	●
ET138-FJN-120175D-RH9	M12×1.75	12	1.75	RH9	4P	D	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	6	11.16	○
ET138-FJN-120175E-RH9	M12×1.75	12	1.75	RH9	2P	E	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	6	11.16	●
ET138-FJN-140200D-RH10	M14×2	14	2	RH10	4P	D	5	88	20	51	10.5	8	11	10.5×8	35.0	6	13.04	○
ET138-FJN-140200E-RH10	M14×2	14	2	RH10	2P	E	5	88	20	51	10.5	8	11	10.5×8	35.0	6	13.04	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

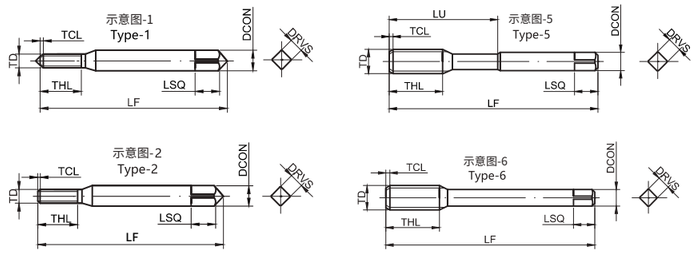
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET138-FJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | AlCrN

经济型 钢用加工挤压丝锥
Economical steel machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP /TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-FJN-160200D-RH10	M16×2	16	2	RH10	4P	D	5	95	20	52	12.5	10	13	12.5×10	40.0	6	15.04	○
ET138-FJN-160200E-RH10	M16×2	16	2	RH10	2P	E	5	95	20	52	12.5	10	13	12.5×10	40.0	6	15.04	●
ET138-FJN-U164D-RH4	NO.1-64UNC	1.854	64	RH4	4P	D	1	37	9	—	3	2.5	3	3×2.5	4.6	—	1.69	○
ET138-FJN-U164E-RH4	NO.1-64UNC	1.854	64	RH4	2P	E	2	35.5	9	—	3	2.5	3	3×2.5	4.6	—	1.69	○
ET138-FJN-U256D-RH4	NO.2-56UNC	2.184	56	RH4	4P	D	1	45	12	—	3	2.5	3	3×2.5	5.5	—	1.99	○
ET138-FJN-U256E-RH4	NO.2-56UNC	2.184	56	RH4	2P	E	2	43.5	12	—	3	2.5	3	3×2.5	5.5	—	1.99	○
ET138-FJN-U348D-RH4	NO.3-48UNC	2.515	48	RH4	4P	D	1	45	15	—	3	2.5	3	3×2.5	6.3	—	2.28	○
ET138-FJN-U348E-RH4	NO.3-48UNC	2.515	48	RH4	2P	E	2	43.5	15	—	3	2.5	3	3×2.5	6.3	—	2.28	○
ET138-FJN-U440D-RH4	NO.4-40UNC	2.845	40	RH4	4P	D	1	45	15	—	3	2.5	3	3×2.5	7.1	—	2.55	○
ET138-FJN-U440E-RH4	NO.4-40UNC	2.845	40	RH4	2P	E	2	43.5	15	—	3	2.5	3	3×2.5	7.1	—	2.55	●
ET138-FJN-U540D-RH4	NO.5-40UNC	3.175	40	RH4	4P	D	1	50	15	—	4	3.2	6	4×3.2	7.9	—	2.88	○
ET138-FJN-U540E-RH4	NO.5-40UNC	3.175	40	RH4	2P	E	2	48	15	—	4	3.2	6	4×3.2	7.9	—	2.88	●
ET138-FJN-U632D-RH7	NO.6-32UNC	3.505	32	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	8.8	—	3.16	●
ET138-FJN-U632E-RH7	NO.6-32UNC	3.505	32	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	8.8	—	3.16	●
ET138-FJN-U832D-RH7	NO.8-32UNC	4.166	32	RH7	4P	D	1	57	18	—	5	4	7	5×4	10.4	—	3.82	●
ET138-FJN-U832E-RH7	NO.8-32UNC	4.166	32	RH7	2P	E	2	54.5	18	—	5	4	7	5×4	10.4	—	3.82	●
ET138-FJN-U1024D-RH7	NO.10-24UNC	4.826	24	RH7	4P	D	1	66	20	—	5.5	4.5	7	5.5×4.5	12.1	—	4.34	●
ET138-FJN-U1024E-RH7	NO.10-24UNC	4.826	24	RH7	2P	E	2	63.5	20	—	5.5	4.5	7	5.5×4.5	12.1	—	4.34	●
ET138-FJN-U1224D-RH7	NO.12-24UNC	5.486	24	RH7	4P	D	1	66	23	—	5.5	4.5	7	5.5×4.5	13.7	—	5.00	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

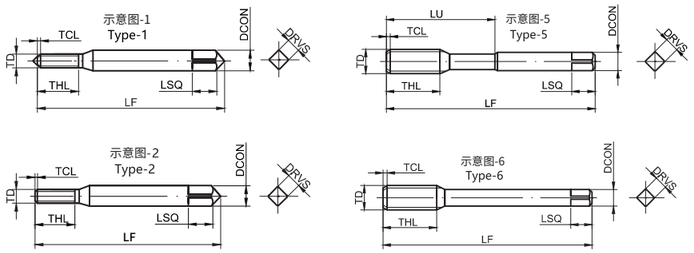
B 经济型丝锥 Economy Taps

ET138-FJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | AlCrN

经济型 钢用加工挤压丝锥
Economical steel machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-FJN-U1224E-RH7	NO.12-24UNC	5.486	24	RH7	2P	E	2	63.5	23	—	5.5	4.5	7	5.5×4.5	13.7	—	5.00	●
ET138-FJN-U1420D-RH7	1/4-20UNC	6.350	20	RH7	4P	D	6	62	27	—	6	4.5	7	6×4.5	15.9	2	5.75	●
ET138-FJN-U1420E-RH7	1/4-20UNC	6.350	20	RH7	2P	E	6	62	27	—	6	4.5	7	6×4.5	15.9	2	5.75	●
ET138-FJN-U51618D-RH8	5/16-18UNC	7.938	18	RH8	4P	D	5	70	15	30	6.1	5	8	6.1×5	19.8	3	7.27	●
ET138-FJN-U51618E-RH8	5/16-18UNC	7.938	18	RH8	2P	E	5	70	15	30	6.1	5	8	6.1×5	19.8	3	7.27	●
ET138-FJN-U3816D-RH8	3/8-16UNC	9.525	16	RH8	4P	D	5	75	16	43	7	5.5	8	7×5.5	23.8	6	8.77	●
ET138-FJN-U3816E-RH8	3/8-16UNC	9.525	16	RH8	2P	E	5	75	16	43	7	5.5	8	7×5.5	23.8	6	8.77	●
ET138-FJN-U71614D-RH8	7/16-14UNC	11.113	14	RH8	4P	D	5	80	20	40	8	6	9	8×6	27.8	6	10.23	○
ET138-FJN-U71614E-RH8	7/16-14UNC	11.113	14	RH8	2P	E	5	80	20	40	8	6	9	8×6	27.8	6	10.23	○
ET138-FJN-U1213D-RH8	1/2-13UNC	12.700	13	RH8	4P	D	5	85	21	48	9	7	10	9×7	31.8	6	11.74	○
ET138-FJN-U1213E-RH8	1/2-13UNC	12.700	13	RH8	2P	E	5	85	21	48	9	7	10	9×7	31.8	6	11.74	●
ET138-FJN-U91612D-RH9	9/16-12UNC	14.288	12	RH9	4P	D	5	90	21	50	10.5	8	11	10.5×8	35.7	6	13.25	○
ET138-FJN-U91612E-RH9	9/16-12UNC	14.288	12	RH9	2P	E	5	90	21	50	10.5	8	11	10.5×8	35.7	6	13.25	○
ET138-FJN-U5811D-RH10	5/8-11UNC	15.875	11	RH10	4P	D	5	95	23	48	12	9	12	12×9	39.7	6	14.75	○
ET138-FJN-U5811E-RH10	5/8-11UNC	15.875	11	RH10	2P	E	5	95	23	48	12	9	12	12×9	39.7	6	14.75	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

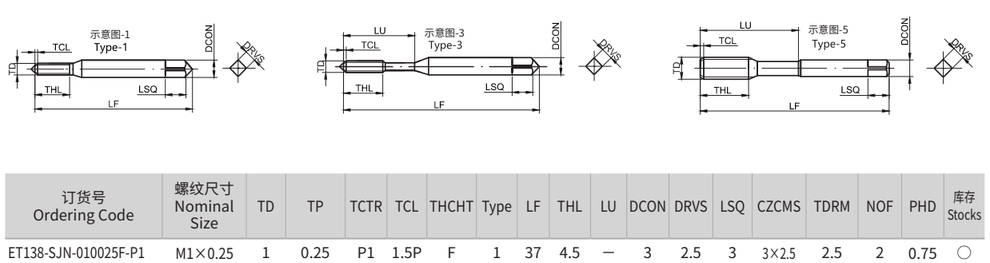
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET138-SJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | AlCrN

经济型 钢用加工螺旋丝锥
Economical steel machining spiral fluted tap





订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-SJN-010025F-P1	M1×0.25	1	0.25	P1	1.5P	F	1	37	4.5	—	3	2.5	3	3×2.5	2.5	2	0.75	○
ET138-SJN-012025F-P1	M1.2×0.25	1.2	0.25	P1	1.5P	F	1	37	4.5	—	3	2.5	3	3×2.5	3.0	2	0.95	○
ET138-SJN-014030F-P1	M1.4×0.3	1.4	0.3	P1	1.5P	F	1	37	6.5	—	3	2.5	3	3×2.5	3.5	2	1.10	○
ET138-SJN-016035F-P2	M1.6×0.35	1.6	0.35	P2	1.5P	F	1	37	8	—	3	2.5	3	3×2.5	4.0	2	1.25	○
ET138-SJN-020040C-P2	M2×0.4	2	0.4	P2	2.5P	C	1	45	11	—	3	2.5	3	3×2.5	5.0	2	1.60	●
ET138-SJN-025045C-P2	M2.5×0.45	2.5	0.45	P2	2.5P	C	1	45	12	—	3	2.5	3	3×2.5	6.3	2	2.05	●
ET138-SJN-030050C-P2	M3×0.5	3	0.5	P2	2.5P	C	3	50	5	18	4	3.2	6	4×3.2	7.5	3	2.50	●
ET138-SJN-035060C-P2	M3.5×0.6	3.5	0.6	P2	2.5P	C	3	50	6	19	4	3.2	6	4×3.2	8.8	3	2.90	○
ET138-SJN-040070C-P2	M4×0.7	4	0.7	P2	2.5P	C	3	57	9	20	5	4	7	5×4	10.0	3	3.30	●
ET138-SJN-050080C-P2	M5×0.8	5	0.8	P2	2.5P	C	3	66	8	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	●
ET138-SJN-060100C-P2	M6×1	6	1	P2	2.5P	C	3	69	12	24	6	4.5	7	6×4.5	15.0	3	5.00	●
ET138-SJN-070100C-P3	M7×1	7	1	P3	2.5P	C	3	78	13	23	6.2	5	8	6.2×5	17.5	3	6.00	●
ET138-SJN-080125C-P3	M8×1.25	8	1.25	P3	2.5P	C	5	70	13	36	6.2	5	8	6.2×5	20.0	3	6.75	●
ET138-SJN-080100C-P3	M8×1	8	1	P3	2.5P	C	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.00	●
ET138-SJN-100150C-P4	M10×1.5	10	1.5	P4	2.5P	C	5	75	15	43	7	5.5	8	7×5.5	25.0	3	8.50	●
ET138-SJN-100125C-P3	M10×1.25	10	1.25	P3	2.5P	C	5	75	13	43	7	5.5	8	7×5.5	25.0	3	8.75	●
ET138-SJN-100100C-P3	M10×1	10	1	P3	2.5P	C	5	75	13	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET138-SJN-120175C-P4	M12×1.75	12	1.75	P4	2.5P	C	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	3	10.25	●
ET138-SJN-120150C-P4	M12×1.5	12	1.5	P4	2.5P	C	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	3	10.50	●
ET138-SJN-120125C-P4	M12×1.25	12	1.25	P4	2.5P	C	5	82	13	42	8.5	6.5	9	8.5×6.5	30.0	3	10.75	●
ET138-SJN-120100C-P3	M12×1	12	1	P3	2.5P	C	5	82	13	42	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○
ET138-SJN-140200C-P5	M14×2	14	2	P5	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

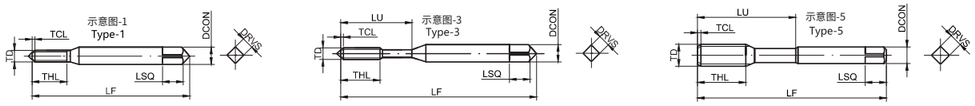
B 经济型丝锥 Economy Taps

ET138-SJN

M MF UNC UNF HSSE JIS ISO 6H/2B AlCrN

经济型 钢用加工螺旋丝锥
Economical steel machining spiral fluted tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP /TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-SJN-140150C-P4	M14×1.5	14	1.5	P4	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET138-SJN-140125C-P4	M14×1.25	14	1.25	P4	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET138-SJN-140100C-P3	M14×1	14	1	P3	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET138-SJN-160200C-P5	M16×2	16	2	P5	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET138-SJN-160150C-P4	M16×1.5	16	1.5	P4	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	●
ET138-SJN-160125C-P4	M16×1.25	16	1.25	P4	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET138-SJN-160100C-P3	M16×1	16	1	P3	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET138-SJN-U080F-P1	NO.0-80UNF	1.524	80	P1	1.5P	F	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET138-SJN-U164F-P1	NO.1-64UNC	1.854	64	P1	1.5P	F	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET138-SJN-U256C-P1	NO.2-56UNC	2.184	56	P1	2.5P	C	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET138-SJN-U348C-P1	NO.3-48UNC	2.515	48	P1	2.5P	C	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET138-SJN-U440C-P2	NO.4-40UNC	2.845	40	P2	2.5P	C	1	45	6	16	3	2.5	3	3×2.5	7.1	3	2.21	●
ET138-SJN-U540C-P2	NO.5-40UNC	3.175	40	P2	2.5P	C	3	50	7	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET138-SJN-U632C-P2	NO.6-32UNC	3.505	32	P2	2.5P	C	3	50	8	20	4	3.2	6	4×3.2	8.8	3	2.71	●
ET138-SJN-U640C-P2	NO.6-40UNF	3.505	40	P2	2.5P	C	3	50	8	20	4	3.2	6	4×3.2	8.8	3	2.87	○
ET138-SJN-U832C-P2	NO.8-32UNC	4.166	32	P2	2.5P	C	3	57	8	21.5	5	4	7	5×4	10.4	3	3.37	●
ET138-SJN-U836C-P2	NO.8-36UNF	4.166	36	P2	2.5P	C	3	57	8	21.5	5	4	7	5×4	10.4	3	3.46	○
ET138-SJN-U1024C-P2	NO.10-24UNC	4.826	24	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	●
ET138-SJN-U1224C-P2	NO.12-24UNC	5.486	24	P2	2.5	C	3	66	10	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET138-SJN-U1420C-P2	1/4-20UNC	6.350	20	P2	2.5P	C	3	69	12	29	6	4.5	7	6×4.5	15.9	3	5.08	●
ET138-SJN-U1428C-P2	1/4-28UNF	6.350	28	P2	2.5P	C	3	69	12	29	6	4.5	7	6×4.5	15.9	3	5.44	●
ET138-SJN-U51618C-P3	5/16-18UNC	7.938	18	P3	2.5P	C	5	70	15	30	6.1	5	8	6.1×5	19.8	3	6.53	●

● 标准库存Stock ○ 需预定Available upon Order

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

单位:mm
unit:mm

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

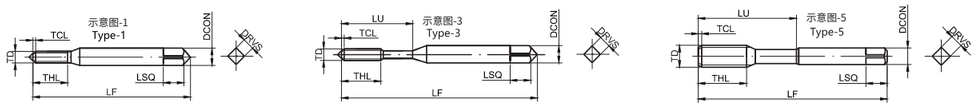
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET138-SJN

M MF UNC UNF HSSE JIS ISO 6H/2B AlCrN

经济型 钢用加工螺旋丝锥
Economical steel machining spiral fluted tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-SJN-U51624C-P3	5/16-24UNF	7.938	24	P3	2.5P	C	5	70	11	30	6.1	5	8	6.1×5	19.8	3	6.88	●
ET138-SJN-U3816C-P3	3/8-16UNC	9.525	16	P3	2.5P	C	5	75	16	43	7	5.5	8	7×5.5	23.8	3	7.94	●
ET138-SJN-U3824C-P3	3/8-24UNF	9.525	24	P3	2.5P	C	5	75	11	43	7	5.5	8	7×5.5	23.8	3	8.47	●
ET138-SJN-U71614C-P4	7/16-14UNC	11.113	14	P4	2.5P	C	5	80	20	40	8	6	9	8×6	27.8	3	9.30	○
ET138-SJN-U71620C-P3	7/16-20UNF	11.113	20	P3	2.5P	C	5	80	13	40	8	6	9	8×6	27.8	3	9.84	○
ET138-SJN-U1213C-P4	1/2-13UNC	12.700	13	P4	2.5P	C	5	85	21	48	9	7	10	9×7	31.8	3	10.75	○
ET138-SJN-U1220C-P3	1/2-20UNF	12.700	20	P3	2.5P	C	5	85	13	48	9	7	10	9×7	31.8	3	11.43	●
ET138-SJN-U91612C-P4	9/16-12UNC	14.288	12	P4	2.5P	C	5	90	21	50	10.5	8	11	10.5×8	35.7	3	12.17	○
ET138-SJN-U91618C-P3	9/16-18UNF	14.288	18	P3	2.5P	C	5	90	15	50	10.5	8	11	10.5×8	35.7	3	12.88	○
ET138-SJN-U5811C-P4	5/8-11UNC	15.875	11	P4	2.5P	C	5	95	23	48	12	9	12	12×9	39.7	3	13.57	○
ET138-SJN-U5818C-P3	5/8-18UNF	15.875	18	P3	2.5P	C	5	95	23	48	12	9	12	12×9	39.7	3	14.46	○

● 标准库存Stock ○ 需预定Available upon Order

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

单位:mm
unit:mm

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

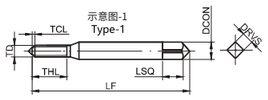
B 经济型丝锥 Economy Taps

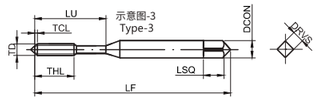
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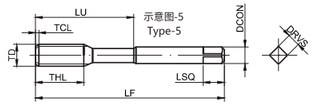
M MF UNC UNF HSSE JIS ISO 6H/2B AlCrN

经济型 钢用加工刃倾角丝锥
Economical steel machining spiral pointed tap









订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-PJN-010025B-P1	M1×0.25	1	0.25	P1	5P	B	1	37	4.5	—	3	2.5	3	3×2.5	2.5	2	0.75	○
ET138-PJN-012025B-P1	M1.2×0.25	1.2	0.25	P1	5P	B	1	37	5.5	—	3	2.5	3	3×2.5	3.0	2	0.95	○
ET138-PJN-014030B-P1	M1.4×0.3	1.4	0.3	P1	5P	B	1	37	9	—	3	2.5	3	3×2.5	3.5	2	1.10	○
ET138-PJN-016035B-P2	M1.6×0.35	1.6	0.35	P2	5P	B	1	37	8	—	3	2.5	3	3×2.5	4.0	2	1.25	○
ET138-PJN-020040B-P2	M2×0.4	2	0.4	P2	5P	B	1	45	11	—	3	2.5	3	3×2.5	5.0	2	1.60	●
ET138-PJN-025045B-P2	M2.5×0.45	2.5	0.45	P2	5P	B	1	45	12	—	3	2.5	3	3×2.5	6.3	2	2.05	●
ET138-PJN-030050B-P2	M3×0.5	3	0.5	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.5	3	2.50	●
ET138-PJN-035060B-P2	M3.5×0.6	3.5	0.6	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.90	○
ET138-PJN-040070B-P2	M4×0.7	4	0.7	P2	5P	B	3	57	14	21	5	4	7	5×4	10.0	3	3.30	●
ET138-PJN-050080B-P2	M5×0.8	5	0.8	P2	5P	B	3	66	16	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	●
ET138-PJN-060100B-P2	M6×1	6	1	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.0	3	5.00	●
ET138-PJN-070100B-P3	M7×1	7	1	P3	5P	B	3	78	13	23	6.2	5	8	6.2×5	17.5	3	6.00	●
ET138-PJN-080125B-P3	M8×1.25	8	1.25	P3	5P	B	5	70	22	37	6.2	5	8	6.2×5	20.0	3	6.75	●
ET138-PJN-080100B-P3	M8×1	8	1	P3	5P	B	5	70	22	37	6.2	5	8	6.2×5	20.0	3	7.00	●
ET138-PJN-100150B-P4	M10×1.5	10	1.5	P4	5P	B	5	75	24	43	7	5	8	7×5	25.0	3	8.50	●
ET138-PJN-100125B-P3	M10×1.25	10	1.25	P3	5P	B	5	75	24	43	7	5	8	7×5	25.0	3	8.75	●
ET138-PJN-100100B-P3	M10×1	10	1	P3	5P	B	5	75	24	43	7	5	8	7×5	25.0	3	9.00	○
ET138-PJN-120175B-P4	M12×1.75	12	1.75	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.25	●
ET138-PJN-120150B-P4	M12×1.5	12	1.5	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.50	●
ET138-PJN-120125B-P4	M12×1.25	12	1.25	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.75	●
ET138-PJN-120100B-P3	M12×1	12	1	P3	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

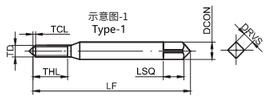
推荐切削参数 ※P62
Recommended Cutting Data ※P62

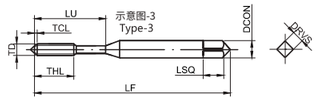
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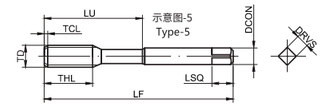
M MF UNC UNF HSSE JIS ISO 6H/2B AlCrN

经济型 钢用加工刃倾角丝锥
Economical steel machining spiral pointed tap









》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TPII	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-PJN-140200B-P5	M14×2	14	2	P5	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET138-PJN-140150B-P4	M14×1.5	14	1.5	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET138-PJN-140125B-P4	M14×1.25	14	1.25	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET138-PJN-140100B-P3	M14×1	14	1	P3	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET138-PJN-160200B-P5	M16×2	16	2	P5	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET138-PJN-160150B-P4	M16×1.5	16	1.5	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	●
ET138-PJN-160125B-P4	M16×1.25	16	1.25	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET138-PJN-160100B-P3	M16×1	16	1	P3	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET138-PJN-U080B-P1	NO.0-80UNF	1.524	80	P1	5P	B	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET138-PJN-U164B-P1	NO.1-64UNC	1.854	64	P1	5P	B	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET138-PJN-U256B-P1	NO.2-56UNC	2.184	56	P1	5P	B	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET138-PJN-U348B-P1	NO.3-48UNC	2.515	48	P1	5P	B	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET138-PJN-U440B-P2	NO.4-40UNC	2.845	40	P2	5P	B	1	45	13	—	3	2.5	3	3×2.5	7.1	3	2.21	●
ET138-PJN-U540B-P2	NO.5-40UNC	3.175	40	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET138-PJN-U632B-P2	NO.6-32UNC	3.505	32	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.71	●
ET138-PJN-U832B-P2	NO.8-32UNC	4.166	32	P2	5P	B	3	57	13.5	21.5	5	4	7	5×4	10.4	3	3.37	●
ET138-PJN-U1024B-P2	NO.10-24UNC	4.826	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	●
ET138-PJN-U1032B-P2	NO.10-32UNF	4.826	32	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET138-PJN-U1224B-P2	NO.12-24UNC	5.486	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET138-PJN-U1228B-P2	NO.12-28UNF	5.486	28	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET138-PJN-U1420B-P2	1/4-20UNC	6.350	20	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.08	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

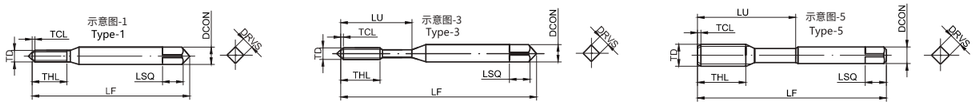
B 经济型丝锥 Economy Taps

ET138-PJN

M MF UNC UNF HSSE JIS ISO 6H/2B AlCrN

经济型 钢用加工刃倾角丝锥
Economical steel machining spiral pointed tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-PJN-U1428B-P2	1/4-28UNF	6.350	28	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.44	●
ET138-PJN-U51618B-P3	5/16-18UNC	7.938	18	P3	5P	B	5	70	23	38	6.1	5	8	6.1×5	19.8	3	6.53	●
ET138-PJN-U51624B-P3	5/16-24UNF	7.938	24	P3	5P	B	5	70	23	38	6.1	5	8	6.1×5	19.8	3	6.88	●
ET138-PJN-U3816B-P3	3/8-16UNC	9.525	16	P3	5P	B	5	75	25	43	7	5.5	8	7×5.5	23.8	3	7.94	●
ET138-PJN-U3824B-P3	3/8-24UNF	9.525	24	P3	5P	B	5	75	25	43	7	5.5	8	7×5.5	23.8	3	8.47	●
ET138-PJN-U71614B-P4	7/16-14UNC	11.113	14	P4	5P	B	5	80	29	45	8	6	9	8×6	27.8	3	9.30	○
ET138-PJN-U71620B-P3	7/16-20UNF	11.113	20	P3	5P	B	5	80	29	45	8	6	9	8×6	27.8	3	9.84	○
ET138-PJN-U1213B-P4	1/2-13UNC	12.700	13	P4	5P	B	5	85	30	48	9	7	10	9×7	31.8	3	10.75	○
ET138-PJN-U1220B-P3	1/2-20UNF	12.700	20	P3	5P	B	5	85	30	48	9	7	10	9×7	31.8	3	11.43	●
ET138-PJN-U91612B-P4	9/16-12UNC	14.288	12	P4	5P	B	5	90	30	50	10.5	8	11	10.5×8	35.7	3	12.17	○
ET138-PJN-U91618B-P3	9/16-18UNF	14.288	18	P3	5P	B	5	90	30	50	10.5	8	11	10.5×8	35.7	3	12.88	○
ET138-PJN-U5811B-P4	5/8-11UNC	15.875	11	P4	5P	B	5	95	23	48	12	9	12	12×9	39.7	3	13.57	○
ET138-PJN-U5818B-P3	5/8-18UNF	15.875	18	P3	5P	B	5	95	23	48	12	9	12	12×9	39.7	3	14.46	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
◎			○										

◎ 最适合 Most Suitable ○ 适合 Suitabel

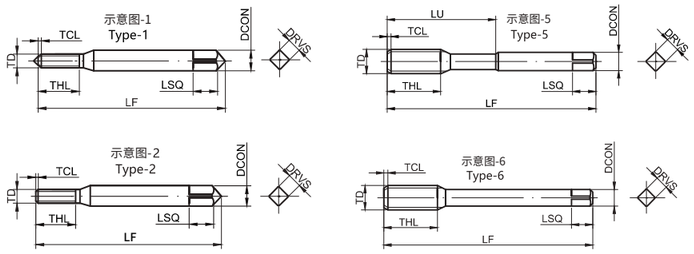
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET168-FJN

M MF UNC UNF HSSE JIS ISO 6H/2B TiAlN

经济型 不锈钢加工挤压丝锥
Economical stainless steel machining fluteless tap





订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-FJN-010025D-RH4	M1×0.25	1	0.25	RH4	4P	D	1	32	4.5	—	3	2.5	3	3×2.5	2.5	—	0.92	○
ET168-FJN-010025E-RH4	M1×0.25	1	0.25	RH4	2P	E	2	31	3.5	—	3	2.5	3	3×2.5	2.5	—	0.92	○
ET168-FJN-012025D-RH4	M1.2×0.25	1.2	0.25	RH4	4P	D	1	32	4.5	—	3	2.5	3	3×2.5	3.0	—	1.12	○
ET168-FJN-012025E-RH4	M1.2×0.25	1.2	0.25	RH4	2P	E	2	31	3.5	—	3	2.5	3	3×2.5	3.0	—	1.12	○
ET168-FJN-014030D-RH4	M1.4×0.3	1.4	0.3	RH4	4P	D	1	37	6.5	—	3	2.5	3	3×2.5	3.5	—	1.29	○
ET168-FJN-014030E-RH4	M1.4×0.3	1.4	0.3	RH4	2P	E	2	36	6.5	—	3	2.5	3	3×2.5	3.5	—	1.29	○
ET168-FJN-016035D-RH4	M1.6×0.35	1.6	0.35	RH4	4P	D	1	37	8	—	3	2.5	3	3×2.5	4.0	—	1.46	○
ET168-FJN-016035E-RH4	M1.6×0.35	1.6	0.35	RH4	2P	E	2	35.5	8	—	3	2.5	3	3×2.5	4.0	—	1.46	○
ET168-FJN-017035D-RH4	M1.7×0.35	1.7	0.35	RH4	4P	D	1	37	8	—	3	2.5	3	3×2.5	4.3	—	1.56	○
ET168-FJN-017035E-RH4	M1.7×0.35	1.7	0.35	RH4	2P	E	2	35.5	8	—	3	2.5	3	3×2.5	4.3	—	1.56	○
ET168-FJN-020040D-RH5	M2×0.4	2	0.4	RH5	4P	D	1	45	10	—	3	2.5	3	3×2.5	5.0	—	1.85	●
ET168-FJN-020040E-RH5	M2×0.4	2	0.4	RH5	2P	E	2	43.5	10	—	3	2.5	3	3×2.5	5.0	—	1.85	●
ET168-FJN-023040D-RH5	M2.3×0.4	2.3	0.4	RH5	4P	D	1	45	10	—	3	2.5	3	3×2.5	5.8	—	2.15	○
ET168-FJN-023040E-RH5	M2.3×0.4	2.3	0.4	RH5	2P	E	2	43.5	10	—	3	2.5	3	3×2.5	5.8	—	2.15	○
ET168-FJN-025045D-RH5	M2.5×0.45	2.5	0.45	RH5	4P	D	1	45	13	—	3	2.5	3	3×2.5	6.3	—	2.32	●
ET168-FJN-025045E-RH5	M2.5×0.45	2.5	0.45	RH5	2P	E	2	43.5	13	—	3	2.5	3	3×2.5	6.3	—	2.32	●
ET168-FJN-026045D-RH5	M2.6×0.45	2.6	0.45	RH5	4P	D	1	45	13	—	3	2.5	3	3×2.5	6.5	—	2.42	○
ET168-FJN-026045E-RH5	M2.6×0.45	2.6	0.45	RH5	2P	E	2	43.5	13	—	3	2.5	3	3×2.5	6.5	—	2.42	●
ET168-FJN-030050D-RH7	M3×0.5	3	0.5	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	7.5	—	2.82	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

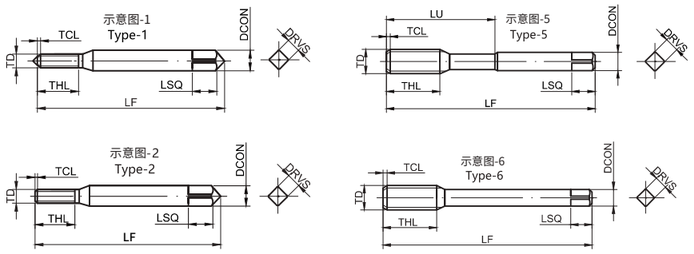
B 经济型丝锥 Economy Taps

ET168-FJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | TiAlN

经济型 不锈钢加工挤压丝锥
Economical stainless steel machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-FJN-030050E-RH7	M3×0.5	3	0.5	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	7.5	—	2.82	●
ET168-FJN-035060D-RH7	M3.5×0.6	3.5	0.6	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	8.8	—	3.26	●
ET168-FJN-035060E-RH7	M3.5×0.6	3.5	0.6	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	8.8	—	3.26	●
ET168-FJN-040070D-RH7	M4×0.7	4	0.7	RH7	4P	D	1	57	18	—	5	4	7	5×4	10.0	—	3.71	●
ET168-FJN-040070E-RH7	M4×0.7	4	0.7	RH7	2P	E	2	55	18	—	5	4	7	5×4	10.0	—	3.71	●
ET168-FJN-050080D-RH7	M5×0.8	5	0.8	RH7	4P	D	1	66	20	—	5.5	4.5	7	5.5×4.5	12.5	—	4.65	●
ET168-FJN-050080E-RH7	M5×0.8	5	0.8	RH7	2P	E	2	63.5	20	—	5.5	4.5	7	5.5×4.5	12.5	—	4.65	●
ET168-FJN-060100D-RH7	M6×1	6	1	RH7	4P	D	1	69	27	—	6	4.5	7	6×4.5	15.0	2	5.55	●
ET168-FJN-060100E-RH7	M6×1	6	1	RH7	2P	E	2	66.5	27	—	6	4.5	7	6×4.5	15.0	2	5.55	●
ET168-FJN-070100D-RH7	M7×1	7	1	RH7	4P	D	5	70	13	23	6.2	5	8	6.2×5	17.5	2	6.55	○
ET168-FJN-070100E-RH7	M7×1	7	1	RH7	2P	E	5	70	13	23	6.2	5	8	6.2×5	17.5	2	6.55	○
ET168-FJN-080125D-RH7	M8×1.25	8	1.25	RH7	4P	D	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.41	●
ET168-FJN-080125E-RH7	M8×1.25	8	1.25	RH7	2P	E	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.41	●
ET168-FJN-100150D-RH8	M10×1.5	10	1.5	RH8	4P	D	5	75	15	43	7	5.5	8	7×5.5	25.0	6	9.29	○
ET168-FJN-100150E-RH8	M10×1.5	10	1.5	RH8	2P	E	5	75	15	43	7	5.5	8	7×5.5	25.0	6	9.29	●
ET168-FJN-120175D-RH9	M12×1.75	12	1.75	RH9	4P	D	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	6	11.16	○
ET168-FJN-120175E-RH9	M12×1.75	12	1.75	RH9	2P	E	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	6	11.16	●
ET168-FJN-140200D-RH10	M14×2	14	2	RH10	4P	D	5	88	20	51	10.5	8	11	10.5×8	35.0	6	13.04	○
ET168-FJN-140200E-RH10	M14×2	14	2	RH10	2P	E	5	88	20	51	10.5	8	11	10.5×8	35.0	6	13.04	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

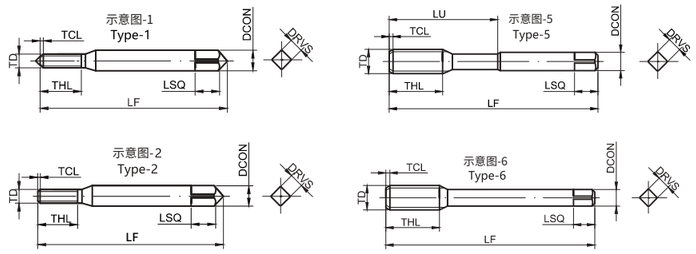
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET168-FJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | TiAlN

经济型 不锈钢加工挤压丝锥
Economical stainless steel machining fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP /TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-FJN-160200D-RH10	M16×2	16	2	RH10	4P	D	5	95	20	52	12.5	10	13	12.5×10	40.0	6	15.04	○
ET168-FJN-160200E-RH10	M16×2	16	2	RH10	2P	E	5	95	20	52	12.5	10	13	12.5×10	40.0	6	15.04	●
ET168-FJN-U164D-RH4	NO.1-64UNC	1.854	64	RH4	4P	D	1	37	9	—	3	2.5	3	3×2.5	4.6	—	1.69	○
ET168-FJN-U164E-RH4	NO.1-64UNC	1.854	64	RH4	2P	E	2	35.5	9	—	3	2.5	3	3×2.5	4.6	—	1.69	○
ET168-FJN-U256D-RH4	NO.2-56UNC	2.184	56	RH4	4P	D	1	45	12	—	3	2.5	3	3×2.5	5.5	—	1.99	○
ET168-FJN-U256E-RH4	NO.2-56UNC	2.184	56	RH4	2P	E	2	43.5	12	—	3	2.5	3	3×2.5	5.5	—	1.99	○
ET168-FJN-U348D-RH4	NO.3-48UNC	2.515	48	RH4	4P	D	1	45	15	—	3	2.5	3	3×2.5	6.3	—	2.28	○
ET168-FJN-U348E-RH4	NO.3-48UNC	2.515	48	RH4	2P	E	2	43.5	15	—	3	2.5	3	3×2.5	6.3	—	2.28	○
ET168-FJN-U440D-RH4	NO.4-40UNC	2.845	40	RH4	4P	D	1	45	15	—	3	2.5	3	3×2.5	7.1	—	2.55	○
ET168-FJN-U440E-RH4	NO.4-40UNC	2.845	40	RH4	2P	E	2	43.5	15	—	3	2.5	3	3×2.5	7.1	—	2.55	●
ET168-FJN-U540D-RH4	NO.5-40UNC	3.175	40	RH4	4P	D	1	50	15	—	4	3.2	6	4×3.2	7.9	—	2.88	○
ET168-FJN-U540E-RH4	NO.5-40UNC	3.175	40	RH4	2P	E	2	48	15	—	4	3.2	6	4×3.2	7.9	—	2.88	●
ET168-FJN-U632D-RH7	NO.6-32UNC	3.505	32	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	8.8	—	3.16	●
ET168-FJN-U632E-RH7	NO.6-32UNC	3.505	32	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	8.8	—	3.16	●
ET168-FJN-U832D-RH7	NO.8-32UNC	4.166	32	RH7	4P	D	1	57	18	—	5	4	7	5×4	10.4	—	3.82	●
ET168-FJN-U832E-RH7	NO.8-32UNC	4.166	32	RH7	2P	E	2	54.5	18	—	5	4	7	5×4	10.4	—	3.82	●
ET168-FJN-U1024D-RH7	NO.10-24UNC	4.826	24	RH7	4P	D	1	66	20	—	5.5	4.5	7	5.5×4.5	12.1	—	4.34	●
ET168-FJN-U1024E-RH7	NO.10-24UNC	4.826	24	RH7	2P	E	2	63.5	20	—	5.5	4.5	7	5.5×4.5	12.1	—	4.34	●
ET168-FJN-U1224D-RH7	NO.12-24UNC	5.486	24	RH7	4P	D	1	66	23	—	5.5	4.5	7	5.5×4.5	13.7	—	5.00	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

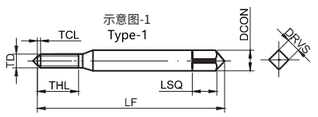
B 经济型丝锥 Economy Taps

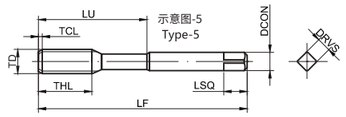
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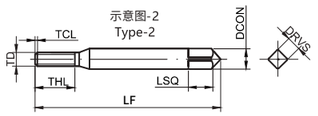
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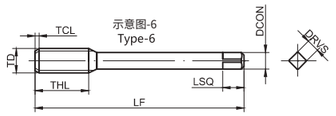
经济型 不锈钢加工挤压丝锥
Economical stainless steel machining fluteless tap











》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-FJN-U1224E-RH7	NO.12-24UNC	5.486	24	RH7	2P	E	2	63.5	23	—	5.5	4.5	7	5.5×4.5	13.7	—	5.00	●
ET168-FJN-U1420D-RH7	1/4-20UNC	6.350	20	RH7	4P	D	6	62	27	—	6	4.5	7	6×4.5	15.9	2	5.75	●
ET168-FJN-U1420E-RH7	1/4-20UNC	6.350	20	RH7	2P	E	6	62	27	—	6	4.5	7	6×4.5	15.9	2	5.75	●
ET168-FJN-U51618D-RH8	5/16-18UNC	7.938	18	RH8	4P	D	5	70	15	30	6.1	5	8	6.1×5	19.8	3	7.27	●
ET168-FJN-U51618E-RH8	5/16-18UNC	7.938	18	RH8	2P	E	5	70	15	30	6.1	5	8	6.1×5	19.8	3	7.27	●
ET168-FJN-U3816D-RH8	3/8-16UNC	9.525	16	RH8	4P	D	5	75	16	43	7	5.5	8	7×5.5	23.8	6	8.77	●
ET168-FJN-U3816E-RH8	3/8-16UNC	9.525	16	RH8	2P	E	5	75	16	43	7	5.5	8	7×5.5	23.8	6	8.77	●
ET168-FJN-U71614D-RH8	7/16-14UNC	11.113	14	RH8	4P	D	5	80	20	40	8	6	9	8×6	27.8	6	10.23	○
ET168-FJN-U71614E-RH8	7/16-14UNC	11.113	14	RH8	2P	E	5	80	20	40	8	6	9	8×6	27.8	6	10.23	○
ET168-FJN-U1213D-RH8	1/2-13UNC	12.700	13	RH8	4P	D	5	85	21	48	9	7	10	9×7	31.8	6	11.74	○
ET168-FJN-U1213E-RH8	1/2-13UNC	12.700	13	RH8	2P	E	5	85	21	48	9	7	10	9×7	31.8	6	11.74	●
ET168-FJN-U91612D-RH9	9/16-12UNC	14.288	12	RH9	4P	D	5	90	21	50	10.5	8	11	10.5×8	35.7	6	13.25	○
ET168-FJN-U91612E-RH9	9/16-12UNC	14.288	12	RH9	2P	E	5	90	21	50	10.5	8	11	10.5×8	35.7	6	13.25	○
ET168-FJN-U5811D-RH10	5/8-11UNC	15.875	11	RH10	4P	D	5	95	23	48	12	9	12	12×9	39.7	6	14.75	○
ET168-FJN-U5811E-RH10	5/8-11UNC	15.875	11	RH10	2P	E	5	95	23	48	12	9	12	12×9	39.7	6	14.75	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

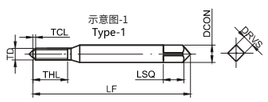
推荐切削参数 ※P62
Recommended Cutting Data ※P62

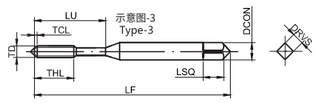
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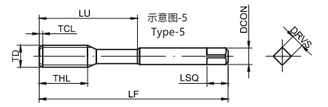
M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | TiAlN

经济型 不锈钢加工螺旋丝锥
Economical stainless steel machining spiral fluted tap









订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-SJN-010025F-P1	M1×0.25	1	0.25	P1	1.5P	F	1	37	4.5	—	3	2.5	3	3×2.5	2.5	2	0.75	○
ET168-SJN-012025F-P1	M1.2×0.25	1.2	0.25	P1	1.5P	F	1	37	5.5	—	3	2.5	3	3×2.5	3.0	2	0.95	○
ET168-SJN-014030F-P1	M1.4×0.3	1.4	0.3	P1	1.5P	F	1	37	6.5	—	3	2.5	3	3×2.5	3.5	2	1.10	○
ET168-SJN-016035F-P1	M1.6×0.35	1.6	0.35	P1	1.5P	F	1	37	8	—	3	2.5	3	3×2.5	4.0	2	1.25	○
ET168-SJN-020040C-P2	M2×0.4	2	0.4	P2	2.5P	C	1	45	11	—	3	2.5	3	3×2.5	5.0	2	1.60	○
ET168-SJN-025045C-P2	M2.5×0.45	2.5	0.45	P2	2.5P	C	1	45	12	—	3	2.5	3	3×2.5	6.3	2	2.05	○
ET168-SJN-030050C-P2	M3×0.5	3	0.5	P2	2.5P	C	3	50	5	18	4	3.2	6	4×3.2	7.5	3	2.50	●
ET168-SJN-035060C-P2	M3.5×0.6	3.5	0.6	P2	2.5P	C	3	50	6	19	4	3.2	6	4×3.2	8.8	3	2.90	○
ET168-SJN-040070C-P2	M4×0.7	4	0.7	P2	2.5P	C	3	57	9	20	5	4	7	5×4	10.0	3	3.30	●
ET168-SJN-050080C-P2	M5×0.8	5	0.8	P2	2.5P	C	3	66	8	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	●
ET168-SJN-060100C-P2	M6×1	6	1	P2	2.5P	C	3	69	12	24	6	4.5	7	6×4.5	15.0	3	5.00	●
ET168-SJN-070100C-P3	M7×1	7	1	P3	2.5P	C	3	78	13	23	6.2	5	8	6.2×5	17.5	3	6.00	○
ET168-SJN-080125C-P3	M8×1.25	8	1.25	P3	2.5P	C	5	70	13	36	6.2	5	8	6.2×5	20.0	3	6.75	●
ET168-SJN-080100C-P3	M8×1	8	1	P3	2.5P	C	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.00	○
ET168-SJN-100150C-P4	M10×1.5	10	1.5	P4	2.5P	C	5	75	15	43	7	5.5	8	7×5.5	25.0	3	8.50	●
ET168-SJN-100125C-P3	M10×1.25	10	1.25	P3	2.5P	C	5	75	13	43	7	5.5	8	7×5.5	25.0	3	8.75	○
ET168-SJN-100100C-P3	M10×1	10	1	P3	2.5P	C	5	75	13	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET168-SJN-120175C-P4	M12×1.75	12	1.75	P4	2.5P	C	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	3	10.25	●
ET168-SJN-120150C-P4	M12×1.5	12	1.5	P4	2.5P	C	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	3	10.50	○
ET168-SJN-120125C-P4	M12×1.25	12	1.25	P4	2.5P	C	5	82	13	42	8.5	6.5	9	8.5×6.5	30.0	3	10.75	○
ET168-SJN-120100C-P3	M12×1	12	1	P3	2.5P	C	5	82	13	42	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考 。 PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

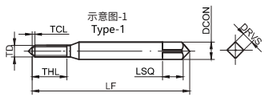
B 经济型丝锥 Economy Taps

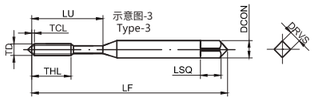
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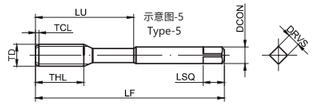
M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | TiAlN

经济型 不锈钢加工螺旋丝锥
Economical stainless steel machining spiral fluted tap









》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-SJN-140200C-P5	M14×2	14	2	P5	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET168-SJN-140150C-P4	M14×1.5	14	1.5	P4	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET168-SJN-140125C-P4	M14×1.25	14	1.25	P4	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET168-SJN-140100C-P3	M14×1	14	1	P3	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET168-SJN-160200C-P5	M16×2	16	2	P5	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET168-SJN-160150C-P4	M16×1.5	16	1.5	P4	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	○
ET168-SJN-160125C-P4	M16×1.25	16	1.25	P4	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET168-SJN-160100C-P3	M16×1	16	1	P3	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET168-SJN-U080F-P1	NO.0-80UNF	1.524	80	P1	1.5P	F	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET168-SJN-U164F-P1	NO.1-64UNC	1.854	64	P1	1.5P	F	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET168-SJN-U256C-P1	NO.2-56UNC	2.184	56	P1	2.5P	C	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET168-SJN-U348C-P1	NO.3-48UNC	2.515	48	P1	2.5P	C	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET168-SJN-U440C-P2	NO.4-40UNC	2.845	40	P2	2.5P	C	3	45	6	16	3	2.5	3	3×2.5	7.1	3	2.21	○
ET168-SJN-U540C-P2	NO.5-40UNC	3.175	40	P2	2.5P	C	3	50	7	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET168-SJN-U632C-P2	NO.6-32UNC	3.505	32	P2	2.5P	C	3	50	8	20	4	3.2	6	4×3.2	8.8	3	2.71	○
ET168-SJN-U832C-P2	NO.8-32UNC	4.166	32	P2	2.5P	C	3	57	8	21.5	5	4	7	5×4	10.4	3	3.37	○
ET168-SJN-U1024C-P2	NO.10-24UNC	4.826	24	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	○
ET168-SJN-U1032C-P2	NO.10-32UNF	4.826	32	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET168-SJN-U1224C-P2	NO.12-24UNC	5.486	24	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET168-SJN-U1228C-P2	NO.12-28UNF	5.486	28	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET168-SJN-U1420C-P2	1/4-20UNC	6.350	20	P2	2.5P	C	3	69	12	29	6	4.5	7	6×4.5	15.9	3	5.08	○

● 标准库存Stock ○ 需预定Available upon Order

[备注 Note] 预孔尺寸仅做参考 。 PHD for referance only.

单位:mm
unit:mm

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

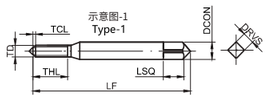
推荐切削参数 ※P62
Recommended Cutting Data ※P62

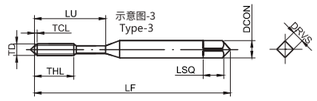
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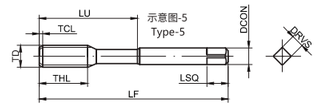
M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | TiAlN

经济型 不锈钢加工螺旋丝锥
Economical stainless steel machining spiral fluted tap









》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-SJN-U1428C-P2	1/4-28UNF	6.350	28	P2	2.5P	C	3	69	12	29	6	4.5	7	6×4.5	15.9	3	5.44	○
ET168-SJN-U51618C-P3	5/16-18UNC	7.938	18	P3	2.5P	C	5	70	15	30	6.1	5	8	6.1×5	19.8	3	6.53	○
ET168-SJN-U51624C-P3	5/16-24UNF	7.938	24	P3	2.5P	C	5	70	11	30	6.1	5	8	6.1×5	19.8	3	6.88	○
ET168-SJN-U3816C-P3	3/8-16UNC	9.525	16	P3	2.5P	C	5	75	16	43	7	5.5	8	7×5.5	23.8	3	7.94	○
ET168-SJN-U3824C-P3	3/8-24UNF	9.525	24	P3	2.5P	C	5	75	11	43	7	5.5	8	7×5.5	23.8	3	8.47	○
ET168-SJN-U71614C-P4	7/16-14UNC	11.113	14	P4	2.5P	C	5	80	20	40	8	6	9	8×6	27.8	3	9.30	○
ET168-SJN-U71620C-P3	7/16-20UNF	11.113	20	P3	2.5P	C	5	80	13	40	8	6	9	8×6	27.8	3	9.84	○
ET168-SJN-U1213C-P4	1/2-13UNC	12.700	13	P4	2.5P	C	5	85	21	48	9	7	10	9×7	31.8	3	10.75	○
ET168-SJN-U1220C-P3	1/2-20UNF	12.700	20	P3	2.5P	C	5	85	13	48	9	7	10	9×7	31.8	3	11.43	○
ET168-SJN-U91612C-P4	9/16-12UNC	14.288	12	P4	2.5P	C	5	90	21	50	10.5	8	11	10.5×8	35.7	3	12.17	○
ET168-SJN-U91618C-P3	9/16-18UNF	14.288	18	P3	2.5P	C	5	90	15	50	10.5	8	11	10.5×8	35.7	3	12.88	○
ET168-SJN-U5811C-P4	5/8-11UNC	15.875	11	P4	2.5P	C	5	95	23	48	12	9	12	12×9	39.7	3	13.57	○
ET168-SJN-U5818C-P3	5/8-18UNF	15.875	18	P3	2.5P	C	5	95	23	48	12	9	12	12×9	39.7	3	14.46	○

● 标准库存Stock ○ 需预定Available upon Order

[备注 Note] 预孔尺寸仅做参考 。 PHD for referance only.

单位:mm
unit:mm

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

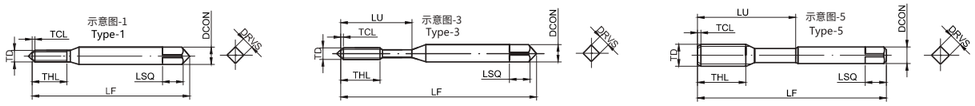
B 经济型丝锥 Economy Taps

ET168-PJN

M MF UNC UNF HSSE JIS ISO 6H/2B TiAlN

经济型 不锈钢加工刃倾角丝锥
Economical stainless steel machining spiral pointed tap





订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-PJN-010025B-P1	M1×0.25	1	0.25	P1	5P	B	1	37	4.5	—	3	2.5	3	3×2.5	2.5	2	0.75	○
ET168-PJN-012025B-P1	M1.2×0.25	1.2	0.25	P1	5P	B	1	37	5.5	—	3	2.5	3	3×2.5	3.0	2	0.95	○
ET168-PJN-014030B-P1	M1.4×0.3	1.4	0.3	P1	5P	B	1	37	9	—	3	2.5	3	3×2.5	3.5	2	1.10	○
ET168-PJN-016035B-P2	M1.6×0.35	1.6	0.35	P2	5P	B	1	37	8	—	3	2.5	3	3×2.5	4.0	2	1.25	○
ET168-PJN-020040B-P2	M2×0.4	2	0.4	P2	5P	B	1	45	11	—	3	2.5	3	3×2.5	5.0	2	1.60	○
ET168-PJN-025045B-P2	M2.5×0.45	2.5	0.45	P2	5P	B	1	45	12	—	3	2.5	3	3×2.5	6.3	2	2.05	○
ET168-PJN-030050B-P2	M3×0.5	3	0.5	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.5	3	2.50	●
ET168-PJN-035060B-P2	M3.5×0.6	3.5	0.6	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.90	○
ET168-PJN-040070B-P2	M4×0.7	4	0.7	P2	5P	B	3	57	14	21	5	4	7	5×4	10.0	3	3.30	●
ET168-PJN-050080B-P2	M5×0.8	5	0.8	P2	5P	B	3	66	16	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	●
ET168-PJN-060100B-P2	M6×1	6	1	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.0	3	5.00	●
ET168-PJN-070100B-P3	M7×1	7	1	P3	5P	B	3	78	13	23	6.2	5	8	6.2×5	17.5	3	6.00	○
ET168-PJN-080125B-P3	M8×1.25	8	1.25	P3	5P	B	5	70	22	37	6.2	5	8	6.2×5	20.0	3	6.75	●
ET168-PJN-080100B-P3	M8×1	8	1	P3	5P	B	5	70	22	37	6.2	5	8	6.2×5	20.0	3	7.00	○
ET168-PJN-100150B-P4	M10×1.5	10	1.5	P4	5P	B	5	75	24	43	7	5.5	8	7×5.5	25.0	3	8.50	●
ET168-PJN-100125B-P3	M10×1.25	10	1.25	P3	5P	B	5	75	24	43	7	5.5	8	7×5.5	25.0	3	8.75	○
ET168-PJN-100100B-P3	M10×1	10	1	P3	5P	B	5	75	24	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET168-PJN-120175B-P4	M12×1.75	12	1.75	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.25	●
ET168-PJN-120150B-P4	M12×1.5	12	1.5	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.50	○
ET168-PJN-120125B-P4	M12×1.25	12	1.25	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.75	○
ET168-PJN-120100B-P3	M12×1	12	1	P3	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

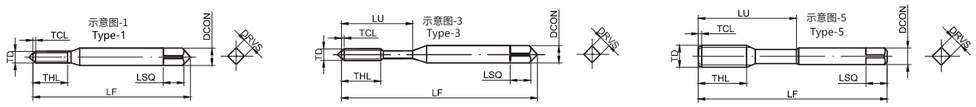
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET168-PJN

M MF UNC UNF HSSE JIS ISO 6H/2B TiAlN

经济型 不锈钢加工刃倾角丝锥
Economical stainless steel machining spiral pointed tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-PJN-140200B-P5	M14×2	14	2	P5	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET168-PJN-140150B-P4	M14×1.5	14	1.5	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET168-PJN-140125B-P4	M14×1.25	14	1.25	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET168-PJN-140100B-P3	M14×1	14	1	P3	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET168-PJN-160200B-P5	M16×2	16	2	P5	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET168-PJN-160150B-P4	M16×1.5	16	1.5	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	○
ET168-PJN-160125B-P4	M16×1.25	16	1.25	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET168-PJN-160100B-P3	M16×1	16	1	P3	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET168-PJN-U080B-P1	NO.0-80UNF	1.524	80	P1	5P	B	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET168-PJN-U164B-P1	NO.1-64UNC	1.854	64	P1	5P	B	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET168-PJN-U256B-P1	NO.2-56UNC	2.184	56	P1	5P	B	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET168-PJN-U348B-P1	NO.3-48UNC	2.515	48	P1	5P	B	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET168-PJN-U440B-P2	NO.4-40UNC	2.845	40	P2	5P	B	1	45	13	—	3	2.5	3	3×2.5	7.1	2	2.21	○
ET168-PJN-U540B-P2	NO.5-40UNC	3.175	40	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET168-PJN-U632B-P2	NO.6-32UNC	3.505	32	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.71	○
ET168-PJN-U832B-P2	NO.8-32UNC	4.166	32	P2	5P	B	3	57	13.5	21.5	5	4	7	5×4	10.4	3	3.37	○
ET168-PJN-U1024B-P2	NO.10-24UNC	4.826	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	○
ET168-PJN-U1032B-P2	NO.10-32UNF	4.826	32	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET168-PJN-U1224B-P2	NO.12-24UNC	5.486	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET168-PJN-U1228B-P2	NO.12-28UNF	5.486	28	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET168-PJN-U1420B-P2	1/4-20UNC	6.350	20	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.08	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

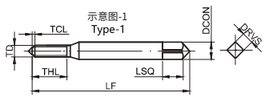
B 经济型丝锥 Economy Taps

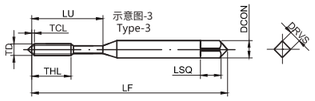
ET168-PJN

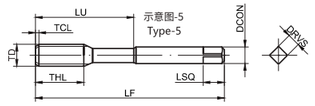
M MF UNC UNF HSSE JIS ISO 6H/2B TiAlN

经济型 不锈钢加工刃倾角丝锥
Economical stainless steel machining spiral pointed tap









》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-PJN-U1428B-P2	1/4-28UNF	6.350	28	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.44	○
ET168-PJN-U51618B-P3	5/16-18UNC	7.938	18	P3	5P	B	5	70	23	38	6.1	5	8	6.1×5	19.8	3	6.53	○
ET168-PJN-U51624B-P3	5/16-24UNF	7.938	24	P3	5P	B	5	70	23	38	6.1	5	8	6.1×5	19.8	3	6.88	○
ET168-PJN-U3816B-P3	3/8-16UNC	9.525	16	P3	5P	B	5	75	25	43	7	5.5	8	7×5.5	23.8	3	7.94	○
ET168-PJN-U3824B-P3	3/8-24UNF	9.525	24	P3	5P	B	5	75	25	43	7	5.5	8	7×5.5	23.8	3	8.47	○
ET168-PJN-U71614B-P4	7/16-14UNC	11.113	14	P4	5P	B	5	80	29	45	8	6	9	8×6	27.8	3	9.30	○
ET168-PJN-U71620B-P3	7/16-20UNF	11.113	20	P3	5P	B	5	80	29	45	8	6	9	8×6	27.8	3	9.84	○
ET168-PJN-U1213B-P4	1/2-13UNC	12.700	13	P4	5P	B	5	85	30	48	9	7	10	9×7	31.8	3	10.75	○
ET168-PJN-U1220B-P3	1/2-20UNF	12.700	20	P3	5P	B	5	85	30	48	9	7	10	9×7	31.8	3	11.43	○
ET168-PJN-U91612B-P4	9/16-12UNC	14.288	12	P4	5P	B	5	90	30	50	10.5	8	11	10.5×8	35.7	3	12.17	○
ET168-PJN-U91618B-P3	9/16-18UNF	14.288	18	P3	5P	B	5	90	30	50	10.5	8	11	10.5×8	35.7	3	12.88	○
ET168-PJN-U5811B-P4	5/8-11UNC	15.875	11	P4	5P	B	5	95	23	48	12	9	12	12×9	39.7	3	13.57	○
ET168-PJN-U5818B-P3	5/8-18UNF	15.875	18	P3	5P	B	5	95	23	48	12	9	12	12×9	39.7	3	14.46	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
○			◎										

◎ 最适合 Most Suitable ○ 适合 Suitabel

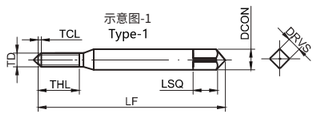
推荐切削参数 ※P62
Recommended Cutting Data ※P62

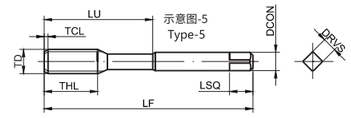
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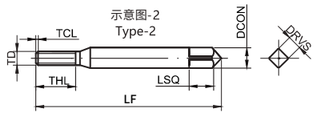
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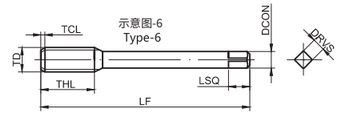
经济型 铜铝加工挤压丝锥
Economical copper and aluminum processing fluteless tap











订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-FJN-010025D-RH4	M1×0.25	1	0.25	RH4	4P	D	1	32	4.5	—	3	2.5	3	3×2.5	2.5	—	0.92	○
ET166-FJN-010025E-RH4	M1×0.25	1	0.25	RH4	2P	E	2	31	3.5	—	3	2.5	3	3×2.5	2.5	—	0.92	○
ET166-FJN-012025D-RH4	M1.2×0.25	1.2	0.25	RH4	4P	D	1	32	4.5	—	3	2.5	3	3×2.5	3.0	—	1.12	○
ET166-FJN-012025E-RH4	M1.2×0.25	1.2	0.25	RH4	2P	E	2	31	3.5	—	3	2.5	3	3×2.5	3.0	—	1.12	○
ET166-FJN-014030D-RH4	M1.4×0.3	1.4	0.3	RH4	4P	D	1	37	6.5	—	3	2.5	3	3×2.5	3.5	—	1.29	○
ET166-FJN-014030E-RH4	M1.4×0.3	1.4	0.3	RH4	2P	E	2	36	6.5	—	3	2.5	3	3×2.5	3.5	—	1.29	○
ET166-FJN-016035D-RH4	M1.6×0.35	1.6	0.35	RH4	4P	D	1	37	8	—	3	2.5	3	3×2.5	4.0	—	1.46	○
ET166-FJN-016035E-RH4	M1.6×0.35	1.6	0.35	RH4	2P	E	2	35.5	8	—	3	2.5	3	3×2.5	4.0	—	1.46	○
ET166-FJN-017035D-RH4	M1.7×0.35	1.7	0.35	RH4	4P	D	1	37	8	—	3	2.5	3	3×2.5	4.3	—	1.56	○
ET166-FJN-017035E-RH4	M1.7×0.35	1.7	0.35	RH4	2P	E	2	35.5	8	—	3	2.5	3	3×2.5	4.3	—	1.56	○
ET166-FJN-020040D-RH5	M2×0.4	2	0.4	RH5	4P	D	1	45	10	—	3	2.5	3	3×2.5	5.0	—	1.85	●
ET166-FJN-020040E-RH5	M2×0.4	2	0.4	RH5	2P	E	2	43.5	10	—	3	2.5	3	3×2.5	5.0	—	1.85	●
ET166-FJN-023040D-RH5	M2.3×0.4	2.3	0.4	RH5	4P	D	1	45	10	—	3	2.5	3	3×2.5	5.8	—	2.15	○
ET166-FJN-023040E-RH5	M2.3×0.4	2.3	0.4	RH5	2P	E	2	43.5	10	—	3	2.5	3	3×2.5	5.8	—	2.15	○
ET166-FJN-025045D-RH5	M2.5×0.45	2.5	0.45	RH5	4P	D	1	45	13	—	3	2.5	3	3×2.5	6.3	—	2.32	●
ET166-FJN-025045E-RH5	M2.5×0.45	2.5	0.45	RH5	2P	E	2	43.5	13	—	3	2.5	3	3×2.5	6.3	—	2.32	●
ET166-FJN-026045D-RH5	M2.6×0.45	2.6	0.45	RH5	4P	D	1	45	13	—	3	2.5	3	3×2.5	6.5	—	2.42	○
ET166-FJN-026045E-RH5	M2.6×0.45	2.6	0.45	RH5	2P	E	2	43.5	13	—	3	2.5	3	3×2.5	6.5	—	2.42	●
ET166-FJN-030050D-RH7	M3×0.5	3	0.5	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	7.5	—	2.82	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

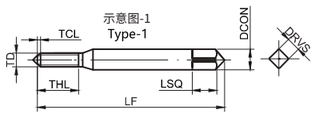
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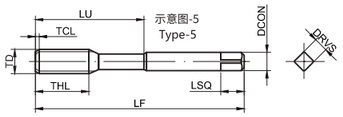
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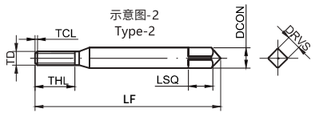
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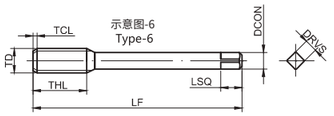
经济型 铜铝加工挤压丝锥
Economical copper and aluminum processing fluteless tap











》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-FJN-030050E-RH7	M3×0.5	3	0.5	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	7.5	—	2.82	●
ET166-FJN-035060D-RH7	M3.5×0.6	3.5	0.6	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	8.8	—	3.26	●
ET166-FJN-035060E-RH7	M3.5×0.6	3.5	0.6	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	8.8	—	3.26	●
ET166-FJN-040070D-RH7	M4×0.7	4	0.7	RH7	4P	D	1	57	18	—	5	4	7	5×4	10.0	—	3.71	●
ET166-FJN-040070E-RH7	M4×0.7	4	0.7	RH7	2P	E	2	55	18	—	5	4	7	5×4	10.0	—	3.71	●
ET166-FJN-050080D-RH7	M5×0.8	5	0.8	RH7	4P	D	1	66	20	—	5.5	4.5	7	5.5×4.5	12.5	—	4.65	●
ET166-FJN-050080E-RH7	M5×0.8	5	0.8	RH7	2P	E	2	63.5	20	—	5.5	4.5	7	5.5×4.5	12.5	—	4.65	●
ET166-FJN-060100D-RH7	M6×1	6	1	RH7	4P	D	1	69	27	—	6	4.5	7	6×4.5	15.0	2	5.55	●
ET166-FJN-060100E-RH7	M6×1	6	1	RH7	2P	E	2	66.5	27	—	6	4.5	7	6×4.5	15.0	2	5.55	●
ET166-FJN-070100D-RH7	M7×1	7	1	RH7	4P	D	5	70	13	23	6.2	5	8	6.2×5	17.5	2	6.55	○
ET166-FJN-070100E-RH7	M7×1	7	1	RH7	2P	E	5	70	13	23	6.2	5	8	6.2×5	17.5	2	6.55	○
ET166-FJN-080125D-RH7	M8×1.25	8	1.25	RH7	4P	D	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.41	●
ET166-FJN-080125E-RH7	M8×1.25	8	1.25	RH7	2P	E	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.41	●
ET166-FJN-100150D-RH8	M10×1.5	10	1.5	RH8	4P	D	5	75	15	43	7	5.5	8	7×5.5	25.0	6	9.29	○
ET166-FJN-100150E-RH8	M10×1.5	10	1.5	RH8	2P	E	5	75	15	43	7	5.5	8	7×5.5	25.0	6	9.29	●
ET166-FJN-120175D-RH9	M12×1.75	12	1.75	RH9	4P	D	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	6	11.16	○
ET166-FJN-120175E-RH9	M12×1.75	12	1.75	RH9	2P	E	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	6	11.16	●
ET166-FJN-140200D-RH10	M14×2	14	2	RH10	4P	D	5	88	20	51	10.5	8	11	10.5×8	35.0	6	13.04	○
ET166-FJN-140200E-RH10	M14×2	14	2	RH10	2P	E	5	88	20	51	10.5	8	11	10.5×8	35.0	6	13.04	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎		◎					

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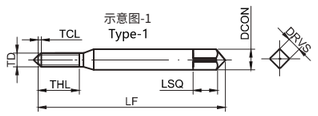
推荐切削参数 ※P62
Recommended Cutting Data ※P62

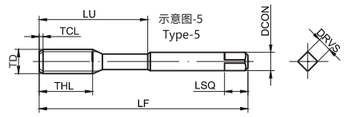
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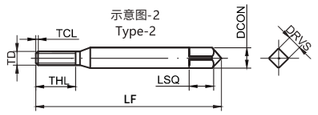
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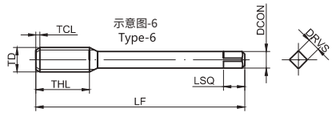
经济型 铜铝加工挤压丝锥
Economical copper and aluminum processing fluteless tap











》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP /TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-FJN-160200D-RH10	M16×2	16	2	RH10	4P	D	5	95	20	52	12.5	10	13	12.5×10	40.0	6	15.04	○
ET166-FJN-160200E-RH10	M16×2	16	2	RH10	2P	E	5	95	20	52	12.5	10	13	12.5×10	40.0	6	15.04	●
ET166-FJN-U164D-RH4	NO.1-64UNC	1.854	64	RH4	4P	D	1	37	9	—	3	2.5	3	3×2.5	4.6	—	1.69	○
ET166-FJN-U164E-RH4	NO.1-64UNC	1.854	64	RH4	2P	E	2	35.5	9	—	3	2.5	3	3×2.5	4.6	—	1.69	○
ET166-FJN-U256D-RH4	NO.2-56UNC	2.184	56	RH4	4P	D	1	45	12	—	3	2.5	3	3×2.5	5.5	—	1.99	○
ET166-FJN-U256E-RH4	NO.2-56UNC	2.184	56	RH4	2P	E	2	43.5	12	—	3	2.5	3	3×2.5	5.5	—	1.99	○
ET166-FJN-U348D-RH4	NO.3-48UNC	2.515	48	RH4	4P	D	1	45	15	—	3	2.5	3	3×2.5	6.3	—	2.28	○
ET166-FJN-U348E-RH4	NO.3-48UNC	2.515	48	RH4	2P	E	2	43.5	15	—	3	2.5	3	3×2.5	6.3	—	2.28	○
ET166-FJN-U440D-RH4	NO.4-40UNC	2.845	40	RH4	4P	D	1	45	15	—	3	2.5	3	3×2.5	7.1	—	2.55	○
ET166-FJN-U440E-RH4	NO.4-40UNC	2.845	40	RH4	2P	E	2	43.5	15	—	3	2.5	3	3×2.5	7.1	—	2.55	●
ET166-FJN-U540D-RH4	NO.5-40UNC	3.175	40	RH4	4P	D	1	50	15	—	4	3.2	6	4×3.2	7.9	—	2.88	○
ET166-FJN-U540E-RH4	NO.5-40UNC	3.175	40	RH4	2P	E	2	48	15	—	4	3.2	6	4×3.2	7.9	—	2.88	●
ET166-FJN-U632D-RH7	NO.6-32UNC	3.505	32	RH7	4P	D	1	50	16	—	4	3.2	6	4×3.2	8.8	—	3.16	●
ET166-FJN-U632E-RH7	NO.6-32UNC	3.505	32	RH7	2P	E	2	48	16	—	4	3.2	6	4×3.2	8.8	—	3.16	●
ET166-FJN-U832D-RH7	NO.8-32UNC	4.166	32	RH7	4P	D	1	57	18	—	5	4	7	5×4	10.4	—	3.82	●
ET166-FJN-U832E-RH7	NO.8-32UNC	4.166	32	RH7	2P	E	2	54.5	18	—	5	4	7	5×4	10.4	—	3.82	●
ET166-FJN-U1024D-RH7	NO.10-24UNC	4.826	24	RH7	4P	D	1	66	20	—	5.5	4.5	7	5.5×4.5	12.1	—	4.34	●
ET166-FJN-U1024E-RH7	NO.10-24UNC	4.826	24	RH7	2P	E	2	63.5	20	—	5.5	4.5	7	5.5×4.5	12.1	—	4.34	●
ET166-FJN-U1224D-RH7	NO.12-24UNC	5.486	24	RH7	4P	D	1	66	23	—	5.5	4.5	7	5.5×4.5	13.7	—	5.00	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

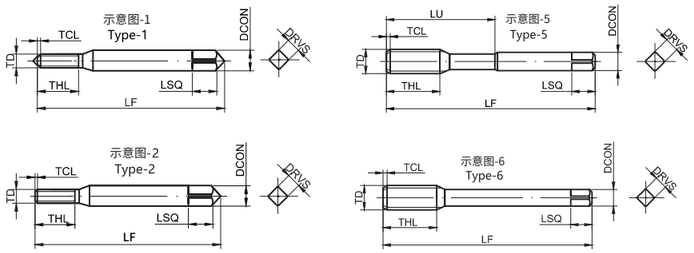
B 经济型丝锥 Economy Taps

ET166-FJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | DLC

经济型 铜铝加工挤压丝锥
Economical copper and aluminum processing fluteless tap





》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-FJN-U1224E-RH7	NO.12-24UNC	5.486	24	RH7	2P	E	2	63.5	23	—	5.5	4.5	7	5.5×4.5	13.7	—	5.00	●
ET166-FJN-U1420D-RH7	1/4-20UNC	6.350	20	RH7	4P	D	6	62	27	—	6	4.5	7	6×4.5	15.9	2	5.75	●
ET166-FJN-U1420E-RH7	1/4-20UNC	6.350	20	RH7	2P	E	6	62	27	—	6	4.5	7	6×4.5	15.9	2	5.75	●
ET166-FJN-U51618D-RH8	5/16-18UNC	7.938	18	RH8	4P	D	5	70	15	30	6.1	5	8	6.1×5	19.8	3	7.27	●
ET166-FJN-U51618E-RH8	5/16-18UNC	7.938	18	RH8	2P	E	5	70	15	30	6.1	5	8	6.1×5	19.8	3	7.27	●
ET166-FJN-U3816D-RH8	3/8-16UNC	9.525	16	RH8	4P	D	5	75	16	43	7	5.5	8	7×5.5	23.8	6	8.77	●
ET166-FJN-U3816E-RH8	3/8-16UNC	9.525	16	RH8	2P	E	5	75	16	43	7	5.5	8	7×5.5	23.8	6	8.77	●
ET166-FJN-U71614D-RH8	7/16-14UNC	11.113	14	RH8	4P	D	5	80	20	40	8	6	9	8×6	27.8	6	10.23	○
ET166-FJN-U71614E-RH8	7/16-14UNC	11.113	14	RH8	2P	E	5	80	20	40	8	6	9	8×6	27.8	6	10.23	○
ET166-FJN-U1213D-RH8	1/2-13UNC	12.700	13	RH8	4P	D	5	85	21	48	9	7	10	9×7	31.8	6	11.74	○
ET166-FJN-U1213E-RH8	1/2-13UNC	12.700	13	RH8	2P	E	5	85	21	48	9	7	10	9×7	31.8	6	11.74	●
ET166-FJN-U91612D-RH9	9/16-12UNC	14.288	12	RH9	4P	D	5	90	21	50	10.5	8	11	10.5×8	35.7	6	13.25	○
ET166-FJN-U91612E-RH9	9/16-12UNC	14.288	12	RH9	2P	E	5	90	21	50	10.5	8	11	10.5×8	35.7	6	13.25	○
ET166-FJN-U5811D-RH10	5/8-11UNC	15.875	11	RH10	4P	D	5	95	23	48	12	9	12	12×9	39.7	6	14.75	○
ET166-FJN-U5811E-RH10	5/8-11UNC	15.875	11	RH10	2P	E	5	95	23	48	12	9	12	12×9	39.7	6	14.75	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸以85%嵌合率计算，仅做参考。PHD was calculated by overlap ratio 85%，for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎		◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

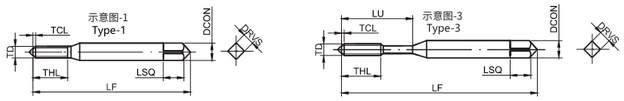
推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET166-SJN

M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | DLC

经济型 铜铝加工螺旋丝锥
Economical copper and aluminum processing spiral fluted tap





订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-SJN-010025F-P1	M1×0.25	1	0.25	P1	1.5P	F	1	37	4.5	—	3	2.5	3	3×2.5	2.5	2	0.75	○
ET166-SJN-012025F-P1	M1.2×0.25	1.2	0.25	P1	1.5P	F	1	37	5.5	—	3	2.5	3	3×2.5	3.0	2	0.95	○
ET166-SJN-014030F-P1	M1.4×0.3	1.4	0.3	P1	1.5P	F	1	37	6.5	—	3	2.5	3	3×2.5	3.5	2	1.10	○
ET166-SJN-016035F-P2	M1.6×0.35	1.6	0.35	P2	1.5P	F	1	37	8	—	3	2.5	3	3×2.5	4.0	2	1.25	○
ET166-SJN-020040C-P2	M2×0.4	2	0.4	P2	2.5P	C	1	45	11	—	3	2.5	3	3×2.5	5.0	2	1.60	●
ET166-SJN-025045C-P2	M2.5×0.45	2.5	0.45	P2	2.5P	C	1	45	12	—	3	2.5	3	3×2.5	6.3	2	2.05	●
ET166-SJN-030050C-P2	M3×0.5	3	0.5	P2	2.5P	C	3	50	5	18	4	3.2	6	4×3.2	7.5	3	2.50	●
ET166-SJN-035060C-P2	M3.5×0.6	3.5	0.6	P2	2.5P	C	3	50	6	19	4	3.2	6	4×3.2	8.8	3	2.90	○
ET166-SJN-040070C-P2	M4×0.7	4	0.7	P2	2.5P	C	3	57	9	20	5	4	7	5×4	10.0	3	3.30	●
ET166-SJN-050080C-P2	M5×0.8	5	0.8	P2	2.5P	C	3	66	8	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	●
ET166-SJN-060100C-P2	M6×1	6	1	P2	2.5P	C	3	69	12	24	6	4.5	7	6×4.5	15.0	3	5.00	●
ET166-SJN-070100C-P3	M7×1	7	1	P3	2.5P	C	3	78	13	23	6.2	5	8	6.2×5	17.5	3	6.00	○
ET166-SJN-080125C-P3	M8×1.25	8	1.25	P3	2.5P	C	5	70	13	36	6.2	5	8	6.2×5	20.0	3	6.75	●
ET166-SJN-080100C-P3	M8×1	8	1	P3	2.5P	C	5	70	13	36	6.2	5	8	6.2×5	20.0	3	7.00	●
ET166-SJN-100150C-P4	M10×1.5	10	1.5	P4	2.5P	C	5	75	15	43	7	5.5	8	7×5.5	25.0	3	8.50	●
ET166-SJN-100125C-P3	M10×1.25	10	1.25	P3	2.5P	C	5	75	13	43	7	5.5	8	7×5.5	25.0	3	8.75	●
ET166-SJN-100100C-P3	M10×1	10	1	P3	2.5P	C	5	75	13	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET166-SJN-120175C-P4	M12×1.75	12	1.75	P4	2.5P	C	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	3	10.25	●
ET166-SJN-120150C-P4	M12×1.5	12	1.5	P4	2.5P	C	5	82	17	42	8.5	6.5	9	8.5×6.5	30.0	3	10.50	●
ET166-SJN-120125C-P4	M12×1.25	12	1.25	P4	2.5P	C	5	82	13	42	8.5	6.5	9	8.5×6.5	30.0	3	10.75	○
ET166-SJN-120100C-P3	M12×1	12	1	P3	2.5P	C	5	82	13	42	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎	◎	◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

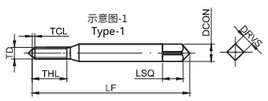
推荐切削参数 ※P62
Recommended Cutting Data ※P62

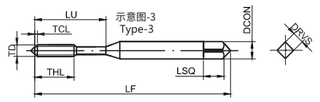
B 经济型丝锥 Economy Taps

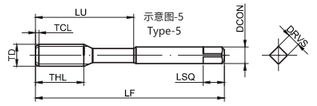
ET166-SJN



经济型 铜铝加工螺旋丝锥
Economical copper and aluminum processing spiral fluted tap







》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-SJN-140200C-P5	M14×2	14	2	P5	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET166-SJN-140150C-P4	M14×1.5	14	1.5	P4	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET166-SJN-140125C-P4	M14×1.25	14	1.25	P4	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET166-SJN-140100C-P3	M14×1	14	1	P3	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET166-SJN-160200C-P5	M16×2	16	2	P5	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET166-SJN-160150C-P4	M16×1.5	16	1.5	P4	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	●
ET166-SJN-160125C-P4	M16×1.25	16	1.25	P4	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET166-SJN-160100C-P3	M16×1	16	1	P3	2.5P	C	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET166-SJN-U080F-P1	NO.0-80UNF	1.524	80	P1	1.5P	F	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET166-SJN-U164F-P1	NO.1-64UNC	1.854	64	P1	1.5P	F	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET166-SJN-U256C-P1	NO.2-56UNC	2.184	56	P1	2.5P	C	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET166-SJN-U348C-P1	NO.3-48UNC	2.515	48	P1	2.5P	C	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET166-SJN-U440C-P2	NO.4-40UNC	2.845	40	P2	2.5P	C	3	45	6	16	3	2.5	3	3×2.5	7.1	3	2.21	●
ET166-SJN-U540C-P2	NO.5-40UNC	3.175	40	P2	2.5P	C	3	50	7	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET166-SJN-U632C-P2	NO.6-32UNC	3.505	32	P2	2.5P	C	3	50	8	20	4	3.2	6	4×3.2	8.8	3	2.71	●
ET166-SJN-U832C-P2	NO.8-32UNC	4.166	32	P2	2.5P	C	3	57	8	21.5	5	4	7	5×4	10.4	3	3.37	●
ET166-SJN-U1024C-P2	NO.10-24UNC	4.826	24	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	●
ET166-SJN-U1032C-P2	NO.10-32UNF	4.826	32	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET166-SJN-U1224C-P2	NO.12-24UNC	5.486	24	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET166-SJN-U1228C-P2	NO.12-28UNF	5.486	28	P2	2.5P	C	3	66	10	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET166-SJN-U1420C-P2	1/4-20UNC	6.350	20	P2	2.5P	C	3	69	12	29	6	4.5	7	6×4.5	15.9	3	5.08	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎	◎	◎					

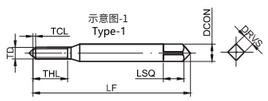
◎ 最适合 Most Suitable ○ 适合 Suitabel

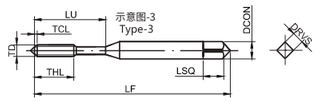
推荐切削参数 ※P62
Recommended Cutting Data ※P62

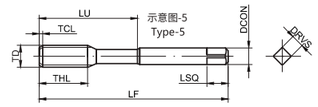
ET166-SJN



经济型 铜铝加工螺旋丝锥
Economical copper and aluminum processing spiral fluted tap







》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-SJN-U1428C-P2	1/4-28UNF	6.350	28	P2	2.5P	C	3	69	12	29	6	4.5	7	6×4.5	15.9	3	5.44	●
ET166-SJN-U51618C-P3	5/16-18UNC	7.938	18	P3	2.5P	C	5	70	15	30	6.1	5	8	6.1×5	19.8	3	6.53	●
ET166-SJN-U51624C-P3	5/16-24UNF	7.938	24	P3	2.5P	C	5	70	11	30	6.1	5	8	6.1×5	19.8	3	6.88	●
ET166-SJN-U3816C-P3	3/8-16UNC	9.525	16	P3	2.5P	C	5	75	16	43	7	5.5	8	7×5.5	23.8	3	7.94	●
ET166-SJN-U3824C-P3	3/8-24UNF	9.525	24	P3	2.5P	C	5	75	11	43	7	5.5	8	7×5.5	23.8	3	8.47	●
ET166-SJN-U71614C-P4	7/16-14UNC	11.113	14	P4	2.5P	C	5	80	20	40	8	6	9	8×6	27.8	3	9.30	○
ET166-SJN-U71620C-P3	7/16-20UNF	11.113	20	P3	2.5P	C	5	80	13	40	8	6	9	8×6	27.8	3	9.84	○
ET166-SJN-U1213C-P4	1/2-13UNC	12.700	13	P4	2.5P	C	5	85	21	48	9	7	10	9×7	31.8	3	10.75	○
ET166-SJN-U1220C-P3	1/2-20UNF	12.700	20	P3	2.5P	C	5	85	13	48	9	7	10	9×7	31.8	3	11.43	○
ET166-SJN-U91612C-P4	9/16-12UNC	14.288	12	P4	2.5P	C	5	90	21	50	10.5	8	11	10.5×8	35.7	3	12.17	○
ET166-SJN-U91618C-P3	9/16-18UNF	14.288	18	P3	2.5P	C	5	90	15	50	10.5	8	11	10.5×8	35.7	3	12.88	○
ET166-SJN-U5811C-P4	5/8-11UNC	15.875	11	P4	2.5P	C	5	95	23	48	12	9	12	12×9	39.7	3	13.57	○
ET166-SJN-U5818C-P3	5/8-18UNF	15.875	18	P3	2.5P	C	5	95	23	48	12	9	12	12×9	39.7	3	14.46	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎	◎	◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

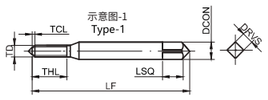
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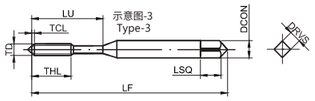
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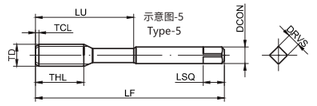
M MF UNC UNF HSSE JIS ISO 6H/2B DLC

经济型 铜铝加工刃倾角丝锥
Economical copper and aluminum processing spiral pointed tap









订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-PJN-010025B-P1	M1×0.25	1	0.25	P1	5P	B	1	37	4.5	—	3	2.5	3	3×2.5	2.5	2	0.75	○
ET166-PJN-012025B-P1	M1.2×0.25	1.2	0.25	P1	5P	B	1	37	5.5	—	3	2.5	3	3×2.5	3.0	2	0.95	○
ET166-PJN-014030B-P1	M1.4×0.3	1.4	0.3	P1	5P	B	1	37	9	—	3	2.5	3	3×2.5	3.5	2	1.10	○
ET166-PJN-016035B-P2	M1.6×0.35	1.6	0.35	P2	5P	B	1	37	8	—	3	2.5	3	3×2.5	4.0	2	1.25	○
ET166-PJN-020040B-P2	M2×0.4	2	0.4	P2	5P	B	1	45	11	—	3	2.5	3	3×2.5	5.0	2	1.60	●
ET166-PJN-025045B-P2	M2.5×0.45	2.5	0.45	P2	5P	B	1	45	12	—	3	2.5	3	3×2.5	6.3	2	2.05	●
ET166-PJN-030050B-P2	M3×0.5	3	0.5	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.5	3	2.50	●
ET166-PJN-035060B-P2	M3.5×0.6	3.5	0.6	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.90	○
ET166-PJN-040070B-P2	M4×0.7	4	0.7	P2	5P	B	3	57	14	21	5	4	7	5×4	10.0	3	3.30	●
ET166-PJN-050080B-P2	M5×0.8	5	0.8	P2	5P	B	3	66	16	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	●
ET166-PJN-060100B-P2	M6×1	6	1	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.0	3	5.00	●
ET166-PJN-070100B-P3	M7×1	7	1	P3	5P	B	3	78	13	23	6.2	5	8	6.2×5	17.5	3	6.00	○
ET166-PJN-080125B-P3	M8×1.25	8	1.25	P3	5P	B	5	70	22	37	6.2	5	8	6.2×5	20.0	3	6.75	●
ET166-PJN-080100B-P3	M8×1	8	1	P3	5P	B	5	70	22	37	6.2	5	8	6.2×5	20.0	3	7.00	●
ET166-PJN-100150B-P4	M10×1.5	10	1.5	P4	5P	B	5	75	24	43	7	5.5	8	7×5.5	25.0	3	8.50	●
ET166-PJN-100125B-P3	M10×1.25	10	1.25	P3	5P	B	5	75	24	43	7	5.5	8	7×5.5	25.0	3	8.75	●
ET166-PJN-100100B-P3	M10×1	10	1	P3	5P	B	5	75	24	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET166-PJN-120175B-P4	M12×1.75	12	1.75	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.25	●
ET166-PJN-120150B-P4	M12×1.5	12	1.5	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.50	●
ET166-PJN-120125B-P4	M12×1.25	12	1.25	P4	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.75	○
ET166-PJN-120100B-P3	M12×1	12	1	P3	5P	B	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎	◎	◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

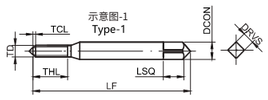
推荐切削参数 ※P62
Recommended Cutting Data ※P62

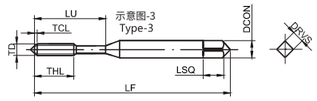
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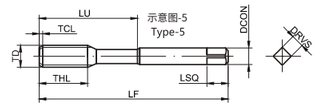
M MF UNC UNF HSSE JIS ISO 6H/2B DLC

经济型 铜铝加工刃倾角丝锥
Economical copper and aluminum processing spiral pointed tap









》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-PJN-140200B-P5	M14×2	14	2	P5	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET166-PJN-140150B-P4	M14×1.5	14	1.5	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET166-PJN-140125B-P4	M14×1.25	14	1.25	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET166-PJN-140100B-P3	M14×1	14	1	P3	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET166-PJN-160200B-P5	M16×2	16	2	P5	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET166-PJN-160150B-P4	M16×1.5	16	1.5	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	●
ET166-PJN-160125B-P4	M16×1.25	16	1.25	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET166-PJN-160100B-P3	M16×1	16	1	P3	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET166-PJN-U080B-P1	NO.0-80UNF	1.524	80	P1	5P	B	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET166-PJN-U164B-P1	NO.1-64UNC	1.854	64	P1	5P	B	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET166-PJN-U256B-P1	NO.2-56UNC	2.184	56	P1	5P	B	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET166-PJN-U348B-P1	NO.3-48UNC	2.515	48	P1	5P	B	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET166-PJN-U440B-P2	NO.4-40UNC	2.845	40	P2	5P	B	1	45	13	—	3	2.5	3	3×2.5	7.1	2	2.21	●
ET166-PJN-U540B-P2	NO.5-40UNC	3.175	40	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET166-PJN-U632B-P2	NO.6-32UNC	3.505	32	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.71	●
ET166-PJN-U832B-P2	NO.8-32UNC	4.166	32	P2	5P	B	3	57	13.5	21.5	5	4	7	5×4	10.4	3	3.37	●
ET166-PJN-U1024B-P2	NO.10-24UNC	4.826	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	●
ET166-PJN-U1032B-P2	NO.10-32UNF	4.826	32	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET166-PJN-U1224B-P2	NO.12-24UNC	5.486	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET166-PJN-U1228B-P2	NO.12-28UNF	5.486	28	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET166-PJN-U1420B-P2	1/4-20UNC	6.350	20	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.08	●

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎	◎	◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

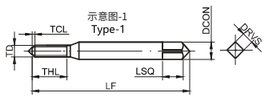
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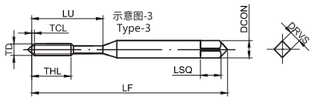
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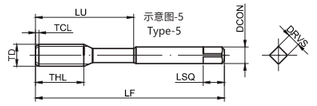
M | MF | UNC | UNF | HSSE | JIS | ISO 6H/2B | DLC

经济型 铜铝加工刃倾角丝锥
Economical copper and aluminum processing spiral pointed tap









》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-PJN-U1428B-P2	1/4-28UNF	6.350	28	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.44	●
ET166-PJN-U51618B-P3	5/16-18UNC	7.938	18	P3	5P	B	5	70	23	38	6.1	5	8	6.1×5	19.8	3	6.53	●
ET166-PJN-U51624B-P3	5/16-24UNF	7.938	24	P3	5P	B	5	70	23	38	6.1	5	8	6.1×5	19.8	3	6.88	●
ET166-PJN-U3816B-P3	3/8-16UNC	9.525	16	P3	5P	B	5	75	25	43	7	5.5	8	7×5.5	23.8	3	7.94	●
ET166-PJN-U3824B-P3	3/8-24UNF	9.525	24	P3	5P	B	5	75	25	43	7	5.5	8	7×5.5	23.8	3	8.47	●
ET166-PJN-U71614B-P4	7/16-14UNC	11.113	14	P4	5P	B	5	80	29	45	8	6	9	8×6	27.8	3	9.30	○
ET166-PJN-U71620B-P3	7/16-20UNF	11.113	20	P3	5P	B	5	80	29	45	8	6	9	8×6	27.8	3	9.84	○
ET166-PJN-U1213B-P4	1/2-13UNC	12.700	13	P4	5P	B	5	85	30	48	9	7	10	9×7	31.8	3	10.75	○
ET166-PJN-U1220B-P3	1/2-20UNF	12.700	20	P3	5P	B	5	85	30	48	9	7	10	9×7	31.8	3	11.43	○
ET166-PJN-U91612B-P4	9/16-12UNC	14.288	12	P4	5P	B	5	90	30	50	10.5	8	11	10.5×8	35.7	3	12.17	○
ET166-PJN-U91618B-P3	9/16-18UNF	14.288	18	P3	5P	B	5	90	30	50	10.5	8	11	10.5×8	35.7	3	12.88	○
ET166-PJN-U5811B-P4	5/8-11UNC	15.875	11	P4	5P	B	5	95	23	48	12	9	12	12×9	39.7	3	13.57	○
ET166-PJN-U5818B-P3	5/8-18UNF	15.875	18	P3	5P	B	5	95	23	48	12	9	12	12×9	39.7	3	14.46	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
						◎	◎	◎					

◎ 最适合 Most Suitable ○ 适合 Suitabel

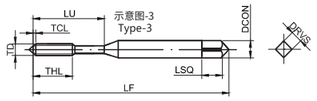
推荐切削参数 ※P62
Recommended Cutting Data ※P62

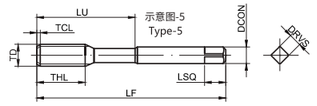
ET128-HJN

M | MF | HSSE | JIS | ISO 6H | TiAl-Si

经济型 铸铁加工直槽丝锥
Economical cast iron processing hand tap







订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET128-HJN-050080C-P3	M5×0.8	5	0.8	P3	2.5P	C	3	66	16	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	○
ET128-HJN-060100C-P3	M6×1	6	1	P3	2.5P	C	3	69	19.5	29	6	4.5	7	6×4.5	15.0	3	5.00	○
ET128-HJN-070100C-P3	M7×1	7	1	P3	2.5P	C	3	78	13	23	6.2	5	8	6.2×5	17.5	3	6.00	○
ET128-HJN-080125C-P4	M8×1.25	8	1.25	P4	2.5P	C	5	70	22	37	6.2	5	8	6.2×5	20.0	3	6.75	○
ET128-HJN-080100C-P4	M8×1	8	1	P4	2.5P	C	5	70	22	37	6.2	5	8	6.2×5	20.0	3	7.00	○
ET128-HJN-100150C-P5	M10×1.5	10	1.5	P5	2.5P	C	5	75	24	43	7	5.5	8	7×5.5	25.0	3	8.50	○
ET128-HJN-100125C-P4	M10×1.25	10	1.25	P4	2.5P	C	5	75	24	43	7	5.5	8	7×5.5	25.0	3	8.75	○
ET128-HJN-100100C-P4	M10×1	10	1	P4	2.5P	C	5	75	24	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET128-HJN-120175C-P5	M12×1.75	12	1.75	P5	2.5P	C	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.25	○
ET128-HJN-120150C-P5	M12×1.5	12	1.5	P5	2.5P	C	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.50	○
ET128-HJN-120125C-P5	M12×1.25	12	1.25	P5	2.5P	C	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.75	○
ET128-HJN-120100C-P4	M12×1	12	1	P4	2.5P	C	5	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○
ET128-HJN-140200C-P6	M14×2	14	2	P6	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	○
ET128-HJN-140150C-P5	M14×1.5	14	1.5	P5	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	○
ET128-HJN-140125C-P5	M14×1.25	14	1.25	P5	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET128-HJN-140100C-P4	M14×1	14	1	P4	2.5P	C	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET128-HJN-160200C-P6	M16×2	16	2	P6	2.5P	C	5	90	20	52	12.5	10	13	12.5×10	40.0	3	14.00	○
ET128-HJN-160150C-P5	M16×1.5	16	1.5	P5	2.5P	C	5	90	20	52	12.5	10	13	12.5×10	40.0	3	14.50	○
ET128-HJN-160125C-P5	M16×1.25	16	1.25	P5	2.5P	C	5	90	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET128-HJN-160100C-P4	M16×1	16	1	P4	2.5P	C	5	90	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material

P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
				◎	○								

◎ 最适合 Most Suitable ○ 适合 Suitabel

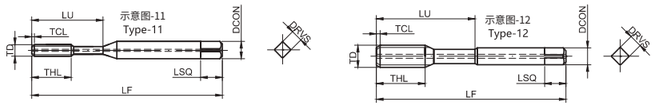
推荐切削参数 ※P62
Recommended Cutting Data ※P62

B 经济型丝锥 Economy Taps

ET128-HJC



经济型 内冷铸铁加工直槽丝锥
Economical internal cooling cast iron processing hand tap



订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET128-HJC-050080C-P3	M5×0.8	5	0.8	P3	2.5P	C	11	61	16	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	○
ET128-HJC-060100C-P3	M6×1	6	1	P3	2.5P	C	11	63	19.5	29	6	4.5	7	6×4.5	15.0	3	5.00	○
ET128-HJC-070100C-P3	M7×1	7	1	P3	2.5P	C	11	72	13	23	6.2	5	8	6.2×5	17.5	3	6.00	○
ET128-HJC-080125C-P4	M8×1.25	8	1.25	P4	2.5P	C	12	70	22	37	6.2	5	8	6.2×5	20.0	3	6.75	○
ET128-HJC-080100C-P4	M8×1	8	1	P4	2.5P	C	12	70	22	37	6.2	5	8	6.2×5	20.0	3	7.00	○
ET128-HJC-100150C-P5	M10×1.5	10	1.5	P5	2.5P	C	12	75	24	43	7	5.5	8	7×5.5	25.0	3	8.50	○
ET128-HJC-100125C-P4	M10×1.25	10	1.25	P4	2.5P	C	12	75	24	43	7	5.5	8	7×5.5	25.0	3	8.75	○
ET128-HJC-100100C-P4	M10×1	10	1	P4	2.5P	C	12	75	24	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET128-HJC-120175C-P5	M12×1.75	12	1.75	P5	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.25	○
ET128-HJC-120150C-P5	M12×1.5	12	1.5	P5	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.50	○
ET128-HJC-120125C-P5	M12×1.25	12	1.25	P5	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.75	○
ET128-HJC-120100C-P4	M12×1	12	1	P4	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○
ET128-HJC-140200C-P6	M14×2	14	2	P6	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	○
ET128-HJC-140150C-P5	M14×1.5	14	1.5	P5	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	○
ET128-HJC-140125C-P5	M14×1.25	14	1.25	P5	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET128-HJC-140100C-P4	M14×1	14	1	P4	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET128-HJC-160200C-P6	M16×2	16	2	P6	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	○
ET128-HJC-160150C-P5	M16×1.5	16	1.5	P5	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	○
ET128-HJC-160125C-P5	M16×1.25	16	1.25	P5	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET128-HJC-160100C-P4	M16×1	16	1	P4	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material															
P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
				◎	○								

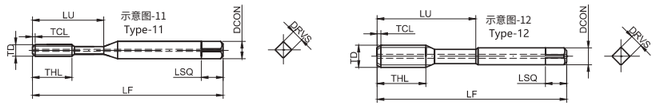
◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

ET128-HJR



经济型 内冷铸铁加工直槽丝锥
Economical internal cooling cast iron processing hand tap



订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET128-HJR-050080C-P3	M5×0.8	5	0.8	P3	2.5P	C	11	61	16	25	5.5	4.5	7	5.5×4.5	12.5	3	4.20	○
ET128-HJR-060100C-P3	M6×1	6	1	P3	2.5P	C	11	63	19.5	29	6	4.5	7	6×4.5	15.0	3	5.00	○
ET128-HJR-070100C-P3	M7×1	7	1	P3	2.5P	C	11	72	13	23	6.2	5	8	6.2×5	17.5	3	6.00	○
ET128-HJR-080125C-P4	M8×1.25	8	1.25	P4	2.5P	C	12	70	22	37	6.2	5	8	6.2×5	20.0	3	6.75	○
ET128-HJR-080100C-P4	M8×1	8	1	P4	2.5P	C	12	70	22	37	6.2	5	8	6.2×5	20.0	3	7.00	○
ET128-HJR-100150C-P5	M10×1.5	10	1.5	P5	2.5P	C	12	75	24	43	7	5.5	8	7×5.5	25.0	3	8.50	○
ET128-HJR-100125C-P4	M10×1.25	10	1.25	P4	2.5P	C	12	75	24	43	7	5.5	8	7×5.5	25.0	3	8.75	○
ET128-HJR-100100C-P4	M10×1	10	1	P4	2.5P	C	12	75	24	43	7	5.5	8	7×5.5	25.0	3	9.00	○
ET128-HJR-120175C-P5	M12×1.75	12	1.75	P5	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.25	○
ET128-HJR-120150C-P5	M12×1.5	12	1.5	P5	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.50	○
ET128-HJR-120125C-P5	M12×1.25	12	1.25	P5	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	10.75	○
ET128-HJR-120100C-P4	M12×1	12	1	P4	2.5P	C	12	82	29	46	8.5	6.5	9	8.5×6.5	30.0	3	11.00	○
ET128-HJR-140200C-P6	M14×2	14	2	P6	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	○
ET128-HJR-140150C-P5	M14×1.5	14	1.5	P5	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	○
ET128-HJR-140125C-P5	M14×1.25	14	1.25	P5	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET128-HJR-140100C-P4	M14×1	14	1	P4	2.5P	C	12	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET128-HJR-160200C-P6	M16×2	16	2	P6	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	○
ET128-HJR-160150C-P5	M16×1.5	16	1.5	P5	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	○
ET128-HJR-160125C-P5	M16×1.25	16	1.25	P5	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET128-HJR-160100C-P4	M16×1	16	1	P4	2.5P	C	12	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○

● 标准库存Stock ○ 需预定Available upon Order

单位:mm
unit:mm

[备注 Note] 预孔尺寸仅做参考。PHD for referance only.

工件材料 Workpiece Material															
P			M	K		N				S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/ Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast Iron	锻造铝合金、铸造铝合金 Forged Aluminium Alloys, Cast Aluminium Alloys	铸造铝合金 Cast Aluminium Alloys	铜合金 Copper Alloys	复合材料 Compound Material	高温合金 Heat Resistant Super Alloys	钛合金 Titanium Alloys	淬硬钢 Hardened Steels	淬硬钢 Hardened Steels
＜35HRC	35-48HRC			＜32HRC	＜43HRC	Si＜12%	Si＞12%	＜HB200		＜HB450	＜HB400	45-55HRC	55-60HRC
				◎	○								

◎ 最适合 Most Suitable ○ 适合 Suitabel

推荐切削参数 ※P62
Recommended Cutting Data ※P62

B 经济型丝锥 Economy Taps

经济型丝锥切削速度表
Economical Tap Cutting Speed Table

工件材料 Workpiece Material		ET138-FJN	ET166-FJN	ET168-FJN	ET138-SJN	ET166-SJN	ET168-SJN	ET138-PJN	ET166-PJN	ET168-PJN	ET128-HJN	ET128-HJC ET128-HJR
		外冷 External Cooling										内冷 Internal Coolant
P	低碳钢 Low carbon steel (<125HB)	5-15		5-10	5-15		5-10	5-15		5-10		
	高碳钢及合金钢 High carbon steel and alloy steel (<35HRC)	5-10		5-10	5-10		5-10	5-10		5-10		
	调质钢和工具钢 (35-48HRC) Quenched and tempered steel and tool steel											
M	奥氏体不锈钢 (35-48HRC) Austenitic stainless steel (130-200HB) (130-200HB)	5-10		5-15	5-10		5-15	5-10		5-15		
	高强度的奥氏体和铸造不锈钢 High-strength austenitic and cast stainless steel (<25HRC)	5-10		5-15	5-10		5-15	5-10		5-15		
	双相不锈钢 Duplex stainless steel (<30HRC)	4-8		5-10	4-8		5-10	4-8		5-10		
K	灰铸铁和球墨铸铁 Gray cast iron and ductile iron (<32HRC)										15-30	20-40
	高合金铸铁 Gray cast iron and ductile iron (<43HRC)										10-20	15-25
N	锻造铝合金和铸造铝合金 Forged aluminum alloy and cast aluminum alloy (Si<12%)		5-10			5-10			5-10			
	铸造铝合金 Cast aluminum alloy (Si>12%)		4-8			4-8			4-8			
	铜合金 Copper alloy (<HB200)		5-10			5-10			5-10			

【注意Note】
1.推荐使用丝锥专用刀柄加工。
It is recommended to use a dedicated tap handle for machining.
2.表中切削参数为推荐参数，加工时请根据实际加工情况适当调整切削参数。
During the machining process, please adjust the cutting parameters according to the actual conditions.

单位:m/min
unit:m/min



C

附录
Appendix

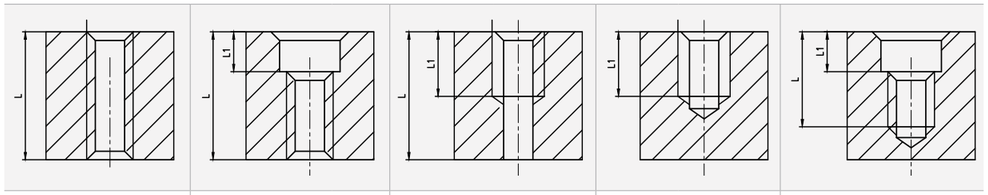
丝锥询单信息表
Tap Desired Form

丝锥询单信息表
Tap Desired Form

1、孔的种类 Hole Type

规格 Specification：	公 差 Tolerance：

螺纹孔特征 Hole Type：



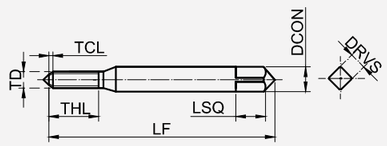
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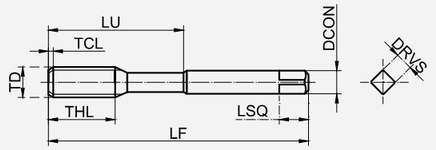
2、加工方式 Machining Method

机床型号 Machining Machine：	加工特点 Machining Characteristics：
加工材料 Workpiece Mterial：	材料硬度 Hardness：
加工参数 Machining Parameters：	冷却方式 Cooling Method：

3、刀具类型 Tool Type

☐ 新项目打样 Sample for new project	☐ 替代 / 优化现有竞品 Replacing/Optimizing Existing Competitors
丝锥类型 Tap Type：	其　他 Others：
期望刀具尺寸 Desired Tool Dimensions：	现用品牌 / 规格 Current Brand/Specification：





TD*TP:	TCL:	THL:
DCON:	LSQ:	LF:

其他尺寸要求 Others：

4、备注 Note：

挤压丝锥螺纹底孔直径表
RECOMMENDED DRILL HOLE DIAMETER FOR FLUTELSS TAPS

公制螺纹
Metric Threads

单位：mm
Unit:mm

螺纹尺寸 Thread Size	1 级螺纹用底孔直径 JIS Class 1 Drill Hole Dia.		2 级螺纹用底孔直径 JIS Class 2 Drill Hole Dia.	
	RH 精度 Precision	最小～最大 (嵌合率 %) MIN ～ MAX(Thread Overlap Ratio:%)	RH 精度 Precision	最小～最大 (嵌合率 %) MIN ～ MAX(Thread Overlap Ratio:%)
M1 ×0.25	2	0.87~0.89[100~85)	4	0.90~0.92(100~80)
M1.2×0.25	2	1.07~1.09 (100~85)	4	1.10~1.12 (100~80)
M1.4×0.3	2	1.244~1.263(100~85)	4	1.270~1.294(100~80)
M1.6×0.35	2	1.40~1.44 (100~80)	4	1.44 ~1.48 (100~75)
M1.7 ×0.35	2	1.51~1.54 (100~80)	4	1.54 ~1.58 (100~75)
M2×0.4	2	1.78~1.82(100~80)	4	1.81~1.85(100~75)
M2.3×0.4	2	2.08~2.12 (100~80)	4	2.11~2.15(100~75)
M2.5 ×0.45	2	2.25~2.29 (100~80)	4	2.28~2.33(100~75)
M2.6×0.45	2	2.35~2.39 (100~80)	4	2.38~2.43(100~75)
M3×0.5	3	2.74~2.78 (100~80)	5	2.76~2.81(100~75)
M3.5×0.6	3	3.18 ~3.21 (100~85)	5	3.20~3.26 (100~75)
M4 ×0.7	4	3.63~3.67(100~85)	6	3.65~3.70(100~85)
M5 ×0.8	4	4.57~4.62(100~85)	6	4.59~4.66 (100~80)
M6×1.0	4	5.45~5.51(100~85)	7	5.48~5.57(100~80)
M7 ×1.0	4	6.45~6.51(100~85)	7	6.48~6.57(100~80)
M8 ×1.25	5	7.31~7.38 (100~85)	7	7.34~7.41 (100~85)
M10 ×1.5	5	9.16~9.22 (100~90)	7	9.18~9.28(100~85)
M12 ×1.75	5	11.01~11.08(100~90)	8	11.05~11.15(100~85)
M14×2.0	6	12.83~12.95(100~90)	10	12.92~13.04(100~85)
M16×2.0	6	14.87~14.95(100~90)	10	14.92~15.04(100~85)

挤压丝锥螺纹底孔直径表
RECOMMENDED DRILL HOLE DIAMETER FOR FLUTELSS TAPS

美制螺纹 Unified Threads　　单位：mm Unit:mm

螺纹尺寸 Thread Size	2B 级螺纹用底孔直径 Class 2B Drill Hole Dia.				3B 级螺纹用底孔直径 Class 3B Drill Hole Dia.	
	外径 Outer Diameter	牙距 pitch Thread	RH 精度 Precision	最小～最大 (嵌合率 %) MIN ～ MAX(Thread Overlap Ratio:%)	RH 精度 Precision	最小～最大 (嵌合率 %) MIN ～ MAX(Thread Overlap Ratio:%)
NO.0 ～ 80UNF	1.524	0.3175	4	1.38 ～ 1.41(100 ～ 65)	3	1.36 ～ 1.40(100 ～ 65)
1 ～ 72UNF	1.854	0.3528	4	1.68 ～ 1.72(100 ～ 65)	3	1.67 ～ 1.71(100 ～ 65)
1 ～ 64UNC	1.854	0.3969	4	1.66 ～ 1.70(100 ～ 65)	3	1.65 ～ 1.69(100 ～ 65)
2 ～ 56UNC	2.184	0.4536	4	1.96 ～ 2.02(100 ～ 65)	3	1.95 ～ 2.01 (100 ～ 65)
2 ～ 64UNF	2.184	0.3969	4	1.98 ～ 2.04 (100 ～ 65)	3	1.97 ～ 2.03 (100 ～ 65)
3 ～ 48UNC	2.514	0.5292	4	2.25 ～ 2.32(100 ～ 65)	3	2.23 ～ 2.31(100 ～ 65)
3 ～ 56UNF	2.514	0.4536	4	2.29 ～ 2.35 (100 ～ 65)	3	2.28 ～ 2.34 (100 ～ 65)
4 ～ 40UNC	2.844	0.635	5	2.52 ～ 2.60 (100 ～ 70)	3	2.50 ～ 2.58 (100 ～ 70)
4 ～ 48UNF	2.844	0.5292	4	2.57 ～ 2.64 (100 ～ 70)	3	2.56 ～ 2.63 (100 ～ 70)
6 ～ 32UNC	3.504	0.7938	5	3.09 ～ 3.17 (100 ～ 75)	3	3.06 ～ 3.14 (100 ～ 75)
6 ～ 40UNF	3.504	0.635	5	3.19 ～ 3.26(100 ～ 70)	3	3.16 ～ 3.22 (100 ～ 75)
8 ～ 32UNC	4.164	0.7938	6	3.75 ～ 3.83 (100 ～ 75)	4	3.74 ～ 3.82(100 ～ 75)
8 ～ 36UNF	4.164	0.7056	5	3.80 ～ 3.88 (100 ～ 75)	4	3.79 ～ 3.86 (100 ～ 75)
10 ～ 24UNC	4.824	1.0583	6	4.26 ～ 4.35 (100 ～ 80)	4	4.24 ～ 4.32(100 ～ 80)
10 ～ 32UNF	4.824	0.7938	5	4.41 ～ 4.48 (100 ～ 80)	4	4.40 ～ 4.46 (100 ～ 80)
12 ～ 24UNC	5.484	1.0583	6	4.92 ～ 5.01 (100 ～ 8O)	4	4.90 ～ 4.96(100 ～ 85)
12 ～ 28UNF	5.484	0.9071	5	5.00 ～ 5.08 (100 ～ 80)	4	4.99 ～ 5.06(100 ～ 80)
1/4 ～ 20UNC	6.35	1.27	6	5.66 ～ 5.76(100 ～ 80)	4	5.64 ～ 5.74 (100 ～ 80)
1/4 ～ 28UNF	6.35	0.9071	5	5.86 ～ 5.93 (100 ～ 80)	4	5.85 ～ 5.92 (100 ～ 80)
5/16 ～ 18UNC	7.9375	1.4111	7	7.18 ～ 7.29 (100 ～ 80)	5	7.15 ～ 7.24 (100 ～ 85)
5/16 ～ 24UNF	7.9375	1.0583	6	7.38 ～ 7.46(100 ～ 80)	5	7.36 ～ 7.43 (100 ～ 85)
3/8 ～ 16UNC	9.525	1.5875	7	8.66 ～ 8.78 (100 ～ 80)	5	8.63 ～ 8.73 (100 ～ 85)
3/8 ～ 24UNF	9.525	1.0583	6	8.96 ～ 9.05 (100 ～ 80)	5	8.95 ～ 9.02 (100 ～ 85)
7/16 ～ 14UNC	11.1125	1.814	7	10.11 ～ 10.25(100 ～ 80)	5	10.08 ～ 10.19[100 ～ 85)
7/16 ～ 20UNF	11.1125	1.27	7	10.44 ～ 10.54 (100 ～ 80)	5	10.41 ～ 10.49(100 ～ 85)
1/2 ～ 13UNC	12.7	1.9538	8	11.62 ～ 11.78 (100 ～ 80)	6	11.60 ～ 11.68 (100 ～ 90)
1/2 ～ 20UNF	12.7	1.27	7	12.02 ～ 12.12(100 ～ 80)	5	12.00 ～ 12.05 (100 ～ 90)
5/8 ～ 11UNC	15.875	2.3091	11	14.62 ～ 14.76(100 ～ 85)	8	14.58 ～ 14.67(100 ～ 90)
5/8 ～ 18UNF	15.875	1.4111	9	15.14 ～ 15.25 (100 ～ 80)	7	15.11 ～ 15.17 (100 ～ 90)

切削丝锥螺纹底孔直径表
Recommended Drill Hole Diameter For Cutting Taps

公制螺纹 Metric Threads　　单位：mm Unit:mm

螺纹尺寸 Thread Size		标准直径 Standard Hole Dia.	2 级牙钻孔径 For JIS Class 2 Drill Hole Dia.	
			最大 MAX	最小 MIN
M1	0.25	0.75	0.785	0.729
M1.1	0.25	0.85	0.885	0.829
M1.2	0.25	0.95	0.985	0.929
M1.4	0.3	1.1	1.142	1.075
M1.6	0.35	1.25	1.321	1.221
M1.7	0.35	1.35	1.421	1.321
M1.8	0.35	1.45	1.521	1.421
M2	0.4	1.6	1.679	1.567
M2.2	0.45	1.75	1.838	1.713
M2.3	0.4	1.9	1.979	1.867
M2.5	0.45	2.1	2.138	2.013
M2.6	0.45	2.2	2.238	2.113
M3	0.5	2.5	2.599	2.459
M3.5	0.6	2.9	3.01	2.85
M4	0.7	3.3	3.422	3.242
M4.5	0.75	3.8	3.878	3.688
M5	0.8	4.2	4.334	4.134
M6	1	5	5.153	4.917
M7	1	6	6.153	5.917
M8	1.25	6.8	6.912	6.647
M8	1	7	7.153	6.917
M9	1.25	7.8	7.912	7.647
M10	1.5	8.5	8.676	8.376
M10	1.25	8.8	8.912	8.647
M10	1	9	9.153	8.917
M11	1.5	9.5	9.676	9.376
M12	1.75	10.3	10.441	10.106
M12	1.5	10.5	10.676	10.376
M12	1.25	10.8	10.912	10.647
M12	1	11	11.153	10.917
M14	2	12	12.21	11.835
M14	1.5	12.5	12.676	12.376
M14	1	13	13.153	12.917
M16	2	14	14.21	13.835
M16	1.5	14.5	14.676	14.376
M16	1	15	15.15	14.917

切削丝锥螺纹底孔直径表
Recommended Drill Hole Diameter For Cutting Taps

公制螺纹 Metric Threads　　单位：mm Unit:mm

美制粗牙螺纹规格 Specification (UNC)		标准直径 Standard Hole Dia.	2 级牙钻孔径 For JIS Class 2 Drill Hole Dia.	
			最大 MAX	最小 MIN
NO.1	-64	1.55	1.582	1.425
NO.2	-56	1.8	1.871	1.695
NO.3	-48	2.05	2.146	1.941
NO.4	-40	2.3	2.385	2.157
NO.5	-40	2.6	2.697	2.487
NO.6	-32	2.8	2.895	2.642
NO.8	-32	3.4	3.53	3.302
NO.10	-24	3.9	3.962	3.683
N0.12	-24	4.5	4.597	4.344
1/4	-20	5.1	5.257	4.979
5/16	-18	6.6	6.731	6.401
3/8	-16	8	8.153	7.798
7/16	-14	9.4	9.55	9.144
1/2	-13	10.9	11.023	10.592
9/16	-12	12.2	12.466	11.989
5/8	-11	13.6	13.868	13.386

美制细牙螺纹规格 Specification (UNF)		标准直径 Standard Hole Dia.	2 级牙钻孔径 For JIS Class 2 Drill Hole Dia.	
			最大 MAX	最小 MIN
NO.0	-80	1.25	1.305	1.182
NO.1	-72	1.55	1.612	1.474
NO.2	-64	1.85	1.912	1.756
NO.3	-56	2.1	2.197	2.025
NO.4	-48	2.4	2.458	2.271
NO.5	-44	2.7	2.74	2.551
NO.6	-40	2.9	3.022	2.82
NO.8	-36	3.5	3.606	3.404
NO.10	-32	4.1	4.165	3.963
NO.12	-28	4.6	4.724	4.496
1/4	-28	5.5	5.588	5.36
5/16	-24	6.9	7.035	6.782
3/8	-24	8.5	8.636	8.382
7/16	-20	9.90	10.033	9.729
1/2	-20	11.5	11.607	11.329
9/16	-18	12.9	13.081	12.751
5/8	-18	14.5	14.681	14.351

工件材料表
Workpiece Material Table

材料组 ISO Material Group	MC	工件材料 Workpiece Material	含量 Content	抗拉强度 Tensile Strength N/mm2	布氏硬度 Brinell Hardness HB	洛氏硬度 Rockwell Hardness HRC
P 钢 Steels	P1	低碳钢，长切屑 Low-carbon Steels，Long Chipping	C<0.25%	<530	<125	
	P2	低碳钢，短切屑，易切钢 Low-carbon Steels，Short Chipping，Freecutting Steels	C<0.25%	<530	<125	
	P3	高碳钢及中碳钢 High-carbon Steels, Medium-carbon Steels	C>0.25%	>530	<220	<25
	P4	合金钢，工具钢 Alloy Steels，Tool Steels	C>0.25%	600-850	<330	<35
	P5	合金钢，工具钢 Alloy Steels，Tool Steels	C>0.25%	850-1400	340-450	35-48
	P6	铁素体不锈钢，马氏体不锈钢，PH不锈钢 Ferritic Stainless Steels，Martensitic Stainless Steels，PH Stainless Steels	C=(0-0.4)%	600-900	<330	<35
	P7	高强度铁素体不锈钢，马氏体不锈钢, PH 不锈钢 High-strength Ferritic Stainless Steels，Martensitic Stainless Steels，PH Stainless Steels	C=(0.1-0.6)%	900-1350	330-450	35-48
M 不锈钢 Stainless Steels	M1	奥氏体不锈钢 Austenitic Stainless Steels	C=(0.05-0.15)%	<600	130-200	
	M2	高强度的奥氏体和铸造不锈钢 High-Strength Austenitic Stainless Steels and Cast Stainless Steels	C=(0.05-0.15)%	600-800	150-230	<25
	M3	双相不锈钢 Duplex Stainless Steels	C=(0.05-0.20)%	<800	135-275	<30
K 铸铁 Cast Iron	K1	灰铸铁 Grey Cast Iron		125-500	120-290	＜32
	K2	中等加工难度的合金铸铁，球墨铸铁 Moderately Difficult Alloy Cast iron，Nodular Cast Iron		<600	130-260	＜28
	K3	难加工的高合金铸铁，球墨铸铁 Difficult High-alloy Cast Iron，Nodular Cast Iron		>600	180-350	＜43
N 有色材料 Non-ferrous Materials	N1	锻造铝合金 Wrought Aluminium Alloys		<520	60-90	
	N2	铸造铝合金 Cast Aluminium Alloys	Si<12%	<350	70-100	
	N3	铸造铝合金 Cast Aluminium Alloys	Si>12%	200-320	60-120	
	N4	铜，铜合金 Copper，Copper Alloys		200-650	60-200	
	N5	石墨，复合材料 Graphite，CFK，CFRP Graphite，Composite Materials		600-1500		
	N6	铝基复合材料(MMCs) GFK，CFK Aluminium-based Composite Materials (MMCs)		<700	<210	
S 耐热合金钛合金 Heat-resistant SuperAlloys、Titanium Alloys	S1	铁基高温合金 Iron-based Heat-resistant Alloys		500-1200	160-260	25-48
	S2	钴基高温合金 Cobalt-based Heat-resistant Alloys		1000-1450	250-450	25-48
	S3	镍基高温合金 Nickel-based Heat-resistant Alloys		600-1700	160-450	<48
	S4	钛及钛合金 Titanium and Titanium Alloys		900-1600	300-400	33-48
H 高硬度硬材料 Hardened Materials	H1	淬硬钢 Hardened Steels				45-55
	H2	淬硬钢 Hardened Steels				55-60
	H3	淬硬钢 Hardened Steels				60-65
	H4	淬硬钢 Hardened Steels				>65

切削定义及计算
Cutting Calculations and Definitions

常用参数及其单位 Parameter and Unit		
D 刀具直径 D Diameter	(mm)	fn 每转进给量 (mm/rev) fn Feed per Revolution (mm/rev)
ap 切削深度 ap Cutting Depth	(mm)	fz 每刃进给量 (mm/tooth) fz Feeding per Teeth (mm/tooth)
ae 切削宽度 ae Cutting Width	(mm)	Z 刀刃数 Z Number of Teeth
Vf 进给速度 Vf Feed Rate	(mm/min)	n 主轴转速 (rev/min) N Spindle Speed (rev/min)
Vc 切削速度(工件长度+ 铣刀直径：l+D) Vc Cutting Speed	(m/min)	L 工作台总进给长度 (mm) L Length (mm)
Q 金属切削率 Q Rate of Metal Removal	(cm^3/min)	Tc 加工时间 (min) Tc Processing Time (min)

通用计算公式 General Formula	
n 主轴转速 n Spindle Speed	$n = \frac{Vc \cdot 1000}{\pi \cdot D}$ (rev/min)
Vc 切削速度 Vc Cutting Speed	$Vc = \frac{\pi \cdot D \cdot n}{1000}$ (m/min)
Vf 进给速度 Vf Feed Rate	$Vf = fz \cdot z \cdot n$ (mm/min)
fz 每刃进给量 fz Feed per Teeth	$fz = \frac{Vf}{z \cdot n}$ (mm)
Q 金属切削率 Q Rate of Metal Removal	$Q = \frac{ae \cdot ap \cdot Vf}{1000}$ (cm^3/min)
Tc 加工时间 Tc Processing Time	$Tc = \frac{L}{Vf}$ (min)

抗拉强度、布氏硬度、洛氏硬度对照表
Comparison Table for Tensile Strength , Brinell Hardness and Rockwell

N/mm2	HV10	HB	HRC
240	75	71	
255	80	76	
270	85	81	
285	90	86	
305	95	90	
320	100	95	
335	105	100	
350	110	105	
370	115	109	
385	120	114	
400	125	119	
415	130	124	
430	135	128	
450	140	133	
465	145	138	
480	150	143	
495	155	147	
510	160	152	
530	165	157	
545	170	162	
560	175	166	
575	180	171	
595	185	176	
610	190	181	
625	195	185	
640	200	190	
660	205	195	
675	210	199	
690	215	204	
705	220	209	
720	225	214	
740	230	219	
755	235	223	
770	240	228	
785	245	233	
800	250	238	22
820	255	242	23
835	260	247	24
860	268	255	25
870	272	258	26
900	280	266	27

N/mm2	HV10	HB	HRC
920	287	273	28
940	293	278	29
970	302	287	30
995	310	295	31
1020	317	301	32
1050	327	311	33
1080	336	319	34
1110	345	328	35
1140	355	337	36
1170	364	346	37
1200	373	354	38
1230	382	363	39
1260	392	372	40
1260	403	383	41
1330	413	393	42
1360	423	402	43
1400	434	413	44
1440	446	424	45
1480	458	435	46
1530	473	449	47
1570	484	460	48
1620	497	472	49
1680	514	488	50
1730	527	501	51
1790	544	517	52
1845	560	632	53
1910	578	549	54
1980	596	567	55
2050	615	584	56
2140	639	607	57
	655	622	58
	675		59
	698		60
	720		61
	745		62
	773		63
	800		64
	829		65
	864		66
	900		67
	940		68

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